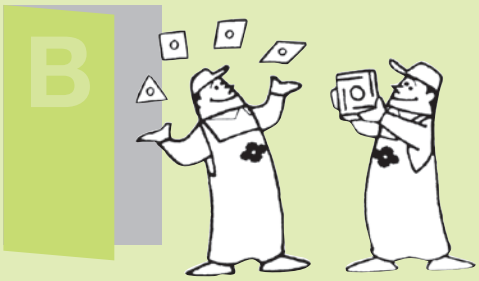
车削用机夹式刀片

负型/正型/陶瓷 B1～B132

B



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负型刀片
C / 80°菱形 (带孔) ……B14
D / 55°菱形 (带孔) ……B25
S / 正方形 (带孔) ……B33
S / 正方形 (无孔) ……B46
T / 三角形 (带孔) ……B48
T / 三角形 (无孔) ……B58
V / 35°菱形 (带孔) ……B60
W / 六角形 (带孔) ……B63

正型刀片
C / 80°菱形 (带孔) ……B68
D / 55°菱形 (带孔) ……B80
R / 圆形 (带孔) ……B88
S / 正方形 (带孔) ……B90
S / 正方形 (无孔) ……B96
T / 三角形 (带孔) ……B100
T / 三角形 (无孔) ……B101
V / 35°菱形 (带孔) ……B118
W / 六角形 (带孔) ……B126

陶瓷负型 (带孔 / 无孔) ……B128
陶瓷正型 (无孔) ……B129
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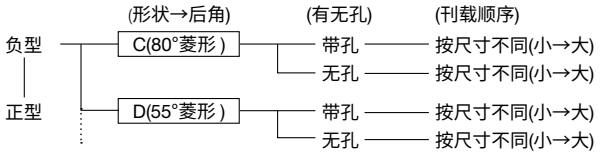
使用修光刃刀片的注意事项 ……B131

本章的构成

① 按照负型→正型的顺序归纳车削用刀片。
② 排列按照C(80°菱形)→ D(55°菱形)→ R(圆形)→ S(正方形) → T(三角形)→ V(35°菱形)→ W(六角形)的顺序。
③ 每个相同后角按带孔、无孔的顺序。
④ 每个相同形状按照尺寸不同(切刃长度与厚度组合的小→大)归纳。

●构成略图



刀片图纸的表示记号

※依照ISO13399。

L：切刃长、IC：内切圆、S：厚度、RE：刀尖半径、
D1：孔径(住友CBN/ 住友金刚石L：边长。)

方向型刀片

※ 方向型刀片的照片原则上是右手方向。

刀片材质的记载

① 住友硬质合金刊载自涂层(CVD、PVD)/金属陶瓷/硬质合金/陶瓷。
② 关于住友CBN/住友金刚石，仅在住友CBN篇(→L34～)、住友金刚石篇(→M10～)中刊载。

库存标识和记号

●●记号：标准库存品
●记号：计划在将来被各页记载的新产品替换
▲记号：计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)
＊记号：准标准库存品(请确认有无库存)
○记号：计划备库品(请确认有无库存)
无记号：接单生产品
－记号：不生产

机夹式刀片型号的称呼方法

〔例〕

C N M G

① C — ①形状记号 参照(表1)

② N — ②后角记号 参照(表2)

③ M — ③精度等级记号 参照(表3)

④ G — ④槽孔记号 参照(表4)

(表1)① 形状记号

记号	刀片形状		顶角
C		菱形	80°
D			55°
E			75°
F			50°
V			35°
R		圆形	—
S		正方形	90°
T		正三角形	60°
W		等边不等角六角形	80°
A		平行四边形	85°
B			82°
K			55°
H		正六角形	120°
O		正八角形	135°
P		正五角形	108°
L		长方形	90°
M		菱形	86°

(表2)② 后角记号

记号	后角
A	3°
B	5°
C	7°
D	15°
E	20°
F	25°
G	30°
N	0°
P★	11°
O	其他

带★的表示也有使用10°的例外情况。

(表3)③ 精度等级记号

(mm)

记号	刀尖高度允许差	内切圆允许差	厚度允许差
A	± 0.005	± 0.025	± 0.025
F	± 0.005	± 0.013	± 0.025
C	± 0.013	± 0.025	± 0.025
H	± 0.013	± 0.013	± 0.025
E	± 0.025	± 0.025	± 0.025
G	± 0.025	± 0.025	± 0.13
J★	± 0.005	± 0.05 ~ ± 0.15	± 0.025
K★	± 0.013	± 0.05 ~ ± 0.15	± 0.025
L★	± 0.025	± 0.05 ~ ± 0.15	± 0.025
M★	± 0.08 ~ ± 0.2	± 0.05 ~ ± 0.15	± 0.13
N★	± 0.08 ~ ± 0.2	± 0.05 ~ ± 0.15	± 0.025
U★	± 0.13 ~ ± 0.38	± 0.08 ~ ± 0.25	± 0.13

★号的刀片原则上侧面是烧结面。M 级精度的详细内容请参照下表〈参考〉。

(表4)④ 槽孔记号

记号	有无孔	孔的形状	断屑槽的有无	形状(断面)	记号	有无孔	孔的形状	断屑槽的有无	形状(断面)
N	无	无	无		A	有	圆柱状	无	
R			单面		M			单面	
F			两面		G			两面	
W	有	圆柱孔＋单面倒角(40°~60°)	无		B	有	圆柱孔＋单面倒角(70°~90°)	无	
T			单面		H			单面	
Q	有	圆柱孔＋双侧倒角(40°~60°)	无		C	有	圆柱孔＋双侧倒角(70°~90°)	无	
U			两面		J			两面	
					X	—	—	—	特殊

(参考)以M 级精度的形状、尺寸分类的明细

● 刀尖高度允许差 (mm)

内切圆	三角形	正方形	80°菱形	55°菱形	35°菱形	圆形
6.35	± 0.08	± 0.08	± 0.08	± 0.11	± 0.16	—
9.525	± 0.08	± 0.08	± 0.08	± 0.11	± 0.16	—
12.70	± 0.13	± 0.13	± 0.13	± 0.15	—	—
15.875	± 0.15	± 0.15	± 0.15	± 0.18	—	—
19.05	± 0.15	± 0.15	± 0.15	± 0.18	—	—
25.40	± 0.18	± 0.18	± 0.18	—	—	—
31.75	—	± 0.20	—	—	—	—

● 内切圆允许差 (mm)

内切圆	三角形	正方形	80°菱形	55°菱形	35°菱形	圆形
6.35	± 0.05	± 0.05	± 0.05	± 0.05	± 0.05	—
9.525	± 0.05	± 0.05	± 0.05	± 0.05	± 0.05	± 0.05
12.70	± 0.08	± 0.08	± 0.08	± 0.08	—	± 0.08
15.875	± 0.10	± 0.10	± 0.10	± 0.10	—	± 0.10
19.05	± 0.10	± 0.10	± 0.10	± 0.10	—	± 0.10
25.40	± 0.13	± 0.13	± 0.13	—	—	± 0.13
31.75	—	± 0.15	—	—	—	± 0.15

机夹式刀片型号的称呼方法

12 04 08 N - GE

⑤ ⑥ ⑦ ⑧ ⑨

- ⑤ 切刃长记号：参照(表5)
- ⑥ 厚度记号：参照(表6)
- ⑦ 刀尖半径记号：参照(表7)
- ⑧ 方向记号：参照(表8)
- ⑨ 断屑槽记号：参照(表9)

例示刀片外观形状

(表5)⑤ 切刃长记号(所示代表例)(注)切刃长为尖刃情况下的尺寸 (mm)

形状	记号	切刃长	内切圆	形状	记号	切刃长	内切圆	形状	记号	切刃长 负型	切刃长 正型	内切圆 负型	内切圆 正型
C 菱形 80°	03	3.55	3.50	D 菱形 55°	07	7.7	6.35	W 六角形	03	3.8		5.56	
	04	4.37	4.30		09	9.7	7.94		04	4.3		6.35	
	06	6.4	6.35		11	11.6	9.525		05	5.4		7.94	
	08	8.0	7.94		15	15.5	12.70		06	6.5	3.2	9.525	3.97
	09	9.7	9.525		19	19.4	15.875		08	8.7	4.6	12.70	4.76
	12	12.9	12.70						10	10.9		15.875	
	16	16.1	15.875	V 菱形 35°	08	8.3	4.76		11		4.3		6.35
	19	19.3	19.05		09	9.7	5.56		16		6.5		9.525
	25	25.8	25.4		11	11.1	6.35	R 圆形	08	8.0		8.0	
					16	16.6	9.525		10	10.0		10.0	
					22	22.1	12.70		12	12.0		12.0	
S 正方形	06	6.35	6.35	T 三角形	06	6.9	3.97		12	12.70		12.70	
	S7	7.14	7.14		08	8.2	4.76		15	15.875		15.875	
	07	7.94	7.94		09	9.6	5.56		16	16.0		16.0	
	09	9.525	9.525		11	11.0	6.35		19	19.05		19.05	
	12	12.70	12.70		13	13.7	7.94		20	20.0		20.0	
	15	15.875	15.875		16	16.5	9.525		24	24.0		24.0	
	19	19.05	19.05		22	22.0	12.70		25	25.0		25.0	
	25	25.40	25.40		27	27.5	15.875		25	25.40		25.40	
	31	31.75	31.75		33	33.0	19.05		32	32.0		32.0	

(表6)⑥ 厚度记号

记号	厚度(mm)
X1	*
01	1.59
02	2.38
T2	2.78
03	3.18
T3	3.97
04	4.76
05	5.56
06	6.35
07	7.94
09	9.52

(*)
CC□T03X1 刀片厚度：1.40
CC□T04X1 刀片厚度：1.80

(表7)⑦ 刀尖半径记号

记号	刀尖半径(mm)
00	尖刃
003	0.03
008	0.08
01	0.1
015	0.15
018	0.18
02	0.2
035	0.35
04	0.4
08	0.8
10	1.0
12	1.2
16	1.6
20	2.0
24	2.4
32	3.2
M0	圆形(公制)
00	圆形(英制)
00	非圆弧刀尖

刀尖半径记号的后面带有“M”的产品表示为负公差

(表8)⑧ 方向记号

记号	方向
R	右手刀
L	左手刀
N	无方向

(表9)⑨ 断屑槽记号

记号	用途	3维型(博基型)	全周型	带方向型
F □	微小切削～精切削用	FA, FL, FE, FF, FB, FC, FK, FP		FT, FX, FZ FYS,FY, FW
S □ L □	轻切削用	SE, SEW, SI, SC, SF, SS, SU, SX LU, LUW, LB		SD SDW ST
G □ U □	一般切削用	GE, GU, GUW UG, UP US, UX	GZ UZ	UM
M □	粗切削用	MP, MU, MX, ME	MC	MM HM
H □	重切削用	HG, HP, HF	HU HW	

其他特例品	
宽口断屑槽	W
双正型断屑槽	GX
倒角加工用	C
圆形刀片用	RD, RP, RX, RH
难削材加工用	EF, EG, EX, EM
铝合金加工用	AW, AG, AX, AY, LD, GD
淬火钢加工用	FV, LV, GH
渗碳淬火层去除加工用	SV
不锈钢加工用	EF, EG, EM

按切削条件分类

断屑槽的选择要领

负型刀片 精加工～中切削

微小切削用

FB型 P M K N S H
低进给加工时的切屑处理和锋利性优良
0.80 27° CNMG1204○○型 0°
C D R S T V W

FA型 P M K N S H
曲面断屑槽、在微小切削中发挥威力
1.0 20° CNMG1204○○型 0°
C D R S T V W

FL型 P M K N S H
最适于铁板材切屑处理的断屑槽
1.0 10° CNMG1204○○型 0°
C D R S T V W

FE型 P M K N S H
在低～高进给加工中可发挥优良的切屑处理性能
1.40 0.70 20° CNMG1204○○型 0°
C D R S T V W

通用例

断屑槽记号 — **GU型** P M K N S H — 适用被削材
低阻力耐磨损的通用断屑槽 — 特长
典型形状图片
0.25 2.05 25° 7° CNMG1204○○型 — 典型断面形状
后角 0°
库存形状 C D R S T V W — 断面图型号

精切削用

LU型 P M K N S H
对切深变动与仿形加工的切屑处理很有效果
1.5 1.0 10° CNMG1204○○型 0°
C D R S T V W

SU型 P M K N S H
在小切深高进给中效果好
1.3 13° CNMG1204○○型 0°
C D R S T V W

SE型 P M K N S H
减轻前刀面的刀具磨损精加工用断屑槽，高效率加工也有效。
0.1 1.5 17° 5° CNMG1204○○型 0°
C D R S T V W

EF型 P M K N S H
断屑性能优良的难削材精加工用断屑槽
1.2 20° CNMG1204○○型 0°
C D R S T V W

LUW型 P M K N S H
带修光刃的高效率精加工用断屑槽
修光刃刀片
1.5 1.0 10° CNMG1204○○型 0°
C D R S T V W

SEW型 P M K N S H
带修光刃的高进给精加工用的新断屑槽
修光刃刀片
0.13 1.9 17° 5° CNMG1204○○型 0°
C D R S T V W

FX型 P M K N S H
具有优良加工性能的尖刃平行断屑槽
1.5 14° TNGG1604○○型 0°
C D R S T V W

FY型 P M K N S H
具有良好加工性能的尖刃宽口断屑槽
2.5 15° TNGG1604○○型 0°
C D R S T V W

FT型 P M K N S H
精加工切削用研磨型的圆弧型断屑槽
0.15 1.35 TNGG1103○○型 0°
C D R S T V W

轻～中切削用

SJ型 P M K N S H
具有卓越刀头强度的全周型断屑槽
0.18 1.2 SNMG1204○○型 0°
C D R S T V W

ST型 P M K N S H
轻切削用研磨型的圆弧型断屑槽
0.15 1.65 TNGG1603○○型 0°
C D R S T V W

GX型 P M K N S H
锋利性好的双正型断屑槽
1.5 15° SNGG1204○○型 0°
C D R S T V W

SX型 P M K N S H
可进行仿形加工和台阶加工
0.2 1.35 15° 3° CNMG1204○○型 0°
C D R S T V W

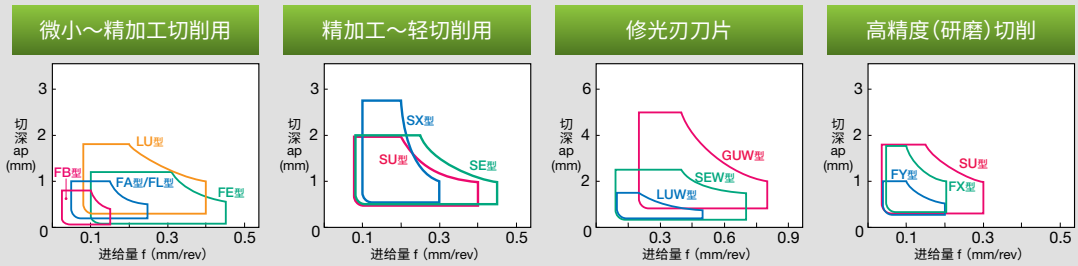
EX型 P M K N S H
难削材专用的全周型断屑槽
2.0 16° CNMG1204○○型 0°
C D R S T V W

UP型 P M K N S H
双正通型刃形最适于不锈钢加工
2.1 10° CNMG1204○○型 0°
C D R S T V W

博基刀片　全周型断屑　方向型断屑槽
断屑金刚(CBN/PCD)　倒角用

适用被削材：P 钢　M 不锈钢　K 铸铁　N 非铁金属　S 难削材　H 高硬度材

断屑槽适用范围图(刀片内切圆尺寸 ～ø 12.7mm)



此处是代表性断屑槽的适用范围、形状，会因型号(尺寸、精度等级等)不同而有差异。详细情况请参照B 章后面的库存页面。

断屑槽的选择要领

负型刀片　中切削～粗切削

中切削用

GU型 P M K N S H
低阻力耐磨损的通用断屑槽
0.25 / 2.05 / 25° / 7° / CNMG1204○○型
0° C D R S T V W

GE型 P M K N S H
在高效率加工中对前刀面也耐磨损的通用断屑槽
2.0 / 0.25 / 23° / 3° / CNMG1204○○型
0° C D R S T V W

UX型 P M K N S H
刀头强度高、可靠性高的通用断屑槽
2.0 / 0.25 / 15° / CNMG1204○○型
0° C D R S T V W

UG型 P M K N S H
通用性强的常盛不衰槽型
1.7 / 0.2 / 21° / 4° / CNMG1204○○型
0° C D R S T V W

EG型 P M K N S H
兼具切屑处理性和耐崩损性的难削材通用断屑槽
1.75 / 0.09 / 30° / CNMG1204○○型
0° C D R S T V W

UM型 P M K N S H
中切削用研磨型的通用型断屑槽
2.0 / 0.15 / 14° / SNMG1204○○型
0° C D R S T V W

GUW型 P M K N S H
带修光刃的高效率中精加工用断屑槽
修光刃刀片
2.5 / 0.3 / 23° / CNMG1204○○型
0° C D R S T V W

中～粗切削用

EM型 P M K N S H
兼顾优异耐崩损性和耐月牙洼磨损性的断屑槽
2.5 / 0.05 / CNMG1204○○型
0° C D R S T V W

MU型 P M K N S H
低阻力经济性的两面使用高进给用
2.5 / 0.3 / 20° / 4° / CNMG1204○○型
0° C D R S T V W

ME型 P M K N S H
抑制前刀面损伤，可应对高进给加工的粗加工用断屑槽
0.3 / 2.4 / 4° / CNMG1204○○型
0° C D R S T V W

MX型 P M K N S H
切刃强度优异的断续切削用
2.3 / 0.2 / 0.4 / 20° / -15° / CNMG1204○○型
0° C D R S T V W

UZ型 P M K N S H
性能稳定的全周型断屑槽
1.9 / 0.3 / 14° / 4° / CNMG1204○○型
0° C D R S T V W

GZ型 P M K N S H
刀头强度优良、可靠性高的全周型断屑槽
1.9 / 0.25 / 16° / CNMG1204○○型
0° C D R S T V W

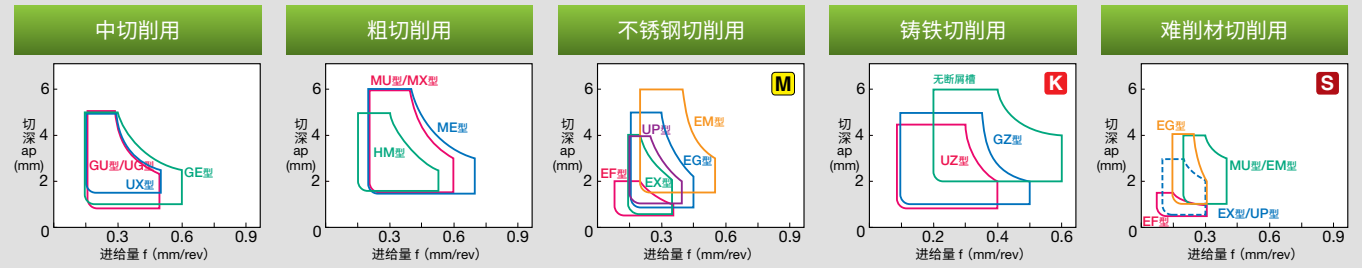
HM型 P M K N S H
宽幅低阻力的M级方向型中～粗加工用断屑槽
2.7 / 0.2 / 15° / 25° / TNMG1604○○型
0° C D R S T V W

MM型 P M K N S H
具有宽幅和平缓前角的研磨断屑槽
2.95 / 0.15 / 10° / SNMG1204○○型
0° C D R S T V W

博基刀片　全周型断屑　方向型断屑槽
断屑金刚(CBN/PCD)　倒角用

适用被削材：P 钢　M 不锈钢　K 铸铁　N 非铁金属　S 难削材　H 高硬度材

断屑槽适用范围图(刀片内切圆尺寸 ～ø 12.7mm)



此处是代表性断屑槽的适用范围、形状，会因型号(尺寸、精度等级等)不同而有差异。详细情况请参照B 章后面的库存页面。

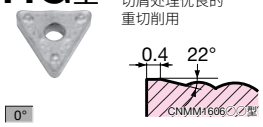
按切削条件分类

断屑槽的选择要领

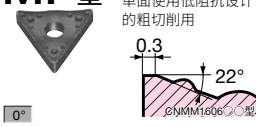
负型刀片 粗切削

粗~重切削用

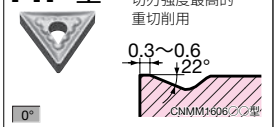
HG型 P M K N S H
切屑处理优良的重切削用



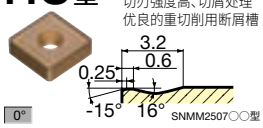
MP型 P M K N S H
单面使用低阻抗设计的粗切削用



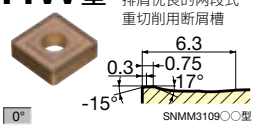
HP型 P M K N S H
切刃强度最高的重切削用



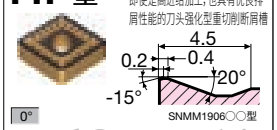
HU型 P M K N S H
切刃强度高、切屑处理优良的重切削用断屑槽



HW型 P M K N S H
排屑优良的两段式重切削用断屑槽



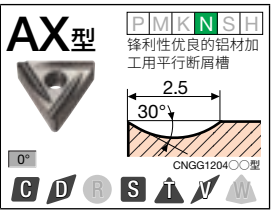
HF型 P M K N S H
即使是高进给加工，也具有优良排屑性能的刀头强化型重切削断屑槽



负型刀片 铝合金加工用

精切削用

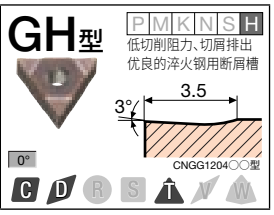
AX型 P M K N S H
锋利性优良的铝材加工用平行断屑槽



负型刀片 淬火钢加工用

精切削用

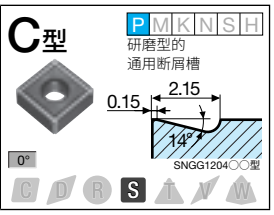
GH型 P M K N S H
低切削阻力、切屑排出优良的淬火钢用断屑槽



负型刀片 倒角用

倒角用

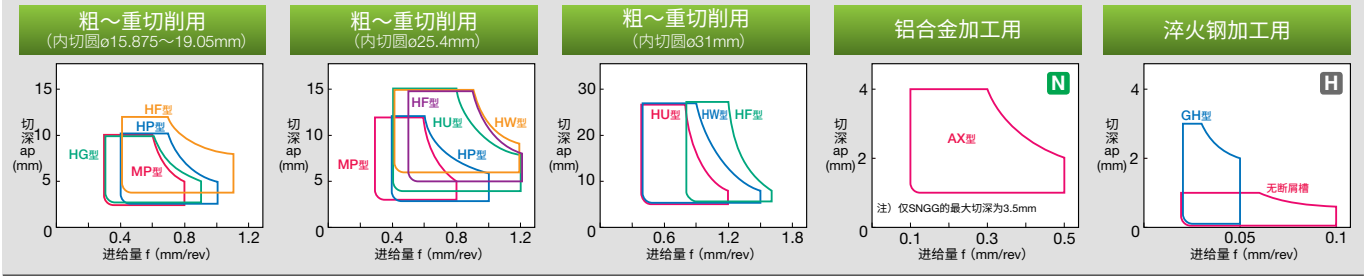
C型 P M K N S H
研磨型的通用断屑槽



博基刀片　全周型断屑　方向型断屑槽
断屑金刚(CBN/PCD)　倒角用

适用被削材：P 钢　M 不锈钢　K 铸铁　N 非铁金属　S 难削材　H 高硬度材

断屑槽适用范围图



此处是代表性断屑槽的适用范围、形状，会因型号(尺寸、精度等级等)不同而有差异。详细情况请参照B 章后面的库存页面。

按切削条件分类

断屑槽的选择要领

正型刀片 M级精～中切削

精加工～轻切削用

FB型 P M K N S H
软钢的切屑处理、加工面品质优良的精加工用断屑槽
0.5 / 20° / 5° 7° 11° / CCMT09T3○○型
C D R S T V W

LU型 P M K N S H
在微小切削方面，大幅提高切屑处理能力
0.8 / 15° / 5° 7° 11° / CCMT09T3○○型
C D R S T V W

LUW型 P M K N S H
具有高性能精加工用修光刃断屑槽
修光刃刀片
1.5 / 10° / 7° 11° / CCMT09T3○○型
C D R S T V W

FP型 P M K N S H
在微小切削方面中的处理切屑处理性能好
1.40 / 10° / 7° / CCMT09T3○○型
C D R S T V W

FK型 P M K N S H
锋利性优良，切屑处理良好的精加工用
1.1 / 11° / TPMT1604○○型
C D R S T V W

轻～中切削用

LB型 P M K N S H
锋利性、切屑处理优良的轻切削用断屑槽
0.8 / 15° / 5° 7° 11° / CCMT09T3○○型
C D R S T V W

SU型 P M K N S H
锋利性优良的通用断屑槽
1.45 / 8° / 5° 7° 11° / TPMT1103○○型
C D R S T V W

GU型 P M K N S H
通用断屑槽的第一推荐
0.2 / 1.6 / 5° / 15° / 5° 7° 11° / CCMT09T3○○型
C D R S T V W

SS型 P M K N S H
切屑处理优良的中切削用断屑槽
1.15 / 5° / 11° / CPMH0903○○型
C D R S T V W

US型 P M K N S H
小径镗孔刀用
1.95 / 10° / 11° / CPMH0903○○型
C D R S T V W

MU型 P M K N S H
低阻力寿命稳定的断屑槽
0.35 / 1.8 / 0.1 / 4° / 20° / 7° 11° / TPMT1604○○型
C D R S T V W

SF型 P M K N S H
切削性能好可靠性高的断屑槽
0.2 / 1.6 / 14° / 11° / TPMT1604○○型
C D R S T V W

UJ型 P M K N S H
刀具寿命稳定
0.1 / 1.5 / 5° / 11° / TPMR1603○○型
C D R S T V W

正型刀片 G级 研磨型

精加工～轻切削用

FW型 P M K N S H
锋利性好的宽倒锥断屑槽
0.90 / 15° (20°) / 5° 11° / TPMT1102○○型
C D R S T V W

FX型 P M K N S H
尖刃平行的断屑槽
0.9 / 15° / 5° 7° 11° / TPGT1103○○型
C D R S T V W

FYS型 P M K N S H
尖刃微小切削用断屑槽
0.5 / 15° / 5° 7° / CCGT04X1○○型
C D R S T V W

FY型 P M K N S H
尖刃宽口断屑槽
1.5 / 15° / 5° 7° 11° / TPGT1103○○型
C D R S T V W

W型 P M K N S H
宽口型精加工用断屑槽
0.15 / 1.0 / 10° / 5° 11° / TPGR1103○○型
C D R S T V W

SD型 P M K N S H
带阶梯平行型研磨型
0.9 / 7° 11° / TPGT1103○○型
C D R S T V W

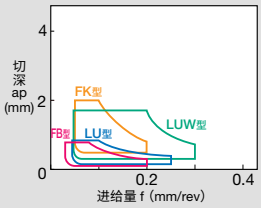
SDW型 P M K N S H
带高性能的修光刃精加工用。研磨平行型断削槽
修光刃刀片
0.9 / 11° / TPGX1103○○型
C D R S T V W

博基刀片	全周型断屑	方向型断屑槽
断屑金刚(CBN/PCD)		倒角用

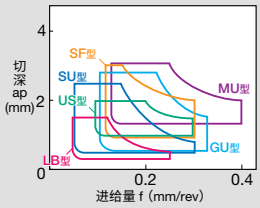
适用被削材：P 钢　M 不锈钢　K 铸铁　N 非铁金属　S 难削材　H 高硬度材

断屑槽适用范围图

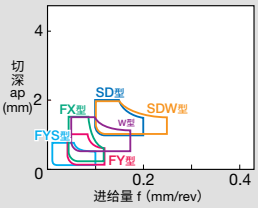
M级　精～轻切削



M级　轻～中切削



G级　研磨型



此处是代表性断屑槽的适用范围、形状，会因型号(尺寸、精度等级等)不同而有差异。详细情况请参照B 章后面的库存页面。

按切削条件分类

断屑槽的选择要领

正型刀片 G级

精加工～轻切削用

FF型 New
P M K N S H
在微小切削条件下实现了优异的切屑处理性能
0.45 / 15°
5° 7° CCGT09T3○○型
C D R S T V W

FC型
P M K N S H
优良的切屑处理与锋利性，外周研磨型三维断屑槽
0.9 / 15°
7° 11° CCGT09T3○○型
C D R S T V W

SI型
P M K N S H
从精加工到轻切削加工，可应对大范围切深的重视锋利性的断屑槽
0.8 / 15°
7° 11° CCGT09T3○○型
C D R S T V W

SC型
P M K N S H
轻切削用
两段式断屑槽
1.0 / 6°
7° TCGT1103○○型
C D R S T V W

正型刀片 圆形刀片

圆形

RX型
P M K N S H
断屑性能优良的博基型圆形刀片
0.2 / 1.7 / 10° / -5°
7° RCMT1606MON型
C D R S T V W

RH型
P M K N S H
切屑排出优良、可靠性高的通用断屑槽
0.30 / -15° / 15°
7° RCMT1606○○型
C D R S T V W

RP型
P M K N S H
仿形加工用的全周型断屑槽
2.5 / 0.25 / 1.04 / -15° / 15°
7° RCMX1606MON型
C D R S T V W

RD型
P M K N S H
锋利性好的全周平行型断屑槽
2.0
11° RCMT1604○○型
C D R S T V W

正型刀片 铝合金加工用

精切削用

AW型
P M K N S H
锋利性优良的铝材精加工用断屑槽
25°
7° VCGT1604○○型
C D R S T V W

AG型
P M K N S H
铝制镜面精加工用，不易附着切屑的断屑槽
20°
7° CCGT09T3○○型
C D R S T V W

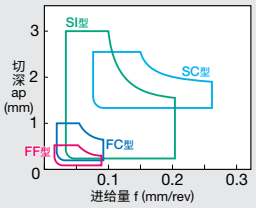
AY型
P M K N S H
高品相研磨断屑槽，加工面品质优良的铝材用断屑槽
2.5 / 15°
5° 7° 11° CCGT09T3○○型
C D R S T V W

博基刀片　全周型断屑　方向型断屑槽
断屑金刚(CBN/PCD)　倒角用

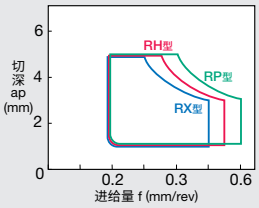
适用被削材：P 钢　M 不锈钢　K 铸铁　N 非铁金属　S 难削材　H 高硬度材

断屑槽适用范围图

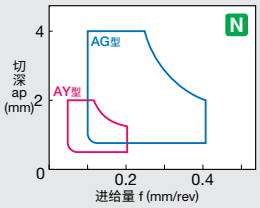
G级断屑槽



圆形刀片
(内切圆～ø12.7mm)



铝合金加工用



此处是代表性断屑槽的适用范围、形状，会因型号(尺寸、精度等级等)不同而有差异。详细情况请参照B 章后面的库存页面。

断屑槽的选择要领

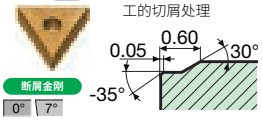
住友CBN刀片 CBN

精加工~轻切削用

LV型

P M K N S H

大幅提高淬火钢精加工的切屑处理



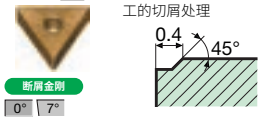
断屑金刚 0° 7°

C D R S T V W

FV型

P M K N S H

大幅提高淬火钢精加工的切屑处理



断屑金刚 0° 7°

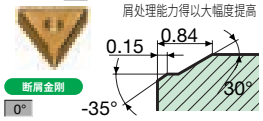
C D R S T V W

去除渗碳淬火层

SV型

P M K N S H

渗碳淬火层去除加工中的切屑处理能力得以大幅度提高



断屑金刚 0°

C D R S T V W

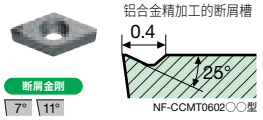
住友金刚石刀片 PCD

精加工~轻切削用

LD型

P M K N S H

采用特殊刀头形状，适合铝合金精加工的断屑槽



断屑金刚 7° 11°

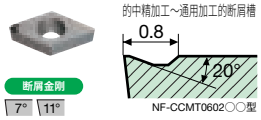
NF-CCMT0602○○型

C D R S T V W

GD型

P M K N S H

采用特殊刀头形状，适合铝合金的中精加工~通用加工的断屑槽



断屑金刚 7° 11°

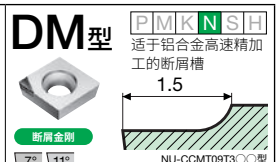
NF-CCMT0602○○型

C D R S T V W

DM型

P M K N S H

适于铝合金高速精加工的断屑槽



断屑金刚 7° 11°

NU-CCMT09T3○○型

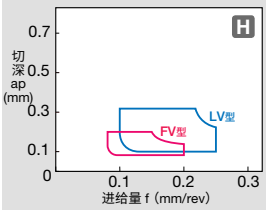
C D R S T V W

博基刀片　全周型断屑　方向型断屑槽
断屑金刚(CBN/PCD)　倒角用

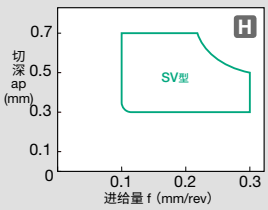
适用被削材：P 钢　M 不锈钢　K 铸铁　N 非铁金属　S 难削材　H 高硬度材

断屑槽适用范围图

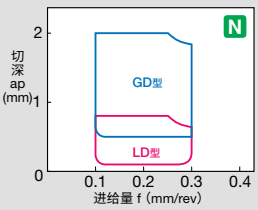
住友CBN（淬火钢加工）（内切圆~ø12.7mm）



住友CBN（渗碳淬火层去除用）（内切圆~ø12.7mm）



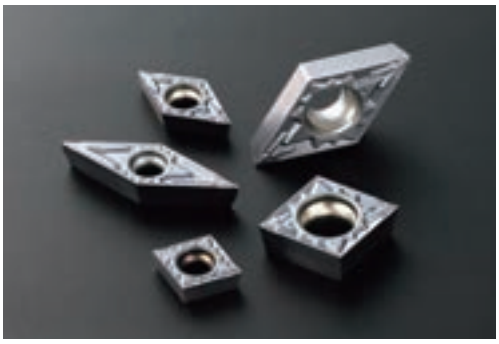
住友金刚石（铝合金加工用）



此处是代表性断屑槽的适用范围、形状，会因型号(尺寸、精度等级等)不同而有差异。详细情况请参照B 章后面的库存页面。

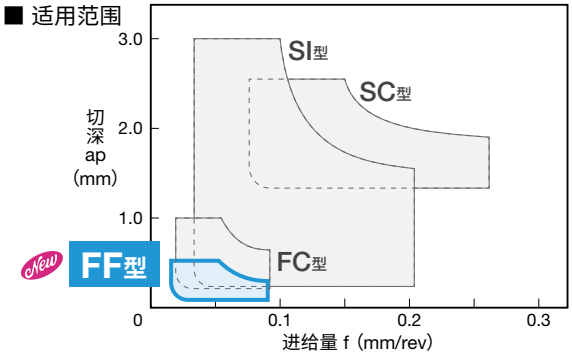
FF型 P 钢 M 不锈钢 K 铸铁 S 难削材

New



- 在切屑处理困难的微小切削条件下分断切屑
- 产品系列丰富，适用于外径、内径加工及各种被削材

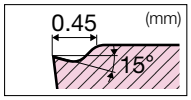
■ 适用范围



特长

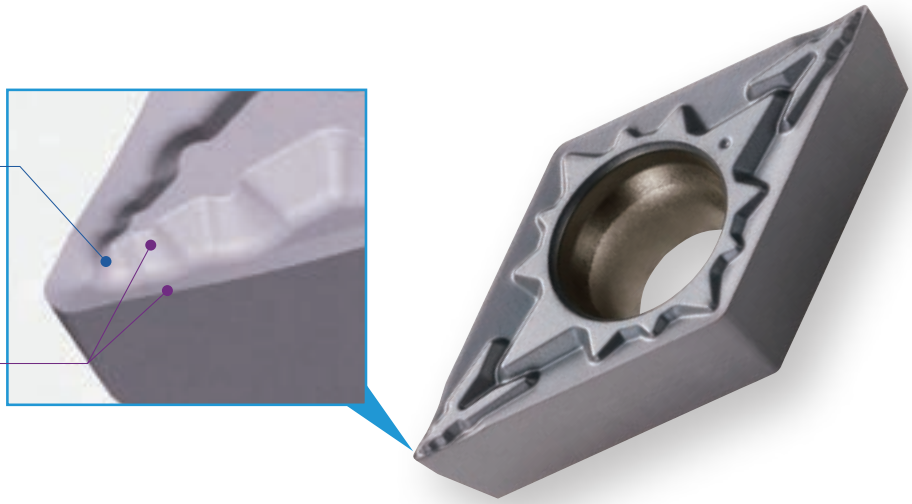
在微小切削条件下
实现了优异的切屑处理性能

通过切刃附近配置的突起
分断切屑



断屑槽横截面形状

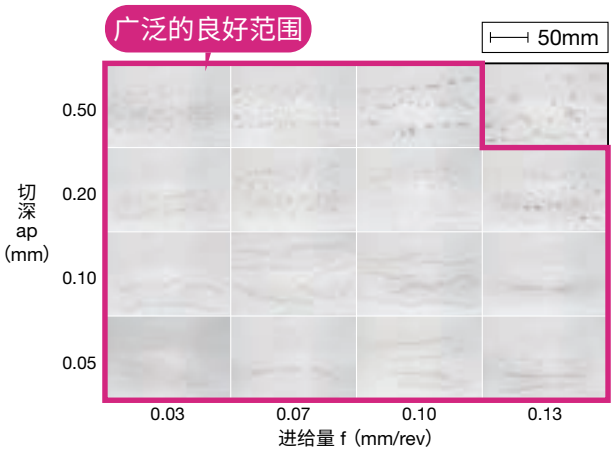
通过倾斜切刃和侧面部的高突起设计
控制切深变动加工产生的切屑



切削性能

切屑处理性能 微小切削条件下分断切屑

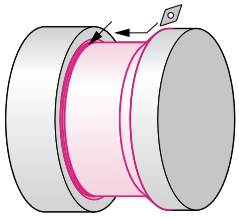
被削材：SCM415 ø30mm　外径加工　刀片：DCGT11T302MN-FF(AC1030U)
切削条件：vc=100m/min f=0.03-0.13mm/rev ap=0.05-0.50mm Wet

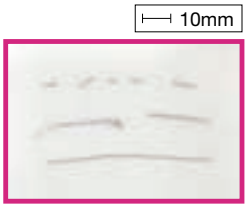


使用实例

在锥度部或退刀槽加工部的精切削中发挥
优异的切屑处理性能

被削材：SCM415 汽车零件 ø12mm外径・锥面・退刀槽加工
刀片：DCGT11T302MN-FF(AC1030U)
切削条件：vc=100m/min f=0.05-0.07mm/rev ap=0.2-0.3mm Wet



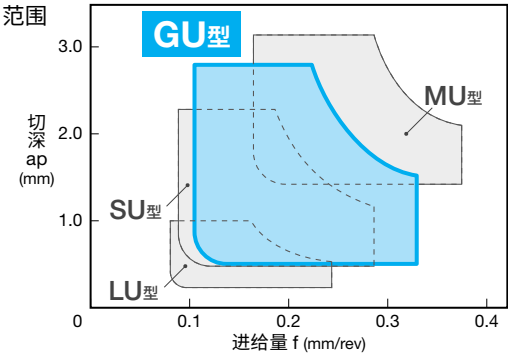


FF型断屑槽
(AC1030U)

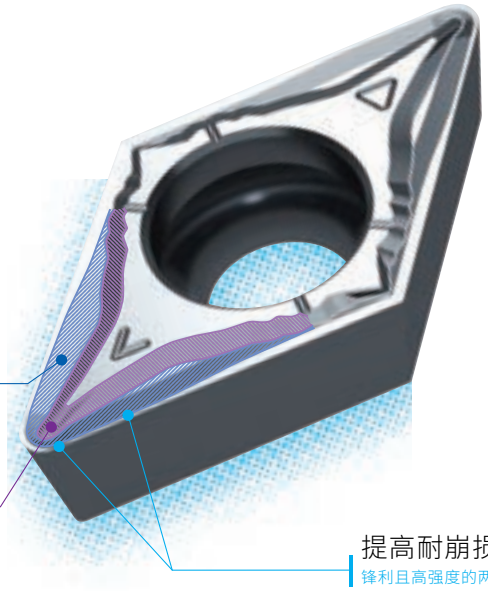
GU型 P 钢 M 不锈钢 S 难削材

- 涵盖粗～精加工领域的优良通用性
- 锋利性和强度优良，在各种条件下实现稳定加工
- 产品系列丰富，适用于多种应用

■ 适用范围



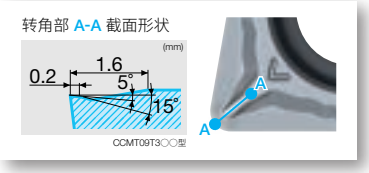
特长

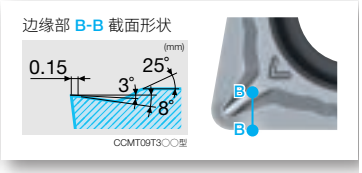


优良的
切屑处理性能
适用于各种切削条件
宽大的排屑槽

低阻力
可抑制振刀发生
一边排出切屑一边进行控制的
突起设计

提高耐崩损性能
锋利且高强度的两段前刀面形状

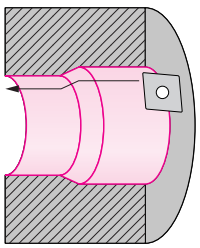


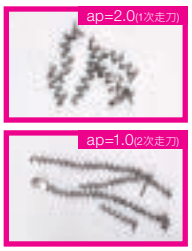


使用实例

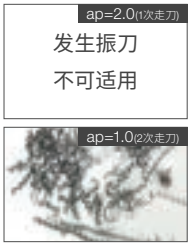
改善切屑缠绕，提高加工效率

被削材：汽车零件(SCM420H)内径锥面加工
刀片：CPMT090308N-GU(AC8025P)
切削条件：vc=200m/min f=0.2mm/rev ap=2.0mm Wet





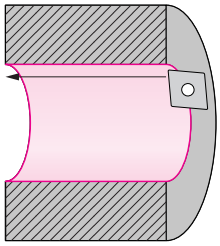
GU型断屑槽
(AC8025P)



以往产品

通过出色强度的设计，实现1.5倍寿命

被削材：连接零件(SCr415)内径加工
刀片：CCMT09T308N-GU(AC8025P)
切削条件：vc=190m/min f=0.25mm/rev ap=1.0mm Wet



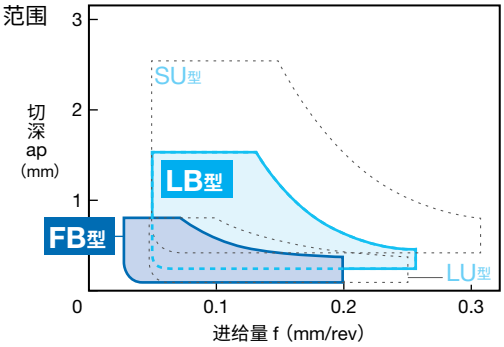
GU型断屑槽
(AC8025P)

其他公司产品

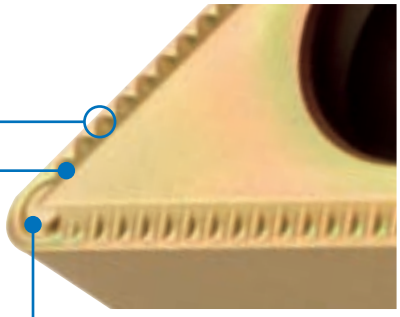
FB型/LB型 P 钢

- 作为低碳钢、一般钢加工用断屑槽系列产品，在精加工切削用LU型、轻切削用SU型的基础上，新加入精切削用FB型、轻切削用LB型，使其形成系列化
- FB型/LB型断屑槽可改善低碳钢、一般钢的精加工切屑处理

■ 适用范围



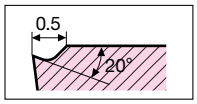
精加工用 FB型断屑槽



利用背脊减小边缘部崩损

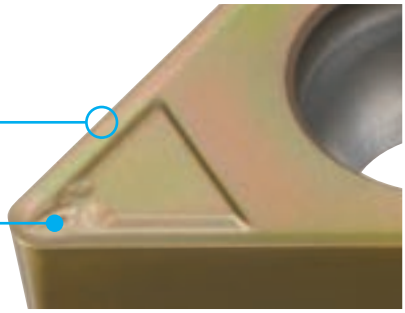
利用大前刀断屑槽壁提高切屑的分断性

通过刀尖 R 内前角变动设计，增大切屑的变形，提高分断性



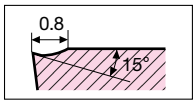
断屑槽横截面形状

轻切削加工用 LB型断屑槽



通过边部强化设计抑制突发性崩损

通过特殊断屑槽棱边形状使切屑处理稳定化



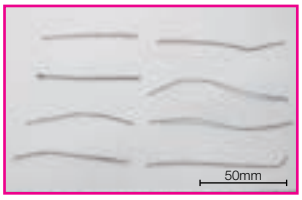
断屑槽横截面形状

切削性能

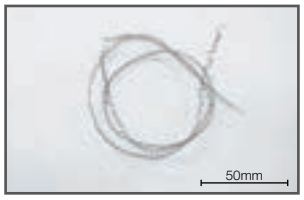
切屑处理性能

被削材：管材(STKM13A) ø30内径加工 刀片：TPMT110304N-FB (T1500A)
切削条件：vc=100m/min, f=0.12mm/rev, ap=0.1mm Wet

小切深、低进给的切屑处理性能稳定



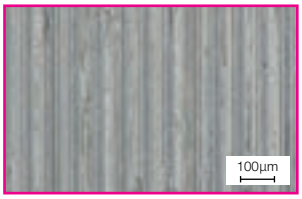
FB型断屑槽(T1500A)



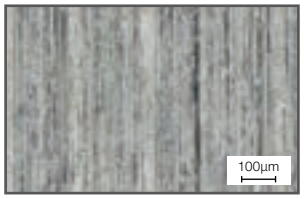
其他公司产品

精加工面 表面粗糙度比较

被削材：管材(STKM13A) ø100内径加工 刀片：TPMT110304N-FB (T1500A)
切削条件：vc=200m/min, f=0.07mm/rev, ap=0.1mm Wet



FB型断屑槽(T1500A)



其他公司产品

切削性能

切屑处理性能①

被削材：管材(STKM13A) ø30内径加工 刀片：TPMT110304N-LB (T1500A)
切削条件：vc=200m/min, f=0.15mm/rev, ap=0.5mm Wet

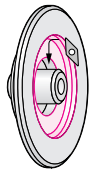
轻切削范围的切屑处理性能稳定

LB型断屑槽(T1500A)

其他公司产品

切屑处理的效果②

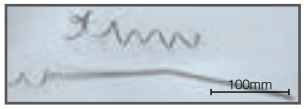
被削材：轮毂S45C　刀片：VBMT160408N-LB (T1500A)
切削条件：vc=240m/min, f=0.25～0.28mm/rev, ap=0.6mm Wet



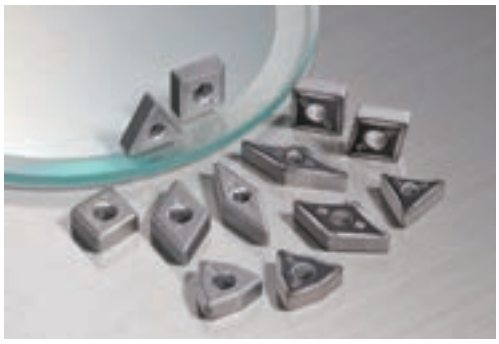
因切屑处理性能提高，缓解了工件表面的鱼尾纹现象，寿命达到2倍

LB型断屑槽(T1500A)

其他公司产品

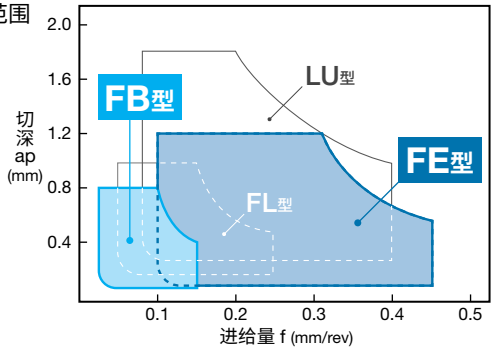


FB型/FE型 P 钢



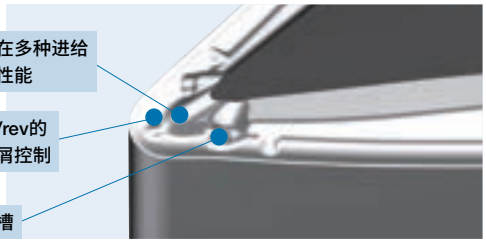
- 精加工用主断屑槽FE型作为低碳钢、一般钢加工用系列，在多种进给领域中均可发挥稳定的切屑处理性能
- 产品系列丰富，适用于多种加工形态
- 低进给精加工用FB型断屑槽通过刀尖R内前角变动设计，增大切屑的变形，提高分断性

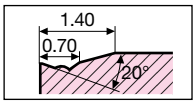
■ 适用范围



精加工用 FE型断屑槽

适用于通用～高进给加工



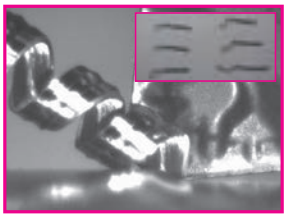


断屑槽横截面形状

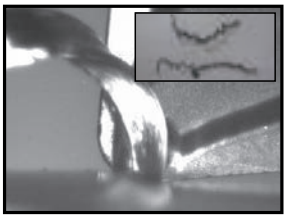
切削性能 切屑处理性能

被削材：管材(STKM13A)刀片：CNMG120408N-FE(AC8025P)
切削条件：vc=200m/min, f=0.4mm/rev, ap=0.2mm Dry

在小切深、高进给条件下实现优良的切屑处理



FE型断屑槽(AC8025P)



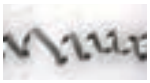
以往产品

使用实例

被削材：铁板材(SPHC440)　端面加工　刀片：CNMG120408N-FE(AC8025P)
切削条件：vc=200m/min, f=0.15mm/rev, ap=0.2-0.5mm Wet

加工铁板材端面时也可通过稳定卷曲分断切屑

FE型断屑槽(AC8025P)



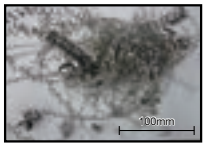
其他公司产品

使用实例

被削材：S53C ø20-100 外径·端面加工 刀片：DNMG150412N-FE(AC8025P)
切削条件：vc=180m/min, f=0.25mm/rev(R部), 0.45mm/rev(直线部), ap=0.3mm Wet

切深小、进给变动的情况下也可实现稳定的切屑控制

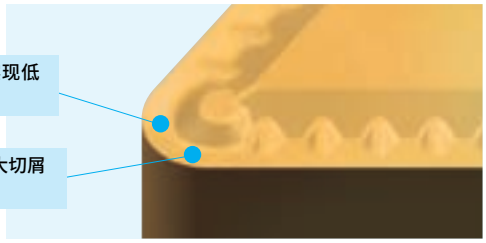
FE型断屑槽(AC8025P)

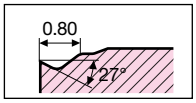


以往产品

低进给精加工用 FB型断屑槽

适用于低进给加工



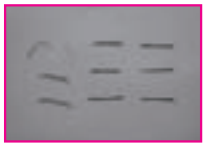


断屑槽横截面形状

使用实例

被削材：管材(STKM13C) 内径加工 刀片：DNMG150404N-FB(T3000Z)
切削条件：vc=352m/min, f=0.03-0.2mm/rev, ap=0.7mm Wet

即使加工管材也可细小地卷曲切屑，
以稳定的切屑长度进行分断



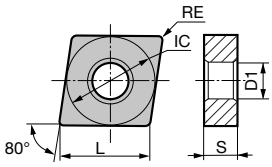
FB型断屑槽(T3000Z)

其他公司产品

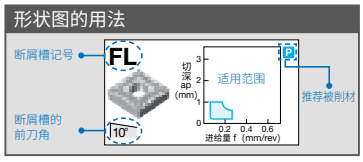
80° 菱形负型刀片

机夹式刀片

CN 80°菱形 负型 带孔



形状图的用法



●: 连续切削 第一推荐
○: 连续切削 第二推荐
: 一般切削 第一推荐
: 一般切削 第二推荐
: 断续切削 第一推荐
: 断续切削 第二推荐

CN■■0903●●

尺寸 (mm)				
	切刃长度L	9.7	厚度S	3.18
	内切圆IC	9.525	孔径D1	3.81

适用外径刀杆 C11　适用内径刀杆 E23～E25

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	○	●	✖	○	○	⚙		○				○								⚙		⚙	●			●	✖	⚙	●	●							
M 不锈钢				⚙			⚙	●	●	✖	○	○									⚙		⚙	●	⚙													
K 铸铁			⚙			⚙							●	●	✖	○	○			⚙		⚙		●						●								
N 非铁金属																																						●
S 难削材																			●	●	✖	○	⚙	⚙														
H 高硬度材																		●																				

	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
微小切削	FB 27°		CNMG 090304N-FB	0.4	—	—	—	—	—	—	—	—	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	▲		●	—	—	—	—	—	—	—
			090308N-FB	0.8	—	—	—	—	—	—	—	—	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	▲		●	—	—	—	—	—	—	—
	FL 10°		CNMG 090308N-FL	0.8			●			●						●						—						—		—	—	—	—	—	—							—
	FE 20°		CNMG 090304N-FE	0.4	●	●	●	●	●		●		●	●								—						—		—	●	●	▲		●							
			090308N-FE	0.8	●	●	●	●	●		●		●	●								—						—		—	●	●	▲		●							
精切削	LU 10°		CNMG 090304N-LU	0.4	●	●	●		●	●			●			●						—						—		—	●	●	▲		●							
			090308N-LU	0.8	●	●	●		●	●			●			●						—						—		—	●	●	▲		●							
	SU 13°		CNMG 090304N-SU	0.4	●	●	●			●												—						—		—	—	—	—	—	—							—
			090308N-SU	0.8	●	●	●			●												—						—		—	—	—	—	—	—							—
中切削	GU 7°		CNMG 090304N-GU	0.4	●	●	●	●		●	●						●	●				—						—		—	—	—	—	—	—							—
			090308N-GU	0.8	●	●	●	●		●	●						●	●				—						—		—	—	—	—	—	—							—
	UX 0°		CNMG 090304N-UX	0.4				●			●											—						—		—	—	—	—	—	—							—
			090308N-UX	0.8				●			●											—						—		—	—	—	—	—	—							—
	UG 4°		CNMG 090304N-UG	0.4			●	●		●	●											—						—		—	—	—	—	—	—							—
			090308N-UG	0.8			●	●		●	●											—						—		—	—	—	—	—	—							—

CN■■09T3●●

尺寸 (mm)				
	切刃长度L	9.7	厚度S	3.97
	内切圆IC	9.525	孔径D1	3.81

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	○	●	✖	○	○	⚙		○				○								⚙		⚙	●			●	✖	⚙	●	●							
M 不锈钢				⚙			⚙	●	●	✖	○	○									⚙		⚙	●	⚙													
K 铸铁			⚙			⚙							●	●	✖	○	○			⚙		⚙		●						●								
N 非铁金属																																						●
S 难削材																			●	●	✖	○	⚙	⚙														
H 高硬度材																		●																				

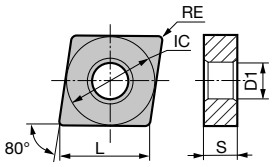
	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
精切削	SU 13°		CNMG 09T304N-SU	0.4	●	●	●			●												—						—		—	—	—	—	—	—							—
			09T308N-SU	0.8	●	●	●			●												—						—		—	—	—	—	—	—							—
中切削	UG 4°		CNMG 09T304N-UG	0.4			●			●												—						—		—	—	—	—	—	—							—
			09T308N-UG	0.8			●			●												—						—		—	—	—	—	—	—							—

▲记号: 计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

80° 菱形负型刀片

机夹式刀片

CN 80°菱形 负型 带孔



材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4～
按被削材分类的刀片材质选择要领 ☞A10～

●：连续切削 第一推荐　○：连续切削 第二推荐　●：一般切削 第一推荐　○：一般切削 第二推荐　✖：断续切削 第一推荐　✖：断续切削 第二推荐

CN■■0904●●

尺寸 (mm)	切刃长度L	9.7	厚度S	4.76
	内切圆IC	9.525	孔径D1	3.81

适用外径刀杆 ☞C11

推荐用途	涂层 CVD									PVD																															
	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	○	●	✖	○	○	✪		○				○								✪		✪	●			●	✖	✪	●	●									
M 不锈钢				✪			✪	●	●	✖	○	○									✪		✪	●	✪															
K 铸铁			✪			✪							●	●	✖	○	○			✪		✪		●						●										
N 非铁金属																																									●
S 难削材																			●	●	✖	○	✪	✪																
H 高硬度材																		●																						

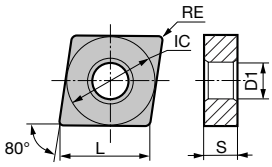
	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
微小切削	**FB** 27°	P	CNMG 090404N-FB	0.4	—	—	—	—	—	—	—	—	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	▲		●	—	—	—	—	—	—	—
			090408N-FB	0.8	—	—	—	—	—	—	—	—	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	▲		●	—	—	—	—	—	—	—
	FE 20°	P	CNMG 090404N-FE	0.4	●	●	●	●	●		●		●	●								—					—			—	●	●	▲		●							
			090408N-FE	0.8	●	●	●	●	●		●		●	●								—					—			—	●	●	▲		●							
精切削	**SU** 13°	P M S	CNMG 090404N-SU	0.4	●	●	●		●	●	●											—					—			—	●			●	●							
			090408N-SU	0.8	●	●	●		●	●	●											—					—			—	●			●	●							
			090412N-SU	1.2	●	●	●	●	●		●											—					—			—	●			●	●							
	SEW 5° →B131 修光刃	P	CNMG 090404N-SEW	0.4	●	●	●	●	●		●											—					—			—	—	—	—	—	—							—
			090408N-SEW	0.8	●	●	●	●	●		●											—					—			—	—	—	—	—	—							—
	EF 20°	M S	CNMG 090404N-EF	0.4								●	●	●								—	●	●	●		—			—	—	—	—	—	—							—
			090408N-EF	0.8								●	●	●								—	●	●	●		—			—	—	—	—	—	—							—
中切削	**GU** 7°	P M	CNMG 090404N-GU	0.4			●		●		●											—					—			—	●			●	●							
			090408N-GU	0.8			●		●		●											—					—			—	●			●	●							
			090412N-GU	1.2	●	●	●	●	●		●						●	●				—					—			—	●			●	●							
	UG 4°	P M	CNMG 090404N-UG	0.4			●			●												—					—			—	—	—	—	—	—							—
			090408N-UG	0.8			●	●		●	●											—					—			—	—	—	—	—	—							—
	EG 0°	M	CNMG 090408N-EG	0.8								●	●	●								—	●	●	●		—			—	—	—	—	—	—							—
			090412N-EG	1.2								●	●	●								—	●	●	●		—			—	—	—	—	—	—							—
中～粗切削	**GZ** 0°	K	CNMG 090408N-GZ	0.8													●	●	●	▲	▲						—			—	—	—	—	—	—							—
			090412N-GZ	1.2													●	●	●	▲	▲						—			—	—	—	—	—	—							—

▲记号：计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

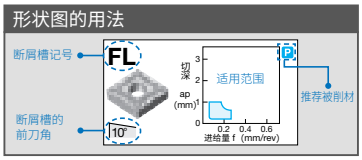
80° 菱形负型刀片

机夹式刀片

CN 80°菱形 负型 带孔



形状图的用法



●: 连续切削 第一推荐
○: 连续切削 第二推荐
●: 一般切削 第一推荐
○: 一般切削 第二推荐
✖: 断续切削 第一推荐
✖: 断续切削 第二推荐

CN■■1204●●

尺寸 (mm)	切刃长度L	12.9	厚度S	4.76
	内切圆IC	12.7	孔径D1	5.16

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	○	●	✖	○	○	✖		○				○								✖		✖	●			●	✖	✖	●	●							
M 不锈钢				✖			✖	●	●	✖	○	○									✖		✖	●	✖													
K 铸铁			✖			✖							●	●	✖	○	○			✖				●						●								
N 非铁金属																																						●
S 难削材																			●	●	✖	○	✖	✖														
H 高硬度材																		●																				

住友CBN(CBN)刀片 ☞L34～　住友金刚石(PCD)刀片 ☞M10
陶瓷刀片☞B128
适用外径刀杆 ☞C10～C12　适用内径刀杆 ☞E15、E23～E25

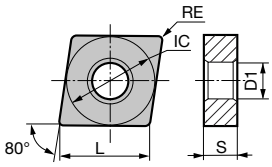
	形状	适用范围	型号	刀尖半径 RE	涂层 CVD								PVD	CVD						PVD							涂层金属陶瓷 PVD			金属陶瓷		硬质合金						
					AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
微小切削	FB 27°		CNMG 120402N-FB	0.2	—	—	—	—	—	—	—	—	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	▲	●	●	—	—	—	—	—	—	—
			120404N-FB	0.4	—	—	—	—	—	—	—	—	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	▲	●	●	—	—	—	—	—	—	—
			120408N-FB	0.8	—	—	—	—	—	—	—	—	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	▲	●	●	—	—	—	—	—	—	—
	FA 20°		CNMG 120402N-FA	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	▲	●	●	—	—	—	—	—	—	—
			120404N-FA	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	▲	●	●	—	—	—	—	—	—	—
			120408N-FA	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	▲	●	●	—	—	—	—	—	—	—
	FL 10°		CNMG 120404N-FL	0.4			●			●						●						—	●	●	●		●	—		—	●	●	▲	●	●							
			120408N-FL	0.8			●			●						●						—	●	●	●		●	—		—	●	●	▲	●	●							
	FE 20°		CNMG 120402N-FE	0.2	●	●	●	●	●		●		●	●								—						—	—	—	●	●	▲	●	●							
			120404N-FE	0.4	●	●	●	●	●		●		●	●								—						—	—	—	●	●	▲	●	●							
			120408N-FE	0.8	●	●	●	●	●		●		●	●								—						—	—	—	●	●	▲	●	●							
			120412N-FE	1.2	●	●	●	●	●		●		●	●								—						—	—	—	●	●	▲	●	●							
精切削	LU 10°		CNMG 120402N-LU	0.2									●			●						—						—	—	—	●	●	▲	●	●							
			120404N-LU	0.4	●	●	●	●	●	●	●		●			●						—						—	—	—	●	●	▲	●	●							
			120408N-LU	0.8	●	●	●	●	●	●	●		●			●						—						—	—	—	●	●	▲	●	●							
			120412N-LU	1.2	●	●	●	●	●	●	●		●			●						—						—	—	—	●	●	▲		●							
			120416N-LU	1.6																		—						—	—	—	—	—	—	—	—							
	LUW 10° →B131 修光刀		CNMG 120404N-LUW	0.4	●	●	●		●	●			●			●						—						—	—	—	●	●	▲		●							
			120408N-LUW	0.8	●	●	●		●	●			●			●						—						—	—	—	●	●	▲		●							
			120412N-LUW	1.2	●	●	●		●	●			●			●						—						—	—	—	●	●	▲		●							
	SU 13°		CNMG 120402N-SU	0.2								●	●	●		●						—	●	●	●		●	—	●	—	●	●	▲	●	●							
			120404N-SU	0.4	●	●	●	●	●	●	●	●	●	●		●						—	●	●	●	●	●	—	●	—	●	●	▲	●	●							
			120408N-SU	0.8	●	●	●	●	●	●	●	●	●	●		●						—	●	●	●	●	●	—	●	—	●	●	▲	●	●							
			120412N-SU	1.2	●	●	●	●	●	●	●	●	●	●		●						—	●	●	●	●	●	—	●	—	●	●	▲	●	●							
	SU 13°		CNGG 120402N-SU	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—		●	●	●					●	●	▲	●	●							
			120404N-SU	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—		●	●	●					●	●	▲	●	●							
			120408N-SU	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—		●	●	●					●	●		●	●							
	SE 5°		CNMG 120404N-SE	0.4	●	●	●	●	●	●	●											—						—	—	—	●	●		●	●							
			120408N-SE	0.8	●	●	●	●	●	●	●											—						—	—	—	●	●		●	●							
			120412N-SE	1.2	●	●	●	●	●	●	●											—						—	—	—	—	—	—	—	—							
			120416N-SE	1.6																		—						—	—	—	—	—	—	—	—							
	SEW 5° →B131 修光刀		CNMG 120404N-SEW	0.4	●	●	●		●	●												—						—	—	—	●	●			●							
			120408N-SEW	0.8	●	●	●		●	●												—						—	—	—	●	●			●							
			120412N-SEW	1.2	●	●	●		●	●												—						—	—	—	—	—	—	—	—							
	EF 20°		CNMG 120404N-EF	0.4	●	●	●	●				●	●	●		●						—	●	●	●	●	●	—	—	—	—	—	—	—	—				●	●	—
			120408N-EF	0.8	●	●	●	●				●	●	●		●						—	●	●	●	●	●	—	—	—	—	—	—	—	—				●	●	—
			120412N-EF	1.2	●	●	●	●				●	●	●								—	●	●	●		●	—	—	—	—	—	—	—	—				●	●	—
	EF 20°		CNGG 120402N-EF	0.2								—	—	—		●						—		●	●	●	●				—	—	—	—	—				●	●	—
			120404N-EF	0.4								—	—	—		●						—		●	●	●	●				—	—	—	—	—				●	●	—
			120408N-EF	0.8								—	—	—		●						—		●	●	●	●				—	—	—	—	—				●	●	—

▲记号: 计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

80° 菱形负型刀片

机夹式刀片

CN 80°菱形 负型 带孔



材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4～
按被削材分类的刀片材质选择要领 ☞A10～

●：连续切削 第一推荐　○：连续切削 第二推荐　◕：一般切削 第一推荐　◔：一般切削 第二推荐　✖：断续切削 第一推荐　✪：断续切削 第二推荐

CN■■1204●●

尺寸 (mm)	切刃长度L	12.9	厚度S	4.76
	内切圆IC	12.7	孔径D1	5.16

住友CBN(CBN)刀片 ☞L34～　住友金刚石(PCD)刀片 ☞M10
陶瓷刀片☞B128
适用外径刀杆 ☞C10～C12　适用内径刀杆 ☞E15、E23～E25

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◕	✖	○	◔	✪		◔				◔								✪		✪	◕			◕	✖	✪	●	◕							
M 不锈钢			✪			✪	●	◕	✖	○	◔										✪		✪	◕	✪													
K 铸铁			✪			✪						●	◕	✖	○	◔				✪		✪		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◔	✪	✪														
H 高硬度材																		●																				

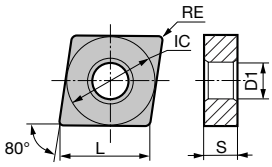
	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
轻～中切削	**SX** 3°	P	CNMG 120404N-SX	0.4	●	●	●	●	●	●	●											—								—	●	●	▲		●							
			120408N-SX	0.8	●	●	●	●	●	●	●											—								—	●	●	▲		●							
			120412N-SX	1.2	●	●	●	●	●	●	●											—								—												
	EX 16°	M S	CNMG 120404N-EX	0.4								●	●	●	▲	●						—	●	●	●	●	●	—	●	—	—	—	—	—	—							
			120408N-EX	0.8								●	●	●	▲	●						—	●	●	●	●	●	—	●	—	—	—	—	—	—							
			120412N-EX	1.2								●	●	●	▲	●						—	●	●	●	●	●	—	●	—	—	—	—	—	—							
			120416N-EX	1.6																		—						—		—	—	—	—	—	—							
	UP 10°	M S	CNMG 120404N-UP	0.4						●	●	●	●	●		●						—	●	●	●	●	●	—	●	—	—	—	—	—	—				●			
			120408N-UP	0.8						●	●	●	●	●	▲	●						—	●	●	●	●	●	—	●	—	—	—	—	—	—				●			
			120412N-UP	1.2						●	●	●	●	●		●						—	●	●	●	●	●	—	●	—	—	—	—	—	—				●			
中切削	**GU** 7°	P M	CNMG 120404N-GU	0.4	●	●	●	●	●	●	●	●	●	●	▲	●	●	●				—	●	●	●		●	—	●	—	●	●			●							
			120408N-GU	0.8	●	●	●	●	●	●	●	●	●	●	▲	●	●	●				—	●	●	●		●	—	●	—	●	●			●							
			120412N-GU	1.2	●	●	●	●	●	●	●	●	●	●	▲	●	●	●				—	●	●	●		●	—	●	—												
			120416N-GU	1.6	●	●	●	●		●	●						●	●				—						—		—												
	GE 3°	P	CNMG 120404N-GE	0.4	●	●	●	●	●	●	●											—						—		—	—	—	—	—	—							
			120408N-GE	0.8	●	●	●	●	●	●	●											—						—		—	—	—	—	—	—							
			120412N-GE	1.2	●	●	●	●	●	●	●											—						—		—	—	—	—	—	—							
			120416N-GE	1.6	●	●	●	●	●	●	●											—						—		—	—	—	—	—	—							
	GUW 0° →B131 修光刃	P	CNMG 120408N-GUW	0.8	●	●	●		●	●												—						—		—	—	—	—	—	—							
			120412N-GUW	1.2	●	●	●		●	●												—						—		—	—	—	—	—	—							
	UX 0°	P K	CNMG 120404N-UX	0.4	●	●	●	●	●	●	●											—						—		—	—	—	—	—	—							
			120408N-UX	0.8	●	●	●	●	●	●	●											—						—		—	—	—	—	—	—							
			120412N-UX	1.2	●	●	●	●	●	●	●											—						—		—	—	—	—	—	—							
			120416N-UX	1.6	●	●	●	●	●	●	●											—						—		—	—	—	—	—	—							
	UG 4°	P M	CNMG 120404N-UG	0.4			●	●		●	●											—						—		—								●				
			120408N-UG	0.8			●	●		●	●											—						—		—								●				
			120412N-UG	1.2			●	●		●	●											—						—		—												
			120416N-UG	1.6			●	●		●	●											—						—		—												
	EG 0°	M	CNMG 120404N-EG	0.4	●	●	●	●				●	●	●								—	●	●	●			—		—												
			120408N-EG	0.8	●	●	●	●				●	●	●		●						—	●	●	●	●	●	—		—										●	●	
			120412N-EG	1.2	●	●	●	●				●	●	●		●						—	●	●	●	●	●	—		—										●	●	
			CNMA 120404	0.4													●	●	●	▲	▲	—						—		—	—	—	—	—	—							
			120408	0.8													●	●	●	▲	▲	—	●	●	●	●		—		—	—	—	—	—	—							
			120412	1.2													●	●	●	▲	▲	—						—		—	—	—	—	—	—							
			120416	1.6													●	●	●	▲	▲	—						—		—	—	—	—	—	—							
			CNGA 120402	0.2	—	—	—	—	—	—	—	—	—	—	—	—						●																				
			120404	0.4	—	—	—	—	—	—	—	—	—	—	—	—						●																				
			120408	0.8	—	—	—	—	—	—	—	—	—	—	—	—						●																				

▲记号：计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

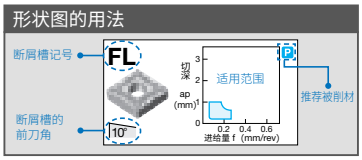
80° 菱形负型刀片

机夹式刀片

CN 80°菱形 负型 带孔



形状图的用法



●：连续切削 第一推荐
○：连续切削 第二推荐
◕：一般切削 第一推荐
◔：一般切削 第二推荐
✖：断续切削 第一推荐
✖：断续切削 第二推荐

CN■■1204●●

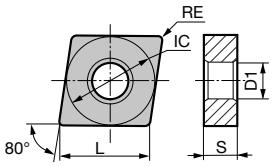
尺寸 (mm)				
	切刃长度L	12.9	厚度S	4.76
	内切圆IC	12.7	孔径D1	5.16

| 推荐用途 | 涂层 | | | |

80° 菱形负型刀片

机夹式刀片

CN 80°菱形 负型 带孔



材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4～
按被削材分类的刀片材质选择要领 ☞A10～

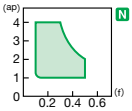
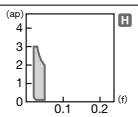
●：连续切削 第一推荐　○：连续切削 第二推荐
◕：一般切削 第一推荐　◔：一般切削 第二推荐
✖：断续切削 第一推荐　✪：断续切削 第二推荐

CN■■1204●●

尺寸 (mm)				
	切刃长度L	12.9	厚度S	4.76
	内切圆IC	12.7	孔径D1	5.16

住友CBN(CBN)刀片 ☞L34～　住友金刚石(PCD)刀片 ☞M10
陶瓷刀片☞B128
适用外径刀杆 ☞C10～C12　适用内径刀杆 ☞E15、E23～E25

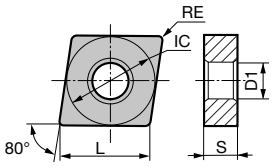
推荐用途	涂层 CVD								PVD	CVD					PVD								PVD											
	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◕	✖	○	◔	✪		◔			◔									✪		✪	◕			◕	✖	✪	●	◕							
M 不锈钢				✪			✪	●	◕	✖	○	◔									✪		✪	◕	✪												
K 铸铁			✪			✪							●	◕	✖	○	◔			✪		✪		◕						●							
N 非铁金属																																					◕
S 难削材																			●	◕	✖	◔	✪	✪													
H 高硬度材																		●																			

	形状	适用范围	型 号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
铝材用	**AX** 30°		CNGG 120402R-AX	0.2																																						●
			120402L-AX	0.2																																						●
			120404R-AX	0.4																																						●
			120404L-AX	0.4																																						●
			120408R-AX	0.8																																						●
			120408L-AX	0.8																																						●
淬火钢轻切削	**GH** 3°		CNGG 120402N-GH	0.2																		●																			
			120404N-GH	0.4																		●																			
			120408N-GH	0.8																		●																			

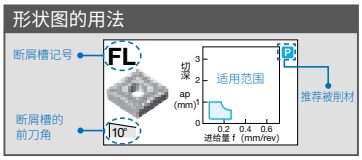
80° 菱形负型刀片

机夹式刀片

CN 80°菱形 负型 带孔



形状图的用法



●：连续切削 第一推荐
○：连续切削 第二推荐
◕：一般切削 第一推荐
◔：一般切削 第二推荐
✖：断续切削 第一推荐
✖：断续切削 第二推荐

CN■■1606●●				
尺寸 (mm)	切刃长度L	16.1	厚度S	6.35
	内切圆IC	15.875	孔径D1	6.35

适用外径刀杆 C10～C12

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◕	✖	○	◔	✖		◔				◔								✖		✖	◕			◕	✖	✖	●	◕							
M 不锈钢				✖			✖	●	◕	✖	○		◔								✖		✖	◕	✖													
K 铸铁			✖			✖								●	◕	✖	○	◔			✖		✖	◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◔	✖	✖														
H 高硬度材																		●																				

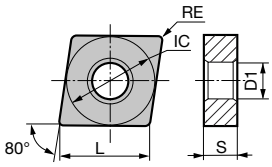
	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
轻～中切削	EX 16°	(ap) 4 2 0 0.2 0.4 (f) M S	CNMG 160612N-EX	1.2																		—	●	●	●	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	UP 10°	(ap) 6 4 2 0 0.2 0.4 0.6 (f) M S	CNMG 160608N-UP	0.8																		—						—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			160612N-UP	1.2																		—						—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	GU 7°	(ap) 6 4 2 0 0.2 0.4 0.6 (f) P M	CNMG 160608N-GU	0.8	●	●	●	●	●	●	●		●	●			●	●				—						—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			160612N-GU	1.2	●	●	●	●	●	●	●		●	●			●	●				—						—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			160616N-GU	1.6	●	●	●	●	●	●	●		●	●			●	●				—						—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	GE 3°	(ap) 6 4 2 0 0.2 0.4 0.6 (f) P	CNMG 160608N-GE	0.8	●	●	●	●	●	●	●											—						—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			160612N-GE	1.2	●	●	●	●	●	●	●											—						—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			160616N-GE	1.6	●	●	●	●	●	●	●											—						—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	GUW 0° →B131 修光刃	(ap) 6 4 2 0 0.2 0.4 0.6 (f) P	CNMG 160612N-GUW	1.2	●	●	●	●	●	●	●											—						—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	UX 0°	(ap) 6 4 2 0 0.2 0.4 0.6 (f) P K	CNMG 160608N-UX	0.8	●	●	●	●	●	●	●											—						—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			160612N-UX	1.2	●	●	●	●	●	●	●											—						—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			160616N-UX	1.6	●	●	●	●	●	●	●											—						—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	UG 4°	(ap) 6 4 2 0 0.2 0.4 0.6 (f) P M	CNMG 160608N-UG	0.8				●			●											—						—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			160612N-UG	1.2				●			●											—						—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			160616N-UG	1.6				●	●		●	●										—						—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	EG 0°	(ap) 6 4 2 0 0.2 0.4 0.6 (f) P	CNMG 160608N-EG	0.8	●	●	●	●				●	●	●								—	●	●	●	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			160612N-EG	1.2	●	●	●	●				●	●	●		●						—	●	●	●	●	●	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—
			160616N-EG	1.6	●	●	●	●				●	●	●								—	●	●	●	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			CNMA 160608	0.8													●	●	●	▲	▲	—						—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			160612	1.2													●	●	●	▲	▲	—						—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			160616	1.6													●	●	●	▲	▲	—						—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
整体CBN 陶瓷 中～粗切削	MU 4°	(ap) 6 4 2 0 0.2 0.4 0.6 (f) P M S	CNMG 160608N-MU	0.8	●	●	●	●	●	●	●											—	●	●	●	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			160612N-MU	1.2	●	●	●	●	●	●	●		●	●		●						—	●	●	●	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			160616N-MU	1.6	●	●	●	●	●	●	●		●			●						—	●	●	●	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	EM 0°	(ap) 6 4 2 0 0.2 0.4 0.6 (f) M S	CNMG 160608N-EM	0.8	●	●	●	●				●	●	●								—	●	●	●			—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			160612N-EM	1.2	●	●	●	●				●	●	●								—	●	●	●			—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			160616N-EM	1.6	●	●	●	●				●	●	●								—	●	●	●			—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	ME 4°	(ap) 8 6 4 2 0 0.4 0.8 (f) P	CNMG 160608N-ME	0.8	●	●	●	●	●	●	●						●	●				—						—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			160612N-ME	1.2	●	●	●	●	●	●	●						●	●				—						—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			160616N-ME	1.6	●	●	●	●	●	●	●						●	●				—						—	—	—	—	—	—	—	—	—	—	—	—	—	—	—

▲记号：计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

80° 菱形负型刀片

机夹式刀片

CN 80°菱形 负型 带孔



材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4～
按被削材分类的刀片材质选择要领 ☞A10～

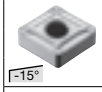
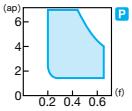
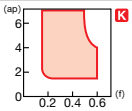
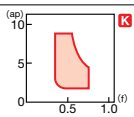
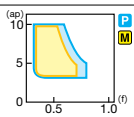
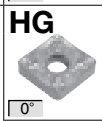
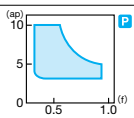
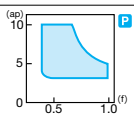
●：连续切削 第一推荐
○：连续切削 第二推荐
●：一般切削 第一推荐
○：一般切削 第二推荐
✖：断续切削 第一推荐
✖：断续切削 第二推荐

CN■■1606●●

尺寸 (mm)	切刃长度L	16.1	厚度S	6.35
	内切圆IC	15.875	孔径D1	6.35

适用外径刀杆 ☞C10～C12

推荐用途	涂层 CVD									PVD																																		
	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	○	◐	✖	○	○	✿		○				○								✿		✿	◐				◐	✖	✿	●	◐												
M 不锈钢				✿			✿	●	◐	✖	○	○									✿		✿	◐	✿																		
K 铸铁			✿			✿							●	◐	✖	○	○			✿		✿		◐							●												
N 非铁金属																																												◐
S 难削材																			●	◐	✖	○	✿	✿																			
H 高硬度材																		●																										

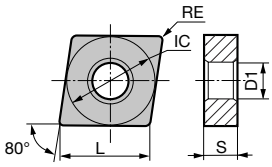
	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
中～粗切削	MX  -15°		CNMG 160608N-MX	0.8		●	●			●																																	
			160612N-MX	1.2		●	●	●		●	●																																
			160616N-MX	1.6		●	●	●		●	●																																
	UZ 4°		CNMG 160608N-UZ	0.8			●	●		●	●																																
			160612N-UZ	1.2			●	●		●	●						●	●	●	▲	▲																						
			160616N-UZ	1.6			●	●		●	●						●	●	●	▲	▲																						
	GZ 0°		CNMG 160608N-GZ	0.8													●	●	●	▲	▲																						
			160612N-GZ	1.2													●	●	●	▲	▲																						
			160616N-GZ	1.6													●	●	●	▲	▲																						
粗切削	MP 0°		CNMM 160608N-MP	0.8			●	●		●	●		●										●	●	●	●																	
			160612N-MP	1.2	●	●	●	●	●	●	●		●										●	●	●	●																		
			160616N-MP	1.6	●	●	●	●	●	●	●		●										●	●	●	●																		
重切削	HG  0°		CNMM 160612N-HG	1.2	●	●	●	●	●	●	●																																
			160616N-HG	1.6	●	●	●	●	●	●	●																																
	HP 0°		CNMM 160608N-HP	0.8			●	●		●	●																																
			160612N-HP	1.2			●	●		●	●																																
			160616N-HP	1.6			●	●		●	●																																

▲记号：计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

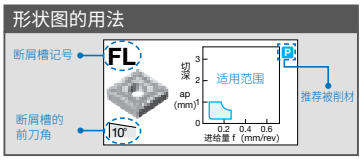
80° 菱形负型刀片

机夹式刀片

CN 80°菱形 负型 带孔



形状图的用法



●：连续切削 第一推荐
○：连续切削 第二推荐
◐：一般切削 第一推荐
◔：一般切削 第二推荐
✖：断续切削 第一推荐
✖：断续切削 第二推荐

CN■■1906●●

尺寸 (mm)	切刃长度L	19.3	厚度S	6.35
	内切圆IC	19.05	孔径D1	7.94

适用外径刀杆 ☞C10～C12　适用内径刀杆 ☞E24、E25

推荐用途	CVD																																							
	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◐	✖	○	◔	✖		◔			◔									✖		✖	◐			◐	✖	✖	●	◐								
M 不锈钢				✖			✖	●	◐	✖	○	◔									✖		✖	◐	✖														
K 铸铁			✖			✖							●	◐	✖	○	◔			✖		✖		◐						●									
N 非铁金属																																							◐
S 难削材																			●	◐	✖	◔	✖	✖															
H 高硬度材																		●																					

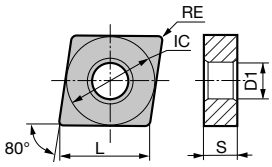
	涂层																										涂层 金属陶瓷					金属陶瓷	硬质合金					
	CVD									P/D			CVD					PVD									PVD											
形状	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
轻～中切削 **EX** (16°)																			●	●	●	●	●															
轻～中切削 **UP** (10°)						●	●																											●				
中切削 **GE** (3°)	●	●	●	●	●	●	●																															
	●	●	●	●	●	●	●																															
中切削 **UX** (0°)				●			●																															
	●	●	●	●	●	●	●																															
	●	●	●	●	●	●	●																															
中切削 **UG** (4°)																																						
				●			●																															
			●	●		●	●																															
			●	●		●	●																															
中切削 **EG** (0°)	●	●	●	●				●	●	●		●							●	●	●	●	●													●	●	
	●	●	●	●				●	●	●		●							●	●	●	●	●													●	●	
													●	●	●	▲	▲																					
													●	●	●	▲	▲																					
中～粗切削 **MU** (4°)																																						
	●	●	●	●	●	●	●		●	●		●							●	●	●	●	●															
	●	●	●	●	●	●	●		●			●							●	●	●	●	●															
	●	●	●	●	●	●	●												●	●	●	●	●															
中～粗切削 **EM** (0°)	●	●	●	●				●	●	●									●	●	●																	
	●	●	●	●				●	●	●									●	●	●																	
	●	●	●	●				●	●	●									●	●	●																	
中～粗切削 **ME** (4°)	●	●	●	●	●	●	●						●	●																								
	●	●	●	●	●	●	●						●	●																								
	●	●	●	●	●	●	●						●	●																								
中～粗切削 **MX** (-15°)		●	●	●		●	●																															
		●	●	●		●	●																															
中～粗切削 **UZ** (4°)			●	●		●	●																															
			●	●		●	●						●	●	●	▲	▲																					
			●	●		●	●						●	●	●	▲	▲																					

▲记号：计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

80° 菱形负型刀片

机夹式刀片

CN 80°菱形 负型 带孔



材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4～
按被削材分类的刀片材质选择要领 ☞A10～

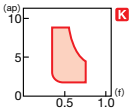
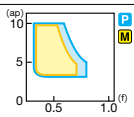
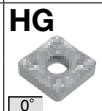
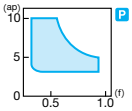
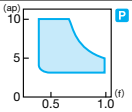
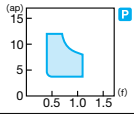
●：连续切削 第一推荐　○：连续切削 第二推荐　◕：一般切削 第一推荐　◔：一般切削 第二推荐　✖：断续切削 第一推荐　✪：断续切削 第二推荐

CN■■1906●●

尺寸 (mm)	切刃长度L	19.3	厚度S	6.35
	内切圆IC	19.05	孔径D1	7.94

适用外径刀杆 ☞C10～C12　适用内径刀杆 ☞E24、E25

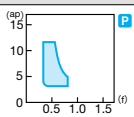
推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◕	✖	○	◔	✪		◔				◔								✪		✪	◕			◕	✖	✪	●	◕							
M 不锈钢			✪				✪	●	◕	✖	○	◔									✪		✪	◕	✪													
K 铸铁				✪			✪						●	◕	✖	○	◔			✪		✪		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◔	✪	✪														
H 高硬度材																		●																				

	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
中～粗切削	GZ		CNMG 190612N-GZ	1.2													●	●	●	▲	▲																					
			190616N-GZ	1.6													●	●	●	▲	▲																					
粗切削	MP		CNMM 190608N-MP	0.8			●	●		●	●		●				●						●	●	●	●																
			190612N-MP	1.2	●	●	●	●	●	●	●	●	●				●						●	●	●	●																
			190616N-MP	1.6	●	●	●	●	●	●	●	●	●	●			●						●	●	●	●																
			190624N-MP	2.4	●	●	●	●	●	●	●	●	●	●			●						●	●	●	●																
重切削	HG 		CNMM 190612N-HG	1.2	●	●	●	●	●	●	●					●																									
			190616N-HG	1.6	●	●	●	●	●	●	●					●																									
			190624N-HG	2.4	●	●	●	●	●	●	●					●																									
	HP		CNMM 190608N-HP	0.8			●	●		●	●					●																									
			190612N-HP	1.2			●	●		●	●					●																									
			190616N-HP	1.6			●	●		●	●					●																									
			190624N-HP	2.4			●	●		●	●					●																									
	HF		CNMM 190616N-HF	1.6			●	●		●	●																														
			190624N-HF	2.4			●	●		●	●																														

CN■■2507●●

尺寸 (mm)	切刃长度L	25.8	厚度S	7.94
	内切圆IC	25.4	孔径D1	9.12

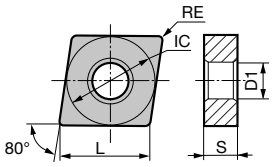
推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◕	✖	○	◔	✪		◔				◔								✪		✪	◕			◕	✖	✪	●	◕							
M 不锈钢			✪				✪	●	◕	✖	○	◔									✪		✪	◕	✪													
K 铸铁				✪			✪						●	◕	✖	○	◔			✪		✪		◕						●								
N 非铁金属																						✪																◕
S 难削材																			●	◕	✖	◔	✪	✪														
H 高硬度材																		●																				

	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
粗切削	MP		CNMM 250724N-MP	2.4			●			●																																

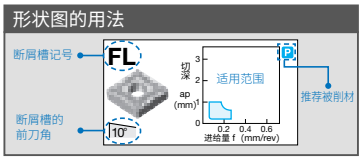
80° 菱形负型刀片

机夹式刀片

CN 80°菱形 负型 带孔



形状图的用法



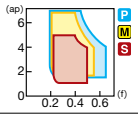
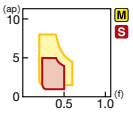
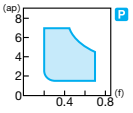
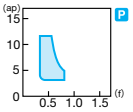
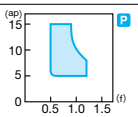
●：连续切削 第一推荐
○：连续切削 第二推荐
：一般切削 第一推荐
：一般切削 第二推荐
：断续切削 第一推荐
：断续切削 第二推荐

CN■■2509●●

尺寸 (mm)				
	切刃长度L	25.8	厚度S	9.52
	内切圆IC	25.4	孔径D1	9.12

适用外径刀杆 ☞C10

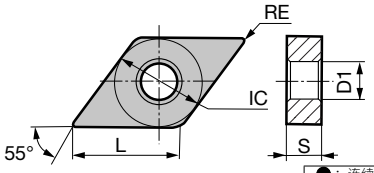
推荐用途	P 钢	M 不锈钢	K 铸铁	N 非铁金属	S 难削材	H 高硬度材

形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
				涂层																									涂层金属陶瓷					金属陶瓷	硬质合金						
				CVD									P/D	CVD							PVD								PVD												
中～粗切削 MU			CNMG 250924N-MU	2.4	●	●	●	●	●	●											—	●	●	●	●	●	—		—	—	—	—	—	—						—
中～粗切削 EM			CNMG 250924N-EM	2.4	●	●	●	●				●	●								—	●	●	●			—		—	—	—	—	—	—						—
中～粗切削 ME			CNMG 250924N-ME	2.4	●	●	●	●	●	●						●	●				—						—		—	—	—	—	—	—							—
粗切削 MP			CNMM 250924N-MP	2.4			●			●											—						—		—	—	—	—	—	—							—
重切削 HF			CNMM 250924N-HF	2.4			●	●		●	●										—						—		—	—	—	—	—	—							—
			250932N-HF	3.2			●	●		●	●										—						—		—	—	—	—	—	—							—

55° 菱形负型刀片

机夹式刀片

DN 55°菱形 负型 带孔



材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4～
按被削材分类的刀片材质选择要领 ☞A10～

●：连续切削 第一推荐　○：连续切削 第二推荐　◕：一般切削 第一推荐　◔：一般切削 第二推荐　✖：断续切削 第一推荐　✪：断续切削 第二推荐

DN■■1104●●

尺寸 (mm)	切刃长度L	11.6	厚度S	4.76
	内切圆IC	9.525	孔径D1	3.81

住友CBN(CBN)刀片☞L54
适用外径刀杆 ☞C16　适用内径刀杆 ☞E32、E33

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◕	✖	○	◔	✪		◔			◔									✪		✪	◕			◕	✖	✪	●	◕							
M 不锈钢			✪				✪	●	◕	✖	○	◔									✪		✪	◕	✪													
K 铸铁				✪		✪							●	◕	✖	○	◔			✪		✪		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◔	✪	✪														
H 高硬度材																		●																				

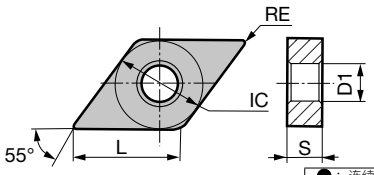
	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
微小切削	FB 27°		DNMG 110404N-FB	0.4										●																	●	●	▲		●							
			110408N-FB	0.8										●																	●	●	▲		●							
	FE 20°		DNMG 110404N-FE	0.4	●	●	●	●	●		●		●	●																	●	●	▲		●							
			110408N-FE	0.8	●	●	●	●	●		●		●	●																	●	●	▲		●							
			110412N-FE	1.2	●	●	●	●	●		●		●	●																	●	●	▲		●							
精切削	LU 10°		DNMG 110404N-LU	0.4	●	●	●			●			●	●		●																			●							
			110408N-LU	0.8	●	●	●			●			●			●																			●							
	SU 13°		DNMG 110404N-SU	0.4	●	●	●	●	●	●	●	●	●	●																	●											
			110408N-SU	0.8	●	●	●	●	●	●	●	●	●	●																	●											
			110412N-SU	1.2	●	●	●	●	●	●	●	●	●	●																	●											
	SE 5°		DNMG 110408N-SE	0.8	●	●	●	●	●	●	●																															
	SEW 5° →B131 修光刃		DNMX 110404N-SEW	0.4	●	●	●	●	●	●	●																															
			110408N-SEW	0.8	●	●	●	●	●	●	●																															
			110412N-SEW	1.2	●	●	●	●	●	●	●																															
	EF 20°		DNMG 110404N-EF	0.4	●	●	●	●				●	●	●									●	●	●		●															
			110408N-EF	0.8	●	●	●	●				●	●	●									●	●	●		●															
			110412N-EF	1.2	●	●	●	●				●	●	●									●	●	●		●															
中切削	GU 7°		DNMG 110404N-GU	0.4	●	●	●	●		●	●	●	●	●		●	●	●																	●							
			110408N-GU	0.8	●	●	●	●		●	●	●	●	●		●	●	●																	●							
			110412N-GU	1.2	●	●	●	●	●	●	●	●	●	●			●	●													●											
	GE 3°		DNMG 110408N-GE	0.8	●	●	●	●	●	●	●																															
			110412N-GE	1.2	●	●	●	●	●	●	●																															
	UX 0°		DNMG 110408N-UX	0.8	●	●	●	●			●																															
	UG 4°		DNMG 110404N-UG	0.4			●	●		●	●																															
			110408N-UG	0.8			●	●		●	●																															
	EG 0°		DNMG 110408N-EG	0.8	●	●	●	●				●	●	●									●	●	●		●															
			110412N-EG	1.2	●	●	●	●				●	●	●									●	●	●		●															

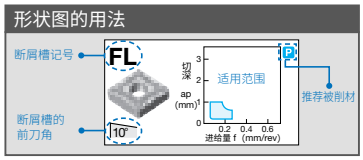
▲记号：计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

55° 菱形负型刀片

机夹式刀片

DN 55°菱形 负型 带孔





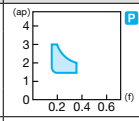
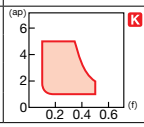
●: 连续切削 第一推荐
○: 连续切削 第二推荐
◕: 一般切削 第一推荐
◔: 一般切削 第二推荐
✖: 断续切削 第一推荐
✪: 断续切削 第二推荐

DN■■1104●●

尺寸 (mm)				
	切刃长度L	11.6	厚度S	4.76
	内切圆IC	9.525	孔径D1	3.81

住友CBN(CBN)刀片☞L54
适用外径刀杆☞C16　适用内径刀杆☞E32、E33

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◕	✖	○	◔	✪			◔											✪		✪	◕			◕	✖	✪	●	◕							
M 不锈钢				✪			✪	●	◕	✖	○	◔									✪		✪	◕	✪													
K 铸铁			✪			✪							●	◕	✖	○	◔			✪		✪		◕						●								
N 非铁金属																																						◕
S 难削材																		●	◕	✖	◔	✪	✪															
H 高硬度材																		●																				

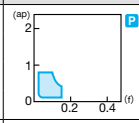
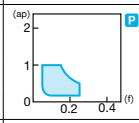
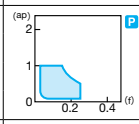
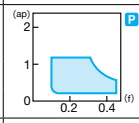
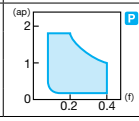
	形状	适用范围	型　号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
中切削	UM 0°		DNGG 110404R-UM	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	—	●	—	—	—
			110404L-UM	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	—	●	—	—	—
			110408R-UM	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	—	—	—	—	—
			110408L-UM	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	—	●	—	—	—
			DNGA 110404	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			110408	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
中～粗切削	GZ 0°		DNMG 110408N-GZ	0.8	—	—	—	—	—	—	—	—	—	—	—	—	●	●	●	▲	▲	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			110412N-GZ	1.2	—	—	—	—	—	—	—	—	—	—	—	—	●	●	●	▲	▲	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—

DN■■1504●●

尺寸 (mm)				
	切刃长度L	15.5	厚度S	4.76
	内切圆IC	12.7	孔径D1	5.16

住友CBN(CBN)刀片☞L54～　住友金刚石(PCD)刀片☞M12
无粘合剂住友金刚石刀片☞M28　陶瓷刀片☞B128
适用外径刀杆☞C14～C16　适用内径刀杆☞E15、E31～E33

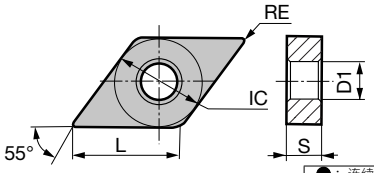
推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◕	✖	○	◔	✪			◔											✪		✪	◕			◕	✖	✪	●	◕							
M 不锈钢				✪			✪	●	◕	✖	○	◔									✪		✪	◕	✪													
K 铸铁			✪			✪							●	◕	✖	○	◔			✪		✪		◕						●								
N 非铁金属																																						◕
S 难削材																		●	◕	✖	◔	✪	✪															
H 高硬度材																		●																				

	形状	适用范围	型　号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
微小切削	FB 27°		DNMG 150404N-FB	0.4	—	—	—	—	—	—	—	—	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	▲	●	●	—	—	—	—	—	—	—
			150408N-FB	0.8	—	—	—	—	—	—	—	—	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	▲	●	●	—	—	—	—	—	—	—
	FA 20°		DNMG 150404N-FA	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	▲	●	●	—	—	—	—	—	—	—
			150408N-FA	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	▲	●	●	—	—	—	—	—	—	—
	FL 10°		DNMG 150404N-FL	0.4			●			●						●						—	—	—	—	—	—	—	—	—	●	●	▲	●	●						
			150408N-FL	0.8			●			●						●						—	—	—	—	—	—	—	—	—	●	●	▲	●	●						
			150412N-FL	1.2			●									●						—	—	—	—	—	—	—	—	—											
	FE 20°		DNMG 150402N-FE	0.2	●	●	●	●	●		●		●	●								—	—	—	—	—	—	—	—	—	●	●	▲	●	●						
			150404N-FE	0.4	●	●	●	●	●		●		●	●								—	—	—	—	—	—	—	—	—	●	●	▲	●	●						
			150408N-FE	0.8	●	●	●	●	●		●		●	●								—	—	—	—	—	—	—	—	—	●	●	▲	●	●						
			150412N-FE	1.2	●	●	●	●	●		●		●	●								—	—	—	—	—	—	—	—	—	●	●	▲	●	●						
精切削	LU 10°		DNMG 150402N-LU	0.2	●	●	●		●	●			●			●						—	—	—	—	—	—	—	—	—	●	●	▲	●	●						
			150404N-LU	0.4	●	●	●	●	●	●	●		●			●						—	—	—	—	—	—	—	—	—	●	●	▲	●	●						
			150408N-LU	0.8	●	●	●	●	●	●	●		●			●						—	—	—	—	—	—	—	—	—	●	●	▲	●	●						
			150412N-LU	1.2	●	●	●	●	●	●	●		●			●						—	—	—	—	—	—	—	—	—	●	●	▲		●						

▲记号: 计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

55° 菱形负型刀片

DN 55°菱形 负型 带孔



材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4～
按被削材分类的刀片材质选择要领 ☞A10～

●：连续切削 第一推荐　○：连续切削 第二推荐　◐：一般切削 第一推荐　◔：一般切削 第二推荐　✖：断续切削 第一推荐　✖：断续切削 第二推荐

DN■■1504●●

尺寸(mm)	切刃长度L	15.5	厚度S	4.76
	内切圆IC	12.7	孔径D1	5.16

住友CBN(CBN)刀片 ☞L54～　住友金刚石(PCD)刀片 ☞M12
无粘合剂住友金刚石刀片 ☞M28　陶瓷刀片 ☞B128
适用外径刀杆 ☞C14～C16　适用内径刀杆 ☞E15、E31～E33

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◐	✖	○	◔	✿		◔			◔									✿		✿	◐			◐	✖	✿	●	◐							
M 不锈钢				✿			✿	●	◐	✖	○	◔									✿		✿	◐	✿													
K 铸铁			✿			✿							●	◐	✖	○	◔			✿		✿		◐						●								
N 非铁金属																																						◐
S 难削材																			●	◐	✖	◔	✿	✿														
H 高硬度材																		●																				

	形状	适用范围	型号	刀尖半径RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
					涂层																									涂层金属陶瓷			金属陶瓷		硬质合金						
					CVD									PVD	CVD								PVD							PVD												
精切削	SU 13°		DNMG 150402N-SU	0.2								●	●	●		●						—	●	●	●		●		●	—	●	●	▲	●	●								
			150404N-SU	0.4	●	●	●	●	●	●	●	●	●	●		●						—	●	●	●		●		●	—	●	●	▲	●	●								
			150408N-SU	0.8	●	●	●	●	●	●	●	●	●	●		●						—	●	●	●	●	●		●	—	●	●	▲	●	●								
			150412N-SU	1.2	●	●	●		●	●		●	●	●		●						—								—	●	●	▲	●	●								
	SU 13°		DNGG 150402N-SU	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—		●	●	●	●					●	●	▲	●	●								
			150404N-SU	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—		●	●	●	●					●	●	▲	●	●								
			150408N-SU	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—		●	●	●	●					●	●	▲	●	●								
	SE 5°		DNMG 150404N-SE	0.4	●	●	●	●	●	●	●											—						—		—	●	●		●	●								
			150408N-SE	0.8	●	●	●	●	●	●	●											—						—		—	●	●		●	●								
			150412N-SE	1.2	●	●	●	●	●	●	●											—						—		—	●	●		●	●								
			150416N-SE	1.6	—	—	—	—	—	—	—											—						—		—	—	—		—	—								
	SEW 5° 修光刃 →B131		DNMX 150404N-SEW	0.4	●	●	●		●	●												—						—		—	●	●			●								
			150408N-SEW	0.8	●	●	●		●	●												—						—		—	●	●			●								
			150412N-SEW	1.2	●	●	●		●	●												—						—		—	—	—		—	—								
	EF 20°		DNMG 150404N-EF	0.4	●	●	●	●				●	●	●		●						—	●	●	●	●	●	—		—	—	—	—	—	—					●	●		
			150408N-EF	0.8	●	●	●	●				●	●	●		●						—	●	●	●	●	●	—		—	—	—	—	—	—					●	●		
			150412N-EF	1.2	●	●	●	●				●	●	●		●						—	●	●	●	●	●	—		—	—	—	—	—	—					●	●		
	EF 20°		DNGG 150404N-EF	0.4	—	—	—	—	—	—	—	—	—	—		●						—		●	●	●	●				—	—	—	—	—	—					●	●		
			150408N-EF	0.8	—	—	—	—	—	—	—	—	—	—		●						—		●	●	●	●				—	—	—	—	—	—					●	●		
	FY 15°		DNGG 150402R-FY	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—						●			—	—	—	—	—	—								
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			150404L-FY	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—						●			—	—	—	—	—	—								
			150408R-FY	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—						●			—	—	—	—	—	—								
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	FX 14°		DNGG 150402R-FX	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—						●			—	—	—	—	—	—								
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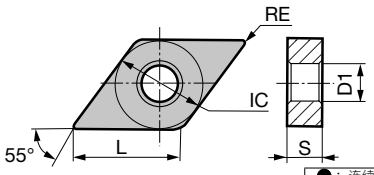
			150408R-FX	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—						●			—	—	—	—	—	—								
			150408L-FX	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—						●			—	—	—	—	—	—								
轻～中切削	SX 3°		DNMG 150404N-SX	0.4	●	●	●	●	●	●	●											—						—		—	●	●	▲		●								
			150408N-SX	0.8	●	●	●	●	●	●	●											—						—		—	●	●	▲		●								
			150412N-SX	1.2	●	●	●	●	●	●	●											—						—		—	—	—		—	—								
	EX 16°		DNMG 150404N-EX	0.4								●	●	●	▲	●						—	●	●	●	●	●	—	●	—	—	—	—	—	—								
			150408N-EX	0.8								●	●	●	▲	●						—	●	●	●	●	●	—	●	—	—	—	—	—	—								
			150412N-EX	1.2								●	●	●	▲	●						—	●	●	●	●	●	—	●	—	—	—	—	—	—								
	UP 10°		DNMG 150404N-UP	0.4						●	●	●	●	●		●						—	●	●	●	●	●	—	●	—	—	—	—	—	—				●				
			150408N-UP	0.8						●	●	●	●	●		●						—	●	●	●	●	●	—	●	—	—	—	—	—	—				●				
			150412N-UP	1.2						●	●	●	●	●		●						—	●	●	●	●	●	—	●	—	—	—	—	—	—				●				
			150416N-UP	1.6																		—						—		—	—	—		—	—								
中切削	GU 7°		DNMG 150404N-GU	0.4	●	●	●	●	●	●	●	●	●	●	▲	●	●	●				—	●	●	●		●	—	●	—	●	●			●								
			150408N-GU	0.8	●	●	●	●	●	●	●	●	●	●	▲	●	●	●				—	●	●	●		●	—	●	—	●	●			●								
			150412N-GU	1.2	●	●	●	●	●	●	●	●	●	●	▲	●	●	●				—	●	●	●		●	—	●	—	●	●			●								
			150416N-GU	1.6			●			●							●	●				—						—		—	—	—		—	—								
	GE 3°		DNMG 150404N-GE	0.4	●	●	●	●	●	●	●											—						—		—	—	—		—	—								
			150408N-GE	0.8	●	●	●	●	●	●	●											—						—		—	—	—		—	—								
			150412N-GE	1.2	●	●	●	●	●	●	●											—						—		—	—	—		—	—								
			150416N-GE	1.6			●															—						—		—	—	—		—	—								

▲记号：计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

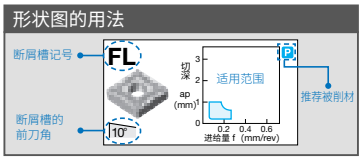
55° 菱形负型刀片

机夹式刀片

DN 55°菱形 负型 带孔



形状图的用法



●：连续切削 第一推荐　○：连续切削 第二推荐　◐：一般切削 第一推荐　◔：一般切削 第二推荐　✖：断续切削 第一推荐　✖：断续切削 第二推荐

DN■■1504●●

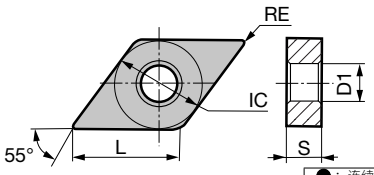
尺寸 (mm)	切刃长度L	15.5	厚度S	4.76
	内切圆IC	12.7	孔径D1	5.16

| 推荐用途 | 涂层 | 涂层 | 涂层

55° 菱形负型刀片

机夹式刀片

DN 55°菱形 负型 带孔



材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4～
按被削材分类的刀片材质选择要领 ☞A10～

●：连续切削 第一推荐
○：连续切削 第二推荐
◕：一般切削 第一推荐
◔：一般切削 第二推荐
✖：断续切削 第一推荐
✪：断续切削 第二推荐

DN■■1504●●

尺寸 (mm)	切刃长度L	15.5	厚度S	4.76
	内切圆IC	12.7	孔径D1	5.16

住友CBN(CBN)刀片 ☞L54～　住友金刚石(PCD)刀片 ☞M12
无粘合剂住友金刚石刀片☞M28　陶瓷刀片 ☞B128
适用外径刀杆 ☞C14～C16　适用内径刀杆 ☞E15、E31～E33

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◕	✖	○	◔	✪		◔				◔								✪		✪	◕			◕	✖	✪	●	◕							
M 不锈钢			✪				✪	●	◕	✖	○	◔									✪		✪	◕	✪													
K 铸铁			✪			✪							●	◕	✖	○	◔			✪		✪		◕						●								
N 非铁金属																																					◕
S 难削材																			●	◕	✖	◔	✪	✪													
H 高硬度材																		●																			

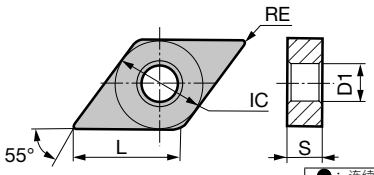
	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
					涂层																									涂层金属陶瓷			金属陶瓷		硬质合金						
					CVD									PVD	CVD							PVD								PVD												
中～粗切削	UZ	K	DNMG 150404N-UZ	0.4			●			●							●	●	●	▲	▲	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			150408N-UZ	0.8			●	●		●	●						●	●	●	▲	▲	—	●	●	●	●	●	—	—	—	—	—	—	—	—	●	●	●			—
			150412N-UZ	1.2			●	●		●	●						●	●	●	▲	▲	—	●	●	●	●	●	—	—	—	—	—	—	—	—	—	—	●			—
	GZ	K	DNMG 150404N-GZ	0.4						●							●	●	●	▲	▲	—						—	—	—	—	—	—	—	—						—
			150408N-GZ	0.8						●							●	●	●	▲	▲	—						—	—	—	—	—	—	—	—						—
			150412N-GZ	1.2						●							●	●	●	▲	▲	—						—	—	—	—	—	—	—	—						—
	HM	P M K	DNMG 150404R-HM	0.4	●	●	●	●	●	●	●	●	●	●		●						—						—	—	—	—	—	—	—	—						—
			150404L-HM	0.4			●			●		●	●	●		●						—						—	—	—	—	—	—	—	—						—
			150408R-HM	0.8	●	●	●	●	●	●	●	●	●	●		●						—						—	—	—	—	—	—	—	—						—
			150408L-HM	0.8			●			●		●	●	●		●						—						—	—	—	—	—	—	—	—						—
粗切削	MP	P	DNMM 150404N-MP	0.4			●	●		●	●											—						—	—	—	—	—	—	—	—						—
			150408N-MP	0.8	●	●	●	●	●	●	●											—						—	—	—	—	—	—	—	—						—
			150412N-MP	1.2	●	●	●	●	●	●	●											—						—	—	—	—	—	—	—	—						—
			150416N-MP	1.6	●	●	●		●	●												—						—	—	—	—	—	—	—	—						—
重切削	HP	P	DNMM 150404N-HP	0.4			●	●		●	●											—						—	—	—	—	—	—	—	—						—
			150408N-HP	0.8			●	●		●	●											—						—	—	—	—	—	—	—	—						—
			150412N-HP	1.2			●	●		●	●											—						—	—	—	—	—	—	—	—						—
			150416N-HP	1.6			●			●												—						—	—	—	—	—	—	—	—						—
铝材用	AX	N	DNGG 150402R-AX	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●
			150402L-AX	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●
			150404R-AX	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●
			150404L-AX	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●
			150408R-AX	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●
			150408L-AX	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●
淬火钢轻切削	GH	H	DNGG 150402N-GH	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			150404N-GH	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			150408N-GH	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—

▲记号：计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

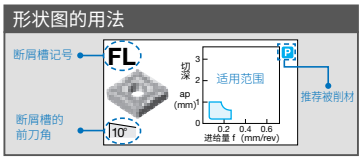
55° 菱形负型刀片

机夹式刀片

DN 55°菱形 负型 带孔



形状图的用法



●：连续切削 第一推荐　○：连续切削 第二推荐　◐：一般切削 第一推荐　◔：一般切削 第二推荐　✖：断续切削 第一推荐　✖：断续切削 第二推荐

DN■■1506●●

尺寸 (mm)	切刃长度L	15.5	厚度S	6.35
	内切圆IC	12.7	孔径D1	5.16

住友CBN(CBN)刀片 ☞L60
适用外径刀杆 ☞C14、C16　适用内径刀杆 ☞E32

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◐	✖	○	◔	✿		◔			◔									✿		✿	◐			◐	✖	✿	●	◐							
M 不锈钢				✿			✿	●	◐	✖	○	◔									✿		✿	◐	✿													
K 铸铁			✿			✿							●	◐	✖	○	◔			✿		✿		◐						●								
N 非铁金属																																						◐
S 难削材																			●	◐	✖	◔	✿	✿														
H 高硬度材																		●																				
	涂层																										涂层金属陶瓷			金属陶瓷		硬质合金						
	CVD									PVD	CVD							PVD									PVD											

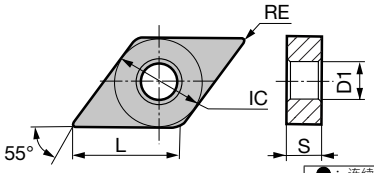
	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
微小切削	FB 27°	P	DNMG 150604N-FB	0.4	—	—	—	—	—	—	—	—	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	▲	●	●	—	—	—	—	—	—	—
			150608N-FB	0.8	—	—	—	—	—	—	—	—	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	▲	●	●	—	—	—	—	—	—	—
	FA 20°	P	DNMG 150604N-FA	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●		●	●	—	—	—	—	—	—	—
			150608N-FA	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●			●	●	—	—	—	—	—	—	—
	FE 20°	P	DNMG 150602N-FE	0.2	●	●	●	●	●		●		●	●								—					—		—	—	●	●	▲	●	●							
			150604N-FE	0.4	●	●	●	●	●		●		●	●								—					—		—	—	●	●	▲	●	●							
			150608N-FE	0.8	●	●	●	●	●		●		●	●								—					—		—	—	●	●	▲	●	●							
			150612N-FE	1.2	●	●	●	●	●		●		●	●								—					—		—	—	●	●	▲	●	●							
精切削	SU 13°	P M S	DNMG 150604N-SU	0.4	●	●	●			●												—					—		—	—	●	●		●	●							
			150608N-SU	0.8	●	●	●	●		●	●											—					—		—	—	●	●		●	●							
			150612N-SU	1.2	●	●	●	●		●	●											—					—		—	—												
	SE 5°	P	DNMG 150604N-SE	0.4																		—					—		—	—				●								
			150608N-SE	0.8																		—					—		—	—				●								
			150612N-SE	1.2																		—					—		—	—												
			150616N-SE	1.6																		—					—		—	—	—	—	—	—	—							—
	SEW 5° →B131 修光刃	P	DNMX 150604N-SEW	0.4																		—					—		—	—												
			150608N-SEW	0.8																		—					—		—	—												
			150612N-SEW	1.2																		—					—		—	—	—	—	—	—	—							—
	EF 20°	M S	DNMG 150604N-EF	0.4	●	●	●	●				●	●	●		●						—	●	●	●	●	●	—		—	—	—	—	—	—				●	●	—
			150608N-EF	0.8	●	●	●	●				●	●	●		●						—	●	●	●	●	●	—		—	—	—	—	—	—				●	●	—
			150612N-EF	1.2	●	●	●	●				●	●	●		●						—	●	●	●	●	●	—		—	—	—	—	—	—				●	●	—
轻～中切削	SX 3°	P	DNMG 150604N-SX	0.4																		—					—		—	—	●	●			●							
			150608N-SX	0.8																		—					—		—	—	●	●			●							
	EX 16°	M S	DNMG 150604N-EX	0.4								●	●	●	▲	●						—					—		—	—	—	—	—	—	—							—
			150608N-EX	0.8								●	●	●	▲	●						—					—		—	—	—	—	—	—	—							—
			150612N-EX	1.2								●	●	●	▲	●						—					—		—	—	—	—	—	—	—							—
整体CBN 陶瓷	UP 10°	M S	DNMG 150604N-UP	0.4																		—					—		—	—	—	—	—	—	—							—
			150608N-UP	0.8																		—					—		—	—	—	—	—	—	—							—
			150612N-UP	1.2																		—					—		—	—	—	—	—	—	—							—
			150616N-UP	1.6																		—					—		—	—	—	—	—	—	—							—

▲记号：计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

55° 菱形负型刀片

机夹式刀片

DN 55°菱形 负型 带孔



材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4～
按被削材分类的刀片材质选择要领 ☞A10～

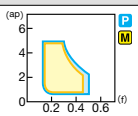
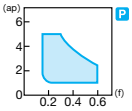
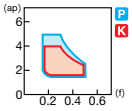
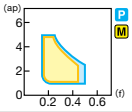
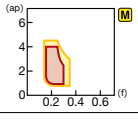
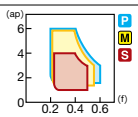
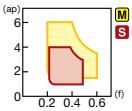
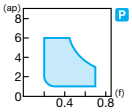
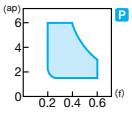
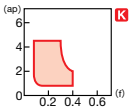
●：连续切削 第一推荐
○：连续切削 第二推荐
●：一般切削 第一推荐
○：一般切削 第二推荐
✖：断续切削 第一推荐
✖：断续切削 第二推荐

DN■■1506●●

尺寸(mm)	切刃长度L	15.5	厚度S	6.35
	内切圆IC	12.7	孔径D1	5.16

住友CBN(CBN)刀片 ☞L60
适用外径刀杆 ☞C14、C16　适用内径刀杆 ☞E32

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
	涂层																										涂层金属陶瓷			金属陶瓷		硬质合金						
	CVD									PVD			CVD					PVD									PVD											
P 钢	●	○	●	✖	○	○	✪		○				○								✪		✪	●			●	✖	✪	●	●							
M 不锈钢				✪			✪	●	●	✖	○	○									✪		✪	●	✪													
K 铸铁			✪				✪						●	●	✖	○	○			✪		✪		●						●								
N 非铁金属																																						●
S 难削材																			●	●	✖	○	✪	✪														
H 高硬度材																		●																				

	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
中切削	GU 7°		DNMG 150604N-GU	0.4	●	●	●	●		●	●						●	●																							
			150608N-GU	0.8	●	●	●	●	●	●	●	●	●	●	▲	●	●	●																							
			150612N-GU	1.2	●	●	●	●	●	●	●	●	●	●	▲	●	●	●																							
			150616N-GU	1.6			●			●							●	●																							
	GE 3°		DNMG 150604N-GE	0.4	●	●	●	●	●	●	●																													
			150608N-GE	0.8	●	●	●	●	●	●	●																													
			150612N-GE	1.2	●	●	●	●	●	●	●																													
			150616N-GE	1.6	●	●	●	●	●	●	●																													
	UX 0°		DNMG 150604N-UX	0.4	●	●	●	●		●	●																													
			150608N-UX	0.8	●	●	●	●	●	●	●																													
			150610N-UX	1.0																																				
			150612N-UX	1.2	●	●	●	●	●	●	●																													
			150616N-UX	1.6			●			●																														
	UG 4°		DNMG 150604N-UG	0.4			●			●																													
			150608N-UG	0.8			●	●		●	●																													
			150612N-UG	1.2			●			●																														
			150616N-UG	1.6			●			●																														
	EG 0°		DNMG 150604N-EG	0.4	●	●	●	●				●	●	●		●							●	●	●	●	●												●	●	
			150608N-EG	0.8	●	●	●	●				●	●	●		●							●	●	●	●	●													●	●	
			150612N-EG	1.2	●	●	●	●				●	●	●		●							●	●	●	●	●													●	●	
			DNMA 150608	0.8													●	●	●	▲	▲																				
			150612	1.2													●	●	●	▲	▲																				
中～粗切削	MU 4°		DNMG 150608N-MU	0.8	●	●	●	●	●	●	●		●	●		●																									
			150612N-MU	1.2	●	●	●	●	●	●	●		●	●		●																									
			150616N-MU	1.6			●			●																															
	EM 0°		DNMG 150608N-EM	0.8	●	●	●	●				●	●	●									●	●	●																
			150612N-EM	1.2	●	●	●	●				●	●	●									●	●	●																
	ME 4°		DNMG 150608N-ME	0.8	●	●	●	●	●	●	●						●	●																							
			150612N-ME	1.2	●	●	●	●	●	●	●						●	●																							
			150616N-ME	1.6	●	●	●	●	●	●	●						●	●																							
	MX -15°		DNMG 150608N-MX	0.8		●	●			●																														
			150612N-MX	1.2		●	●			●																															
			150616N-MX	1.6																																					
	UZ 4°		DNMG 150608N-UZ	0.8			●			●							●	●	●	▲	▲																				
			150612N-UZ	1.2			●			●							●	●	●	▲	▲																				

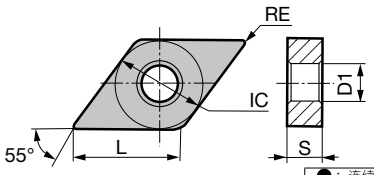
刀片 B 负型 正型 C D R S T V W 整体CBN 陶瓷

▲记号：计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

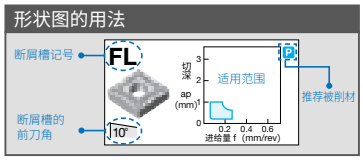
55° 菱形负型刀片

机夹式刀片

DN 55°菱形 负型 带孔



形状图的用法



●：连续切削 第一推荐　○：连续切削 第二推荐　◕：一般切削 第一推荐　◔：一般切削 第二推荐　✖：断续切削 第一推荐　✪：断续切削 第二推荐

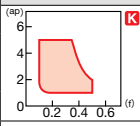
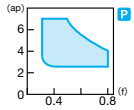
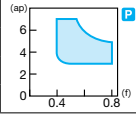
DN■■1506●●

尺寸 (mm)	切刃长度L	15.5	厚度S	6.35
	内切圆IC	12.7	孔径D1	5.16

住友 CBN(CBN) 刀片 ☞L60

适用外径刀杆 ☞C14、C16　适用内径刀杆 ☞E32

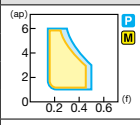
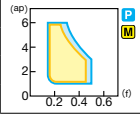
推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◕	✖	○	◔	✪		◔				◔								✪		✪	◕			◕	✖	✪	●	◕							
M 不锈钢				✪			✪	●	◕	✖	○	◔									✪		✪	◕	✪													
K 铸铁			✪			✪							●	◕	✖	○	◔			✪		✪		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◔	✪	✪														
H 高硬度材																		●																				

	形状	适用范围	型　号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
中～粗切削	GZ 0°		DNMG 150608N-GZ	0.8						●							●	●	●	▲	▲	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			150612N-GZ	1.2						●							●	●	●	▲	▲	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
粗切削	MP 0°		DNMM 150604N-MP	0.4			●			●												—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			150608N-MP	0.8	●	●	●	●	●	●	●											—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			150612N-MP	1.2	●	●	●	●	●	●	●											—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			150616N-MP	1.6	●	●	●		●	●												—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
重切削	HP 0°		DNMM 150604N-HP	0.4			●			●												—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			150608N-HP	0.8			●	●		●	●											—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			150612N-HP	1.2			●	●		●	●											—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			150616N-HP	1.6			●			●												—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—

DN■■1906●●

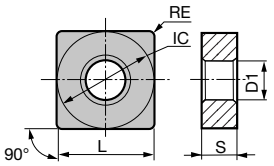
尺寸 (mm)	切刃长度L	19.4	厚度S	6.35
	内切圆IC	15.875	孔径D1	6.35

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◕	✖	○	◔	✪		◔				◔								✪		✪	◕			◕	✖	✪	●	◕							
M 不锈钢				✪			✪	●	◕	✖	○	◔									✪		✪	◕	✪													
K 铸铁			✪			✪							●	◕	✖	○	◔			✪		✪		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◔	✪	✪														
H 高硬度材																		●																				

	形状	适用范围	型　号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
中切削	UG 4°		DNMG 190608N-UG	0.8																		—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			190612N-UG	1.2																		—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			190616N-UG	1.6																		—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
中～粗切削	UZ 4°		DNMG 190608N-UZ	0.8																		—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			190612N-UZ	1.2																		—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			190616N-UZ	1.6																		—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—

▲记号：计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

SN 正方形 负型 带孔



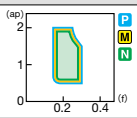
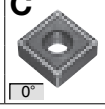
材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4～
按被削材分类的刀片材质选择要领 ☞A10～

●：连续切削 第一推荐　○：连续切削 第二推荐　◕：一般切削 第一推荐　◔：一般切削 第二推荐　✖：断续切削 第一推荐　✪：断续切削 第二推荐

SN■■S702●●

尺寸 (mm)	切刃长度L	7.14	厚度S	2.38
	内切圆IC	7.14	孔径D1	2.97

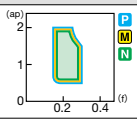
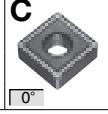
推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
	涂层																										涂层 金属陶瓷			金属陶瓷		硬质合金						
	CVD									PVD	CVD							PVD									PVD											
P 钢	●	○	◕	✖	○	○	✪		○			○								✪		✪	◕			◕	✖	✪	●	◕								
M 不锈钢			✪			✪	●	◕	✖	○	○									✪		✪	◕	✪														
K 铸钢			✪			✪							●	◕	✖	○	○			✪		✪		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	○	✪	✪														
H 高硬度材																		●																				

	形状	适用范围	型 号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
轻切削	GX 15°		SNGG S70204R-GX	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●					
			S70204L-GX	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●					
			S70208R-GX	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	
			S70208L-GX	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●		●				●
倒角用	C  0°	※因为是倒角用，所以不能使用刀尖半径。	SNGG S70200-C	(0.8)	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●		●				

SN■■07T2●●

尺寸 (mm)	切刃长度L	7.94	厚度S	2.78
	内切圆IC	7.94	孔径D1	3.15

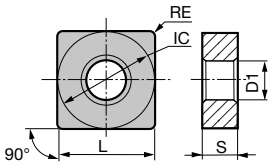
推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
	涂层																										涂层 金属陶瓷			金属陶瓷		硬质合金						
	CVD									PVD	CVD							PVD									PVD											
P 钢	●	○	◕	✖	○	○	✪		○			○								✪		✪	◕			◕	✖	✪	●	◕								
M 不锈钢			✪			✪	●	◕	✖	○	○									✪		✪	◕	✪														
K 铸钢			✪			✪							●	◕	✖	○	○			✪		✪		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	○	✪	✪														
H 高硬度材																		●																				

	形状	适用范围	型 号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
轻切削	GX 15°		SNGG 07T204R-GX	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●					
			07T204L-GX	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●					
			07T208R-GX	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	
			07T208L-GX	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●		●				
倒角用	C  0°	※因为是倒角用，所以不能使用刀尖半径。	SNGG 07T200-C	(0.8)	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●		●				

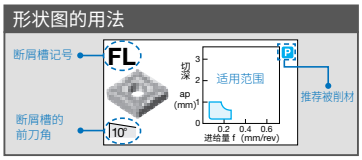
正方形负型刀片

机夹式刀片

SN 正方形 负型 带孔



形状图的用法



●：连续切削 第一推荐
○：连续切削 第二推荐
◕：一般切削 第一推荐
◔：一般切削 第二推荐
✖：断续切削 第一推荐
✖：断续切削 第二推荐

SN■■0903●●

尺寸 (mm)				
	切刃长度L	9.525	厚度S	3.18
	内切圆IC	9.525	孔径D1	3.81

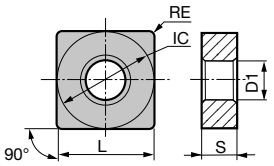
适用外径刀杆 ☞C22～C26

| 推荐用途 | 涂层 | | | |

正方形负型刀片

机夹式刀片

SN 正方形 负型 带孔



材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4～
按被削材分类的刀片材质选择要领 ☞A10～

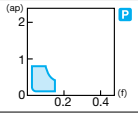
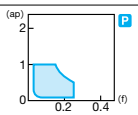
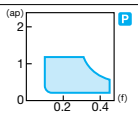
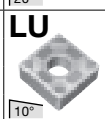
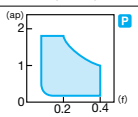
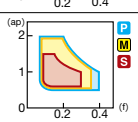
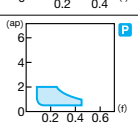
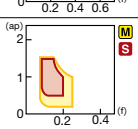
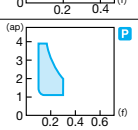
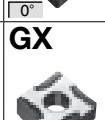
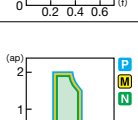
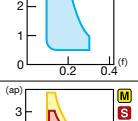
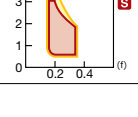
●：连续切削 第一推荐
○：连续切削 第二推荐
◕：一般切削 第一推荐
◔：一般切削 第二推荐
✖：断续切削 第一推荐
✪：断续切削 第二推荐

SN■■1204●●

尺寸 (mm)	切刃长度L	12.7	厚度S	4.76
	内切圆IC	12.7	孔径D1	5.16

住友 CBN(CBN) 刀片 ☞L69～
无粘合剂住友金刚石刀片☞M28
陶瓷刀片 ☞B128
适用外径刀杆 ☞C21～C26
适用内径刀杆 ☞E39～E41

推荐用途		涂层 CVD								PVD			CVD					PVD								PVD														
		AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
	P 钢	●	◔	◕	✖	○	◔	✪		◔			◔									✪		✪	◕			◕	✖	✪	●	◕								●
	M 不锈钢			✪				✪	●	◕	✖	○	◔									✪		✪	◕	✪														
	K 铸铁			✪			✪							●	◕	✖	○	◔			✪		✪		◕						●									
	N 非铁金属																																							◕
	S 难削材																		●	◕	✖	◔	✪	✪																
	H 高硬度材																	●																						

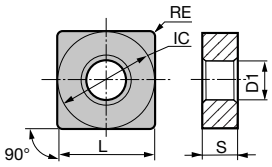
	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
微小切削	FB 27°		SNMG 120404N-FB	0.4	—	—	—	—	—	—	—	—	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	▲	●	●	—	—	—	—	—	—	—
			120408N-FB	0.8	—	—	—	—	—	—	—	—	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	▲	●	●	—	—	—	—	—	—	—
	FL 10°		SNMG 120408N-FL	0.8			●			●						●						—						—	—	—	●	●	▲		●							
	FE 20°		SNMG 120404N-FE	0.4	●	●	●	●	●		●		●	●								—						—	—	—	●	●	▲	●	●							
			120408N-FE	0.8	●	●	●	●	●		●		●	●								—						—	—	—	●	●	▲	●	●							
			120412N-FE	1.2	●	●	●	●	●		●		●	●								—						—	—	—	●	●	▲	●	●							
精切削	LU  10°		SNMG 120408N-LU	0.8	●	●	●		●	●			●			●						—						—	—	—	●	●	▲		●							
			120412N-LU	1.2	●	●	●		●	●			●			●						—						—	—	—	●	●	▲		●							
	SU 13°		SNMG 120404N-SU	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			120408N-SU	0.8	●	●	●	●	●	●	●	●	●	●		●						—	●	●	●	●	●	—	●	—	●	●	▲	●	●							
	SE 5°		SNMG 120408N-SE	0.8	●	●	●	●	●	●	●											—						—	—	—	—	—	—	—	—							—
			120412N-SE	1.2	●	●	●	●	●	●	●											—						—	—	—	—	—	—	—	—							—
	EF 20°		SNMG 120404N-EF	0.4	●	●	●	●				●	●	●								—	●	●	●			—	—	—	—	—	—	—	—							—
			120408N-EF	0.8	●	●	●	●				●	●	●								—	●	●	●			—	—	—	—	—	—	—	—							—
倒角用	SJ 0°		SNMG 120404N-SJ	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	—	—	—	—	—	—
轻切削	GX  15°		SNGG 120404R-GX	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—																				
			120404L-GX	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—															●		●			
			120408R-GX	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—																	●			
			120408L-GX	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—															●		●			●
			120412R-GX	1.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—																				
			120412L-GX	1.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—																				
轻～中切削	SX 3°		SNMG 120404N-SX	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	▲		●	—	—	—	—	—	—
			120408N-SX	0.8	●	●	●	●	●	●	●											—						—	—	—	●	●	▲		●							
			120412N-SX	1.2	●	●	●	●	●	●	●											—						—	—	—	—	—	—	—	—							—
	EX 16°		SNMG 120404N-EX	0.4								●	●	●	▲	●						—	●	●	●	●	●	—	●	—	—	—	—	—	—	—							—
			120408N-EX	0.8								●	●	●	▲	●						—	●	●	●	●	●	—	●	—	—	—	—	—	—	—							—
			120412N-EX	1.2								●	●	●	▲	●						—	●	●	●	●	●	—	●	—	—	—	—	—	—	—							—

▲记号：计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

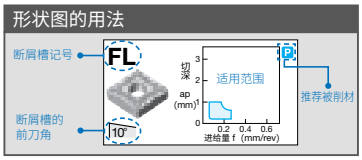
正方形负型刀片

机夹式刀片

SN 正方形 负型 带孔



形状图的用法



●: 连续切削 第一推荐
○: 连续切削 第二推荐
: 一般切削 第一推荐
: 一般切削 第二推荐
: 断续切削 第一推荐
: 断续切削 第二推荐

推荐用途																																			
P 钢	●	◔	◕	✖	○	◔	✪		◔			◔							✪		✪	◕		◕	◕	✪	●	◕							
M 不锈钢				✪			✪	●	◕	✖	○	◔							✪		✪	◕	✪												
K 铸铁			✪			✪							●	◕	✖	○	◔			✪		✪		◕					●						
N 非铁金属																																			◕
S 难削材																		●	◕	✖	◔	✪	✪												
H 高硬度材																	●																		

SN■■1204●●				
尺寸 (mm)	切刃长度L	12.7	厚度S	4.76
	内切圆IC	12.7	孔径D1	5.16

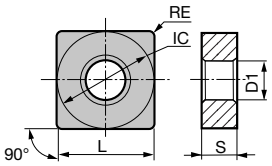
住友 CBN(CBN) 刀片 ☞L69 ～
无粘合剂住友金刚石刀片☞M28
陶瓷刀片 ☞B128
适用外径刀杆 ☞C21 ～ C26
适用内径刀杆 ☞E39 ～ E41

	形状	适用范围	型 号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
					涂层																									涂层金属陶瓷				金属陶瓷	硬质合金							
					CVD									PVD		CVD						PVD								PVD												
轻～中切削	UP		SNMG 120404N-UP	0.4						●	●	●	●	●		●						—								—				—				●				
			120408N-UP	0.8						●	●	●	●	●		●						—	●	●	●	●		●		—				—				●				
			120412N-UP	1.2						●	●	●	●	●		●						—	●	●	●	●		●		—				—				●				
	GU		SNMG 120404N-GU	0.4	●	●	●	●	●	●	●	●	●	●	▲	●	●	●				—	●	●	●		●		●	—	●	●			●							
			120408N-GU	0.8	●	●	●	●	●	●	●	●	●	●	▲	●	●	●				—	●	●	●		●		●	—	●	●			●							
			120412N-GU	1.2	●	●	●	●	●	●	●	●	●	●	▲	●	●	●				—	●	●	●		●		●	—												
			120416N-GU	1.6	●	●	●	●		●	●						●	●				—								—												
	GE		SNMG 120408N-GE	0.8	●	●	●	●	●	●	●											—								—												
			120412N-GE	1.2	●	●	●	●	●	●	●											—								—												
			120416N-GE	1.6	●	●	●	●	●	●	●											—								—												
	UX		SNMG 120404N-UX	0.4				●			●											—								—												
			120408N-UX	0.8	●	●	●	●	●	●	●											—								—												
			120412N-UX	1.2	●	●	●	●	●	●	●											—								—												
			120416N-UX	1.6	●	●	●	●	●	●	●											—								—												
	UG		SNMG 120408N-UG	0.8			●	●		●	●											—								—						●		●				
			120412N-UG	1.2			●	●		●	●											—								—												
			120416N-UG	1.6				●			●											—								—												
	EG		SNMG 120404N-EG	0.4	●	●	●	●				●	●	●								—	●	●	●					—				—								
			120408N-EG	0.8	●	●	●	●				●	●	●		●						—	●	●	●	●	●			—				—						●	●	
			120412N-EG	1.2	●	●	●	●				●	●	●		●						—	●	●	●	●	●			—				—						●	●	
中切削	UM		SNMG 120404R-UM	0.4																		—								—					●							
			120404L-UM	0.4																		—								—					●							
			120408R-UM	0.8																		—								—					●							
			120408L-UM	0.8																		—								—					●							
			120412R-UM	1.2																		—								—					●							
			120412L-UM	1.2																		—								—					●							
	UM		SNGG 120404R-UM	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—													●	●		●		●			
			120404L-UM	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—													●	●	●	●					
			120408R-UM	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—			●	●	●								●	●	●	●	●	●			
			120408L-UM	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—			●	●	●								●	●	●	●	●	●			
			120412R-UM	1.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—													●	●							
			120412L-UM	1.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—																					
			120416R-UM	1.6	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—																					
			120416L-UM	1.6	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—																					
			SNMA 120404	0.4													●	●	●	▲	▲	—								—												
			120408	0.8													●	●	●	▲	▲	—								—								●				●
			120412	1.2													●	●	●	▲	▲	—								—												
			120416	1.6													●	●	●	▲	▲	—								—												
			120420	2.0													●	●	●	▲	▲	—								—												
			SNGA 120404	0.4	—	—	—	—	—	—	—	—	—	—	—	—						●																●				
			120408	0.8	—	—	—	—	—	—	—	—	—	—	—	—						●																●				●
			120412	1.2	—	—	—	—	—	—	—	—	—	—	—	—						—												●				●				

▲记号: 计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

正方形负型刀片

SN 正方形 负型 带孔



材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4～
按被削材分类的刀片材质选择要领 ☞A10～

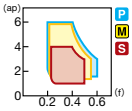
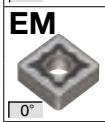
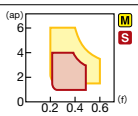
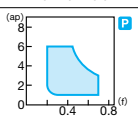
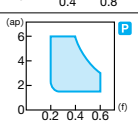
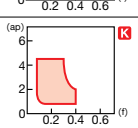
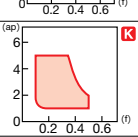
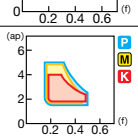
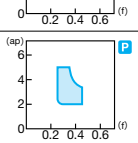
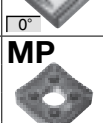
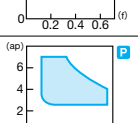
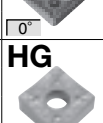
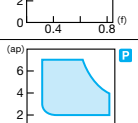
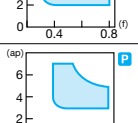
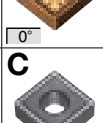
●：连续切削 第一推荐
○：连续切削 第二推荐
◕：一般切削 第一推荐
◔：一般切削 第二推荐
✖：断续切削 第一推荐
✪：断续切削 第二推荐

SN■■1204●●

尺寸 (mm)	切刃长度L	12.7	厚度S	4.76
	内切圆IC	12.7	孔径D1	5.16

住友 CBN(CBN) 刀片 ☞L69～
无粘合剂住友金刚石刀片☞M28　陶瓷刀片 ☞B128
适用外径刀杆 ☞C21～C26　适用内径刀杆 ☞E39～E41

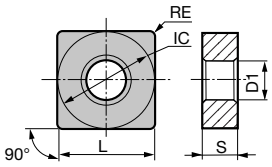
推荐用途	涂层 CVD								PVD			CVD					PVD							PVD			金属陶瓷		硬质合金					
	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◕	✖	○	◔	✪		◔			◔															◕	✖	✪	●	◕							
M 不锈钢				✪			✪	●	◕	✖	○	◔									✪		✪	◕	✪												
K 铸铁			✪			✪							●	◕	✖	○	◔			✪		✪		◕						●							
N 非铁金属																																					◕
S 难削材																			●	◕	✖	◔	✪	✪													
H 高硬度材																		●																			

	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
中～粗切削	MU 4°		SNMG 120408N-MU	0.8	●	●	●	●	●	●	●		●	●		●						—	●	●	●	●	●		●		—	—	—	—	—	—	—	—	—	—	—	—
			120412N-MU	1.2	●	●	●	●	●	●	●		●	●		●						—	●	●	●	●	●		●		—	—	—	—	—	—	—	—	—	—	—	—
			120416N-MU	1.6	●	●	●	●		●	●											—									—	—	—	—	—	—	—	—	—	—	—	—
	EM  0°		SNMG 120408N-EM	0.8	●	●	●	●				●	●	●								—	●	●	●						—	—	—	—	—	—	—	—	—	—	—	—
			120412N-EM	1.2	●	●	●	●				●	●	●								—	●	●	●						—	—	—	—	—	—	—	—	—	—	—	—
	ME 4°		SNMG 120408N-ME	0.8	●	●	●	●	●	●	●						●	●				—									—	—	—	—	—	—	—	—	—	—	—	—
			120412N-ME	1.2	●	●	●	●	●	●	●						●	●				—									—	—	—	—	—	—	—	—	—	—	—	—
			120416N-ME	1.6	●	●	●	●	●	●	●						●	●				—									—	—	—	—	—	—	—	—	—	—	—	—
	MX -15°		SNMG 120408N-MX	0.8		●	●	●		●	●											—									—	—	—	—	—	—	—	—	—	—	—	—
			120412N-MX	1.2		●	●	●		●	●											—									—	—	—	—	—	—	—	—	—	—	—	—
			120416N-MX	1.6		●	●			●												—									—	—	—	—	—	—	—	—	—	—	—	—
	UZ 4°		SNMG 120408N-UZ	0.8			●	●		●	●						●	●	●	▲	▲	—	●	●	●	●	●				—	—	—	—	—	●	●	●	●	—	—	—
			120412N-UZ	1.2			●	●		●	●						●	●	●	▲	▲	—	●	●	●	●	●				—	—	—	—	—			●	●	—	—	—
			120416N-UZ	1.6			●	●		●	●						●	●	●	▲	▲	—									—	—	—	—	—				●	—	—	—
	GZ 0°		SNMG 120408N-GZ	0.8						●							●	●	●	▲	▲	—									—	—	—	—	—							—
			120412N-GZ	1.2						●							●	●	●	▲	▲	—									—	—	—	—	—							—
			120416N-GZ	1.6						●							●	●	●	▲	▲	—									—	—	—	—	—							—
	HM 15°		SNMG 120408R-HM	0.8	●	●	●	●	●	●	●	●	●	●		●						—									—	—	—	—	—							—
			120408L-HM	0.8	●	●	●	●	●	●	●	●	●	●		●						—									—	—	—	—	—							—
	MM 0°		SNGG 120408R-MM	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—																			
			120408L-MM	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—																			
粗切削	MP  0°		SNMM 120408N-MP	0.8	●	●	●	●	●	●	●	●	●	●		●						—	●	●	●	●					—	—	—	—	—							—
			120412N-MP	1.2	●	●	●	●	●	●	●	●	●	●		●						—	●	●	●	●					—	—	—	—	—							—
			120416N-MP	1.6	●	●	●	●	●	●	●		●			●						—	●	●	●	●					—	—	—	—	—							—
			120420N-MP	2.0			●			●												—									—	—	—	—	—							—
重切削	HG  0°		SNMM 120408N-HG	0.8	●	●	●	●	●	●	●					●						—									—	—	—	—	—							—
			120412N-HG	1.2	●	●	●	●	●	●	●					●						—									—	—	—	—	—							—
			120416N-HG	1.6	●	●	●	●	●	●	●					●						—									—	—	—	—	—							—
	HP 0°		SNMM 120408N-HP	0.8			●	●		●	●					●						—									—	—	—	—	—							—
			120412N-HP	1.2			●	●		●	●					●						—									—	—	—	—	—							—
			120416N-HP	1.6			●	●		●	●					●						—									—	—	—	—	—							—
倒角用	C  0°	※因为是倒角用，所以不能使用刀尖半径。	SNGG 120400-C	(0.8)	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—													●		●				●

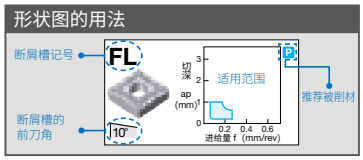
▲记号：计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

正方形负型刀片

SN 正方形 负型 带孔



形状图的用法



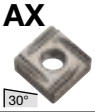
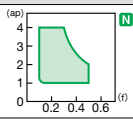
●：连续切削 第一推荐
○：连续切削 第二推荐
：一般切削 第一推荐
：一般切削 第二推荐
：断续切削 第一推荐
：断续切削 第二推荐

SN■■1204●●

尺寸 (mm)	切刃长度L	12.7	厚度S	4.76
	内切圆IC	12.7	孔径D1	5.16

住友 CBN(CBN) 刀片 ☞L69～ 无粘合剂住友金刚石刀片☞M28
陶瓷刀片 ☞B128 适用外径刀杆 ☞C21～C26
适用内径刀杆 ☞E39～E41

推荐用途	涂层 CVD								PVD	CVD						PVD							PVD			涂层金属陶瓷	金属陶瓷	硬质合金						
	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◕	✖	○	◔	✿		◔			◔									✿		✿	◕			◕	✖	✿	●	◕							
M 不锈钢				✿			✿	●	◕	✖	○	◔									✿		✿	◕	✿												
K 铸铁			✿			✿							●	◕	✖	○	◔			✿		✿		◕						●							
N 非铁金属																																					◕
S 难削材																			●	◕	✖	◔	✿	✿													
H 高硬度材																		●																			

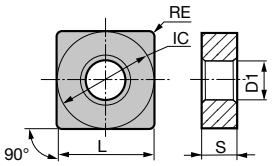
	形状	适用范围	型 号	刀尖半径 RE
铝材用	AX  30°		SNGG 120404R-AX	0.4
			120404L-AX	0.4
			120408R-AX	0.8
			120408L-AX	0.8

型号	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
SNGG 120404R-AX																																						●
120404L-AX																																						●
120408R-AX																																						●
120408L-AX																																						●

正方形负型刀片

机夹式刀片

SN 正方形 负型 带孔



材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4～
按被削材分类的刀片材质选择要领 ☞A10～

●：连续切削 第一推荐　○：连续切削 第二推荐
●：一般切削 第一推荐　○：一般切削 第二推荐
✖：断续切削 第一推荐　✖：断续切削 第二推荐

SN■■1506●●

尺寸 (mm)	切刃长度L	15.875	厚度S	6.35
	内切圆IC	15.875	孔径D1	6.35

适用外径刀杆 ☞C21～C24

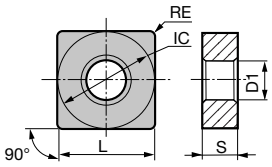
推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
	涂层																										涂层 金属陶瓷			金属陶瓷		硬质合金						
	CVD									PVD			CVD						PVD								PVD											
P 钢	●	○	◐	✖	○	○	⊛		○				○														◐	✖	⊛	●	◐							
M 不锈钢			⊛				⊛	●	◐	✖	○	○									⊛		⊛	◐	⊛													
K 铸铁			⊛			⊛							●	◐	✖	○	○				⊛		⊛	◐						●								
N 非铁金属																																						◐
S 难削材																			●	◐	✖	○	⊛	⊛														
H 高硬度材																		●																				

	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
轻～中切削	EX 16°		SNMG 150612N-EX	1.2																		—	●	●	●	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
中切削	GU 7°		SNMG 150608N-GU	0.8	●	●	●	●	●	●	●		●	●			●	●				—						—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			150612N-GU	1.2	●	●	●	●	●	●	●		●	●			●	●				—						—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			150616N-GU	1.6	●	●	●	●	●	●	●		●	●			●	●				—						—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	GE 3°		SNMG 150608N-GE	0.8	●	●	●	●	●	●	●											—						—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			150612N-GE	1.2	●	●	●	●	●	●	●											—						—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			150616N-GE	1.6	●	●	●	●	●	●	●											—						—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	UG 4°		SNMG 150612N-UG	1.2				●			●											—						—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	EG 0°		SNMG 150608N-EG	0.8	●	●	●	●				●	●	●								—	●	●	●	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			150612N-EG	1.2	●	●	●	●				●	●	●		●						—	●	●	●	●	●	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—
			150616N-EG	1.6	●	●	●	●				●	●	●								—	●	●	●	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			SNMA 150612	1.2													●	●	●	▲	▲							—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			150616	1.6													●	●	●	▲	▲							—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
中～粗切削	MU 4°		SNMG 150608N-MU	0.8	●	●	●	●	●	●	●											—	●	●	●	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			150612N-MU	1.2	●	●	●	●	●	●	●		●	●		●						—	●	●	●	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			150616N-MU	1.6	●	●	●	●	●	●	●		●			●						—	●	●	●	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	EM 0°		SNMG 150608N-EM	0.8	●	●	●	●				●	●	●								—	●	●	●			—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			150612N-EM	1.2	●	●	●	●				●	●	●								—	●	●	●			—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			150616N-EM	1.6	●	●	●	●				●	●	●								—	●	●	●			—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	ME 4°		SNMG 150608N-ME	0.8	●	●	●	●	●	●	●						●	●				—						—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			150612N-ME	1.2	●	●	●	●	●	●	●						●	●				—						—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			150616N-ME	1.6	●	●	●	●	●	●	●						●	●				—						—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	MX -15°		SNMG 150612N-MX	1.2		●	●			●												—						—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			150616N-MX	1.6		●	●			●												—						—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	UZ 4°		SNMG 150612N-UZ	1.2			●	●		●	●											—						—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			150616N-UZ	1.6																		—						—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	GZ 0°		SNMG 150612N-GZ	1.2													●	●	●	▲	▲	—						—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			150616N-GZ	1.6													●	●	●	▲	▲	—						—	—	—	—	—	—	—	—	—	—	—	—	—	—	—

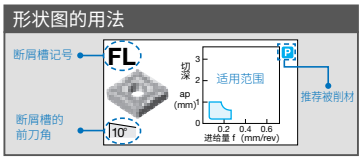
▲记号：计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

正方形负型刀片

SN 正方形 负型 带孔



形状图的用法



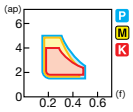
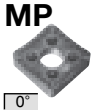
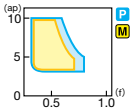
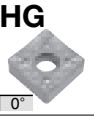
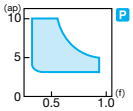
●：连续切削 第一推荐
○：连续切削 第二推荐
：一般切削 第一推荐
：一般切削 第二推荐
：断续切削 第一推荐
：断续切削 第二推荐

SN■■1506●●

尺寸 (mm)				
	切刃长度L	15.875	厚度S	6.35
	内切圆IC	15.875	孔径D1	6.35

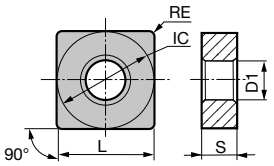
适用外径刀杆 ☞C21～C24

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◕	✖	○	◔	✪		◔			◔									✪		✪	◕			◕	✖	✪	●	◕							
M 不锈钢				✪			✪	●	◕	✖	○	◔									✪		✪	◕	✪													
K 铸铁			✪			✪							●	◕	✖	○	◔			✪		✪		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◔	✪	✪														
H 高硬度材																		●																				

	形状	适用范围	型 号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
中～粗切削	HM 15°		SNMG 150608R-HM	0.8								●	●	●								—					—	—	—	—	—	—	—	—	—	—						—
			150608L-HM	0.8								●	●	●								—					—	—	—	—	—	—	—	—	—	—						—
重切削	MP  0°		SNMM 150612N-MP	1.2	●	●	●		●	●			●									—					—	—	—	—	—	—	—	—	—	—						—
			150616N-MP	1.6	●	●	●		●	●			●									—					—	—	—	—	—	—	—	—	—	—						—
	HG  0°		SNMM 150616N-HG	1.6	●	●	●		●	●												—					—	—	—	—	—	—	—	—	—	—						—

正方形负型刀片

SN 正方形 负型 带孔



材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4～
按被削材分类的刀片材质选择要领 ☞A10～

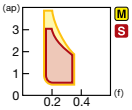
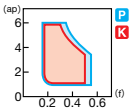
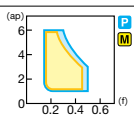
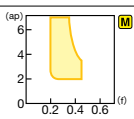
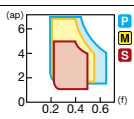
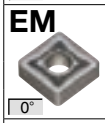
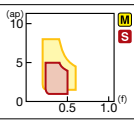
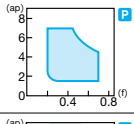
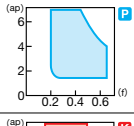
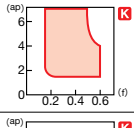
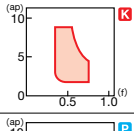
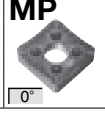
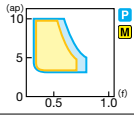
●：连续切削 第一推荐
○：连续切削 第二推荐
●：一般切削 第一推荐
○：一般切削 第二推荐
✖：断续切削 第一推荐
✖：断续切削 第二推荐

SN■■1906●●

尺寸 (mm)	切刃长度L	19.05	厚度S	6.35
	内切圆IC	19.05	孔径D1	7.94

适用外径刀杆 ☞C21～C24　适用内径刀杆 ☞E39、E40

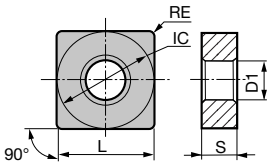
推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
	涂层																										涂层 金属陶瓷			金属陶瓷		硬质合金						
	CVD									PVD			CVD						PVD								PVD											
P 钢	●	○	●	✖	○	○	✪		○				○								✪		✪	●			●	✖	✪	●	●							
M 不锈钢				✪			✪	●	●	✖	○	○									✪		✪	●	✪													
K 铸铁			✪			✪							●	●	✖	○	○			✪		✪		●						●								
N 非铁金属																																						●
S 难削材																			●	●	✖	○	✪	✪														
H 高硬度材																		●																				

	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
轻～中切削	EX 16°		SNMG 190612N-EX	1.2																			●	●	●	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
中切削	UX 0°		SNMG 190612N-UX	1.2	●	●	●	●	●	●	●											—						—	—	—	—	—	—	—	—	—	—	—	—	—	—
			190616N-UX	1.6	●	●	●	●	●	●	●											—						—	—	—	—	—	—	—	—	—	—	—	—	—	—
	UG 4°		SNMG 190612N-UG	1.2				●			●											—						—	—	—	—	—	—	—	—	—	—	—	—	—	—
			190616N-UG	1.6				●			●											—						—	—	—	—	—	—	—	—	—	—	—	—	—	—
	EG 0°		SNMG 190612N-EG	1.2	●	●	●	●				●	●	●		●						—	●	●	●	●	●	—	—	—	—	—	—	—	—	—	—	—	●	●	—
			190616N-EG	1.6	●	●	●	●				●	●	●		●						—	●	●	●	●	●	—	—	—	—	—	—	—	—	—	—	—	●	●	—
			SNMA 190612	1.2													●	●	●	▲	▲	—						—	—	—	—	—	—	—	—	—	—	—	—	—	—
			190616	1.6													●	●	●	▲	▲	—						—	—	—	—	—	—	—	—	—	—	—	—	—	—
中～粗切削	MU 4°		SNMG 190612N-MU	1.2	●	●	●	●	●	●	●		●	●		●						—	●	●	●	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			190616N-MU	1.6	●	●	●	●	●	●	●		●	●		●						—	●	●	●	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			190624N-MU	2.4	●	●	●	●	●	●	●											—	●	●	●	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	EM  0°		SNMG 190612N-EM	1.2	●	●	●	●				●	●	●								—	●	●	●			—	—	—	—	—	—	—	—	—	—	—	—	—	—
			190616N-EM	1.6	●	●	●	●				●	●	●								—	●	●	●			—	—	—	—	—	—	—	—	—	—	—	—	—	—
			190624N-EM	2.4	●	●	●	●				●	●	●								—	●	●	●			—	—	—	—	—	—	—	—	—	—	—	—	—	—
	ME 4°		SNMG 190612N-ME	1.2	●	●	●	●	●	●	●						●	●				—						—	—	—	—	—	—	—	—	—	—	—	—	—	—
			190616N-ME	1.6	●	●	●	●	●	●	●						●	●				—						—	—	—	—	—	—	—	—	—	—	—	—	—	—
			190624N-ME	2.4	●	●	●	●	●	●	●						●	●				—						—	—	—	—	—	—	—	—	—	—	—	—	—	—
	MX -15°		SNMG 190612N-MX	1.2		●	●	●		●	●											—						—	—	—	—	—	—	—	—	—	—	—	—	—	—
			190616N-MX	1.6		●	●	●		●	●											—						—	—	—	—	—	—	—	—	—	—	—	—	—	—
	UZ 4°		SNMG 190608N-UZ	0.8																		—						—	—	—	—	—	—	—	—	—	—	—	—	—	—
			190612N-UZ	1.2			●	●		●	●						●	●	●	▲	▲	—						—	—	—	—	—	—	—	—	—	●	—	—	—	—
			190616N-UZ	1.6			●	●		●	●						●	●	●	▲	▲	—						—	—	—	—	—	—	—	—	—	—	—	—	—	—
	GZ 0°		SNMG 190612N-GZ	1.2													●	●	●	▲	▲	—						—	—	—	—	—	—	—	—	—	—	—	—	—	—
			190616N-GZ	1.6													●	●	●	▲	▲	—						—	—	—	—	—	—	—	—	—	—	—	—	—	—
重切削	MP  0°		SNMM 190612N-MP	1.2	●	●	●	●	●	●	●	●	●	●		●						—	●	●	●	●		—	—	—	—	—	—	—	—	—	—	—	—	—	—
			190616N-MP	1.6	●	●	●	●	●	●	●	●	●	●		●						—	●	●	●	●		—	—	—	—	—	—	—	—	—	—	—	—	—	—

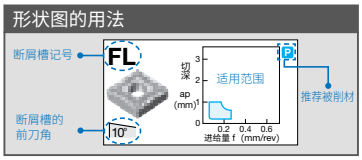
▲记号：计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

正方形负型刀片

SN 正方形 负型 带孔



形状图的用法



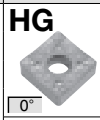
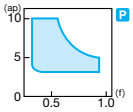
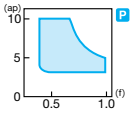
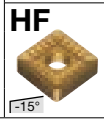
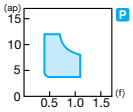
●：连续切削 第一推荐　○：连续切削 第二推荐　◕：一般切削 第一推荐　◔：一般切削 第二推荐　✖：断续切削 第一推荐　✪：断续切削 第二推荐

SN■■1906●●

尺寸 (mm)	切刃长度L	19.05	厚度S	6.35
	内切圆IC	19.05	孔径D1	7.94

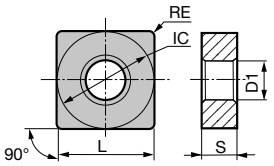
适用外径刀杆 ☞C21～C24　适用内径刀杆 ☞E39、E40

推荐用途	涂层 CVD									P/D		CVD					PVD								涂层 金属陶瓷 PVD			金属陶瓷		硬质合金					
	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◕	✖	○	◔	✪		◔											✪		✪	◕			◕	✖	✪	●	◕							
M 不锈钢				✪			✪	●	◕	✖	○	◔								✪		✪	◕	✪													
K 铸铁			✪			✪							●	◕	✖	○	◔			✪		✪		◕						●							
N 非铁金属																																					◕
S 难削材																			●	◕	✖	◔	✪	✪													
H 高硬度材																		●																			

	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
重切削	HG  0°		SNMM 190612N-HG	1.2	●	●	●	●	●	●	●					●						—						—		—	—	—	—	—	—	—							—
			190616N-HG	1.6	●	●	●	●	●	●	●					●						—						—		—	—	—	—	—	—	—							—
			190624N-HG	2.4	●	●	●	●		●	●					●						—						—		—	—	—	—	—	—	—							—
	HP 0°		SNMM 190612N-HP	1.2			●	●		●	●					●						—						—		—	—	—	—	—	—	—							—
			190616N-HP	1.6			●	●		●	●					●						—						—		—	—	—	—	—	—	—							—
	HF  -15°		SNMM 190616N-HF	1.6			●	●		●	●											—						—		—	—	—	—	—	—	—							—
			190624N-HF	2.4			●	●		●	●											—						—		—	—	—	—	—	—	—							—

正方形负型刀片

SN 正方形 负型 带孔



材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4～
按被削材分类的刀片材质选择要领 ☞A10～

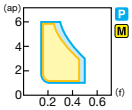
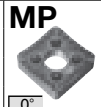
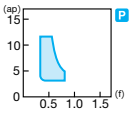
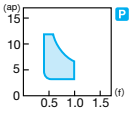
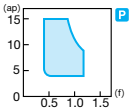
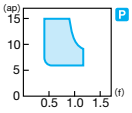
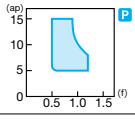
●：连续切削 第一推荐
○：连续切削 第二推荐
◕：一般切削 第一推荐
◔：一般切削 第二推荐
✖：断续切削 第一推荐
✪：断续切削 第二推荐

SN■■2507●●

尺寸 (mm)	切刃长度L	25.4	厚度S	7.94
	内切圆IC	25.4	孔径D1	9.12

适用外径刀杆 ☞C21、C22、C24

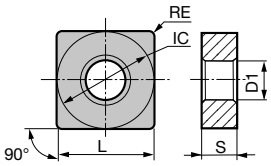
推荐用途	涂层 CVD									PVD			CVD					PVD								涂层 金属陶瓷 PVD			金属陶瓷		硬质合金					
	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◕	✖	○	◔	✪		◔			◔									✪		✪	◕			◕	✖	✪	●	◕							
M 不锈钢				✪			✪	●	◕	✖	○	◔									✪		✪	◕	✪												
K 铸铁			✪			✪							●	◕	✖	○	◔			✪		✪		◕						●							
N 非铁金属																																					◕
S 难削材																			●	◕	✖	◔	✪	✪													
H 高硬度材																		●																			

	形状	适用范围	型 号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
中切削	UG 4°		SNMG 250724N-UG	2.4																		—									—	—	—	—	—							—
重切削	MP  0°		SNMM 250724N-MP	2.4	●	●	●	●	●	●	●		●			●						—									—	—	—	—	—							—
	HP 0°		SNMM 250724N-HP	2.4	●	●	●	●	●	●	●					●						—									—	—	—	—	—							—
	HU -15°		SNMM 250724N-HU	2.4	●	●	●		●	●						●						—									—	—	—	—	—							—
	HW -15°		SNMM 250724N-HW	2.4	●	●	●		●	●						●						—									—	—	—	—	—							—
	HF -15°		SNMM 250724N-HF	2.4			●	●		●	●					●						—									—	—	—	—	—							—
			250732N-HF	3.2			●	●		●	●											—									—	—	—	—	—							—

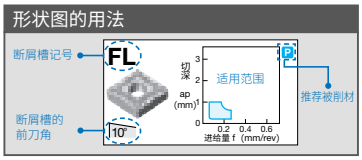
正方形负型刀片

机夹式刀片

SN 正方形 负型 带孔



形状图的用法



●：连续切削 第一推荐
○：连续切削 第二推荐
◕：一般切削 第一推荐
◔：一般切削 第二推荐
✖：断续切削 第一推荐
✪：断续切削 第二推荐

SN■■2509●●

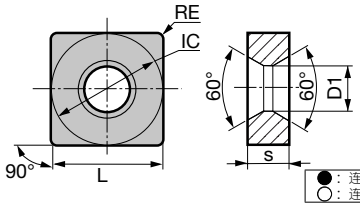
尺寸 (mm)				
	切刃长度L	25.4	厚度S	9.52
	内切圆IC	25.4	孔径D1	9.12

适用外径刀杆 ☞C21、C22

| 推荐用途 | 涂层 | | | |

正方形负型刀片

SN 正方形 负型 带孔



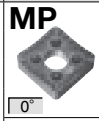
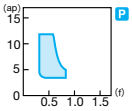
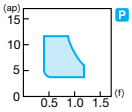
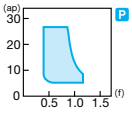
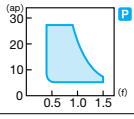
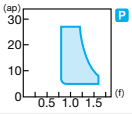
材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4～
按被削材分类的刀片材质选择要领 ☞A10～

●：连续切削 第一推荐
○：连续切削 第二推荐
●：一般切削 第一推荐
◐：一般切削 第二推荐
✖：断续切削 第一推荐
✖：断续切削 第二推荐

SN■■3109●●

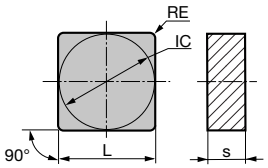
尺寸 (mm)	切刃长度L	31.75	厚度S	9.52
	内切圆IC	31.75	孔径D1	8.8

推荐用途	涂层 CVD									PVD		CVD						PVD									涂层 金属陶瓷 PVD			金属陶瓷		硬质合金						
	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◐	◐	✖	○	◐	✖		◐			◐									✖		✖	◐			◐	✖	✖	●	◐							
M 不锈钢				✖			✖														✖		✖	◐	✖													
K 铸铁			✖			✖		●	◐	✖	○	◐		●	◐	✖	○	◐			✖		✖	◐						●								
N 非铁金属																																						◐
S 难削材																			●	◐	✖	◐	✖	✖														
H 高硬度材																		●																				

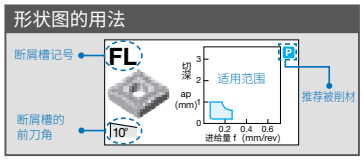
	形状	适用范围	型 号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
重切削	MP  0°		SNMM 310924N-MP	2.4	●	●	●		●	●			●			●						—								—	—	—	—	—	—			●				—
	HP 0°		SNMM 310924N-HP	2.4	●	●	●		●	●						●						—								—	—	—	—	—	—							—
	HU -15°		SNMM 310924N-HU	2.4	●	●	●		●	●						●						—								—	—	—	—	—	—							—
	HW -15°		SNMM 310924N-HW	2.4	●	●	●		●	●						●						—								—	—	—	—	—	—							—
	HF -15°		SNMM 310924N-HF	2.4			●	●		●	●											—								—	—	—	—	—	—							—

正方形负型刀片

SN 正方形 负型 无孔



形状图的用法



●：连续切削 第一推荐　○：连续切削 第二推荐　◕：一般切削 第一推荐　◔：一般切削 第二推荐　✖：断续切削 第一推荐　✪：断续切削 第二推荐

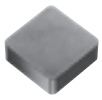
SN■■0903●●

尺寸 (mm)				
	切刃长度L	9.525	厚度S	3.18
	内切圆IC	9.525		

住友 CBN(CBN) 刀片☞L72、L73　适用外径刀杆 ☞L122

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◕	✖	○	◔	✪		◔				◔								✪		✪	◕			◕	✖	✪	●	◕							
M 不锈钢				✪			✪	●	◕	✖	○	◔									✪		✪	◕	✪													
K 铸铁			✪			✪							●	◕	✖	○	◔			✪		✪		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◔	✪	✪														
H 高硬度材																		●																				

	涂层																										涂层 金属陶瓷			金属陶瓷		硬质合金						
	CVD									PVD	CVD							PVD									PVD										

	形状	适用范围	型　号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
中切削			SNGN 090304	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			090308	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			090312	1.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—

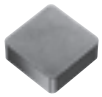
SN■■1203●●

尺寸 (mm)				
	切刃长度L	12.7	厚度S	3.18
	内切圆IC	12.7		

住友 CBN(CBN) 刀片☞L74　适用外径刀杆 ☞L122

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◕	✖	○	◔	✪		◔				◔								✪		✪	◕			◕	✖	✪	●	◕							
M 不锈钢				✪			✪	●	◕	✖	○	◔									✪		✪	◕	✪													
K 铸铁			✪			✪							●	◕	✖	○	◔			✪		✪		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◔	✪	✪														
H 高硬度材																		●																				

	涂层																										涂层 金属陶瓷			金属陶瓷		硬质合金						
	CVD									PVD	CVD							PVD									PVD										

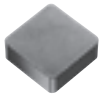
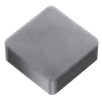
	形状	适用范围	型　号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
中切削			SNGN 120304	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			120308	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			120312	1.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—

SN■■1204●●

尺寸 (mm)				
	切刃长度L	12.7	厚度S	4.76
	内切圆IC	12.7		

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◕	✖	○	◔	✪		◔				◔								✪		✪	◕			◕	✖	✪	●	◕							
M 不锈钢				✪			✪	●	◕	✖	○	◔									✪		✪	◕	✪													
K 铸铁			✪			✪							●	◕	✖	○	◔			✪		✪		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◔	✪	✪														
H 高硬度材																		●																				

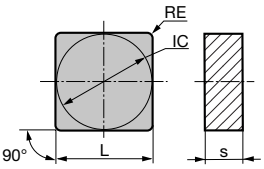
	涂层																										涂层 金属陶瓷			金属陶瓷		硬质合金						
	CVD									PVD	CVD							PVD									PVD										

	形状	适用范围	型　号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
中切削			SNMN 120404	0.4																		—	—	—	—	—	—	—	—	—	—	—	●	—	—	—	—	—	—	—	—
			120408	0.8													●	●	●	▲	▲	—	●	●	●	●	—	—	—	—	—	—	—	●	●	●	●	●	●	—	—
			120412	1.2													●	●	●	▲	▲	—	●	●	●	●	—	—	●	—	—	—	—	—	—	—	—	●	●	—	—
			120416	1.6													●	●	●	▲	▲	—	●	●	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			120420	2.0																		—	—	—	—	—	—	—	●	—	—	—	—	—	—	—	—	—	—	—	—
			120424	2.4																		—	—	—	—	—	—	—	●	—	—	—	—	—	—	—	—	—	—	—	—
			SNGN 120404	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			120408	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	—	●	—	—	—
			120412	1.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			120416	1.6	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—

▲记号：计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

正方形负型刀片

SN 正方形 负型 无孔



材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4～
按被削材分类的刀片材质选择要领 ☞A10～

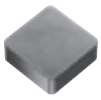
●：连续切削 第一推荐
○：连续切削 第二推荐
◕：一般切削 第一推荐
◔：一般切削 第二推荐
✖：断续切削 第一推荐
✪：断续切削 第二推荐

SN■■1207●●

尺寸 (mm)	切刃长度L	12.7	厚度S	7.94
	内切圆IC	12.7		

陶瓷刀片☞B128

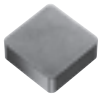
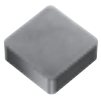
推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◕	✖	○	◔	✪		◔			◔									✪		✪	◕			◕	✖	✪	●	◕							
M 不锈钢				✪			✪	●	◕	✖	○	◔									✪		✪	◕	✪													
K 铸铁			✪			✪							●	◕	✖	○	◔			✪		✪		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◔	✪	✪														
H 高硬度材																		●																				

	形状	适用范围	型 号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
中切削			SNGN 120708	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			120712	1.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			120716	1.6	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			120720	2.0	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—

SN■■1504●●

尺寸 (mm)	切刃长度L	15.875	厚度S	4.76
	内切圆IC	15.875		

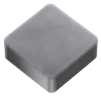
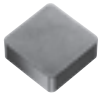
推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◕	✖	○	◔	✪		◔			◔									✪		✪	◕			◕	✖	✪	●	◕							
M 不锈钢				✪			✪	●	◕	✖	○	◔									✪		✪	◕	✪													
K 铸铁			✪			✪							●	◕	✖	○	◔			✪		✪		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◔	✪	✪														
H 高硬度材																		●																				

	形状	适用范围	型 号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
中切削			SNMN 150408	0.8																		—						—	—							●			●				
			150412	1.2																		—						—	—														
			SNGN 150408	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			150412	1.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			150416	1.6	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—

SN■■1904●●

尺寸 (mm)	切刃长度L	19.05	厚度S	4.76
	内切圆IC	19.05		

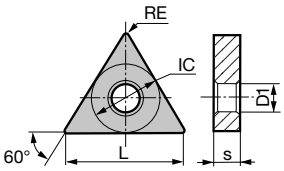
推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◕	✖	○	◔	✪		◔			◔									✪		✪	◕			◕	✖	✪	●	◕							
M 不锈钢				✪			✪	●	◕	✖	○	◔									✪		✪	◕	✪													
K 铸铁			✪			✪							●	◕	✖	○	◔			✪		✪		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◔	✪	✪														
H 高硬度材																		●																				

	形状	适用范围	型 号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
中切削			SNMN 190412	1.2																		—						—	—								●	●					
			SNGN 190402	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			190404	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			190408	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			190412	1.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			190416	1.6	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—

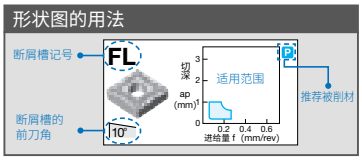
三角形负型刀片

机夹式刀片

TN 三角形 负型 带孔



形状图的用法

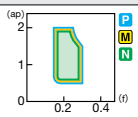


●：连续切削 第一推荐
○：连续切削 第二推荐
◕：一般切削 第一推荐
◔：一般切削 第二推荐
✖：断续切削 第一推荐
✖：断续切削 第二推荐

TN■■0902●●

尺寸 (mm)	切刃长度L	9.6	厚度S	2.38
	内切圆IC	5.56	孔径D1	2.57

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
	涂层																										涂层 金属陶瓷			金属陶瓷		硬质合金						
	CVD									PVD	CVD							PVD									PVD											
P 钢	●	◔	◕	✖	○	◔	✪		◔			◔									✪		✪	◕			◕	✖	✪	●	◕							
M 不锈钢				✪			✪	●	◕	✖	○	◔									✪		✪	◕	✪													
K 铸铁			✪			✪							●	◕	✖	○	◔			✪		✪		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◔	✪	✪														
H 高硬度材																		●																				

	形状	适用范围	型 号	刀尖半径 RE
轻切削	GX 15°		TNGG 090204R-GX	0.4
			090204L-GX	0.4
			090208R-GX	0.8
			090208L-GX	0.8

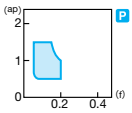
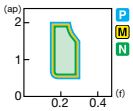
型号	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
TNGG 090204R-GX	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	●	—	—	●
090204L-GX	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
090208R-GX	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
090208L-GX	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—

TN■■1103●●

尺寸 (mm)	切刃长度L	11.0	厚度S	3.18
	内切圆IC	6.35	孔径D1	2.26

适用外径刀杆 ☞C32～C34

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
	涂层																										涂层 金属陶瓷			金属陶瓷		硬质合金						
	CVD									PVD	CVD							PVD									PVD											
P 钢	●	◔	◕	✖	○	◔	✪		◔			◔									✪		✪	◕			◕	✖	✪	●	◕							
M 不锈钢				✪			✪	●	◕	✖	○	◔									✪		✪	◕	✪													
K 铸铁			✪			✪							●	◕	✖	○	◔			✪		✪		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◔	✪	✪														
H 高硬度材																		●																				

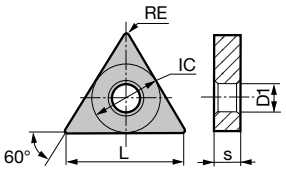
	形状	适用范围	型 号	刀尖半径 RE
精切削	FT 0°		TNGG 110302R-FT	0.2
			110302L-FT	0.2
			110304R-FT	0.4
			110304L-FT	0.4
			110308R-FT	0.8
			110308L-FT	0.8
轻切削	GX 15°		TNGG 110302R-GX	0.2
			110302L-GX	0.2
			110304R-GX	0.4
			110304L-GX	0.4
			110308R-GX	0.8
			110308L-GX	0.8
中切削			TNMA 110304	0.4
			110308	0.8
			TNGA 110302	0.2
			110304	0.4
			110308	0.8

型号	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
TNGG 110302R-FT	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	●	—	—	—	—	—	—
110302L-FT	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	—	—	—	—	—
110304R-FT	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	●	●	—	—	—	—	—
110304L-FT	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	—	—	—	—	—
110308R-FT	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
110308L-FT	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
TNGG 110302R-GX	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
110302L-GX	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
110304R-GX	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	—	—
110304L-GX	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	—	—
110308R-GX	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
110308L-GX	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
TNMA 110304																		—						—		—	—	—	—	—	—							—
110308																		—						—		—	—	—	—	—	—							—
TNGA 110302	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—				●			
110304	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—				●			●
110308	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—				●			

三角形负型刀片

机夹式刀片

TN 三角形 负型 带孔



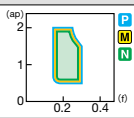
材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4～
按被削材分类的刀片材质选择要领 ☞A10～

●：连续切削 第一推荐　○：连续切削 第二推荐　●：一般切削 第一推荐　○：一般切削 第二推荐　✖：断续切削 第一推荐　✖：断续切削 第二推荐

TN■■11T2●●

尺寸 (mm)	切刃长度L	11.0	厚度S	2.78
	内切圆IC	6.35	孔径D1	2.76

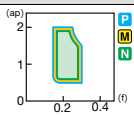
推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	○	●	✖	○	○	✪		○			○									✪		✪	●			●	✖	✪	●	●							
M 不锈钢				✪			✪	●	●	✖	○	○									✪		✪	●	✪													
K 铸铁			✪			✪							●	●	✖	○	○			✪		✪		●						●								
N 非铁金属																																						●
S 难削材																			●	●	✖	○	✪	✪														
H 高硬度材																		●																				

	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
轻切削	GX 15°		TNGG 11T204R-GX	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	—	—	—
			11T204L-GX	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	●	—	—	●
			11T208R-GX	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	—	—
			11T208L-GX	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	●	—	—	—
中切削			TNGA 11T204	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●

TN■■1303●●

尺寸 (mm)	切刃长度L	13.7	厚度S	3.18
	内切圆IC	7.94	孔径D1	3.15

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	○	●	✖	○	○	✪		○			○									✪		✪	●			●	✖	✪	●	●							
M 不锈钢				✪			✪	●	●	✖	○	○									✪		✪	●	✪													
K 铸铁			✪			✪							●	●	✖	○	○			✪		✪		●						●								
N 非铁金属																																						●
S 难削材																			●	●	✖	○	✪	✪														
H 高硬度材																		●																				

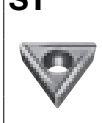
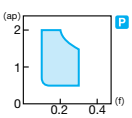
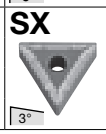
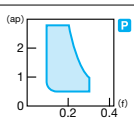
	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
轻切削	GX 15°		TNGG 130304R-GX	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	—	—
			130304L-GX	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	—	—	●
			130308R-GX	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	●	—	—	—
			130308L-GX	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	●	—	—	●

TN■■1603●●

尺寸 (mm)	切刃长度L	16.5	厚度S	3.18
	内切圆IC	9.525	孔径D1	3.81

适用外径刀杆 ☞C32～C34

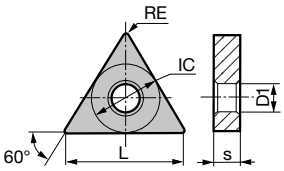
推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	○	●	✖	○	○	✪		○			○									✪		✪	●			●	✖	✪	●	●							
M 不锈钢				✪			✪	●	●	✖	○	○									✪		✪	●	✪													
K 铸铁			✪			✪							●	●	✖	○	○			✪		✪		●						●								
N 非铁金属																																						●
S 难削材																			●	●	✖	○	✪	✪														
H 高硬度材																		●																				

	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
轻切削	ST  0°		TNGG 160302R-ST	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●								
			160302L-ST	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●								
			160304R-ST	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●		●						
			160304L-ST	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	●							
			160308R-ST	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●								
			160308L-ST	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●								
轻～中切削	SX  3°		TNMG 160304N-SX	0.4	●	●	●			●												—						—		—												
			160308N-SX	0.8	●	●	●	●		●	●											—						—		—													

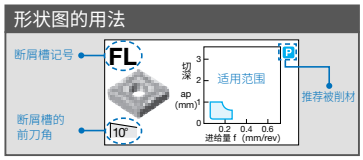
三角形负型刀片

机夹式刀片

TN 三角形 负型 带孔



形状图的用法



●：连续切削 第一推荐
○：连续切削 第二推荐
◕：一般切削 第一推荐
◔：一般切削 第二推荐
✖：断续切削 第一推荐
✪：断续切削 第二推荐

TN■■1603●●

尺寸 (mm)	切刃长度L	16.5	厚度S	3.18
	内切圆IC	9.525	孔径D1	3.81

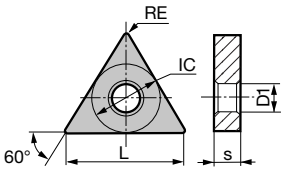
适用外径刀杆 ☞C32～C34

| 推荐用途 | | 涂层 | | |

三角形负型刀片

机夹式刀片

TN 三角形 负型 带孔



材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4～
按被削材分类的刀片材质选择要领 ☞A10～

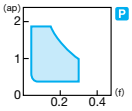
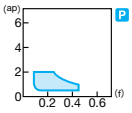
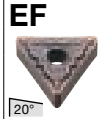
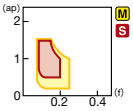
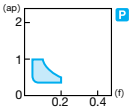
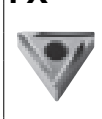
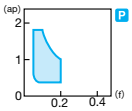
●：连续切削 第一推荐　○：连续切削 第二推荐　◐：一般切削 第一推荐　◔：一般切削 第二推荐　✖：断续切削 第一推荐　✪：断续切削 第二推荐

TN■■1604●●

尺寸 (mm)	切刃长度L	16.5	厚度S	4.76
	内切圆IC	9.525	孔径D1	3.81

住友 CBN(CBN) 刀片☞L80～　住友金刚石 (PCD) 刀片☞M16
陶瓷刀片☞B128
适用外径刀杆 ☞C29～C35、D16、D20　适用内径刀杆 ☞E15、E47～E49

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◐	✖	○	◔	✪		◔				◔								✪		✪	◐			◐	✖	✪	●	◐							
M 不锈钢			✪				✪	●	◐	✖	○	◔									✪		✪	◐	✪													
K 铸铁				✪			✪						●	◐	✖	○	◔			✪		✪		◐						●								
N 非铁金属																																						◐
S 难削材																			●	◐	✖	◔	✪	✪														
H 高硬度材																		●																				

	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
					涂层																									涂层 金属陶瓷			金属陶瓷		硬质合金							
					CVD									PVD	CVD								PVD								PVD											
精切削	SU 13°		TNGG 160402N-SU	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	●	●	●				●	●	▲	●	●							
			160404N-SU	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	●	●	●				●	●	▲	●	●							
			160408N-SU	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	●	●	●				●	●	▲	●	●							
	SE 5°		TNMG 160404N-SE	0.4	●	●	●	●	●	●	●											—						—	—	—	●	●		●	●							
			160408N-SE	0.8	●	●	●	●	●	●	●											—						—	—	—	●	●		●	●							
			160412N-SE	1.2	●	●	●	●	●	●	●											—						—	—	—	—	—		—	—							—
	EF  20°		TNMG 160404N-EF	0.4	●	●	●	●				●	●	●		●						—	●	●	●	●	●	—	—	—	—	—	—	—	—	—				●	●	—
			160408N-EF	0.8	●	●	●	●				●	●	●		●						—	●	●	●	●	●	—	—	—	—	—	—	—	—	—				●	●	—
	FY 15°		TNGG 160401R-FY	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—									●			●	●	—	—	—	—	—	—	—
			160401L-FY	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—									●			●	●	—	—	—	—	—	—	—
			160402R-FY	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—		●	●		●	●	●	●	●	●	▲	●	●							
			160402L-FY	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—		●	●		●	●	●	●	●	●	▲	●	●							
			160404R-FY	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—		●	●		●	●	●	●	●	●	▲	●	●							
			160404L-FY	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—		●	●		●	●	●	●	●	●	▲	●	●							
			160408R-FY	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—							●	●		●			●	●							
			160408L-FY	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—							●	●		●			●	●							
			160412R-FY	1.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—										●				●	—	—	—	—	—	—	—
			160412L-FY	1.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—										●				●	—	—	—	—	—	—	—
	FX  14°		TNGG 160402R-FX	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—		●	●		●	●	●	●	●	●	▲	●	●							
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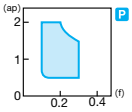
轻切削	ST 0°		TNGG 160402R-ST	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—												●	●							
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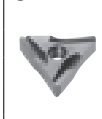
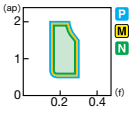
	GX  15°		TNGG 160404R-GX	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—														●		●				
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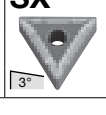
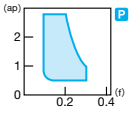
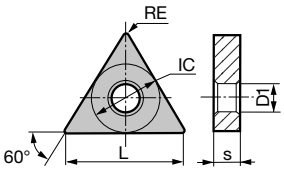
轻～中切削	SX  3°		TNMG 160404N-SX	0.4	●	●	●	●	●	●	●											—						—	—	—	●	●	▲		●							
			160408N-SX	0.8	●	●	●	●	●	●	●											—						—	—	—	●	●	▲		●							
			160412N-SX	1.2																		—						—	—	—	—	—	—	—	—							—
			160416N-SX	1.6																		—						—	—	—	—	—	—	—	—							—

▲记号：计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

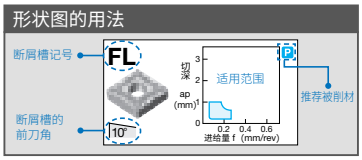
三角形负型刀片

机夹式刀片

TN 三角形 负型 带孔



形状图的用法



●：连续切削 第一推荐
○：连续切削 第二推荐
◕：一般切削 第一推荐
◔：一般切削 第二推荐
✖：断续切削 第一推荐
✪：断续切削 第二推荐

TN■■1604●●

尺寸 (mm)	切刃长度L	16.5	厚度S	4.76
	内切圆IC	9.525	孔径D1	3.81

住友CBN(CBN)刀片☞L80～ 住友金刚石(PCD)刀片☞M16 陶瓷刀片☞B128
适用外径刀杆 ☞C29～C35、D16、D20 适用内径刀杆 ☞E15、E47～E49

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◕	✖	○	◔	✪			◔											✪		✪	◕			◕	✖	✪	●	◕							
M 不锈钢				✪			✪	●	◕	✖	○	◔									✪		✪	◕	✪													
K 铸铁			✪			✪							●	◕	✖	○	◔			✪		✪		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◔	✪	✪														
H 高硬度材																		●																				

	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
轻～中切削	EX 16°	(ap) 3 2 1 0 0.2 0.4 (f) M S	TNMG 160404N-EX	0.4								●	●	●	▲	●						—	●	●	●	●	●	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—
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			160416	1.6													●	●	●	▲	▲	—						—		—												
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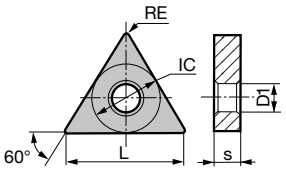
▲记号：计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

三角形负型刀片

机夹式刀片

TN 三角形 负型 带孔



材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4～
按被削材分类的刀片材质选择要领 ☞A10～

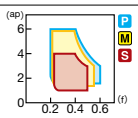
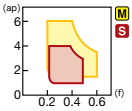
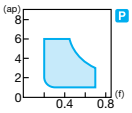
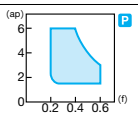
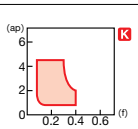
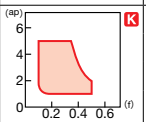
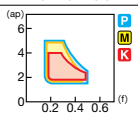
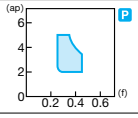
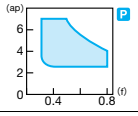
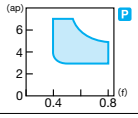
●：连续切削 第一推荐　○：连续切削 第二推荐
◐：一般切削 第一推荐　◔：一般切削 第二推荐
✖：断续切削 第一推荐　✪：断续切削 第二推荐

TN■■1604●●

尺寸 (mm)	切刃长度L	16.5	厚度S	4.76
	内切圆IC	9.525	孔径D1	3.81

住友CBN(CBN)刀片☞L80～　住友金刚石(PCD)刀片☞M16　陶瓷刀片☞B128
适用外径刀杆 ☞C29～C35、D16、D20　适用内径刀杆 ☞E15、E47～E49

推荐用途	涂层 CVD									PVD															涂层金属陶瓷 PVD			金属陶瓷		硬质合金					
	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◐	◔	✖	○	◐	✪		◐			◐									✪		✪	◔			◔	✖	✪	●	◔							
M 不锈钢			✪			✪		●	◔	✖	○	◐									✪		✪	◔	✪												
K 铸铁			✪			✪							●	◔	✖	○	◐			✪		✪		◔						●							
N 非铁金属																																					◔
S 难削材																			●	◔	✖	◐	✪	✪													
H 高硬度材																		●																			

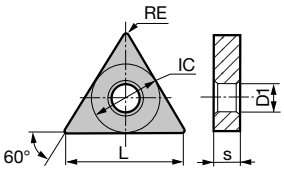
	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
中切削			TNGA 160402	0.2																		●																				
			160404	0.4																		●		●	●	●								●					●			●
			160408	0.8																		●												●	●				●			●
			160412	1.2																																		●			
			160416	1.6																																					
中～粗切削	MU 4° 		TNMG 160408N-MU	0.8	●	●	●	●	●	●	●		●	●		●						—	●	●	●	●	●	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—
			160412N-MU	1.2	●	●	●	●	●	●	●		●	●		●						—	●	●	●	●	●	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—
	EM 0° 		TNMG 160408N-EM	0.8	●	●	●	●				●	●	●								—	●	●	●			—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			160412N-EM	1.2	●	●	●	●				●	●	●								—	●	●	●			—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	ME 4° 		TNMG 160408N-ME	0.8	●	●	●	●	●	●	●						●	●				—						—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			160412N-ME	1.2	●	●	●	●	●	●	●						●	●				—						—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	MX -15° 		TNMG 160408N-MX	0.8		●	●	●		●	●											—						—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			160412N-MX	1.2		●	●	●		●	●											—						—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	UZ 4° 		TNMG 160404N-UZ	0.4			●			●							●	●	●	▲	▲	—						—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			160408N-UZ	0.8			●	●		●	●						●	●	●	▲	▲	—						—	—	—	—	—	—	—	—	—	—	●	—	—	—	—
			160412N-UZ	1.2			●	●		●	●						●	●	●	▲	▲	—						—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			160416N-UZ	1.6			●			●							●	●	●	▲	▲	—						—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			160420N-UZ	2.0			●			●							●	●	●	▲	▲	—						—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	GZ 0° 		TNMG 160404N-GZ	0.4						●							●	●	●	▲	▲	—						—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			160408N-GZ	0.8						●							●	●	●	▲	▲	—						—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			160412N-GZ	1.2						●							●	●	●	▲	▲	—						—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	HM 15° 		TNMG 160404R-HM	0.4	●	●	●	●	●	●	●	●	●	●		●						—	●	●	●	●		—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			160404L-HM	0.4	●	●	●	●	●	●	●	●	●	●		●						—	●	●	●	●		—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			160408R-HM	0.8	●	●	●	●	●	●	●	●	●	●		●						—	●	●	●	●		—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			160408L-HM	0.8	●	●	●	●	●	●	●	●	●	●		●						—	●	●	●	●		—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	MM 10° 		TNGG 160404R-MM	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—																					
			160404L-MM	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—																					
			160408R-MM	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—																					
			160408L-MM	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—																					
重切削	MP 0° 		TNMM 160404N-MP	0.4			●			●												—						—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			160408N-MP	0.8			●	●	●	●	●											—						—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			160412N-MP	1.2			●	●	●	●	●											—						—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			160416N-MP	1.6																		—						—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	HP 0° 		TNMM 160408N-HP	0.8			●	●		●	●											—						—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			160412N-HP	1.2			●	●		●	●											—						—	—	—	—	—	—	—	—	—	—	—	—	—	—	—

▲记号：计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

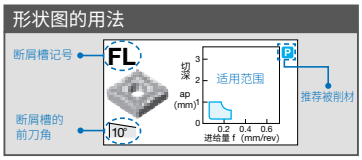
三角形负型刀片

机夹式刀片

TN 三角形 负型 带孔



形状图的用法



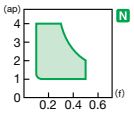
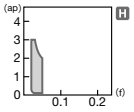
●：连续切削 第一推荐
○：连续切削 第二推荐
：一般切削 第一推荐
：一般切削 第二推荐
：断续切削 第一推荐
：断续切削 第二推荐

TN■■1604●●

尺寸 (mm)	切刃长度L	16.5	厚度S	4.76
	内切圆IC	9.525	孔径D1	3.81

住友CBN(CBN)刀片☞L80～ 住友金刚石(PCD)刀片☞M16 陶瓷刀片☞B128
适用外径刀杆 ☞C29～C35、D16、D20 适用内径刀杆 ☞E15、E47～E49

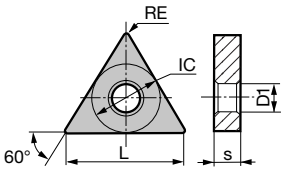
推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◕	✖	○	◔	✿		◔			◔									✿		✿	◕		◕	✖	✿	●	◕							
M 不锈钢				✿			✿	●	◕	✖	○	◔									✿		✿	◕	✿												
K 铸铁			✿			✿							●	◕	✖	○	◔			✿		✿		◕						●							
N 非铁金属																																					◕
S 难削材																			●	◕	✖	◔	✿	✿													
H 高硬度材																		●																			
	涂层																									涂层金属陶瓷				金属陶瓷		硬质合金					
	CVD									PVD	CVD							PVD								PVD											

	形状	适用范围	型 号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
铝材用	**AX** 30°		TNGG 160402R-AX	0.2																																						●
			160402L-AX	0.2																																						●
			TNGG 160404R-AX	0.4																																						●
			160404L-AX	0.4																																						●
			TNGG 160408R-AX	0.8																																						●
			160408L-AX	0.8																																						●
淬火钢轻切削	**GH** 3°		TNGG 160402N-GH	0.2																		●																			
			160404N-GH	0.4																		●																			
			160408N-GH	0.8																		●																			

三角形负型刀片

机夹式刀片

TN 三角形 负型 带孔



材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4～
按被削材分类的刀片材质选择要领 ☞A10～

●：连续切削 第一推荐
○：连续切削 第二推荐
◕：一般切削 第一推荐
◔：一般切削 第二推荐
✖：断续切削 第一推荐
✪：断续切削 第二推荐

TN■■2204●●

尺寸(mm)	切刃长度L	22.0	厚度S	4.76
	内切圆IC	12.7	孔径D1	5.16

住友CBN(CBN)刀片☞L85
适用外径刀杆 ☞C30～C35
适用内径刀杆 ☞E48、E49

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
	涂层																										涂层金属陶瓷			金属陶瓷		硬质合金						
	CVD								PVD		CVD							PVD									PVD											
P 钢	●	◔	◕	✖	○	◔	✪		◔				◔								✪		✪	◕			◕	✖	✪	●	◕							
M 不锈钢			✪				✪	●	◕	✖	○	◔									✪		✪	◕	✪													
K 铸铁			✪			✪							●	◕	✖	○	◔			✪		✪		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◔	✪	✪														
H 高硬度材																		●																				

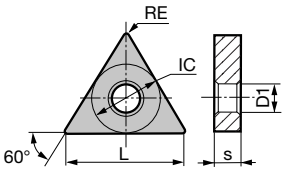
	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
精切削	SE 5°	(ap) 6 4 2 0 0.2 0.4 0.6 (f) P	TNMG 220404N-SE	0.4	●	●	●	●	●	●	●																															
			220408N-SE	0.8	●	●	●	●	●	●	●																															
			220412N-SE	1.2	●	●	●	●	●	●	●																															
轻切削	GX 15°	(ap) 2 1 0 0.2 0.4 (f) P M N	TNGG 220408R-GX	0.8																																		●				
			220408L-GX	0.8																																		●				
轻～中切削	SX 3°	(ap) 2 1 0 0.2 0.4 (f) P	TNMG 220404N-SX	0.4	●	●	●	●		●	●																															
			220408N-SX	0.8	●	●	●	●		●	●																															
			220412N-SX	1.2	●	●	●	●		●	●																															
	UP 10°	(ap) 4 3 2 1 0 0.2 0.4 0.6 (f) M S	TNMG 220408N-UP	0.8						●	●												●	●	●	●	●											●				
			220412N-UP	1.2						●	●																															
中切削	GU 7°	(ap) 6 4 2 0 0.2 0.4 0.6 (f) P M	TNMG 220404N-GU	0.4			●			●							●	●																								
			220408N-GU	0.8	●	●	●	●	●	●	●						●	●																								
			220412N-GU	1.2	●	●	●	●	●	●	●						●	●																								
	GE 3°	(ap) 6 4 2 0 0.2 0.4 0.6 (f) P	TNMG 220408N-GE	0.8	●	●	●	●	●	●	●																															
			220412N-GE	1.2	●	●	●	●	●	●	●																															
	UX 0°	(ap) 6 4 2 0 0.2 0.4 0.6 (f) P K	TNMG 220408N-UX	0.8	●	●	●	●	●	●	●																															
			220412N-UX	1.2	●	●	●	●	●	●	●																															
	UG 4°	(ap) 6 4 2 0 0.2 0.4 0.6 (f) P M	TNMG 220408N-UG	0.8			●	●		●	●																															
			220412N-UG	1.2			●	●		●	●																															
			220416N-UG	1.6																																						
	UM 0°	(ap) 4 3 2 1 0 0.2 0.4 0.6 (f) P M K	TNMG 220404R-UM	0.4																														●								
			220404L-UM	0.4																														●								
			220408R-UM	0.8																														●								
			220408L-UM	0.8																														●								
	UM 0°	(ap) 4 3 2 1 0 0.2 0.4 0.6 (f) P	TNGG 220404R-UM	0.4																													●	●	●	●		●				
			220404L-UM	0.4																													●	●	●	●		●				
			220408R-UM	0.8																													●	●		●		●				
			220408L-UM	0.8																													●	●		●		●				
			TNMA 220404	0.4																																						
			220408	0.8													●	●	●	▲	▲																	●				
			220412	1.2													●	●	●	▲	▲																	●				
			220416	1.6													●	●	●	▲	▲																					
			220420	2.0																																						

▲记号：计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

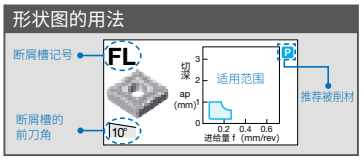
三角形负型刀片

机夹式刀片

TN 三角形 负型 带孔



形状图的用法



●：连续切削 第一推荐
○：连续切削 第二推荐
◐：一般切削 第一推荐
◔：一般切削 第二推荐
✖：断续切削 第一推荐
✖：断续切削 第二推荐

TN■■2204●●

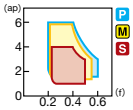
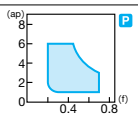
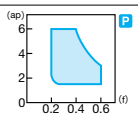
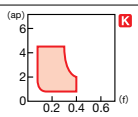
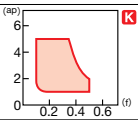
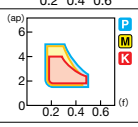
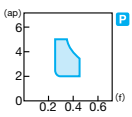
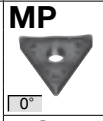
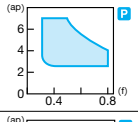
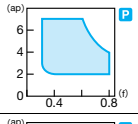
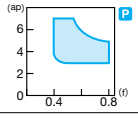
尺寸 (mm)	切刃长度L	22.0	厚度S	4.76
	内切圆IC	12.7	孔径D1	5.16

住友CBN(CBN)刀片☞L85

适用外径刀杆 ☞C30～C35

适用内径刀杆 ☞E48、E49

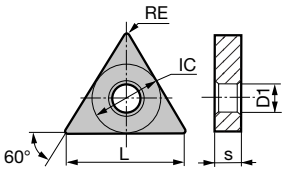
推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◐	✖	○	◔	✿		◔			◔									✿		✿	◐			◐	✖	✿	●	◐							
M 不锈钢				✿			✿	●	◐	✖	○	◔									✿		✿	◐	✿													
K 铸铁			✿			✿							●	◐	✖	○	◔			✿		✿		◐						●								
N 非铁金属																																					◐
S 难削材																		●	◐	✖	◔	✿	✿														
H 高硬度材																		●																			

					刀尖半径 RE	涂层 CVD								PVD	CVD						PVD								涂层金属陶瓷 PVD				金属陶瓷		硬质合金					
	形状		适用范围	型 号		AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
中切削				TNGA 220404	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	—	—
				220408	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	—	●
				220412	1.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
				220416	1.6	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
中～粗切削	MU 4°			TNMG 220408N-MU	0.8	●	●	●	●	●	●	●	—	—	—	—	—	—	—	—	—	—	—	●	●	●	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
				220412N-MU	1.2	●	●	●	●	●	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
				220416N-MU	1.6	●	●	●	●	●	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	ME 4°			TNMG 220408N-ME	0.8	●	●	●	●	●	●	●	—	—	—	—	—	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
				220412N-ME	1.2	●	●	●	●	●	●	●	—	—	—	—	—	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
				220416N-ME	1.6	●	●	●	●	●	●	●	—	—	—	—	—	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	MX -15°			TNMG 220408N-MX	0.8	—	●	●	●	—	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
				220412N-MX	1.2	—	●	●	●	—	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	UZ 4°			TNMG 220408N-UZ	0.8	—	—	●	●	—	●	●	—	—	—	—	—	●	●	●	▲	▲	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	—
				220412N-UZ	1.2	—	—	●	●	—	●	●	—	—	—	—	—	●	●	●	▲	▲	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	—	—	—
				220416N-UZ	1.6	—	—	●	●	—	●	●	—	—	—	—	—	●	●	●	▲	▲	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
				220420N-UZ	2.0	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	GZ 0°			TNMG 220408N-GZ	0.8	—	—	—	—	—	—	—	—	—	—	—	—	●	●	●	▲	▲	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
				220412N-GZ	1.2	—	—	—	—	—	—	—	—	—	—	—	—	●	●	●	▲	▲	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
				220416N-GZ	1.6	—	—	—	—	—	—	—	—	—	—	—	—	●	●	●	▲	▲	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	HM 15°			TNMG 220404R-HM	0.4	●	●	●	●	●	●	●	—	—	—	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
				220404L-HM	0.4	●	●	●	●	●	●	●	—	—	—	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
				220408R-HM	0.8	●	●	●	●	●	●	●	—	—	—	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
				220408L-HM	0.8	●	●	●	●	●	●	●	—	—	—	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	MM 0°			TNGG 220404R-MM	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
				220404L-MM	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
				220408R-MM	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	—	—
				220408L-MM	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	—	—
				220412R-MM	1.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
				220412L-MM	1.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
				220416R-MM	1.6	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
				220416L-MM	1.6	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
重切削	MP  0°			TNMM 220408N-MP	0.8	—	—	●	●	●	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
				220412N-MP	1.2	—	—	●	●	●	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
				220416N-MP	1.6	—	—	●	●	●	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	HG 0°			TNMM 220408N-HG	0.8	—	—	●	●	●	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
				220412N-HG	1.2	—	—	●	●	●	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
				220416N-HG	1.6	—	—	●	●	●	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	HP 0°			TNMM 220408N-HP	0.8	—	—	●	●	—	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
				220412N-HP	1.2	—	—	●	●	—	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
				220416N-HP	1.6	—	—	●	—	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—

▲记号：计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

三角形负型刀片

TN 三角形 负型 带孔



材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4～
按被削材分类的刀片材质选择要领 ☞A10～

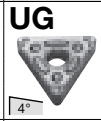
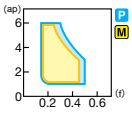
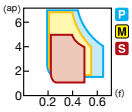
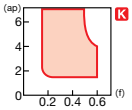
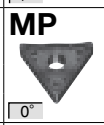
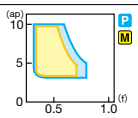
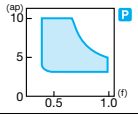
●：连续切削 第一推荐
○：连续切削 第二推荐
●：一般切削 第一推荐
○：一般切削 第二推荐
✖：断续切削 第一推荐
✪：断续切削 第二推荐

TN■■2706●●

尺寸 (mm)	切刃长度L	27.5	厚度S	6.35
	内切圆IC	15.875	孔径D1	6.35

适用外径刀杆 ☞C30、C31

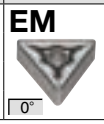
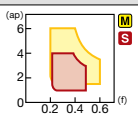
推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
	涂层																										涂层 金属陶瓷			金属陶瓷		硬质合金						
	CVD									PVD	CVD							PVD									PVD											
P 钢	●	○	◐	✖	○	○	✪		○				○								✪		✪	◐			◐	✖	✪	●	◐							
M 不锈钢			✪				✪	●	◐	✖	○	○									✪		✪	◐	✪													
K 铸铁			✪			✪							●	◐	✖	○	○			✪		✪		◐						●								
N 非铁金属																																						◐
S 难削材																			●	◐	✖	○	✪	✪														
H 高硬度材																		●																				

	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
中切削	UG 		TNMG 270608N-UG	0.8																																						
			TNMG 270612N-UG	1.2																																						
			TNMG 270616N-UG	1.6																																						
中～粗切削	MU		TNMG 270612N-MU	1.2			●	●		●	●																															
			TNMG 270616N-MU	1.6			●			●																																
	UZ		TNMG 270608N-UZ	0.8			●			●																																
			TNMG 270612N-UZ	1.2			●			●																																
			TNMG 270616N-UZ	1.6			●	●		●	●																															
粗～重切削	MP 		TNMM 270612N-MP	1.2			●			●																																
			TNMM 270616N-MP	1.6			●			●																																
重切削	HP		TNMM 270612N-HP	1.2			●	●		●	●																															
			TNMM 270616N-HP	1.6			●	●		●	●																															

TN■■3309●●

尺寸 (mm)	切刃长度L	33.0	厚度S	9.52
	内切圆IC	19.05	孔径D1	7.93

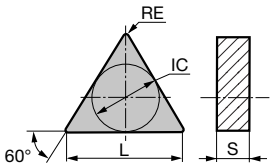
推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
	涂层																										涂层 金属陶瓷			金属陶瓷		硬质合金						
	CVD									PVD	CVD							PVD									PVD											
P 钢	●	○	◐	✖	○	○	✪		○				○								✪		✪	◐			◐	✖	✪	●	◐							
M 不锈钢			✪				✪	●	◐	✖	○	○									✪		✪	◐	✪													
K 铸铁			✪			✪							●	◐	✖	○	○			✪		✪		◐						●								
N 非铁金属																																						◐
S 难削材																			●	◐	✖	○	✪	✪														
H 高硬度材																		●																				

	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
中～粗切削	EM 		TNMG 330924N-EM	2.4			●	●					●	●					●	●	●																					

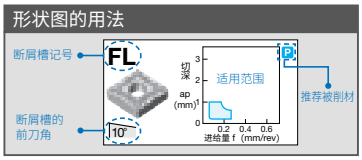
三角形负型刀片

机夹式刀片

TN 三角形 负型 无孔



形状图的用法



●：连续切削 第一推荐
○：连续切削 第二推荐
◕：一般切削 第一推荐
◔：一般切削 第二推荐
✖：断续切削 第一推荐
✪：断续切削 第二推荐

TN■■1603●●

尺寸 (mm)	切刃长度L	16.5	厚度S	3.18
	内切圆IC	9.525		

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◕	✖	○	◔	✪		◔			◔									✪		✪	◕		◕	✖	✪	●	◕							
M 不锈钢				✪			✪	●	◕	✖	○	◔									✪		✪	◕	✪												
K 铸铁			✪			✪							●	◕	✖	○	◔			✪		✪		◕						●							
N 非铁金属																																					◕
S 难削材																			●	◕	✖	◔	✪	✪													
H 高硬度材																		●																			

	形状	适用范围	型号	刀尖半径 RE
中切削			TNMN 160304	0.4
			160308	0.8
			TNGN 160304	0.4
			160308	0.8
			160312	1.2

TN■■1604●●

尺寸 (mm)	切刃长度L	16.5	厚度S	4.76
	内切圆IC	9.525		

住友 CBN(CBN) 刀片☞L86

适用外径刀杆 ☞L122

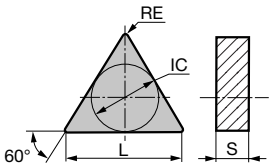
推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◕	✖	○	◔	✪		◔			◔									✪		✪	◕		◕	✖	✪	●	◕							
M 不锈钢				✪			✪	●	◕	✖	○	◔									✪		✪	◕	✪												
K 铸铁			✪			✪							●	◕	✖	○	◔			✪		✪		◕						●							
N 非铁金属																																					◕
S 难削材																			●	◕	✖	◔	✪	✪													
H 高硬度材																		●																			

	形状	适用范围	型号	刀尖半径 RE
中切削			TNMN 160404	0.4
			160408	0.8
			160412	1.2
			160416	1.6
			160420	2.0
			TNGN 160404	0.4
			160408	0.8
			160412	1.2

▲记号：计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

三角形负型刀片

TN 三角形 负型 无孔



材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4～
按被削材分类的刀片材质选择要领 ☞A10～

●：连续切削 第一推荐
○：连续切削 第二推荐
●：一般切削 第一推荐
◐：一般切削 第二推荐
✖：断续切削 第一推荐
✖：断续切削 第二推荐

TN■■1607●●

尺寸 (mm)	切刃长度L	16.5	厚度S	7.94
	内切圆IC	9.525		

陶瓷刀片☞B128

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◐	◐	✖	○	◐	✪		◐			◐									✪		✪	◐			◐	✖	✪	●	◐							
M 不锈钢				✪			✪	●	◐	✖	○	◐									✪		✪	◐	✪													
K 铸铁			✪			✪							●	◐	✖	○	◐			✪		✪		◐						●								
N 非铁金属																																						◐
S 难削材																			●	◐	✖	◐	✪	✪														
H 高硬度材																		●																				

	涂层																																					
	CVD									PVD	CVD							PVD									涂层 金属陶瓷 PVD			金属陶瓷		硬质合金						
形状 / 型号 / 刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
中切削 / 形状 / 适用范围 / **TNGN 160712** / 1.2	—	—	—	—	—	—	—	—	—	—	—	—																										

TN■■2204●●

尺寸 (mm)	切刃长度L	22.0	厚度S	4.76
	内切圆IC	12.7	孔径D1	

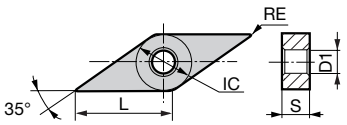
推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◐	◐	✖	○	◐	✪		◐			◐									✪		✪	◐			◐	✖	✪	●	◐							
M 不锈钢				✪			✪	●	◐	✖	○	◐									✪		✪	◐	✪													
K 铸铁			✪			✪							●	◐	✖	○	◐			✪		✪		◐						●								
N 非铁金属																																						◐
S 难削材																			●	◐	✖	◐	✪	✪														
H 高硬度材																		●																				

	涂层																																					
	CVD									PVD	CVD							PVD									涂层 金属陶瓷 PVD			金属陶瓷		硬质合金						
形状 / 型号 / 刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
中切削 / 形状 / 适用范围 / **TNMN 220408** / 0.8																		—						—		—						●		●					
220412 / 1.2																		—						—		—													
220416 / 1.6																		—						—		—													
中切削 / 形状 / 适用范围 / **TNGN 220404** / 0.4	—	—	—	—	—	—	—	—	—	—	—	—																										
220408 / 0.8	—	—	—	—	—	—	—	—	—	—	—	—																										
220412 / 1.2	—	—	—	—	—	—	—	—	—	—	—	—																										
220416 / 1.6	—	—	—	—	—	—	—	—	—	—	—	—																										

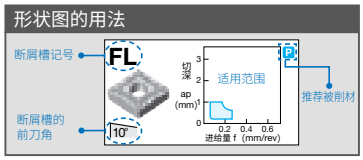
35° 菱形负型刀片

机夹式刀片

VN 35°菱形 负型 带孔



形状图的用法



●：连续切削 第一推荐
○：连续切削 第二推荐
◕：一般切削 第一推荐
◔：一般切削 第二推荐
✖：断续切削 第一推荐
✪：断续切削 第二推荐

VN■■1604●●

尺寸 (mm)	切刃长度L	16.6	厚度S	4.76
	内切圆IC	9.525	孔径D1	3.81

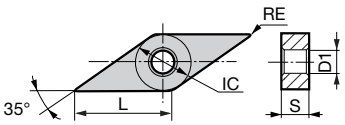
住友CBN(CBN)刀片 ☞L103～ 住友金刚石(PCD)刀片 ☞M23 无粘合剂住友金刚石刀片 ☞M28
陶瓷刀片☞B128 适用外径刀杆 ☞C38、C39

| 推荐用途 | 涂层 CVD | 涂层 PVD | 涂层 CVD | 涂层 PVD | 涂层 PVD | 涂层 P

35° 菱形负型刀片

机夹式刀片

VN 35°菱形 负型 带孔



材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4～
按被削材分类的刀片材质选择要领 ☞A10～

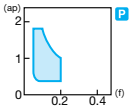
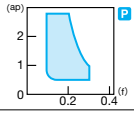
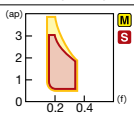
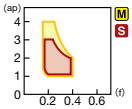
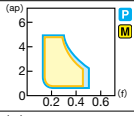
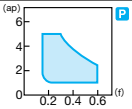
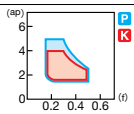
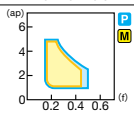
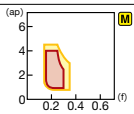
●：连续切削 第一推荐 ○：连续切削 第二推荐
●：一般切削 第一推荐 ○：一般切削 第二推荐
✖：断续切削 第一推荐 ✖：断续切削 第二推荐

VN■■1604●●

尺寸(mm)	切刃长度L	16.6	厚度S	4.76
	内切圆IC	9.525	孔径D1	3.81

住友CBN(CBN)刀片 ☞L103～ 住友金刚石(PCD)刀片 ☞M23 无粘合剂住友金刚石刀片 ☞M28
陶瓷刀片☞B128 适用外径刀杆 ☞C38、C39

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	○	◐	✖	○	○	✪		○				○								✪		✪	◐			◐	✖	✪	●	◐							
M 不锈钢			✪				✪	●	◐	✖	○	○									✪		✪	◐	✪													
K 铸铁				✪			✪						●	◐	✖	○	○			✪		✪		◐						●								
N 非铁金属																																					◐
S 难削材																			●	◐	✖	○	✪	✪													
H 高硬度材																		●																			

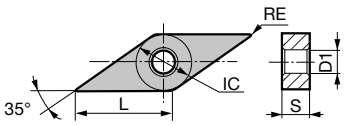
	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
					涂层																									涂层金属陶瓷			金属陶瓷		硬质合金						
					CVD									PVD	CVD								PVD							PVD												
精切削	FX		VNGG 160402R-FX	0.2																								●														
			160402L-FX	0.2																								●														
			160404R-FX	0.4																								●														
			160404L-FX	0.4																								●														
			160408R-FX	0.8																								●														
			160408L-FX	0.8																								●														
轻～中切削	SX		VNMG 160404N-SX	0.4	●	●	●	●	●	●	●																				●	●			●							
			160408N-SX	0.8	●	●	●	●	●	●	●																				●	●			●							
			160412N-SX	1.2																																						
	EX		VNMG 160404N-EX	0.4								●	●	●	▲	●							●	●	●	●	●		●														
			160408N-EX	0.8								●	●	●	▲	●							●	●	●	●	●		●														
	UP		VNMG 160404N-UP	0.4						●	●	●	●	●		●																							●			
			160408N-UP	0.8						●	●	●	●	●		●																							●			
中切削	GU		VNMG 160404N-GU	0.4	●	●	●	●	●	●	●	●	●	●	▲	●	●	●					●	●	●		●		●		●	●			●							
			160408N-GU	0.8	●	●	●	●	●	●	●	●	●	●	▲	●	●	●					●	●	●		●		●		●	●			●							
			160412N-GU	1.2	●	●	●	●		●	●			●			●	●					●	●	●		●		●													
	GE		VNMG 160404N-GE	0.4	●	●	●	●	●	●	●																															
			160408N-GE	0.8	●	●	●	●	●	●	●																															
			160412N-GE	1.2	●	●	●	●	●	●	●																															
	UX		VNMG 160404N-UX	0.4	●	●	●	●	●	●	●																															
			160408N-UX	0.8	●	●	●	●	●	●	●																															
			160412N-UX	1.2	●	●	●	●	●	●	●																															
	UG		VNMG 160404N-UG	0.4			●	●		●	●																															
			160408N-UG	0.8			●	●		●	●																															
	EG		VNMG 160404N-EG	0.4	●	●	●	●				●	●	●									●	●	●																	
			160408N-EG	0.8	●	●	●	●				●	●	●		●							●	●	●	●	●														●	●
			160412N-EG	1.2	●	●	●	●				●	●	●									●	●	●																	
			VNMA 160404	0.4													●	●	●	▲	▲																					
			160408	0.8													●	●	●	▲	▲																					
			160412	1.2													●	●	●	▲	▲																					
			VNGA 160404	0.4																		●																				
			160408	0.8																		●																				

▲记号：计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

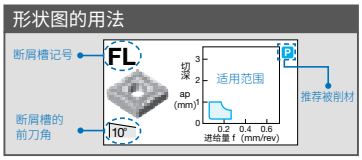
35° 菱形负型刀片

机夹式刀片

VN 35°菱形 负型 带孔



形状图的用法



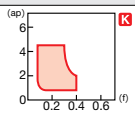
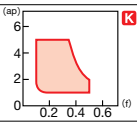
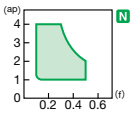
●：连续切削 第一推荐　○：连续切削 第二推荐　◐：一般切削 第一推荐　◔：一般切削 第二推荐　✖：断续切削 第一推荐　✪：断续切削 第二推荐

VN■■1604●●

尺寸 (mm)	切刃长度L	16.6	厚度S	4.76
	内切圆IC	9.525	孔径D1	3.81

住友CBN(CBN)刀片 L103～　住友金刚石(PCD)刀片 M23　无粘合剂住友金刚石刀片 M28　陶瓷刀片 B128　适用外径刀杆 C38、C39

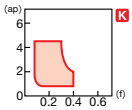
推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
	涂层																									涂层金属陶瓷				金属陶瓷		硬质合金						
	CVD									PVD	CVD							PVD								PVD												
P 钢	●	◔	◐	✖	○	◔	✪		◔			◔								✪			✪	◐		◐	✖	✪	●	◐								
M 不锈钢				✪			✪	●	◐	✖	○	◔								✪			✪	◐	✪													
K 铸铁			✪			✪							●	◐	✖	○	◔			✪		✪		◐						●								
N 非铁金属																																						◐
S 难削材																			●	◐	✖	◔	✪	✪														
H 高硬度材																		●																				

	形状	适用范围	型　号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
中～粗切削	UZ 4°		VNMG 160404N-UZ	0.4			●	●		●	●						●	●	●	▲	▲		●	●	●	●	●	—		—	—	—	—	—	—	●	●		●			—
			160408N-UZ	0.8			●	●		●	●						●	●	●	▲	▲		●	●	●	●	●	—		—	—	—	—	—	—	●	●		●			—
			160412N-UZ	1.2			●	●		●	●						●	●	●	▲	▲							—		—	—	—	—	—	—	●			●			—
中～粗切削	GZ 0°		VNMG 160404N-GZ	0.4						●							●	●	●	▲	▲							—		—	—	—	—	—	—							—
			160408N-GZ	0.8						●							●	●	●	▲	▲							—		—	—	—	—	—	—							—
			160412N-GZ	1.2						●							●	●	●	▲	▲							—		—	—	—	—	—	—							—
铝材用	AX 30°		VNGG 160402R-AX	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●
			160402L-AX	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●
			160404R-AX	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●
			160404L-AX	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●
			160408R-AX	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●
			160408L-AX	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●

VN■■2204●●

尺寸 (mm)	切刃长度L	22.1	厚度S	4.76
	内切圆IC	12.7	孔径D1	5.16

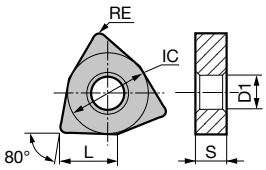
推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
	涂层																									涂层金属陶瓷				金属陶瓷		硬质合金						
	CVD									PVD	CVD							PVD								PVD												
P 钢	●	◔	◐	✖	○	◔	✪		◔			◔								✪			✪	◐		◐	✖	✪	●	◐								
M 不锈钢				✪			✪	●	◐	✖	○	◔								✪			✪	◐	✪													
K 铸铁			✪			✪							●	◐	✖	○	◔			✪		✪		◐						●								
N 非铁金属																																						◐
S 难削材																			●	◐	✖	◔	✪	✪														
H 高硬度材																		●																				

	形状	适用范围	型　号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
中～粗切削	UZ 4°		VNMG 220408N-UZ	0.8																																						
			220412N-UZ	1.2																																						

六角形负型刀片

机夹式刀片

WN 六角形 负型 带孔



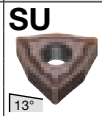
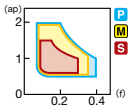
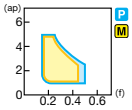
材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4～
按被削材分类的刀片材质选择要领 ☞A10～

●：连续切削 第一推荐　○：连续切削 第二推荐　◐：一般切削 第一推荐　◔：一般切削 第二推荐　✖：断续切削 第一推荐　✪：断续切削 第二推荐

WN■■06T3●●

尺寸 (mm)	切刃长度L	6.5	厚度S	3.97
	内切圆IC	9.525	孔径D1	3.81

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
	涂层																										涂层 金属陶瓷			金属陶瓷		硬质合金						
	CVD									PVD	CVD							PVD									PVD											
P 钢	●	◔	◐	✖	○	◔	✪		◔			◔									✪		✪	◐			◐	✖	✪	●	◐							
M 不锈钢			✪			✪	●	◐	✖	○	◔										✪		✪	◐	✪													
K 铸钢			✪			✪							●	◐	✖	○	◔			✪		✪		◐						●								
N 非铁金属																																						◐
S 难削材																			●	◐	✖	◔	✪	✪														
H 高硬度材																		●																				

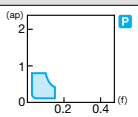
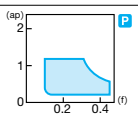
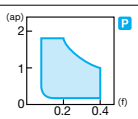
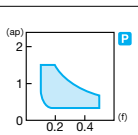
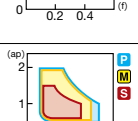
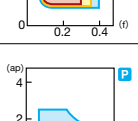
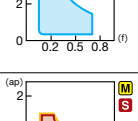
	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
精切削	SU  13°		WNMG 06T304N-SU	0.4			●			●																																
			06T308N-SU	0.8			●			●																																
中切削	UG 4°		WNMG 06T304N-UG	0.4			●			●																																
			06T308N-UG	0.8			●			●																																

WN■■0604●●

尺寸 (mm)	切刃长度L	6.5	厚度S	4.76
	内切圆IC	9.525	孔径D1	3.81

适用外径刀杆 ☞C43　适用内径刀杆 ☞E64、E65

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
	涂层																										涂层 金属陶瓷			金属陶瓷		硬质合金						
	CVD									PVD	CVD							PVD									PVD											
P 钢	●	◔	◐	✖	○	◔	✪		◔			◔									✪		✪	◐			◐	✖	✪	●	◐							
M 不锈钢			✪			✪	●	◐	✖	○	◔										✪		✪	◐	✪													
K 铸钢			✪			✪							●	◐	✖	○	◔			✪		✪		◐						●								
N 非铁金属																																						◐
S 难削材																			●	◐	✖	◔	✪	✪														
H 高硬度材																		●																				

	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
微小切削	FB 27°		WNMG 060404N-FB	0.4										●																●	●	▲		●								
			060408N-FB	0.8										●																●	●	▲		●								
	FE 20°		WNMG 060404N-FE	0.4	●	●	●	●	●		●		●	●																●	●	▲		●								
			060408N-FE	0.8	●	●	●	●	●		●		●	●																●	●	▲		●								
精切削	LU 10°		WNMG 060404N-LU	0.4	●	●	●	●	●	●	●																			●	●											
			060408N-LU	0.8	●	●	●	●	●	●	●																			●	●											
			060412N-LU	1.2	●	●	●	●	●	●	●																			●												
	LUW 10° →B131 修光刃		WNMG 060404N-LUW	0.4	●	●	●		●	●			●			●															●	●			●								
			060408N-LUW	0.8	●	●	●		●	●			●			●															●	●			●								
	SU 13°		WNMG 060404N-SU	0.4	●	●	●	●	●	●	●	●	●	●																	●	●											
			060408N-SU	0.8	●	●	●	●	●	●	●	●	●	●																	●	●											
			060412N-SU	1.2	●	●	●	●	●	●	●	●	●	●																	●												
	SEW 5° →B131 修光刃		WNMG 060404N-SEW	0.4	●	●	●	●	●	●	●																																
			060408N-SEW	0.8	●	●	●	●	●	●	●																																
	EF 20°		WNMG 060404N-EF	0.4	●	●	●	●				●	●	●									●	●	●		●															
			060408N-EF	0.8	●	●	●	●				●	●	●									●	●	●		●																

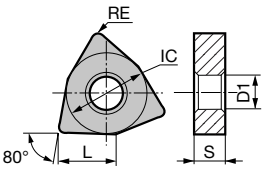
▲记号：计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

住友硬质合金

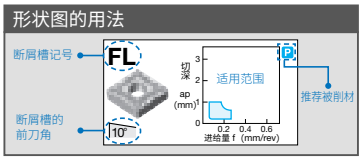
六角形负型刀片

机夹式刀片

WN 六角形 负型 带孔



形状图的用法



●：连续切削 第一推荐
○：连续切削 第二推荐
◕：一般切削 第一推荐
◔：一般切削 第二推荐
✖：断续切削 第一推荐
✖：断续切削 第二推荐

WN■■0604●●

尺寸 (mm)	切刃长度L	6.5	厚度S	4.76
	内切圆IC	9.525	孔径D1	3.81

适用外径刀杆 ☞C43　适用内径刀杆 ☞E64、E65

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◕	✖	○	◔	✪		◔			◔									✪		✪	◕			◕	✖	✪	●	◕							
M 不锈钢				✪			✪	●	◕	✖	○	◔									✪		✪	◕	✪													
K 铸铁			✪			✪							●	◕	✖	○	◔			✪		✪		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◔	✪	✪														
H 高硬度材																		●																				
	涂层																										涂层金属陶瓷					金属陶瓷				硬质合金			
	CVD									P/D	CVD							PVD									PVD											

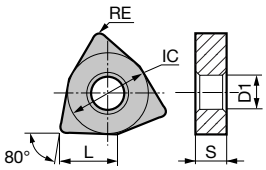
	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
中切削	GU 7°	P M	WNMG 060404N-GU	0.4	●	●	●	●	●	●	●	●	●	●			●	●				—						—		—	●	●										
			060408N-GU	0.8	●	●	●	●	●	●	●	●	●	●			●	●				—						—		—	●	●										
			060412N-GU	1.2	●	●	●	●	●	●	●	●	●	●			●	●				—						—		—	●											
	GE 3°	P	WNMG 060408N-GE	0.8	●	●	●	●	●	●	●											—						—		—	—	—	—	—	—							—
			060412N-GE	1.2	●	●	●	●	●	●	●											—						—		—	—	—	—	—	—							—
	GUW 0° →B131 修光刃	P	WNMG 060408N-GUW	0.8	●	●	●	●	●	●	●											—						—		—	—	—	—	—	—							—
	UG 4°	P M	WNMG 060404N-UG	0.4			●			●												—						—		—	—	—	—	—	—							—
			060408N-UG	0.8			●			●												—						—		—	—	—	—	—	—							—
	EG 0°	M	WNMG 060408N-EG	0.8	●	●	●	●				●	●	●								—	●	●	●		●	—		—	—	—	—	—	—							—
			060412N-EG	1.2	●	●	●	●				●	●	●								—	●	●	●		●	—		—	—	—	—	—	—							—
中～粗切削	MU 4°	P M S	WNMG 060408N-MU	0.8			●			●												—						—		—	—	—	—	—	—							—
			060412N-MU	1.2			●			●												—						—		—	—	—	—	—	—							—
	ME 4°	P	WNMG 060408N-ME	0.8	●	●	●	●	●	●	●						●	●				—						—		—	—	—	—	—	—							—
			060412N-ME	1.2	●	●	●	●	●	●	●						●	●				—						—		—	—	—	—	—	—							—
	GZ 0°	K	WNMG 060408N-GZ	0.8													●	●	●	▲	▲	—						—		—	—	—	—	—	—							—
			060412N-GZ	1.2													●	●	●	▲	▲	—						—		—	—	—	—	—	—							—

▲记号：计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

六角形负型刀片

机夹式刀片

WN 六角形 负型 带孔



材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4～
按被削材分类的刀片材质选择要领 ☞A10～

●：连续切削 第一推荐　○：连续切削 第二推荐　◐：一般切削 第一推荐　◔：一般切削 第二推荐　✖：断续切削 第一推荐　✪：断续切削 第二推荐

WN■■0804●●

尺寸(mm)	切刃长度L	8.7	厚度S	4.76
	内切圆IC	12.7	孔径D1	5.16

住友CBN(CBN)刀片☞L114、L115
适用外径刀杆 ☞C42、C43　适用内径刀杆 ☞E64、E65

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◐	✖	○	◔	✪		◔			◔									✪		✪	◐			◐	✖	✪	●	◐							
M 不锈钢			✪				✪	●	◐	✖	○	◔									✪		✪	◐	✪													
K 铸铁				✪			✪						●	◐	✖	○	◔			✪		✪		◐						●								
N 非铁金属																																						◐
S 难削材																			●	◐	✖	◔	✪	✪														
H 高硬度材																		●																				

	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
微小切削	FB 27°	(ap) 2 1 0 0.2 0.4 (f) P	WNMG 080402N-FB	0.2										●																	●	●	▲	●	●							
			080404N-FB	0.4										●																	●	●	▲	●	●							
			080408N-FB	0.8										●																	●	●	▲	●	●							
	FA 20°	(ap) 2 1 0 0.2 0.4 (f) P	WNMG 080402N-FA	0.2																											●	●	▲	●	●							
			080404N-FA	0.4																											●	●	▲	●	●							
			080408N-FA	0.8																											●	●	▲	●	●							
	FL 10°	(ap) 2 1 0 0.2 0.4 (f) P	WNMG 080404N-FL	0.4			●			●						●															●	●	▲	●	●							
			080408N-FL	0.8			●			●						●															●	●	▲	●	●							
	FE 20°	(ap) 2 1 0 0.2 0.4 (f) P	WNMG 080402N-FE	0.2	●	●	●	●	●		●		●	●																	●	●	▲	●	●							
			080404N-FE	0.4	●	●	●	●	●		●		●	●																	●	●	▲	●	●							
			080408N-FE	0.8	●	●	●	●	●		●		●	●																	●	●	▲	●	●							
			080412N-FE	1.2	●	●	●	●	●		●		●	●																	●	●	▲	●	●							
精切削	LU 10°	(ap) 2 1 0 0.2 0.4 (f) P	WNMG 080404N-LU	0.4	●	●	●	●	●	●	●		●			●															●	●	▲	●	●							
			080408N-LU	0.8	●	●	●	●	●	●	●		●			●															●	●	▲	●	●							
			080412N-LU	1.2	●	●	●	●	●	●	●		●			●															●	●	▲		●							
	LUW 10° →B131 修光刃	(ap) 2 1 0 0.2 0.4 (f) P	WNMG 080404N-LUW	0.4	●	●	●		●	●			●			●															●	●	▲		●							
			080408N-LUW	0.8	●	●	●		●	●			●			●															●	●	▲		●							
			080412N-LUW	1.2	●	●	●		●	●			●			●															●	●	▲		●							
	SU 13°	(ap) 2 1 0 0.2 0.4 (f) P M S	WNMG 080404N-SU	0.4	●	●	●	●	●	●	●	●	●	●		●							●	●	●	●	●		●		●	●	▲	●	●							
			080408N-SU	0.8	●	●	●	●	●	●	●	●	●	●		●							●	●	●	●	●		●		●	●	▲	●	●							
			080412N-SU	1.2	●	●	●	●	●	●	●	●	●	●		●							●	●	●	●	●		●		●	●	▲	●	●							
	SU 13°	(ap) 2 1 0 0.2 0.4 (f) P	WNGG 080404N-SU	0.4																											●	●	▲	●	●							
	SE 5°	(ap) 6 4 2 0 0.2 0.4 0.6 (f) P	WNMG 080404N-SE	0.4	●	●	●	●	●	●	●																				●	●		●	●							
			080408N-SE	0.8	●	●	●	●	●	●	●																				●	●		●	●							
			080412N-SE	1.2	●	●	●	●	●	●	●																															
	SEW 5° →B131 修光刃	(ap) 4 2 0 0.2 0.5 0.8 (f) P	WNMG 080404N-SEW	0.4	●	●	●		●	●																					●	●			●							
			080408N-SEW	0.8	●	●	●		●	●																					●	●			●							
			080412N-SEW	1.2	●	●	●		●	●																																
	EF 20°	(ap) 2 1 0 0.2 0.4 (f) M S	WNMG 080404N-EF	0.4	●	●	●	●				●	●	●		●							●	●	●	●	●													●	●	
			080408N-EF	0.8	●	●	●	●				●	●	●		●							●	●	●	●	●														●	●	

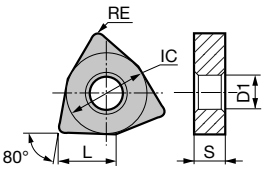
涂层：CVD / PVD　涂层金属陶瓷：PVD　金属陶瓷　硬质合金

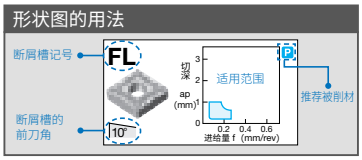
▲记号：计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

六角形负型刀片

机夹式刀片

WN 六角形 负型 带孔





●：连续切削 第一推荐
○：连续切削 第二推荐
◕：一般切削 第一推荐
◔：一般切削 第二推荐
✖：断续切削 第一推荐
✖：断续切削 第二推荐

WN■■0804●●

尺寸 (mm)	切刃长度L	8.7	厚度S	4.76
	内切圆IC	12.7	孔径D1	5.16

住友CBN(CBN)刀片☞L114、L115

适用外径刀杆☞C42、C43

适用内径刀杆☞E64、E65

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◕	✖	○	◔	⊕		◔			◔									⊕		⊕	◕			◕	✖	⊕	●	◕							
M 不锈钢				⊕			⊕	●	◕	✖	○	◔									⊕		⊕	◕	⊕													
K 铸铁			⊕			⊕							●	◕	✖	○	◔			⊕		⊕		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◔	⊕	⊕														
H 高硬度材																		●																				

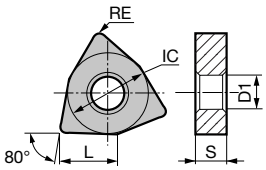
	形状	适用范围	型号	刀尖半径 RE	涂层 CVD								PVD	CVD							PVD					涂层金属陶瓷 PVD			金属陶瓷		硬质合金						
					AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
轻～中切削	SX 3°		WNMG 080404N-SX	0.4	●	●	●	●		●	●																			●	●	▲		●							
			080408N-SX	0.8	●	●	●	●	●	●	●																			●	●	▲		●							
			080412N-SX	1.2	●	●	●	●	●	●	●																														
	EX 16°		WNMG 080404N-EX	0.4								●	●	●	▲	●						●	●	●	●	●		●													
			080408N-EX	0.8								●	●	●	▲	●						●	●	●	●	●		●													
			080412N-EX	1.2								●	●	●	▲	●						●	●	●	●	●		●													
	UP 10°		WNMG 080408N-UP	0.8						●	●	●	●	●		●						●	●	●	●	●		●													
			080412N-UP	1.2						●	●	●	●	●		●						●	●	●	●	●		●													
中切削	GU 7°		WNMG 080404N-GU	0.4	●	●	●	●	●	●	●	●	●	●	▲	●	●	●				●	●	●		●		●		●	●			●							
			080408N-GU	0.8	●	●	●	●	●	●	●	●	●	●	▲	●	●	●				●	●	●		●		●		●	●			●							
			080412N-GU	1.2	●	●	●	●	●	●	●	●	●	●	▲	●	●	●				●	●	●		●		●													
	GE 3°		WNMG 080404N-GE	0.4	●	●	●	●	●	●	●																														
			080408N-GE	0.8	●	●	●	●	●	●	●																														
			080412N-GE	1.2	●	●	●	●	●	●	●																														
			080416N-GE	1.6	●	●	●	●	●	●	●																														
	GUW 0° →B131 修光刀		WNMG 080408N-GUW	0.8	●	●	●		●	●																															
			080412N-GUW	1.2	●	●	●		●	●																															
	UX 0°		WNMG 080404N-UX	0.4	●	●	●	●	●	●	●																														
			080408N-UX	0.8	●	●	●	●	●	●	●																														
			080412N-UX	1.2	●	●	●	●	●	●	●																														
	UG 4°		WNMG 080404N-UG	0.4			●	●		●	●																														
			080408N-UG	0.8			●	●		●	●																														
			080412N-UG	1.2			●	●		●	●																														
	EG 0°		WNMG 080404N-EG	0.4	●	●	●	●				●	●	●									●	●	●																
			080408N-EG	0.8	●	●	●	●				●	●	●		●							●	●	●	●	●												●	●	
			080412N-EG	1.2	●	●	●	●				●	●	●		●							●	●	●	●	●												●	●	
整体CBN 陶瓷			WNMA 080408	0.8													●	●	●	▲	▲																				
			080412	1.2													●	●	●	▲	▲																				
			080416	1.6													●	●	●	▲	▲																				
中～粗切削	MU 4°		WNMG 080408N-MU	0.8	●	●	●	●	●	●	●		●	●		●							●	●	●	●	●		●												
			080412N-MU	1.2	●	●	●	●	●	●	●		●	●		●							●	●	●	●	●		●												
			080416N-MU	1.6	●	●	●		●	●																															
	EM 0°		WNMG 080408N-EM	0.8	●	●	●	●				●	●	●									●	●	●																
			080412N-EM	1.2	●	●	●	●				●	●	●									●	●	●																

▲记号：计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

六角形负型刀片

机夹式刀片

WN 六角形 负型 带孔



材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4～
按被削材分类的刀片材质选择要领 ☞A10～

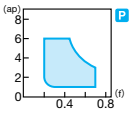
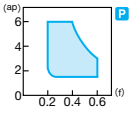
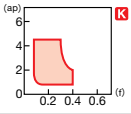
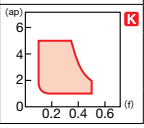
●：连续切削 第一推荐　○：连续切削 第二推荐　◐：一般切削 第一推荐　◔：一般切削 第二推荐　✖：断续切削 第一推荐　✪：断续切削 第二推荐

WN■■0804●●

尺寸 (mm)	切刃长度L	8.7	厚度S	4.76
	内切圆IC	12.7	孔径D1	5.16

住友CBN(CBN)刀片☞L114、L115
适用外径刀杆 ☞C42、C43　适用内径刀杆 ☞E64、E65

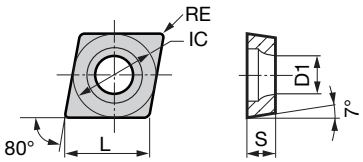
推荐用途	涂层 CVD								PVD				CVD					PVD							涂层金属陶瓷 PVD			金属陶瓷		硬质合金						
	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◐	✖	○	◔	✪		◔			◔									✪		✪	◐			◐	✖	✪	●	◐							
M 不锈钢			✪			✪	●	◐	✖	○	◔										✪		✪	◐	✪													
K 铸铁			✪			✪							●	◐	✖	○	◔			✪		✪		◐						●								
N 非铁金属																																					◐
S 难削材																			●	◐	✖	◔	✪	✪													
H 高硬度材																		●																			

	形状	适用范围	型 号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
中～粗切削	ME 4°		WNMG 080408N-ME	0.8	●	●	●	●	●	●	●						●	●				—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			080412N-ME	1.2	●	●	●	●	●	●	●						●	●				—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			080416N-ME	1.6	●	●	●	●	●	●	●						●	●				—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	MX -15°		WNMG 080408N-MX	0.8		●	●	●		●	●											—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			080412N-MX	1.2		●	●	●		●	●											—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	UZ 4°		WNMG 080404N-UZ	0.4			●			●							●	●	●	▲	▲	—	●	●	●	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			080408N-UZ	0.8			●	●		●	●						●	●	●	▲	▲	—	●	●	●	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			080412N-UZ	1.2			●	●		●	●						●	●	●	▲	▲	—	●	●	●	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	GZ 0°		WNMG 080404N-GZ	0.4						●							●	●	●	▲	▲																				
			080408N-GZ	0.8						●							●	●	●	▲	▲																				
			080412N-GZ	1.2						●							●	●	●	▲	▲																				

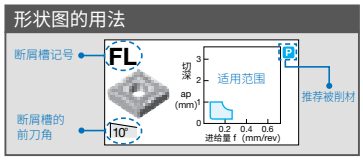
▲记号：计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

80° 菱形正型刀片

CC 80°菱形 7°正型 带孔



形状图的用法



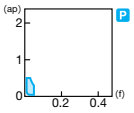
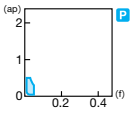
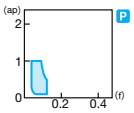
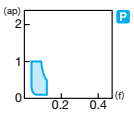
●：连续切削 第一推荐
○：连续切削 第二推荐
◕：一般切削 第一推荐
◔：一般切削 第二推荐
✖：断续切削 第一推荐
✪：断续切削 第二推荐

CC■■03X1●●

尺寸(mm)				
	切刃长度L	3.55	厚度S	1.4
	内切圆IC	3.5	孔径D1	1.9

住友CBN(CBN)刀片☞L43
无粘合剂住友金刚石刀片☞M28
适用内径刀杆☞E18、E20

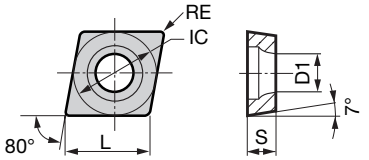
推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
	涂层																									涂层金属陶瓷			金属陶瓷		硬质合金						
	CVD									PVD	CVD							PVD								PVD											
P 钢	●	◔	◕	✖	○	◔	✪		◔			◔								✪			✪	◕		◕	✖	✪	●	◕							
M 不锈钢				✪			✪	●	◕	✖	○	◔								✪			✪	◕	✪												
K 铸铁			✪			✪							●	◕	✖	○	◔			✪		✪		◕						●							
N 非铁金属																																					◕
S 难削材																			●	◕	✖	◔	✪	✪													
H 高硬度材																		●																			

	形状	适用范围	型 号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
精切削	**FYS** 15°		CCGT 03X1003R-FYS	0.03																				●	●			●														
			03X1003L-FYS	0.03																				●	●			●														
			03X101R-FYS	0.1																				●	●			●														
			03X101L-FYS	0.1																				●	●			●														
			03X102R-FYS	0.2																				●	●			●														
			03X102L-FYS	0.2																				●	●			●														
			03X104R-FYS	0.4																				●	●			●														
			03X104L-FYS	0.4																				●	●			●														
	FYS 15°		CCET 03X1003R-FYS	0.03																								●														
			03X1003L-FYS	0.03																								●														
			03X101R-FYS	0.1																								●														
			03X101L-FYS	0.1																								●														
			03X102R-FYS	0.2																								●														
			03X102L-FYS	0.2																								●														
			03X104R-FYS	0.4																								●														
			03X104L-FYS	0.4																								●														
	FY 15°		CCGT 03X101R-FY	0.1																				●	●			●			●			●	●							
			03X101L-FY	0.1																				●	●			●			●			●	●							
			03X102R-FY	0.2																				●	●			●			●			●	●							
			03X102L-FY	0.2																				●	●			●			●			●	●							
			03X104R-FY	0.4																				●	●			●			●			●	●							
			03X104L-FY	0.4																				●	●			●			●			●	●							
	FY 15°		CCET 03X1003R-FY	0.03																								●		●				●	●							
			03X1003L-FY	0.03																								●	●	●				●	●							
			03X101R-FY	0.1																								●		●				●	●							
			03X101L-FY	0.1																								●	●	●				●	●							
			03X102R-FY	0.2																								●		●				●	●							
			03X102L-FY	0.2																								●	●	●				●	●							
			03X104R-FY	0.4																								●		●				●	●							
			03X104L-FY	0.4																								●	●	●				●	●							

80° 菱形正型刀片

机夹式刀片

CC 80°菱形 7°正型 带孔



材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4～
按被削材分类的刀片材质选择要领 ☞A10～

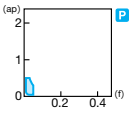
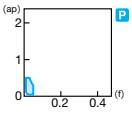
●：连续切削 第一推荐　○：连续切削 第二推荐　◐：一般切削 第一推荐　◔：一般切削 第二推荐　✖：断续切削 第一推荐　✪：断续切削 第二推荐

CC■■04X1●●

尺寸(mm)	切刃长度L	4.37	厚度S	1.8
	内切圆IC	4.3	孔径D1	2.3

住友CBN(CBN)刀片☞L44　无粘合剂住友金刚石刀片☞M28
适用内径刀杆 ☞E18、E20

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
	涂层																									涂层金属陶瓷			金属陶瓷		硬质合金						
	CVD									PVD	CVD							PVD								PVD											
P 钢	●	◔	◐	✖	○	◔	✪		◔				◔								✪		✪	◐			◐	✖	✪	●	◐							
M 不锈钢			✪				✪	●	◐	✖	○	◔									✪		✪	◐	✪													
K 铸铁			✪			✪							●	◐	✖	○	◔			✪		✪		◐						●								
N 非铁金属																																						◐
S 难削材																			●	◐	✖	◔	✪	✪														
H 高硬度材																		●																				

	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
精切削	FYS 15°		CCGT 04X1003R-FYS	0.03																				●	●			●														
			04X1003L-FYS	0.03																				●	●			●														
			04X101R-FYS	0.1																				●	●			●														
			04X101L-FYS	0.1																				●	●			●														
			04X102R-FYS	0.2																				●	●			●														
			04X102L-FYS	0.2																				●	●			●														
			04X104R-FYS	0.4																				●	●			●														
			04X104L-FYS	0.4																				●	●			●														
	FYS 15°		CCET 04X1003R-FYS	0.03																								●														
			04X1003L-FYS	0.03																								●														
			04X101R-FYS	0.1																								●														
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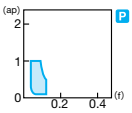
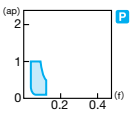
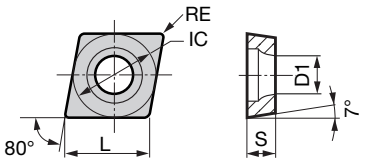
			04X102L-FYS	0.2																								●														
			04X104R-FYS	0.4																								●														
			04X104L-FYS	0.4																								●														
	FY 15°		CCGT 04X101R-FY	0.1																				●	●			●			●			●	●							
			04X101L-FY	0.1																				●	●			●			●			●	●							
			04X102R-FY	0.2																				●	●			●			●			●	●							
			04X102L-FY	0.2																				●	●			●			●			●	●							
			04X104R-FY	0.4																				●	●			●			●			●	●							
			04X104L-FY	0.4																				●	●			●			●			●	●							
	FY 15°		CCET 04X1003R-FY	0.03																								●		●				●	●							
			04X1003L-FY	0.03																								●	●	●				●	●							
			04X101R-FY	0.1																								●		●				●	●							
			04X101L-FY	0.1																								●	●	●				●	●							
			04X102R-FY	0.2																								●		●				●	●							
			04X102L-FY	0.2																								●	●	●				●	●							
			04X104R-FY	0.4																								●		●				●	●							
			04X104L-FY	0.4																								●	●	●				●	●							

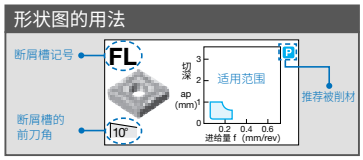
80° 菱形正型刀片

机夹式刀片

CC 80°菱形 7°正型 带孔



形状图的用法



●：连续切削 第一推荐
○：连续切削 第二推荐
：一般切削 第一推荐
：一般切削 第二推荐
：断续切削 第一推荐
：断续切削 第二推荐

CC■■0602●●

尺寸(mm)	切刃长度L	6.4	厚度S	2.38
	内切圆IC	6.35	孔径D1	2.8

住友CBN(CBN)刀片☞L45、L46　住友金刚石(PCD)刀片☞M10
无粘合剂住友金刚石刀片☞M28
适用外径刀杆☞C13、D13、D17、D22、D23　适用内径刀杆☞E18～E20

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	●	✖	○	◔	✿		◔			◔									✿		✿	●			◕	✖	✿	●	◕							
M 不锈钢				✿			✿	●	◕	✖	○	◔									✿		✿	◕	✿													
K 铸铁			✿			✿							●	◕	✖	○	◔			✿		✿		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◔	✿	✿														
H 高硬度材																		●																				

					涂层																					涂层金属陶瓷			金属陶瓷		硬质合金						
					CVD							PVD	CVD					PVD								PVD											
	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
微小切削	**FF**		CCGT 060201MN-FF New	< 0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●			●			—	—	—	—	—	—	—	—	—	—	—	—
			060202MN-FF New	< 0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●			●			—	—	—	—	—	—	—	—	—	—	—	—
			060204MN-FF New	< 0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●			●			—	—	—	—	—	—	—	—	—	—	—	—
精切削	**FB**		CCMT 060202N-FB	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	●	●	▲	●	●	—	—	—	—	—	—	—
			060204N-FB	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	●	●	▲	●	●	—	—	—	—	—	—	—
	LU		CCMT 060202N-LU	0.2	●	●	●		●	●		●	●	●		●						—						—	●	—	●	●	▲	●	●							
			060204N-LU	0.4	●	●	●		●	●		●	●	●		●						—						—	●	—	●	●	▲	●	●							
	FP		CCMT 060202N-FP	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	—	—	—	—	—	—
			060208N-FP	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	—	—	—	—	—	—
	FC		CCGT 060201MN-FC	< 0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	●				●	●	—	—	—	—	—	—	—
			060202MN-FC	< 0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	●				●	●	—	—	—	—	—	—	—
			060204MN-FC	< 0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	●				●	●	—	—	—	—	—	—	—
	FX		CCGT 0602003R-FX	0.03	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●			●	●					●	●							
			0602003L-FX	0.03	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●			●	●					●	●							
			060201R-FX	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●			●	●		●			●	●							
			060201L-FX	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●			●	●		●			●	●							
			060202R-FX	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●			●	●		●			●	●							
			060202L-FX	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●			●	●		●			●	●							
			060204R-FX	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●			●	●						●							
			060204L-FX	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●			●	●		●				●							
	FX		CCET 0602003R-FX	0.03	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●		●												
			0602003L-FX	0.03	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●		●												
			060201R-FX	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●		●												
			060201L-FX	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●		●												
			060202R-FX	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●		●												
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			060204R-FX	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●		●												
			060204L-FX	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●		●												
陶瓷 CBN	**FY**		CCET 0602003R-FY	0.03	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●		●												
			0602003L-FY	0.03	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●		●												
			0602008R-FY	0.08	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—															
			0602008L-FY	0.08	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—															
			060201R-FY	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●		●					●	●						
			060201L-FY	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●		●					●	●						
			0602018R-FY	0.18	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—															
			0602018L-FY	0.18	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—															
			060202R-FY	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●		●					●	●						
			060202L-FY	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●		●					●	●						
			060204R-FY	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●		●												
			060204L-FY	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●		●												

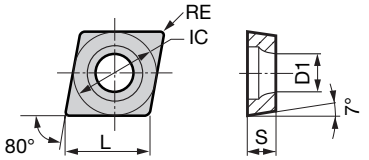
用“<”表示刀尖半径RE的产品，表示其为负公差。

▲记号：计划在将来被新产品替换、改为接单生产或停止生产（请确认有无库存）

80° 菱形正型刀片

机夹式刀片

CC 80°菱形 7°正型 带孔



材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4～
按被削材分类的刀片材质选择要领 ☞A10～

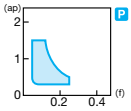
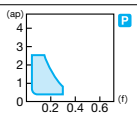
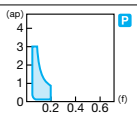
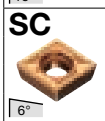
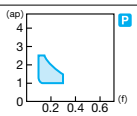
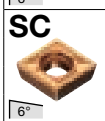
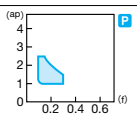
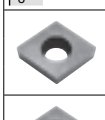
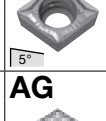
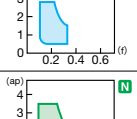
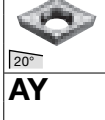
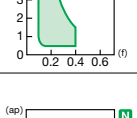
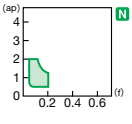
●：连续切削 第一推荐　○：连续切削 第二推荐　◕：一般切削 第一推荐　◔：一般切削 第二推荐　✖：断续切削 第一推荐　✿：断续切削 第二推荐

CC■■0602●●

尺寸 (mm)	切刃长度L	6.4	厚度S	2.38
	内切圆IC	6.35	孔径D1	2.8

住友CBN（CBN）刀片☞L45、L46　住友金刚石（PCD）刀片☞M10
无粘合剂住友金刚石刀片☞M28
适用外径刀杆 ☞C13、D13、D17、D22、D23　适用内径刀杆 ☞E18～E20

推荐用途	涂层 CVD								PVD																涂层金属陶瓷 PVD			金属陶瓷		硬质合金					
	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◕	✖	○	◔	✿		◔			◔									✿		✿	◕			◕	✖	✿	●	◕							
M 不锈钢			✿			✿		●	◕	✖	○	◔									✿		✿	◕	✿													
K 铸铁			✿			✿							●	◕	✖	○	◔			✿		✿		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◔	✿	✿														
H 高硬度材																		●																				

	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
轻切削	LB 15°		CCMT 060202N-LB	0.2		●	●	●		●	●	●	●	●								—						—	—	●	●	▲		●							
			060204N-LB	0.4		●	●	●		●	●	●	●	●								—						—	—	●	●	▲		●							
			060208N-LB	0.8		●	●	●		●	●	●	●	●								—						—	—	●	●	▲		●							
	SU 8°		CCMT 060202N-SU	0.2	●	●	●	●		●	●	●	●	●	▲	●						—	●	●	●			—	●	—	●	●	▲	●	●							
			060204N-SU	0.4	●	●	●	●		●	●	●	●	●	▲	●						—	●	●	●			—	●	—	●	●	▲	●	●							
			060208N-SU	0.8	●	●	●	●		●	●	●	●	●	▲	●						—	●	●	●		●	—	●	—	●	●		●	●							
	SI 15°		CCGT 060201MN-SI New	< 0.1	—	—	—	—	—	—	—	—	—	—			—	—	—	—	—	—	●	●			●			—	—	—	—	—	—							
			060202MN-SI New	< 0.2	—	—	—	—	—	—	—	—	—	—			—	—	—	—	—	—	●	●			●			—	—	—	—	—	—							
			060204MN-SI New	< 0.4	—	—	—	—	—	—	—	—	—	—			—	—	—	—	—	—	●	●			●			—	—	—	—	—	—							
	SC  6°		CCMT 060204N-SC	0.4			●			●												—						—	—	—	—	—	—	—	—		●					—
	SC  6°		CCGT 0602003N-SC	0.03	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—						●	●	●			●	●	—	—	—	—	—	—	—
			CCGT 060201MN-SC	< 0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—						●	●	●	●	●		●	●	—	—	—	—	—	—	—
			060202MN-SC	< 0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—						●	●	●	●	●		●	●	—	—	—	—	—	—	—
			060204MN-SC	< 0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—									●	●			●	—	—	—	—	—	—	—
			CCMW 060204	0.4													●	●	●	▲	▲	—						—	—	—	—	—	—	—	—							—
			CCGW 060200	0	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—																			
			060201	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—																			
轻～中切削	GU  5°		CCMT 060204N-GU	0.4	●	●	●	●				●	●	●								—			●			—	—	●	●			●							
			060208N-GU	0.8	●	●	●	●				●	●	●								—			●			—	—	●	●			●							
铝材用	AG  20°		CCGT 060202N-AG	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●
			060204N-AG	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●
	AY 15°		CCGT 060201R-AY	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●
			060201L-AY	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●
			060202R-AY	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●
			060202L-AY	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●
			060204R-AY	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●
			060204L-AY	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●

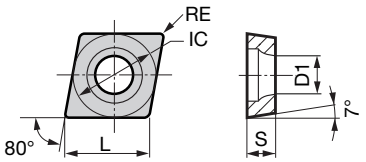
用“<”表示刀尖半径RE的产品，表示其为负公差。

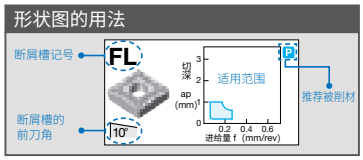
▲记号：计划在将来被新产品替换、改为接单生产或停止生产（请确认有无库存）

80° 菱形正型刀片

机夹式刀片

CC 80°菱形 7°正型 带孔



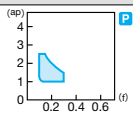
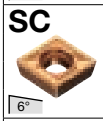
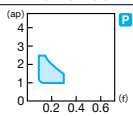


●：连续切削 第一推荐　○：连续切削 第二推荐　◐：一般切削 第一推荐　◔：一般切削 第二推荐　✖：断续切削 第一推荐　✖：断续切削 第二推荐

CC■■0802●●

尺寸(mm)				
	切刃长度L	8.0	厚度S	2.38
	内切圆IC	7.94	孔径D1	3.4

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◐	✖	○	◔	✪		◔				◔								✪		✪	◐			◐	✖	✪	●	◐							
M 不锈钢				✪			✪	●	◐	✖	○	◔									✪		✪	◐	✪													
K 铸铁			✪			✪							●	◐	✖	○	◔			✪		✪		◐						●								
N 非铁金属																																						◐
S 难削材																			●	◐	✖	◔	✪	✪														
H 高硬度材																		●																				

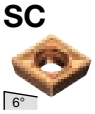
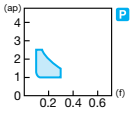
	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
轻切削	SC		CCMT 080204N-SC	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
轻切削	SC 		CCGT 080201MN-SC	< 0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●			●	●	—	—	—	—	—	—	—
			080202MN-SC	< 0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●			●	●	—	—	—	—	—	—	—
			CCGW 080200	0	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			080201	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—

用“<”表示刀尖半径RE的产品，表示其为负公差。

CC■■0803●●

尺寸(mm)				
	切刃长度L	8.0	厚度S	3.18
	内切圆IC	7.94	孔径D1	3.4

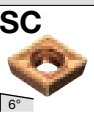
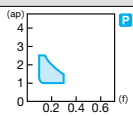
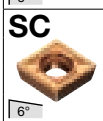
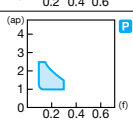
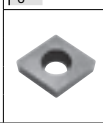
推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◐	✖	○	◔	✪		◔				◔								✪		✪	◐			◐	✖	✪	●	◐							
M 不锈钢				✪			✪	●	◐	✖	○	◔									✪		✪	◐	✪													
K 铸铁			✪			✪							●	◐	✖	○	◔			✪		✪		◐						●								
N 非铁金属																																						◐
S 难削材																			●	◐	✖	◔	✪	✪														
H 高硬度材																		●																				

	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
轻切削	SC 		CCMT 080304N-SC	0.4	—	—	●	—	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—

CC■■0903●●

尺寸(mm)				
	切刃长度L	9.7	厚度S	3.18
	内切圆IC	9.525	孔径D1	4.4

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◐	✖	○	◔	✪		◔				◔								✪		✪	◐			◐	✖	✪	●	◐							
M 不锈钢				✪			✪	●	◐	✖	○	◔									✪		✪	◐	✪													
K 铸铁			✪			✪							●	◐	✖	○	◔			✪		✪		◐						●								
N 非铁金属																																						◐
S 难削材																			●	◐	✖	◔	✪	✪														
H 高硬度材																		●																				

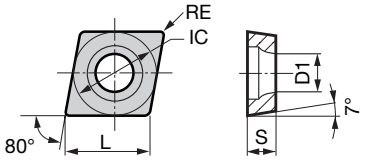
	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
轻切削	SC 		CCMT 090308N-SC	0.8	—	—	●	—	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	—	—	—	—	—	—
轻切削	SC 		CCGT 090301MN-SC	< 0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●			●	●	—	—	—	—	—	—	—
			090302MN-SC	< 0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●			●	●	—	—	—	—	—	—	—
			CCGW 090300	0	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			090301	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—

用“<”表示刀尖半径RE的产品，表示其为负公差。

80° 菱形正型刀片

机夹式刀片

CC 80°菱形 7°正型 带孔



材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4～
按被削材分类的刀片材质选择要领 ☞A10～

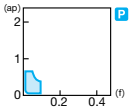
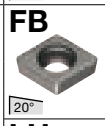
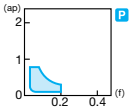
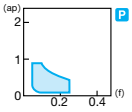
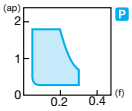
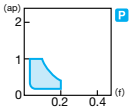
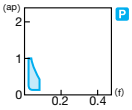
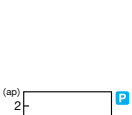
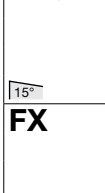
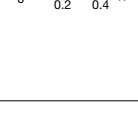
●：连续切削 第一推荐　○：连续切削 第二推荐　◐：一般切削 第一推荐　◔：一般切削 第二推荐　✖：断续切削 第一推荐　✪：断续切削 第二推荐

CC■■09T3●●

尺寸(mm)	切刃长度L	9.7	厚度S	3.97
	内切圆IC	9.525	孔径D1	4.4

住友CBN(CBN)刀片☞L47～　住友金刚石(PCD)刀片☞M11
无粘合剂住友金刚石刀片☞M28
适用外径刀杆 ☞C13、D13、D17、D22、D23　适用内径刀杆 ☞E12、E18～E20

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
	涂层																									涂层金属陶瓷			金属陶瓷		硬质合金						
	CVD									PVD		CVD						PVD								PVD											
P 钢	●	◔	◐	✖	○	◔	✪		◔			◔								✪			✪	◐			◐	✖	✪	●	◐							
M 不锈钢				✪			✪	●	◐	✖	○	◔								✪			✪	◐	✪													
K 铸铁			✪			✪							●	◐	✖	○	◔			✪		✪		◐						●								
N 非铁金属																																						◐
S 难削材																			●	◐	✖	◔	✪	✪														
H 高硬度材																		●																				

	形状	适用范围	型号	刀尖半径RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
微小切削	**FF** 15°		CCGT 09T301MN-FF New	< 0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—
			09T302MN-FF New	< 0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—
			09T304MN-FF New	< 0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—
	FB  20°		CCMT 09T302N-FB	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	●	●	▲	●	●	—	—	—	—	—	—	—
			09T304N-FB	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	●	●	▲	●	●	—	—	—	—	—	—	—
			09T308N-FB	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	●	●	▲	●	●	—	—	—	—	—	—	—
	LU 15°		CCMT 09T302N-LU	0.2																																					
			09T304N-LU	0.4	●	●	●		●	●			●	●		●													●	—	●	●	▲	●	●							
			09T308N-LU	0.8	●	●	●		●	●			●	●		●													●	—	●	●	▲	●	●							
	LUW →B131 修光刃 10°		CCMT 09T304N-LUW	0.4	●	●	●		●	●						●															●	●	▲		●							
			09T308N-LUW	0.8	●	●	●		●	●						●															●	●	▲		●							
	FP 10°		CCMT 09T302N-FP	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	—	—	—	—	—	—
			09T304N-FP	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	—	—	—	—	—	—
精切削	**FC** 15°		CCGT 09T301MN-FC	< 0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	●	—	—	—	●	●	—	—	—	—	—	—	—
			09T302MN-FC	< 0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	●	—	—	—	●	●	—	—	—	—	—	—	—
			09T304MN-FC	< 0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	●	—	—	—	●	●	—	—	—	—	—	—	—
	FX 15°		CCGT 09T3003R-FX	0.03	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	●	●	—	—	—	—	●	●	—	—	—	—	—	—	—
			09T3003L-FX	0.03	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	●	●	—	—	—	—	●	●	—	—	—	—	—	—	—
			09T301R-FX	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	●	●	—	●	—	—	●	●	—	—	—	—	—	—	—
			09T301L-FX	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	●	●	—	●	—	—	●	●	—	—	—	—	—	—	—
			09T302R-FX	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	●	●	—	●	—	—	●	●	—	—	—	—	—	—	—
			09T302L-FX	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	●	●	—	●	—	—	●	●	—	—	—	—	—	—	—
			09T304R-FX	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—
			09T304L-FX	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—
			09T308R-FX	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—
			09T308L-FX	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—
	FX  15°		CCET 09T3003R-FX	0.03	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	●	—	—	—	—	—	—	—	—	—	—	—	—
			09T3003L-FX	0.03	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	●	—	—	—	—	—	—	—	—	—	—	—	—
			09T301R-FX	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	●	—	—	—	—	—	—	—	—	—	—	—	—
			09T301L-FX	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	●	—	—	—	—	—	—	—	—	—	—	—	—
			09T302R-FX	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	●	—	—	—	—	—	—	—	—	—	—	—	—
			09T302L-FX	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	●	—	—	—	—	—	—	—	—	—	—	—	—
			09T304R-FX	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	●	—	—	—	—	—	—	—	—	—	—	—	—
			09T304L-FX	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	●	—	—	—	—	—	—	—	—	—	—	—	—

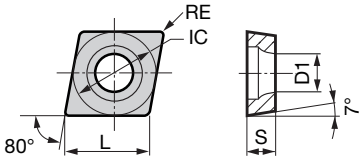
用“<”表示刀尖半径RE的产品，表示其为负公差。

▲记号：计划在将来被新产品替换、改为接单生产或停止生产（请确认有无库存）

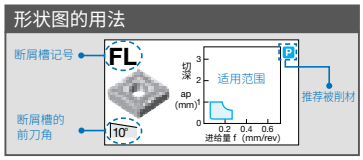
80° 菱形正型刀片

机夹式刀片

CC 80°菱形 7°正型 带孔



形状图的用法



●: 连续切削 第一推荐
○: 连续切削 第二推荐
◕: 一般切削 第一推荐
◔: 一般切削 第二推荐
✖: 断续切削 第一推荐
✖: 断续切削 第二推荐

CC■■09T3●●

尺寸 (mm)	切刃长度L	9.7	厚度S	3.97
	内切圆IC	9.525	孔径D1	4.4

住友CBN(CBN)刀片☞L47～ 住友金刚石(PCD)刀片☞M11
无粘合剂住友金刚石刀片☞M28
适用外径刀杆☞C13、D13、D17、D22、D23 适用内径刀杆☞E12、E18～E20

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◕	◕	✖	○	◕	⚙		◔			◔								⚙		⚙	◕			◕	✖	⚙	●	◕								
M 不锈钢				⚙			⚙	●	◕	✖	○	◔								⚙		⚙	◕	⚙														
K 铸铁			⚙			⚙							●	◕	✖	○	◔			⚙		⚙		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◔	⚙	⚙														
H 高硬度材																		●																				

	涂层																									涂层金属陶瓷			金属陶瓷		硬质合金							
	CVD									P/D	CVD							PVD								PVD												
形状 / 型号	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1

	形状	适用范围	型号	RE	刀尖半径
精切削	**FY**		CCET 09T3003R-FY	0.03	
			09T3003L-FY	0.03	
			09T3008R-FY	0.08	
			09T3008L-FY	0.08	
			09T301R-FY	0.1	
			09T301L-FY	0.1	
			09T3018R-FY	0.18	
			09T3018L-FY	0.18	
			09T302R-FY	0.2	
			09T302L-FY	0.2	
			09T304R-FY	0.4	
			09T304L-FY	0.4	
轻切削	**LB**		CCMT 09T302N-LB	0.2	
			09T304N-LB	0.4	
			09T308N-LB	0.8	
	SU		CCMT 09T302N-SU	0.2	
			09T304N-SU	0.4	
			09T308N-SU	0.8	
	SI		CCGT 09T301MN-SI	< 0.1	
			09T302MN-SI	< 0.2	
			09T304MN-SI	< 0.4	
	SC		CCGT 09T3003N-SC	0.03	
			CCGT 09T301MN-SC	< 0.1	
			09T302MN-SC	< 0.2	
			CCMW 09T304	0.4	
			09T308	0.8	
			CCGW 09T300	0	
			09T301	0.1	
			09T304 New	0.4	
			09T308 New	0.8	
轻～中切削	**GU**		CCMT 09T304N-GU	0.4	
			09T308N-GU	0.8	
	MU		CCMT 09T304N-MU	0.4	
			09T308N-MU	0.8	

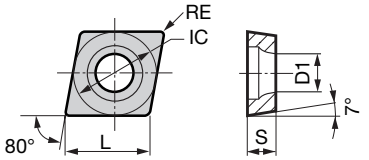
用“<”表示刀尖半径RE的产品，表示其为负公差。

▲记号：计划在将来被新产品替换、改为接单生产或停止生产（请确认有无库存）

80° 菱形正型刀片

机夹式刀片

CC 80°菱形 7°正型 带孔



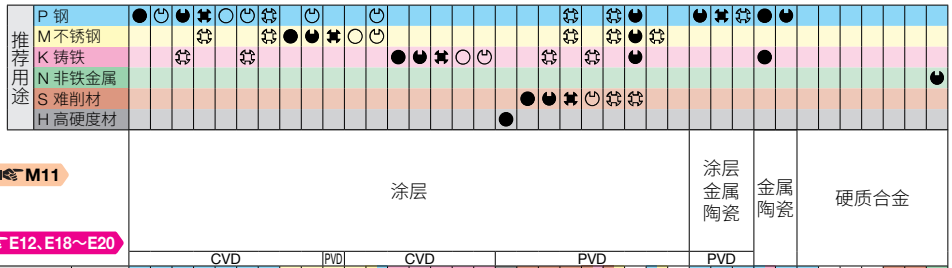
材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4～
按被削材分类的刀片材质选择要领 ☞A10～

●：连续切削 第一推荐
○：连续切削 第二推荐
◕：一般切削 第一推荐
◔：一般切削 第二推荐
✖：断续切削 第一推荐
✪：断续切削 第二推荐

CC■■09T3●●

尺寸 (mm)	切刃长度L	9.7	厚度S	3.97
	内切圆IC	9.525	孔径D1	4.4

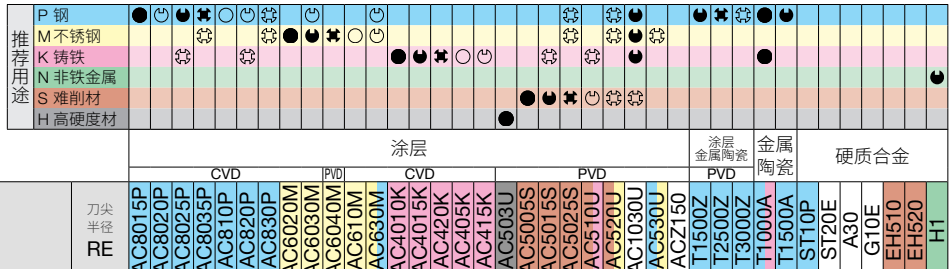
住友CBN(CBN)刀片☞L47～　住友金刚石(PCD)刀片☞M11
无粘合剂住友金刚石刀片☞M28
适用外径刀杆 ☞C13、D13、D17、D22、D23　适用内径刀杆 ☞E12、E18～E20



	形状	适用范围	型号	刀尖半径 RE
铝材用	AG	N	CCGT 09T302N-AG	0.2
			09T304N-AG	0.4
			09T308N-AG	0.8
	AY	N	CCGT 09T301R-AY	0.1
			09T301L-AY	0.1
			09T302R-AY	0.2
			09T302L-AY	0.2
			09T304R-AY	0.4
			09T304L-AY	0.4

CC■■1204●●

尺寸 (mm)	切刃长度L	12.9	厚度S	4.76
	内切圆IC	12.7	孔径D1	5.5

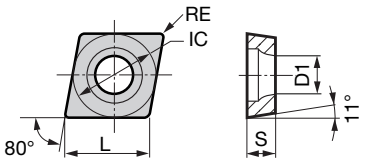


	形状	适用范围	型号	刀尖半径 RE
精切削	FP	P	CCMT 120404N-FP	0.4
			120408N-FP	0.8
轻切削	SU	P	CCMT 120404N-SU	0.4
			120408N-SU	0.8
	SC	P	CCMT 120408N-SC	0.8
轻～中切削	GU	P	CCMT 120408N-GU	0.8

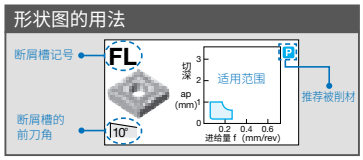
80° 菱形正型刀片

机夹式刀片

CP 80°菱形 11°正型 带孔



形状图的用法

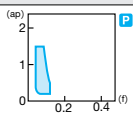
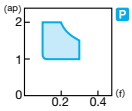


●：连续切削 第一推荐
○：连续切削 第二推荐
◕：一般切削 第一推荐
◔：一般切削 第二推荐
✖：断续切削 第一推荐
✪：断续切削 第二推荐

CP■■0602●●

尺寸(mm)				
	切刃长度L	6.4	厚度S	2.38
	内切圆IC	6.35	孔径D1	2.8

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◕	✖	○	◔	✪		◔			◔									✪		✪	◕			◕	✖	✪	●	◕							
M 不锈钢				✪			✪	●	◕	✖	○	◔									✪		✪	◕	✪													
K 铸铁			✪			✪							●	◕	✖	○	◔			✪		✪		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◔	✪	✪														
H 高硬度材																		●																				

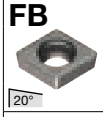
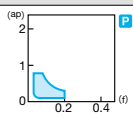
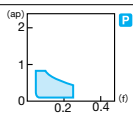
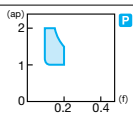
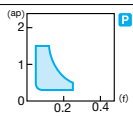
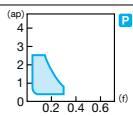
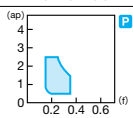
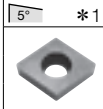
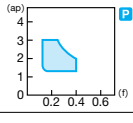
	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
精切削	FX 15°		CPGT 060204L-FX	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●			●	●								
轻切削	US 10°		CPMT 060204N-US	0.4												●						—					—	—	—	—	—	—	—	—	—	●	●				—

CP■■0802●●

尺寸(mm)				
	切刃长度L	8.0	厚度S	2.38
	内切圆IC	7.94	孔径D1	3.4

住友CBN（CBN）刀片☞L52　住友金刚石（PCD）刀片☞M11
适用内径刀杆☞E21、E22

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◕	✖	○	◔	✪		◔			◔									✪		✪	◕			◕	✖	✪	●	◕							
M 不锈钢				✪			✪	●	◕	✖	○	◔									✪		✪	◕	✪													
K 铸铁			✪			✪							●	◕	✖	○	◔			✪		✪		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◔	✪	✪														
H 高硬度材																		●																				

	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
精切削	FB  20°		CPMT 080204N-FB	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	●	●	▲	●	●	—	—	—	—	—	—	—
	LU 15°		CPMT 080204N-LU	0.4	●	●	●			●												—						—	—	—	●	●	▲	●	●							
精～轻切削	SD 0°		CPGT 080202N-SD	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—			●	●	●								●	●							
			080204N-SD	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—			●	●	●					●	●	▲	●	●				●			
			080208N-SD	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—			●	●	●					●	●		●	●							
轻切削	LB 15°		CPMT 080204N-LB	0.4		●	●	●		●	●	●	●	●								—					—		—	●	●	▲		●							
	SU 8°		CPMT 080204N-SU	0.4	●	●	●	●	●	●	●				▲	●						—	●	●	●			—		—	●	●		●	●							
			080208N-SU	0.8	●	●	●	●	●	●	●				▲	●						—	●	●	●			—		—	●	●	▲	●	●							
	SS 5° ＊1		CPMT 080208N-SS	0.8												●						—					—		—	—	—	—	—	—	—		●				—
			CPMW 080204	0.4													●	●	●	▲	▲	—						—		—	—	—	—	—	—						—
			080208	0.8													●	●	●	▲	▲	—						—		—	—	—	—	—	—						—
轻～中切削	MU 0°		CPMT 080204N-MU	0.4	●	●	●		●	●						●	●	●	●	▲	▲	—						—		—	—	—	—	—	—						—
			080208N-MU	0.8	●	●	●		●	●						●	●	●	●	▲	▲	—						—		—	—	—	—	—	—						—

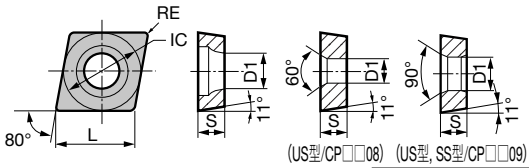
＊1：孔径D1=4.8。

▲记号：计划在将来被新产品替换、改为接单生产或停止生产（请确认有无库存）

80° 菱形正型刀片

机夹式刀片

CP 80°菱形 11°正型 带孔



材质选择要领 ☞A2

刀片断屑槽选择要领 ☞B4～

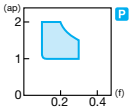
按被削材分类的刀片材质选择要领 ☞A10～

●：连续切削 第一推荐　○：连续切削 第二推荐　◕：一般切削 第一推荐　◔：一般切削 第二推荐　✖：断续切削 第一推荐　✪：断续切削 第二推荐

CP■■0803●●

尺寸(mm)	切刃长度L	8.0	厚度S	3.18
	内切圆IC	7.94	孔径D1	3.4

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◕	✖	○	◔	✪		◔			◔									✪		✪	◕			◕	✖	✪	●	◕							
M 不锈钢			✪				✪	●	◕	✖	○	◔									✪		✪	◕	✪													
K 铸铁				✪			✪						●	◕	✖	○	◔			✪		✪		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◔	✪	✪														
H 高硬度材																		●																				

	形状	适用范围	型号	刀尖半径RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
轻切削	US 10°		CPMT 080308N-US	0.8												●						—								—	—	—	—	—	—		●	●				—

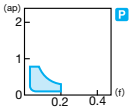
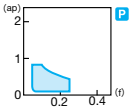
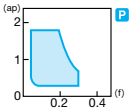
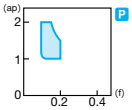
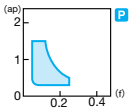
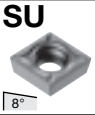
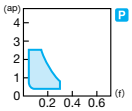
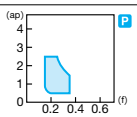
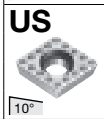
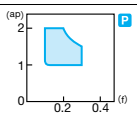
CP■■0903●●

尺寸(mm)	切刃长度L	9.7	厚度S	3.18
	内切圆IC	9.525	孔径D1	4.4

住友CBN(CBN)刀片☞L53　住友金刚石(PCD)刀片☞M11

适用内径刀杆 ☞E12、E21、E22

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◕	✖	○	◔	✪		◔			◔									✪		✪	◕			◕	✖	✪	●	◕							
M 不锈钢			✪				✪	●	◕	✖	○	◔									✪		✪	◕	✪													
K 铸铁				✪			✪						●	◕	✖	○	◔			✪		✪		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◔	✪	✪														
H 高硬度材																		●																				

	形状	适用范围	型号	刀尖半径RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
精切削	FB 20°		CPMT 090304N-FB	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	●	●	▲	●	●	—	—	—	—	—	—	—
			090308N-FB	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	●	●	▲	●	●	—	—	—	—	—	—	—
	LU 15°		CPMT 090304N-LU	0.4	●	●	●		●	●			●	●		●						—						—		—	●	●	▲	●	●							
			090308N-LU	0.8	●	●	●		●	●			●	●		●						—						—		—	●	●	▲	●	●							
	LUW 10° →B131 修光刃		CPMT 090304N-LUW	0.4	●	●	●		●	●						●						—						—		—	●	●	▲		●							
			090308N-LUW	0.8	●	●	●		●	●						●						—						—		—	●	●	▲		●							
精～轻切削	SD 0°		CPGT 090302N-SD	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—		●	●	●									●	●						
			090304N-SD	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—		●	●	●						●	●	▲	●	●				●			
			090308N-SD	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—		●	●	●						●	●		●	●							
轻切削	LB 15°		CPMT 090304N-LB	0.4		●	●	●		●	●	●	●	●								—						—		—	●	●	▲		●							
			090308N-LB	0.8		●	●	●		●	●	●	●	●								—						—		—	●	●	▲		●							
	SU  8°		CPMT 090304N-SU	0.4	●	●	●	●	●	●	●	●	●	●	▲	●						—	●	●	●			—		—	●	●	▲	●	●							
			090308N-SU	0.8	●	●	●	●	●	●	●	●	●	●	▲	●						—	●	●	●			—		—	●	●	▲	●	●							
	SS 5° ＊1		CPMH 090308N-SS	0.8												●						—						—		—	—	—	—	—	—		●					—
	US  10°		CPMH 090304N-US	0.4																		—						—		—	—	—	—	—	—							—
			090308N-US	0.8												●						—						—		—	—	—	—	—	—		●					—

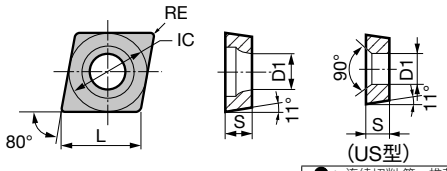
＊1：孔径D1=4.8。

▲记号：计划在将来被新产品替换、改为接单生产或停止生产（请确认有无库存）

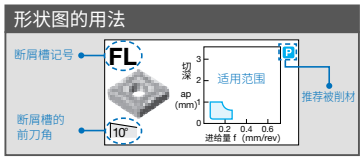
80° 菱形正型刀片

机夹式刀片

CP 80°菱形 11°正型 带孔



形状图的用法



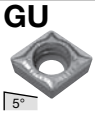
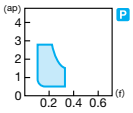
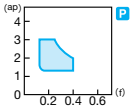
●：连续切削 第一推荐
○：连续切削 第二推荐
：一般切削 第一推荐
：一般切削 第二推荐
：断续切削 第一推荐
：断续切削 第二推荐

CP■■0903●●

尺寸 (mm)				
	切刃长度L	9.7	厚度S	3.18
	内切圆IC	9.525	孔径D1	4.4

住友CBN（CBN）刀片 L53　住友金刚石（PCD）刀片 M11
适用内径刀杆 E12、E21、E22

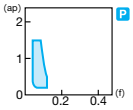
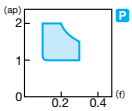
推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◕	✖	○	◔	✿		◔			◔									✿		✿	◕			◕	✖	✿	●	◕							
M 不锈钢				✿			✿	●	◕	✖	○	◔									✿		✿	◕	✿													
K 铸铁			✿			✿							●	◕	✖	○	◔			✿		✿		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◔	✿	✿														
H 高硬度材																		●																				

	形状	适用范围	型　号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
轻切削			CPMW 090304	0.4													●	●	●	▲	▲	—						—		—												
			090308	0.8													●	●	●	▲	▲	—						—		—												
轻～中切削	GU  5°		CPMT 090304N-GU	0.4	●	●	●	●				●	●	●								—						—		—	●	●			●							
			090308N-GU	0.8	●	●	●	●				●	●	●								—						—		—	●	●			●							
	MU 0°		CPMT 090304N-MU	0.4	●	●	●		●	●		●	●			●	●	●	●	▲	▲	—						—		—	—	—	—	—	—							—
			090308N-MU	0.8	●	●	●		●	●		●	●			●	●	●	●	▲	▲	—						—		—	—	—	—	—	—							—

CP■■09T3●●

尺寸 (mm)				
	切刃长度L	9.7	厚度S	3.97
	内切圆IC	9.525	孔径D1	4.4

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◕	✖	○	◔	✿		◔			◔									✿		✿	◕			◕	✖	✿	●	◕							
M 不锈钢				✿			✿	●	◕	✖	○	◔									✿		✿	◕	✿													
K 铸铁			✿			✿							●	◕	✖	○	◔			✿		✿		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◔	✿	✿														
H 高硬度材																		●																				

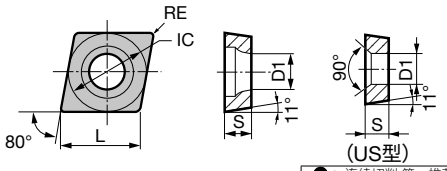
	形状	适用范围	型　号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
精切削	FX 15°		CPGT 09T308L-FX	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
轻切削	US 10°		CPMT 09T308N-US	0.8												●						—						—		—	—	—	—	—	—			●	●			—

刀片 B 负型 正型 C D R S T V W 整体CBN 陶瓷

▲记号：计划在将来被新产品替换、改为接单生产或停止生产（请确认有无库存）

80° 菱形正型刀片

CP 80°菱形 11°正型 带孔



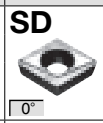
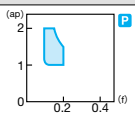
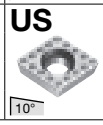
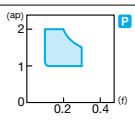
材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4～
按被削材分类的刀片材质选择要领 ☞A10～

●：连续切削 第一推荐
○：连续切削 第二推荐
◕：一般切削 第一推荐
◔：一般切削 第二推荐
✖：断续切削 第一推荐
✪：断续切削 第二推荐

CP■■1204●●

尺寸 (mm)	切刃长度L	12.9	厚度S	4.76
	内切圆IC	12.7	孔径D1	5.5

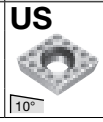
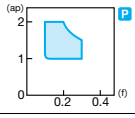
推荐用途	涂层	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
		CVD									PVD	CVD							PVD									PVD											
																												涂层金属陶瓷			金属陶瓷		硬质合金					
P 钢		●	◔	◕	✖	○	◔	✪		◔			◔								✪		✪	◕				◕	✖	✪	●	◕							
M 不锈钢					✪			✪	●	◕	✖	○	◔								✪		✪	◕	✪														
K 铸铁				✪			✪							●	◕	✖	○	◔			✪		✪		◕						●								
N 非铁金属																																							◕
S 难削材																				●	◕	✖	◔	✪	✪														
H 高硬度材																			●																				

	形状	适用范围	型 号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
精～轻切削	SD  0°		CPGT 120402N-SD	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—		●	●	●							●	●					●			
			120404N-SD	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—		●	●	●						●			●	●				●			
			120408N-SD	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—		●	●	●									●	●							
轻切削	US  10°		CPMH 120408N-US	0.8												●						—						—		—	—	—	—	—	—			●	●			—

CP■■1604●●

尺寸 (mm)	切刃长度L	16.1	厚度S	4.76
	内切圆IC	15.875	孔径D1	6.5

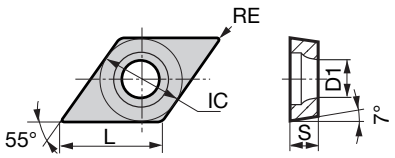
推荐用途	涂层	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
		CVD									PVD	CVD							PVD									PVD											
																												涂层金属陶瓷			金属陶瓷		硬质合金					
P 钢		●	◔	◕	✖	○	◔	✪		◔			◔								✪		✪	◕				◕	✖	✪	●	◕							
M 不锈钢					✪			✪	●	◕	✖	○	◔								✪		✪	◕	✪														
K 铸铁				✪			✪							●	◕	✖	○	◔			✪		✪		◕						●								
N 非铁金属																																							◕
S 难削材																				●	◕	✖	◔	✪	✪														
H 高硬度材																			●																				

	形状	适用范围	型 号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
轻切削	US  10°		CPMH 160408N-US	0.8												●						—						—		—	—	—	—	—	—			●					—

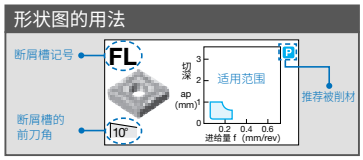
55° 菱形正型刀片

机夹式刀片

DC 55°菱形 7°正型 带孔



形状图的用法



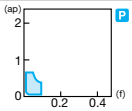
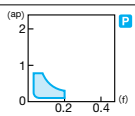
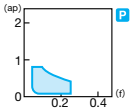
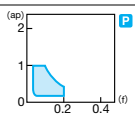
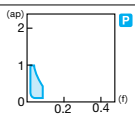
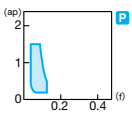
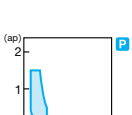
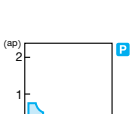
●：连续切削 第一推荐
○：连续切削 第二推荐
◕：一般切削 第一推荐
◔：一般切削 第二推荐
✖：断续切削 第一推荐
✪：断续切削 第二推荐

DC■■0702●●

尺寸 (mm)				
	切刃长度L	7.7	厚度S	2.38
	内切圆IC	6.35	孔径D1	2.8

住友CBN(CBN)刀片 L62、L63　住友金刚石(PCD)刀片 M12　无粘合剂住友金刚石刀片 M28
适用外径刀杆 C19、D14、D18、D19、D24、D25　适用内径刀杆 E16、E26～E30

推荐用途	涂层 CVD																																											
	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC2Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◕	✖	○	◔	✪		◔				◔								✪			✪	◕		◕	✖	✪	●	◕													
M 不锈钢				✪			✪	●	◕	✖	○	◔									✪			✪	◕	✪																	
K 铸铁			✪			✪							●	◕	✖	○	◔			✪		✪			◕					●													
N 非铁金属																																												◕
S 难削材																			●	◕	✖	◔	✪	✪																			
H 高硬度材																		●																										

	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC2Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
微小切削	FF 15°		DCGT 070201MN-FF New	< 0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			070202MN-FF New	< 0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			070204MN-FF New	< 0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	FB 20°		DCMT 070202N-FB	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	●	●	▲	●	●	—	—	—	—	—	—	—	—	—
			070204N-FB	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	●	●	▲	●	●	—	—	—	—	—	—	—	—	—
			070208N-FB	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	●	●	▲	●	●	—	—	—	—	—	—	—	—	—
	LU 15°		DCMT 070202N-LU	0.2	●	●	●		●	●		●	●	●		●						—						—	●	—	●	●	▲	●	●								
			070204N-LU	0.4	●	●	●		●	●		●	●	●		●						—						—	●	—	●	●	▲	●	●								
	FP 10°		DCMT 070202N-FP	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	—	—	—	—	—	—	—
			070204N-FP	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	—	—	—	—	—	—	—
	FC 15°		DCGT 070201MN-FC	< 0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	●	—	●	●	●	●	—	—	—	●	●	—	—	—	—	—	—	—	—
			070202MN-FC	< 0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	●	—	●	●	●	●	—	—	—	●	●	—	—	—	—	—	—	—	—
			070204MN-FC	< 0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	●	—	●	●	●	●	—	—	—	●	●	—	—	—	—	—	—	—	—
精切削	FX 15°		DCGT 0702003R-FX	0.03	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	●	—	●	●	●	—	—	—	—	●	●	—	—	—	—	—	—	—	—
			0702003L-FX	0.03	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	●	—	●	●	●	—	—	—	—	●	●	—	—	—	—	—	—	—	—
			070201R-FX	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	●	—	●	●	●	—	●	—	—	●	●	—	—	—	—	—	—	—	—
			070201L-FX	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	●	—	●	●	●	—	●	—	—	●	●	—	—	—	—	—	—	—	—
			070202R-FX	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	●	—	●	●	●	—	●	—	—	●	●	—	—	—	—	—	—	—	—
			070202L-FX	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	●	—	●	●	●	—	●	—	—	●	●	—	—	—	—	—	—	—	—
			070204R-FX	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	—	—	—	—	—	—	—
			070204L-FX	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	—	—	—	—	—	—	—
	FX 15°		DCET 0702003R-FX	0.03	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			0702003L-FX	0.03	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			0702008R-FX	0.08	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			0702008L-FX	0.08	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			070201R-FX	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			070201L-FX	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			0702018R-FX	0.18	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			0702018L-FX	0.18	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			070204R-FX	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			070204L-FX	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	FYS 15°		DCGT 0702003R-FYS	0.03	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			0702003L-FYS	0.03	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			070201R-FYS	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			070201L-FYS	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			070202R-FYS	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			070202L-FYS	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			070204R-FYS	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			070204L-FYS	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—

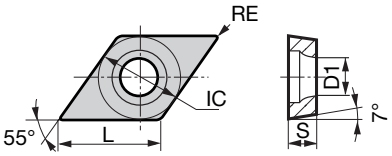
用“<”表示刀尖半径RE的产品，表示其为负公差。

▲记号：计划在将来被新产品替换、改为接单生产或停止生产（请确认有无库存）

55° 菱形正型刀片

机夹式刀片

DC 55°菱形 7°正型 带孔



材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4～
按被削材分类的刀片材质选择要领 ☞A10～

●：连续切削 第一推荐 ○：连续切削 第二推荐 ◕：一般切削 第一推荐 ◔：一般切削 第二推荐 ✖：断续切削 第一推荐 ✪：断续切削 第二推荐

DC■■0702●●

尺寸(mm)	切刃长度L	7.7	厚度S	2.38
	内切圆IC	6.35	孔径D1	2.8

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◕	✖	○	◔	✪		◔			◔									✪		✪	◕			◕	✖	✪	●	◕							
M 不锈钢			✪				✪	●	◕	✖	○	◔									✪		✪	◕	✪													
K 铸铁				✪			✪						●	◕	✖	○	◔			✪		✪		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◔	✪	✪														
H 高硬度材																		●																				

住友CBN(CBN)刀片☞L62、L63　住友金刚石(PCD)刀片☞M12　无粘合剂住友金刚石刀片☞M28

适用外径刀杆 ☞C19、D14、D18、D19、D24、D25　适用内径刀杆 ☞E16、E26～E30

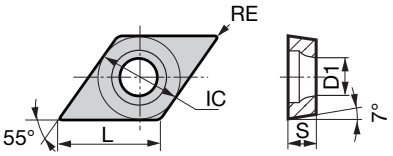
	形状	适用范围	型号	刀尖半径RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
精切削	**FYS**		DCET 0702003R-FYS	0.03																								●														
			0702003L-FYS	0.03																								●														
			070201R-FYS	0.1																								●														
			070201L-FYS	0.1																								●														
			070202R-FYS	0.2																								●														
			070202L-FYS	0.2																								●														
			070204R-FYS	0.4																								●														
			070204L-FYS	0.4																								●														
	FY		DCGT 0702003R-FY	0.03																				●	●		●	●	●													
			0702003L-FY	0.03																				●	●		●	●	●													
			070201R-FY	0.1																				●	●		●	●	●					●								
			070201L-FY	0.1																				●	●		●	●	●					●								
			070202R-FY	0.2																				●	●		●	●	●					●								
			070202L-FY	0.2																				●	●		●	●	●					●								
			070204R-FY	0.4																				●	●		●	●	●					●								
			070204L-FY	0.4																				●	●		●	●	●					●								
精切削	**FY**		DCET 0702003R-FY	0.03																								●		●												
			0702003L-FY	0.03																								●		●												
			0702008R-FY	0.08																								●		●												
			0702008L-FY	0.08																								●		●												
			070201R-FY	0.1																								●		●												
			070201L-FY	0.1																								●		●												
			0702018R-FY	0.18																								●		●												
			0702018L-FY	0.18																								●		●												
			070202R-FY	0.2																																						
			070202L-FY	0.2																																						
			070204R-FY	0.4																								●		●												
			070204L-FY	0.4																								●		●												
精～轻切削	**SD**		DCGT 070202R-SD	0.2																											●			●	●							
			070202L-SD	0.2																											●			●	●							
			070204R-SD	0.4																											●			●	●							
			070204L-SD	0.4																											●			●	●							
轻切削	**LB**		DCMT 070202N-LB	0.2		●	●	●		●	●	●	●	●								—						—		—	●	●	▲		●							
			070204N-LB	0.4		●	●	●		●	●	●	●	●								—						—		—	●	●	▲		●							
			070208N-LB	0.8		●	●	●		●	●	●	●	●								—						—		—	●	●	▲		●							
轻切削	**SU**		DCMT 070202N-SU	0.2	●	●	●	●		●	●	●	●	●	▲	●						—	●	●	●			—	●	—	●	●	▲	●	●							
			070204N-SU	0.4	●	●	●	●	●	●	●	●	●	●	▲	●		●				—	●	●	●			—	●	—	●	●	▲	●	●							
			070208N-SU	0.8	●	●	●	●	●	●	●	●	●	●	▲	●		●				—	●	●	●			—		—	●	●	▲	●	●							
	SI		DCGT 070201MN-SI	< 0.1											▲	●						—		●	●	●	●	●	●		●	●		●	●							
			070202MN-SI	< 0.2											▲	●						—		●	●	●	●	●	●		●	●		●	●							
			070204MN-SI	< 0.4											▲	●						—		●	●	●	●	●	●		●	●		●	●							
	SC		DCGT 0702003N-SC	0.03																		—						●	●	●				●	●							
			DCGT 070201MN-SC	< 0.1																		—						●	●	●	●	●		●	●	—	—	—				
			070202MN-SC	< 0.2																		—						●	●	●	●	●		●	●	—	—	—				
			070204MN-SC	< 0.4																		—								●	●	●		●	●	—	—	—				

用“<”表示刀尖半径RE的产品，表示其为负公差。

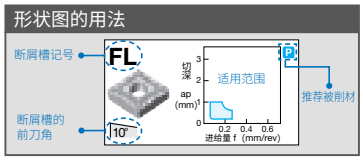
▲记号：计划在将来被新产品替换、改为接单生产或停止生产（请确认有无库存）

55° 菱形正型刀片

DC 55°菱形 7°正型 带孔



形状图的用法



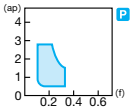
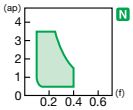
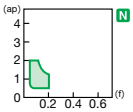
●: 连续切削 第一推荐
○: 连续切削 第二推荐
: 一般切削 第一推荐
: 一般切削 第二推荐
: 断续切削 第一推荐
: 断续切削 第二推荐

DC■■0702●●

尺寸 (mm)				
	切刃长度L	7.7	厚度S	2.38
	内切圆IC	6.35	孔径D1	2.8

住友CBN(CBN)刀片 L62、L63　住友金刚石(PCD)刀片 M12　无粘合剂住友金刚石刀片 M28
适用外径刀杆 C19、D14、D18、D19、D24、D25　适用内径刀杆 E16、E26～E30

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◐	◕	✖	○	◐	✿		◐			◐									✿		✿	◕			◕	✖	✿	●	◕							
M 不锈钢				✿			✿	●	◕	✖	○	◐									✿		✿	◕	✿													
K 铸铁			✿			✿							●	◕	✖	○	◐			✿		✿		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◐	✿	✿														
H 高硬度材																		●																				

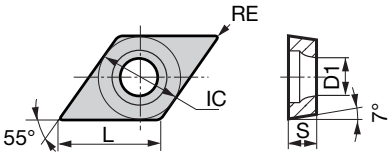
	形状	适用范围	型 号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
轻切削			DCMW 070204	0.4													●	●	●	▲	▲	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			070208	0.8													●	●	●	▲	▲	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
轻切削			DCGW 070200	0	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			070201	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			070202	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			070204	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●
			070208	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●
轻～中切削	GU 5°		DCMT 070204N-GU	0.4	●	●	●	●				●	●	●								—					—		—	●	●			●							
			070208N-GU	0.8	●	●	●	●				●	●	●								—					—		—	●	●			●							
铝材用	AG 20°		DCGT 070202N-AG	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●
			070204N-AG	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●
铝材用	AY 15°		DCGT 070201R-AY	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●
			070201L-AY	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●
			070202R-AY	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●
			070202L-AY	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●
			070204R-AY	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●
			070204L-AY	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●

▲记号: 计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

55° 菱形正型刀片

机夹式刀片

DC 55°菱形 7°正型 带孔

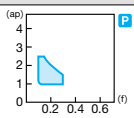


材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4～
按被削材分类的刀片材质选择要领 ☞A10～

●：连续切削 第一推荐　○：连续切削 第二推荐　◕：一般切削 第一推荐　◔：一般切削 第二推荐　✖：断续切削 第一推荐　✪：断续切削 第二推荐

DC■■0902●●

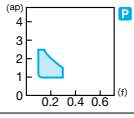
尺寸 (mm)	切刃长度L	9.7	厚度S	2.38
	内切圆IC	7.94	孔径D1	3.4

推荐用途		形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
						涂层																									涂层 金属陶瓷			金属陶瓷		硬质合金							
						CVD									PVD	CVD							PVD								PVD												
P 钢						●	◔	◕	✖	○	◔	✪		◔			◔									✪		✪	◕		◕	✖	✪	●	◕								
M 不锈钢								✪			✪		●	◕	✖	○	◔									✪		✪	◕	✪													
K 铸铁								✪			✪							●	◕	✖	○	◔			✪		✪		◕						●								
N 非铁金属																																											◕
S 难削材																							●	◕	✖	◔	✪	✪															
H 高硬度材																						●																					
轻切削		SC		DCGT 090201MN-SC	< 0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	—	—	—	—	—	—
				090202MN-SC	< 0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	—	—	—	—	—	—
				DCGW 090200	0	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
				090201	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—

用“<”表示刀尖半径RE的产品，表示其为负公差。

DC■■1103●●

尺寸 (mm)	切刃长度L	11.6	厚度S	3.18
	内切圆IC	9.525	孔径D1	4.4

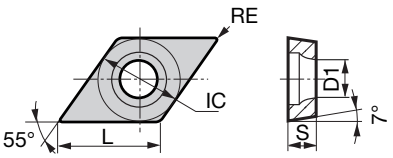
推荐用途		形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
						涂层																									涂层 金属陶瓷			金属陶瓷		硬质合金							
						CVD									PVD	CVD							PVD								PVD												
P 钢						●	◔	◕	✖	○	◔	✪		◔			◔									✪		✪	◕		◕	✖	✪	●	◕								
M 不锈钢								✪			✪		●	◕	✖	○	◔									✪		✪	◕	✪													
K 铸铁								✪			✪							●	◕	✖	○	◔			✪		✪		◕						●								
N 非铁金属																																											◕
S 难削材																							●	◕	✖	◔	✪	✪															
H 高硬度材																						●																					
轻切削		SC		DCGT 110301MN-SC	< 0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	—	—	—	—	—	—
				110302MN-SC	< 0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	—	—	—	—	—	—
				DCGW 110300	0	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
				110301	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—

用“<”表示刀尖半径RE的产品，表示其为负公差。

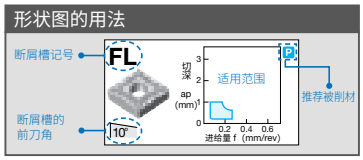
55° 菱形正型刀片

机夹式刀片

DC 55°菱形 7°正型 带孔



形状图的用法



●：连续切削 第一推荐　○：连续切削 第二推荐　◐：一般切削 第一推荐　◔：一般切削 第二推荐　✖：断续切削 第一推荐　✖：断续切削 第二推荐

DC■■11T3●●

尺寸 (mm)	切刃长度L	11.6	厚度S	3.97
	内切圆IC	9.525	孔径D1	4.4

住友CBN(CBN)刀片 L64～　住友金刚石(PCD)刀片 M13　无粘合剂住友金刚石刀片 M28
适用外径刀杆 C19、D14、D18、D19、D24、D25　适用内径刀杆 E13、E26～E30

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC2150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◐	✖	○	◔	✪			◔											✪			✪	◐		◐	✖	✪	●	◐							
M 不锈钢				✪			✪	●	◐	✖	○	◔									✪			✪	◐	✪												
K 铸铁			✪			✪							●	◐	✖	○	◔			✪		✪			◐					●								
N 非铁金属																																						◐
S 难削材																			●	◐	✖	◔	✪	✪														
H 高硬度材																		●																				

	形状	适用范围	型　号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC2150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
微小切削	**FF**		DCGT 11T301MN-FF New	< 0.1																				●	●			●														
			11T302MN-FF New	< 0.2																				●	●			●														
			11T304MN-FF New	< 0.4																				●	●			●														
精切削	**FB**		DCMT 11T302N-FB	0.2																									●		●	●	▲	●	●							
			11T304N-FB	0.4																									●		●	●	▲	●	●							
			11T308N-FB	0.8																									●		●	●	▲	●	●							
	LU		DCMT 11T302N-LU	0.2	●	●	●			●				●															●		●	●	▲	●	●							
			11T304N-LU	0.4	●	●	●		●	●			●	●		●													●		●	●	▲	●	●							
			11T308N-LU	0.8	●	●	●		●	●			●	●		●													●		●	●	▲	●	●							
	FP		DCMT 11T308N-FP	0.8																															●							
	FC		DCGT 11T301MN-FC	< 0.1																				●	●		●	●	●	●					●	●							
			11T302MN-FC	< 0.2																				●	●		●	●	●	●					●	●							
			11T304MN-FC	< 0.4																				●	●		●	●	●	●					●	●							
	FX		DCGT 11T3003R-FX	0.03																				●	●		●	●	●						●	●							
			11T3003L-FX	0.03																				●	●		●	●	●						●	●							
			11T301R-FX	0.1																				●	●		●	●	●						●	●							
			11T301L-FX	0.1																				●	●		●	●	●						●	●							
			11T302R-FX	0.2																				●	●		●	●	●		●				●	●							
			11T302L-FX	0.2																				●	●		●	●	●		●				●	●							
			11T304R-FX	0.4																				●	●			●														
			11T304L-FX	0.4																				●	●			●														
	FX		DCET 11T3003R-FX	0.03																								●		●												
			11T3003L-FX	0.03																								●		●												
			11T3008R-FX	0.08																								●		●												
			11T3008L-FX	0.08																								●		●												
			11T301R-FX	0.1																								●		●												
			11T301L-FX	0.1																								●		●												
			11T3018R-FX	0.18																								●		●												
			11T3018L-FX	0.18																								●		●												
			11T304R-FX	0.4																								●		●												
			11T304L-FX	0.4																								●		●												
	FYS		DCGT 11T3003R-FYS	0.03																				●	●			●														
			11T3003L-FYS	0.03																				●	●			●														
			11T301R-FYS	0.1																				●	●			●														
			11T301L-FYS	0.1																				●	●			●														
			11T302R-FYS	0.2																				●	●			●														
			11T302L-FYS	0.2																				●	●			●														
			11T304R-FYS	0.4																				●	●			●														
			11T304L-FYS	0.4																				●	●			●														

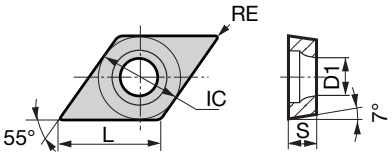
用“<”表示刀尖半径RE的产品，表示其为负公差。

▲记号：计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

55° 菱形正型刀片

机夹式刀片

DC 55°菱形 7°正型 带孔



材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4～
按被削材分类的刀片材质选择要领 ☞A10～

●：连续切削 第一推荐　○：连续切削 第二推荐　◕：一般切削 第一推荐　◔：一般切削 第二推荐　✖：断续切削 第一推荐　✪：断续切削 第二推荐

DC■■11T3●●

尺寸 (mm)	切刃长度L	11.6	厚度S	3.97
	内切圆IC	9.525	孔径D1	4.4

住友CBN(CBN)刀片☞L64～　住友金刚石(PCD)刀片☞M13　无粘合剂住友金刚石刀片☞M28
适用外径刀杆 ☞C19、D14、D18、D19、D24、D25　适用内径刀杆 ☞E13、E26～E30

推荐用途	涂层 CVD									PVD		CVD						PVD							PVD															
	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◕	✖	○	◔	✪		◔			◔									✪		✪	◕			◕	✖	✪	●	◕								
M 不锈钢			✪				✪	●	◕	✖	○	◔									✪		✪	◕	✪														
K 铸铁				✪			✪						●	◕	✖	○	◔			✪		✪		◕						●									
N 非铁金属																																							◕
S 难削材																			●	◕	✖	◔	✪	✪															
H 高硬度材																		●																					

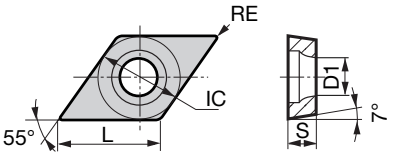
	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
精切削	**FYS**	(ap) 2 1 0 0.2 0.4 (f) P	DCET 11T3003R-FYS	0.03																								●														
			11T3003L-FYS	0.03																								●														
			11T301R-FYS	0.1																								●														
			11T301L-FYS	0.1																								●														
			11T302R-FYS	0.2																								●														
			11T302L-FYS	0.2																								●														
			11T304R-FYS	0.4																								●														
	15°		11T304L-FYS	0.4																								●														
	FY	(ap) 2 1 0 0.2 0.4 (f) P	DCGT 11T3003R-FY	0.03																			●	●		●	●	●														
			11T3003L-FY	0.03																			●	●		●	●	●														
			11T301R-FY	0.1																			●	●		●	●	●						●	●								
			11T301L-FY	0.1																			●	●		●	●	●						●	●								
			11T302R-FY	0.2																			●	●		●	●	●						●	●								
			11T302L-FY	0.2																			●	●		●	●	●						●	●								
			11T304R-FY	0.4																			●	●		●	●	●						●	●								
	15°		11T304L-FY	0.4																			●	●		●	●	●						●	●								
	FY	(ap) 2 1 0 0.2 0.4 (f) P	DCET 11T3003R-FY	0.03																								●		●												
			11T3003L-FY	0.03																								●		●												
			11T3008R-FY	0.08																								●		●												
			11T3008L-FY	0.08																								●		●												
			11T301R-FY	0.1																								●		●												
			11T301L-FY	0.1																								●		●												
			11T3018R-FY	0.18																								●		●												
			11T3018L-FY	0.18																								●		●												
			11T302R-FY	0.2																																						
			11T302L-FY	0.2																																						
			11T304R-FY	0.4																								●		●												
	15°		11T304L-FY	0.4																								●		●												
精～轻切削	**SD**	(ap) 2 1 0 0.2 0.4 (f) P	DCGT 11T304R-SD	0.4																											●			●	●							
			11T304L-SD	0.4																											●			●	●							
			11T308R-SD	0.8																											●			●	●							
	0°		11T308L-SD	0.8																											●			●	●							
轻切削	**LB**	(ap) 2 1 0 0.2 0.4 (f) P	DCMT 11T302N-LB	0.2		●	●	●		●	●	●	●	●																	●	●	▲		●							
			11T304N-LB	0.4		●	●	●		●	●	●	●	●																	●	●	▲		●							
			11T308N-LB	0.8		●	●	●		●	●	●	●	●																	●	●	▲		●							
	15°																																									
	SU	(ap) 4 3 2 1 0 0.2 0.4 0.6 (f) P	DCMT 11T302N-SU	0.2	●	●	●	●		●	●	●	●	●	▲	●							●	●	●				●		●	●	▲	●	●							
			11T304N-SU	0.4	●	●	●	●	●	●	●	●	●	●	▲	●							●	●	●				●		●	●	▲	●	●							
			11T308N-SU	0.8	●	●	●	●	●	●	●	●	●	●	▲	●							●	●	●				●		●	●	▲	●	●							
	8°																																									
	SI	(ap) 4 3 2 1 0 0.2 0.4 0.6 (f) P	DCGT 11T301MN-SI	< 0.1											▲	●							●	●	●	●	●	●			●	●			●	●						
			11T302MN-SI	< 0.2											▲	●							●	●	●	●	●	●			●	●			●	●						
			11T304MN-SI	< 0.4											▲	●							●	●	●	●	●	●			●	●			●	●						
	15°		11T308MN-SI	< 0.8											▲	●							●	●	●	●		●			●	●			●	●						
	SC	(ap) 4 3 2 1 0 0.2 0.4 0.6 (f) P	DCGT 11T3003N-SC	0.03																								●	●	●					●	●						
			DCGT 11T301MN-SC	< 0.1																								●	●	●	●	●			●	●						
			11T302MN-SC	< 0.2																								●	●	●	●	●			●	●						
			11T304MN-SC	< 0.4																								●	●	●	●	●			●	●						
	6°		11T308MN-SC	< 0.8																								●	●		●	●			●	●						

用“<”表示刀尖半径RE的产品，表示其为负公差。

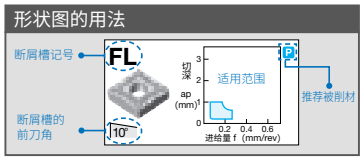
▲记号：计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

55° 菱形正型刀片

DC 55°菱形 7°正型 带孔



形状图的用法



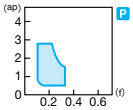
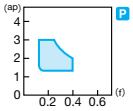
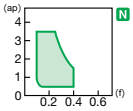
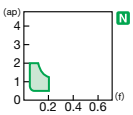
●：连续切削 第一推荐
○：连续切削 第二推荐
◕：一般切削 第一推荐
◔：一般切削 第二推荐
✖：断续切削 第一推荐
✪：断续切削 第二推荐

DC■■11T3●●

尺寸 (mm)	切刃长度L	11.6	厚度S	3.97
	内切圆IC	9.525	孔径D1	4.4

住友CBN(CBN)刀片☞L64～ 住友金刚石(PCD)刀片☞M13 无粘合剂住友金刚石刀片☞M28
适用外径刀杆 ☞C19、D14、D18、D19、D24、D25 适用内径刀杆 ☞E13、E26～E30

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◕	✖	○	◔	✪		◔			◔									✪		✪	◕			◕	✖	✪	●	◕							
M 不锈钢				✪			✪	●	◕	✖	○	◔									✪		✪	◕	✪													
K 铸铁			✪			✪							●	◕	✖	○	◔			✪		✪		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◔	✪	✪														
H 高硬度材																		●																				
	涂层																									涂层金属陶瓷				金属陶瓷		硬质合金						
	CVD									PVD	CVD							PVD								PVD												

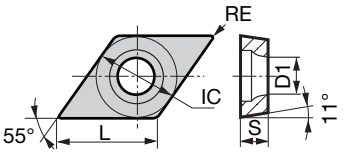
	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
轻切削			DCMW 11T304	0.4													●	●	●	▲	▲	—					—	—	—	—	—	—	—	—	—							—
			11T308	0.8													●	●	●	▲	▲	—					—	—	—	—	—	—	—	—	—							—
轻切削			DCGW 11T300	0	—	—	—	—	—	—	—	—	—	—	—	—																										—
			11T301	0.1	—	—	—	—	—	—	—	—	—	—	—	—																										—
			11T302	0.2	—	—	—	—	—	—	—	—	—	—	—	—						●																				—
			11T304	0.4	—	—	—	—	—	—	—	—	—	—	—	—						●																				—
			11T308	0.8	—	—	—	—	—	—	—	—	—	—	—	—						●																				—
轻～中切削	GU 5°		DCMT 11T302N-GU	0.2	●	●	●	●				●	●	●								—					—	—	—	—	●	●			●							
			11T304N-GU	0.4	●	●	●	●				●	●	●								—					—	—	—	—	●	●			●							
			11T308N-GU	0.8	●	●	●	●				●	●	●								—					—	—	—	—	●	●			●							
			11T312N-GU	1.2			●						●									—					—	—	—	—	—	—	—	—	—							
轻～中切削	MU 0°		DCMT 11T304N-MU	0.4	●	●	●		●	●		●	●			●	●	●	●	▲	▲	—					—	—	—	—	—	—	—	—	—							
			11T308N-MU	0.8	●	●	●	●	●	●	●	●	●			●	●	●	●	▲	▲	—					—	—	—	—	—	—	—	—	—							
铝材用	AG 20°		DCGT 11T302N-AG	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●
			11T304N-AG	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●
			11T308N-AG	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●
铝材用	AY 15°		DCGT 11T301R-AY	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●
			11T301L-AY	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●
			11T302R-AY	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●
			11T302L-AY	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●
			11T304R-AY	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●
			11T304L-AY	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●

▲记号：计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

55° 菱形正型刀片

机夹式刀片

DP 55°菱形 11°正型 带孔



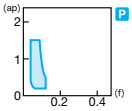
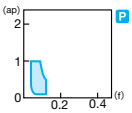
材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4～
按被削材分类的刀片材质选择要领 ☞A10～

●：连续切削 第一推荐 ○：连续切削 第二推荐
●：一般切削 第一推荐 ○：一般切削 第二推荐
✖：断续切削 第一推荐 ✖：断续切削 第二推荐

DP■■0702●●

尺寸 (mm)	切刃长度L	7.7	厚度S	2.38
	内切圆IC	6.35	孔径D1	2.8

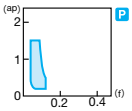
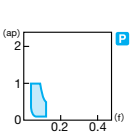
推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
	涂层																										涂层金属陶瓷			金属陶瓷		硬质合金						
	CVD									PVD	CVD							PVD									PVD											
P 钢	●	○	◐	✖	○	○	✪		○			○									✪		✪	◐			◐	✖	✪	●	◐							
M 不锈钢			✪				✪	●	◐	✖	○	○									✪		✪	◐	✪													
K 铸铁			✪			✪							●	◐	✖	○	○			✪		✪		◐						●								
N 非铁金属																																						◐
S 难削材																			●	◐	✖	○	✪	✪														
H 高硬度材																		●																				

	形状	适用范围	型 号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
精切削	FX 15°		DPGT 0702003R-FX	0.03	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			0702003L-FX	0.03	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			070201R-FX	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			070201L-FX	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			070202R-FX	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			070202L-FX	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	FY 15°		DPGT 0702003R-FY	0.03	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			0702003L-FY	0.03	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			070201R-FY	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			070201L-FY	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			070202R-FY	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			070202L-FY	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—

DP■■11T3●●

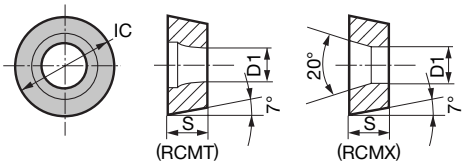
尺寸 (mm)	切刃长度L	11.6	厚度S	3.97
	内切圆IC	9.525	孔径D1	4.4

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
	涂层																										涂层金属陶瓷			金属陶瓷		硬质合金						
	CVD									PVD	CVD							PVD									PVD											
P 钢	●	○	◐	✖	○	○	✪		○			○									✪		✪	◐			◐	✖	✪	●	◐							
M 不锈钢			✪				✪	●	◐	✖	○	○									✪		✪	◐	✪													
K 铸铁			✪			✪							●	◐	✖	○	○			✪		✪		◐						●								
N 非铁金属																																						◐
S 难削材																			●	◐	✖	○	✪	✪														
H 高硬度材																		●																				

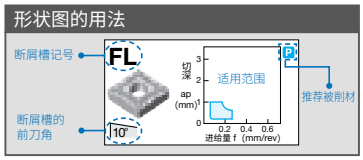
	形状	适用范围	型 号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
精切削	FX 15°		DPGT 11T3003R-FX	0.03	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			11T3003L-FX	0.03	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			11T301R-FX	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			11T301L-FX	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			11T302R-FX	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			11T302L-FX	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	FY 15°		DPGT 11T3003R-FY	0.03	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			11T3003L-FY	0.03	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			11T301R-FY	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			11T301L-FY	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			11T302R-FY	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			11T302L-FY	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—

圆形正型刀片

RC 圆形 7°正型 带孔



形状图的用法



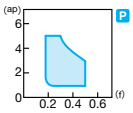
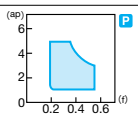
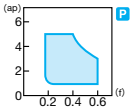
●：连续切削 第一推荐
○：连续切削 第二推荐
：一般切削 第一推荐
：一般切削 第二推荐
：断续切削 第一推荐
：断续切削 第二推荐

RC■■●●●●●●

尺寸 (mm)				
	内切圆IC	10.0~32.0	厚度S	3.18~9.52
	孔径D1	3.6~9.5		

适用外径刀杆 ☞C20

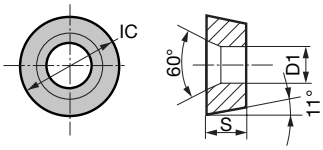
推荐用途	涂层 CVD									PVD		CVD					PVD							涂层 金属陶瓷 PVD				金属陶瓷	硬质合金					
	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◐	◕	✖	○	◐	✪		◐											✪		✪	✪	◕			◕	✖	✪	●	◕							
M 不锈钢				✪			✪	●	◕	✖	○	◐								✪			✪	◕	✪													
K 铸铁			✪			✪							●	◕	✖	○	◐			✪		✪		◕						●								
N 非铁金属																																					◕
S 难削材																			●	◕	✖	◐	✪	✪													
H 高硬度材																		●																			

	形状	适用范围	型 号	IC	S	D1	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
中～粗切削	**RX** -5°		RCMT 1003M0N-RX	10.0	3.18	4.4	●	●	●	●	●	●	●					●																											
			1204M0N-RX	12.0	4.76	4.4	●	●	●	●	●	●	●					●																											
			1606M0N-RX	16.0	6.35	5.0	●	●	●	●	●	●	●					●																											
			2006M0N-RX	20.0	6.35	6.5	●	●	●	●	●	●	●					●																											
			2507M0N-RX	25	7.94	7.6	●	●	●	●	●	●	●					●																											
	RH -5°		RCMT 1204M0N-RH	12	4.76	4.4	●	●	●	●	●	●	●					●																											
			1606M0N-RH	16.0	6.35	5.0	●	●	●	●	●	●	●					●																											
			2006M0N-RH	20	6.35	6.5	●	●	●	●	●	●	●					●																											
粗切削	**RP** -15°		RCMX 1003M0N-RP	10.0	3.18	3.6	●	●	●	●	●	●	●					●	●	●	●	▲	▲																●					
			1204M0N-RP	12	4.76	4.2	●	●	●	●	●	●	●					●	●	●	●	▲	▲		●	●	●	●												●					
			1606M0N-RP	16	6.35	5.2	●	●	●	●	●	●	●					●	●	●	●	▲	▲																	●					
			2006M0N-RP	20.0	6.35	6.5	●	●	●	●	●	●	●					●							●	●	●	●												●					
			2507M0N-RP	25	7.94	7.2	●	●	●	●	●	●	●																																
			3209M0N-RP	32	9.52	9.5	●	●	●		●	●																																	

▲记号：计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

圆形正型刀片

RP 圆形 11°正型 带孔



材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4～
按被削材分类的刀片材质选择要领 ☞A10～

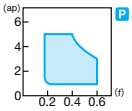
●：连续切削 第一推荐　○：连续切削 第二推荐
◕：一般切削 第一推荐　◔：一般切削 第二推荐
✖：断续切削 第一推荐　✪：断续切削 第二推荐

RP■■●●●●●●

尺寸 (mm)	内切圆IC	8.0～24.0	厚度S	3.18～6.35
	孔径D1	3.3～7.3		

住友金刚石(PCD)刀片☞M26

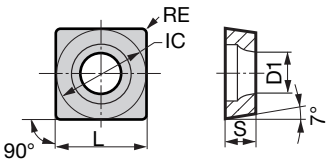
推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
	涂层																										涂层 金属陶瓷			金属陶瓷		硬质合金						
	CVD									PVD	CVD								PVD								PVD											
P 钢	●	◔	◕	✖	○	◔	✪		◔			◔								✪			✪	◕			◕	✖	✪	●	◕							
M 不锈钢				✪			✪	●	◕	✖	○	◔								✪			✪	◕	✪													
K 铸铁			✪			✪							●	◕	✖	○	◔			✪		✪		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◔	✪	✪														
H 高硬度材																		●																				

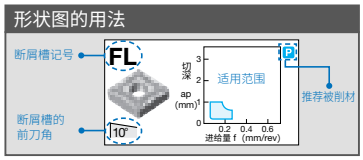
	形状	适用范围	型 号	IC	S	D1	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
中切削			RPGW 0803M0	8	3.18	3.3																				●	●	●													●				
			1004M0	10	4.76	3.8																				●	●	●													●				
			1204M0	12	4.76	4.3																				●	●	●													●				
			1604M0	16.0	4.76	5.3																																			●				
			2004M0	20.0	4.76	6.3																																							
			2406M0	24	6.35	7.3																																							
粗切削	RD 0°		RPGT 0803M0N-RD	8.0	3.18	3.3																															●							
			1004M0N-RD	10	4.76	3.8																															●							
			1204M0N-RD	12	4.76	4.3																															●							
			1604M0N-RD	16.0	4.76	5.3																																							
			2004M0N-RD	20.0	4.76	6.3																																							
			2406M0N-RD	24	6.35	7.3																																							

正方形正型刀片

机夹式刀片

SC 正方形 7°正型 带孔





●：连续切削 第一推荐
○：连续切削 第二推荐
◕：一般切削 第一推荐
◔：一般切削 第二推荐
✖：断续切削 第一推荐
✪：断续切削 第二推荐

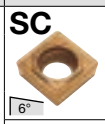
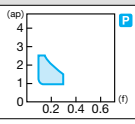
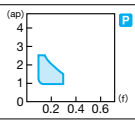
SC■■0702●●

尺寸 (mm)				
	切刃长度L	7.94	厚度S	2.38
	内切圆IC	7.94	孔径D1	3.4

住友金刚石(PCD)刀片 M14

适用外径刀杆 D26

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◕	✖	○	◔	✪		◔			◔									✪		✪	◕			◕	✖	✪	●	◕							
M 不锈钢				✪			✪	●	◕	✖	○	◔									✪		✪	◕	✪													
K 铸铁			✪			✪							●	◕	✖	○	◔			✪		✪		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◔	✪	✪														
H 高硬度材																		●																				

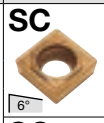
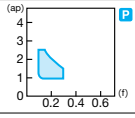
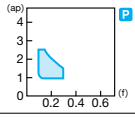
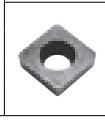
	形状	适用范围	型 号	刀尖半径 RE
轻切削			SCMT 070204N-SC	0.4
轻切削			SCGT 070201MN-SC 070202MN-SC	< 0.1 < 0.2
			SCGW 070200 070201	0 0.1

用“<”表示刀尖半径RE的产品，表示其为负公差。

SC■■0903●●

尺寸 (mm)				
	切刃长度L	9.525	厚度S	3.18
	内切圆IC	9.525	孔径D1	4.4

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◕	✖	○	◔	✪		◔			◔									✪		✪	◕			◕	✖	✪	●	◕							
M 不锈钢				✪			✪	●	◕	✖	○	◔									✪		✪	◕	✪													
K 铸铁			✪			✪							●	◕	✖	○	◔			✪		✪		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◔	✪	✪														
H 高硬度材																		●																				

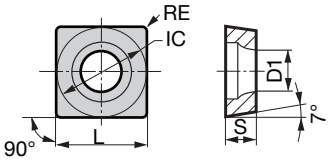
	形状	适用范围	型 号	刀尖半径 RE
轻切削			SCMT 090308N-SC	0.8
轻切削			SCGT 090301MN-SC 090302MN-SC	< 0.1 < 0.2
			SCGW 090300 090301	0 0.1

用“<”表示刀尖半径RE的产品，表示其为负公差。

正方形正型刀片

机夹式刀片

SC 正方形 7°正型 带孔



材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4～
按被削材分类的刀片材质选择要领 ☞A10～

●：连续切削 第一推荐　○：连续切削 第二推荐　◕：一般切削 第一推荐　◔：一般切削 第二推荐　✖：断续切削 第一推荐　✪：断续切削 第二推荐

SC■■09T3●●

尺寸(mm)	切刃长度L	9.525	厚度S	3.97
	内切圆IC	9.525	孔径D1	4.4

适用外径刀杆 ☞D26　适用内径刀杆 ☞E38

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
	涂层																										涂层 金属陶瓷			金属陶瓷		硬质合金						
	CVD									PVD	CVD								PVD								PVD											
P 钢	●	◔	◕	✖	○	◔	✪		◔			◔									✪		✪	◕			◕	✖	✪	●	◕							
M 不锈钢			✪			✪		●	◕	✖	○	◔									✪		✪	◕	✪													
K 铸铁			✪			✪							●	◕	✖	○	◔			✪		✪		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◔	✪	✪														
H 高硬度材																		●																				

	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
精切削	FB 20°	(ap) 2 1 0 0.2 0.4 (f) P	SCMT 09T304N-FB	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	●	●	●	●	●	—	—	—	—	—	—	—	
			09T308N-FB	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	●	●	▲	●	●	—	—	—	—	—	—	—	
	LU 15°	(ap) 2 1 0 0.2 0.4 (f) P	SCMT 09T304N-LU	0.4	●	●	●		●	●			●	●		●						—						—		—	●	●	▲	●	●								
			09T308N-LU	0.8	●	●	●		●	●			●	●		●						—						—		—	●	●	▲	●	●								
	FP 10°	(ap) 2 1 0 0.2 0.4 (f) P	SCMT 09T304N-FP	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—					●	—	—	—	—	—	—	—	
			09T308N-FP	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—					●	—	—	—	—	—	—	—	
	FX 15°	(ap) 2 1 0 0.2 0.4 (f) P	SCGT 09T302R-FX	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—			●	●			●	●														
			09T302L-FX	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—			●	●			●	●														
			09T304R-FX	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—			●	●			●	●														
			09T304L-FX	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—			●	●			●	●														
轻切削	LB 15°	(ap) 2 1 0 0.2 0.4 (f) P	SCMT 09T304N-LB	0.4		●	●	●		●	●	●	●	●								—						—		—	●	●	▲		●								
			09T308N-LB	0.8		●	●	●		●	●	●	●	●								—						—		—	●	●	▲		●								
	SU 8°	(ap) 4 3 2 1 0 0.2 0.4 0.6 (f) P	SCMT 09T304N-SU	0.4	●	●	●	●	●	●	●	●	●	●	▲	●						—	●	●	●			—		—												
			09T308N-SU	0.8	●	●	●	●	●	●	●	●	●	●	▲	●						—	●	●	●			—		—												—
	SC 6°	(ap) 4 3 2 1 0 0.2 0.4 0.6 (f) P	SCGT 09T301MN-SC	< 0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—						●	●					●	●	—	—	—	—	—	—	—	
			09T302MN-SC	< 0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—						●	●					●	●	—	—	—	—	—	—	—	
			SCMW 09T308	0.8													●	●	●	▲	▲	—						—		—	—	—	—	—	—	—						—
			SCGW 09T300	0	—	—	—	—	—	—	—	—	—	—	—	—																										
			09T301	0.1	—	—	—	—	—	—	—	—	—	—	—	—																										
轻～中切削	GU 5°	(ap) 4 3 2 1 0 0.2 0.4 0.6 (f) P	SCMT 09T304N-GU	0.4	●	●	●	●				●	●	●								—						—		—	—	—	—	—	—							—
			09T308N-GU	0.8	●	●	●	●				●	●	●								—						—		—	—	—	—	—	—							—
	MU 0°	(ap) 4 3 2 1 0 0.2 0.4 0.6 (f) P	SCMT 09T308N-MU	0.8	●	●	●		●	●		●	●			●	●	●	●	▲	▲	—						—		—	—	—	—	—	—							—

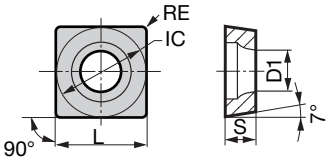
用“<”表示刀尖半径RE的产品，表示其为负公差。

▲记号：计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

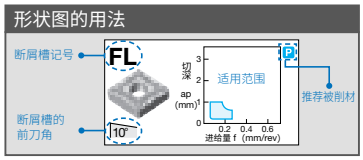
正方形正型刀片

机夹式刀片

SC 正方形 7°正型 带孔



形状图的用法



●：连续切削 第一推荐
○：连续切削 第二推荐
◕：一般切削 第一推荐
◔：一般切削 第二推荐
✖：断续切削 第一推荐
✖：断续切削 第二推荐

SC■■1204●●

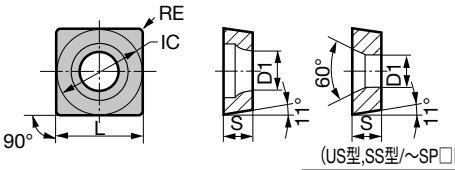
尺寸 (mm)				
	切刃长度L	12.7	厚度S	4.76
	内切圆IC	12.7	孔径D1	5.5

适用内径刀杆 E38

| 推荐用途 | 涂层 CVD | | | |

正方形正型刀片

SP 正方形 11°正型 带孔

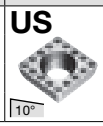
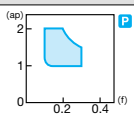


材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4~
按被削材分类的刀片材质选择要领 ☞A10~

●：连续切削 第一推荐　○：连续切削 第二推荐　◕：一般切削 第一推荐　◔：一般切削 第二推荐　✖：断续切削 第一推荐　✪：断续切削 第二推荐

SP■■0602●●

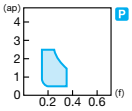
尺寸 (mm)	切刃长度L	6.35	厚度S	2.38
	内切圆IC	6.35	孔径D1	2.8

推荐用途	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
轻切削	US 		SPMT 060204N-US	0.4												●						—								—	—	—	—	—	—		●					—

推荐用途：P 钢 ●◕✖✪○◔✪；M 不锈钢 ✪●◕✖○◔；K 铸铁 ✪●◕✖○◔；N 非铁金属 ◕；S 难削材 ●◕✖◔✪✪；H 高硬度材 ●

SP■■0702●●

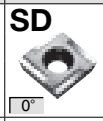
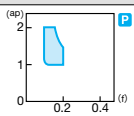
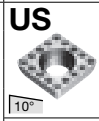
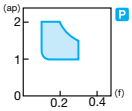
尺寸 (mm)	切刃长度L	7.94	厚度S	2.38
	内切圆IC	7.94	孔径D1	3.4

推荐用途	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
轻切削	SS		SPMT 070208N-SS	0.8			●									●		●				—								—	—	—	—	—	—		●					—

推荐用途：P 钢 ●◕✖✪○◔✪；M 不锈钢 ✪●◕✖○◔；K 铸铁 ✪●◕✖○◔；N 非铁金属 ◕；S 难削材 ●◕✖◔✪✪；H 高硬度材 ●

SP■■0703●●

尺寸 (mm)	切刃长度L	7.94	厚度S	3.18
	内切圆IC	7.94	孔径D1	3.4

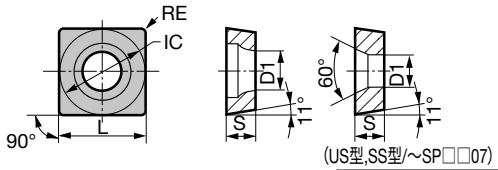
推荐用途	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
精~轻切削	SD 		SPGT 070304R-SD	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—																●		●				
			070304L-SD	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—																						
			070308R-SD	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—																						
			070308L-SD	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—																						
轻切削	US 		SPMT 070308N-US	0.8			●									●		●				—								—	—	—	—	—	—			●					—
			SPGW 070304	0.4	—	—	—	—	—	—	—	—	—	—	—	—		●																					●				●
			070308	0.8	—	—	—	—	—	—	—	—	—	—	—	—		●																									●

推荐用途：P 钢 ●◕✖✪○◔✪；M 不锈钢 ✪●◕✖○◔；K 铸铁 ✪●◕✖○◔；N 非铁金属 ◕；S 难削材 ●◕✖◔✪✪；H 高硬度材 ●

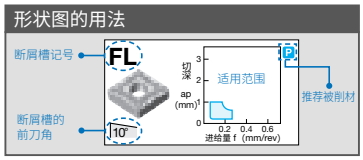
正方形正型刀片

机夹式刀片

SP 正方形 11°正型 带孔



形状图的用法



●：连续切削 第一推荐
○：连续切削 第二推荐
：一般切削 第一推荐
：一般切削 第二推荐
：断续切削 第一推荐
：断续切削 第二推荐

SP■■0903●●

尺寸(mm)				
	切刃长度L	9.525	厚度S	3.18
	内切圆IC	9.525	孔径D1	3.4

住友金刚石(PCD)刀片 M14

适用内径刀杆 E36

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◐	●	✖	○	◐	⊕		◐			◐									⊕		⊕	●			◐	✖	⊕	●	◐							
M 不锈钢				⊕			⊕	●	◐	✖	○	◐									⊕		⊕	●	⊕													
K 铸铁			⊕			⊕							●	◐	✖	○	◐			⊕		⊕		●						●								
N 非铁金属																																						◐
S 难削材																			●	◐	✖	◐	⊕	⊕														
H 高硬度材																		●																				
	涂层																									涂层金属陶瓷				金属陶瓷		硬质合金						
	CVD									PVD	CVD							PVD								PVD												

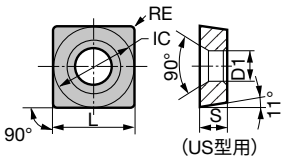
	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
精切削	FB 20°		SPMT 090304N-FB	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	●	●	▲	●	●	—	—	—	—	—	—	—
			090308N-FB	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	●	●	▲	●	●	—	—	—	—	—	—	—
	LU 15°		SPMT 090304N-LU	0.4	●	●	●		●	●		●	●			●						—					—	—		—		●	▲	●	●							
			090308N-LU	0.8	●	●	●		●	●		●	●			●						—					—	—		—		●	▲	●	●							
精～轻切削	SD 0°		SPGT 090302R-SD	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●			●	●							
			090302L-SD	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●			●	●							
			090304R-SD	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●			●	●				●			
			090304L-SD	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	▲	●	●				●			
			090308R-SD	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●			●	●							
			090308L-SD	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	▲	●	●				●			
轻切削	LB 15°		SPMT 090304N-LB	0.4		●	●	●		●	●	●	●	●				●				—					—	—		—	●	●	▲		●							
			090308N-LB	0.8		●	●	●		●	●	●	●	●				●				—					—	—		—	●	●	▲		●							
	SS 5° ＊1		SPMH 090308N-SS	0.8												●						—					—	—		—	—	—	—	—	—	—		●				—
	US 10° ＊1		SPMH 090308N-US	0.8												●						—					—	—		—	—	—	—	—	—	—		●				—
			SPGW 090300	0	—	—	—	—	—	—	—	—	—	—	—	—																										
			090304	0.4	—	—	—	—	—	—	—	—	—	—	—	—		●																					●		●
			090308 New	0.8	—	—	—	—	—	—	—	—	—	—	—	—		●																							●
轻～中切削	SF 0° ＊2		SPMT 090304N-SF	0.4			●	●		●	●											—					—	—		—	—	—	—	—	—	—						—
			090308N-SF	0.8			●	●		●	●											—					—	—		—	—	—	—	—	—	—						—

＊1：孔径D1=4.4。
＊2：孔径D1=3.3。

▲记号：计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

正方形正型刀片

SP 正方形 11°正型 带孔



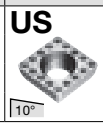
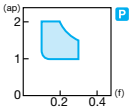
材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4～
按被削材分类的刀片材质选择要领 ☞A10～

●：连续切削 第一推荐　○：连续切削 第二推荐　◕：一般切削 第一推荐　◔：一般切削 第二推荐　✖：断续切削 第一推荐　✪：断续切削 第二推荐

SP■■09T3●●

尺寸 (mm)	切刃长度L	9.525	厚度S	3.97
	内切圆IC	9.525	孔径D1	4.4

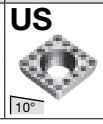
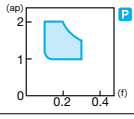
推荐用途	涂层 CVD									PVD	CVD					PVD								涂层 金属陶瓷 PVD			金属陶瓷		硬质合金					
	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◕	✖	○	◔	✪		◔			◔									✪		✪	◕			◕	✖	✪	●	◕							
M 不锈钢			✪				✪	●	◕	✖	○	◔									✪		✪	◕	✪												
K 铸铁			✪			✪							●	◕	✖	○	◔			✪		✪		◕						●							
N 非铁金属																																					◕
S 难削材																			●	◕	✖	◔	✪	✪													
H 高硬度材																		●																			

	形状	适用范围	型 号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
轻切削	US 		SPMT 09T308N-US	0.8												●						—								—	—	—	—	—	—		●					—

SP■■1204●●

尺寸 (mm)	切刃长度L	12.7	厚度S	4.76
	内切圆IC	12.7	孔径D1	5.5

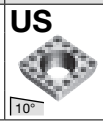
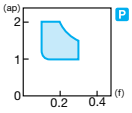
推荐用途	涂层 CVD									PVD	CVD					PVD								涂层 金属陶瓷 PVD			金属陶瓷		硬质合金					
	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◕	✖	○	◔	✪		◔			◔									✪		✪	◕			◕	✖	✪	●	◕							
M 不锈钢			✪				✪	●	◕	✖	○	◔									✪		✪	◕	✪												
K 铸铁			✪			✪							●	◕	✖	○	◔			✪		✪		◕						●							
N 非铁金属																																					◕
S 难削材																			●	◕	✖	◔	✪	✪													
H 高硬度材																		●																			

	形状	适用范围	型 号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
轻切削	US 		SPMH 120408N-US	0.8												●						—								—	—	—	—	—	—		●					—

SP■■1504●●

尺寸 (mm)	切刃长度L	15.875	厚度S	4.76
	内切圆IC	15.875	孔径D1	6.5

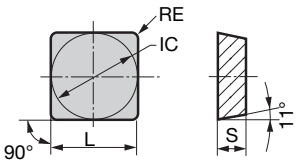
推荐用途	涂层 CVD									PVD	CVD					PVD								涂层 金属陶瓷 PVD			金属陶瓷		硬质合金					
	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◕	✖	○	◔	✪		◔			◔									✪		✪	◕			◕	✖	✪	●	◕							
M 不锈钢			✪				✪	●	◕	✖	○	◔									✪		✪	◕	✪												
K 铸铁			✪			✪							●	◕	✖	○	◔			✪		✪		◕						●							
N 非铁金属																																					◕
S 难削材																			●	◕	✖	◔	✪	✪													
H 高硬度材																		●																			

	形状	适用范围	型 号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
轻切削	US 		SPMH 150408N-US	0.8												●						—								—	—	—	—	—	—		●					—

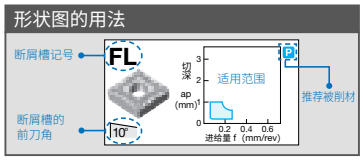
正方形正型刀片

机夹式刀片

SP 正方形 11°正型 无孔



形状图的用法



●：连续切削 第一推荐
○：连续切削 第二推荐
◕：一般切削 第一推荐
◔：一般切削 第二推荐
✖：断续切削 第一推荐
✪：断续切削 第二推荐

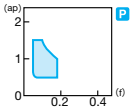
刀片 B 负型 正型 C D R S T V W 整体CBN 陶瓷

SP■■0702●●

尺寸 (mm)				
	切刀长度L	7.94	厚度S	2.38
	内切圆IC	7.94		

推荐用途：P 钢 / M 不锈钢 / K 铸铁 / N 非铁金属 / S 难削材 / H 高硬度材

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◕	✖	○	◔	✪		◔			◔									✪		✪	◕			◕	✖	✪	●	◕							
M 不锈钢				✪			✪	●	◕	✖	○	◔									✪		✪	◕	✪													
K 铸铁			✪			✪							●	◕	✖	○	◔			✪		✪		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◔	✪	✪														
H 高硬度材																		●																				

	形状	适用范围	型 号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
精～轻切削	W 0°		SPGR 070204L-W	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●							
轻切削			SPGN 070204	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●

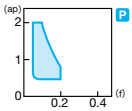
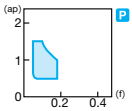
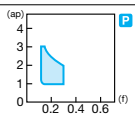
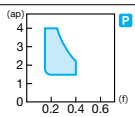
SP■■0903●●

尺寸 (mm)				
	切刀长度L	9.525	厚度S	3.18
	内切圆IC	9.525		

推荐用途：P 钢 / M 不锈钢 / K 铸铁 / N 非铁金属 / S 难削材 / H 高硬度材

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◕	✖	○	◔	✪		◔			◔									✪		✪	◕			◕	✖	✪	●	◕							
M 不锈钢				✪			✪	●	◕	✖	○	◔									✪		✪	◕	✪													
K 铸铁			✪			✪							●	◕	✖	○	◔			✪		✪		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◔	✪	✪														
H 高硬度材																		●																				

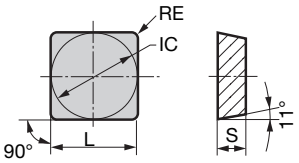
住友 CBN(CBN) 刀片 ☞L78　住友金刚石 (PCD) 刀片 ☞M14
陶瓷刀片 ☞B128
适用内径刀杆 ☞E37

	形状	适用范围	型 号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
精切削	FK 0°		SPMR 090304N-FK	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●			●	●	—	—	—	—	—	—	—	—
			090308N-FK	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	▲	●	●	—	—	—	—	—	—	—	—
精～轻切削	W 0°		SPGR 090304L-W	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●							
轻～中切削	SF 0°		SPMR 090304N-SF	0.4			●	●		●	●												—				—		—	—	—	—	—	—	—							—
			090308N-SF	0.8			●	●		●	●												—				—		—	—	—	—	—	—	—							—
轻～中切削	UJ 0°		SPMR 090304N-UJ	0.4			●			●													—				—		—	—	—	—	—	—	—							—
			090308N-UJ	0.8			●	●		●	●												—				—		—	—	—	—	—	—	—							—
中切削			SPMN 090304	0.4													●	●	●	▲	▲	—					—		—		●	●			●							
			090308	0.8													●	●	●	▲	▲	—					—		—		●	●			●							
			SPGN 090302	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			090304	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●							●
			090308	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	●	—	—	—	—	—	—	—	●	●				●			●
			090312	1.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—

▲记号：计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

正方形正型刀片

SP 正方形 11°正型 无孔



材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4～
按被削材分类的刀片材质选择要领 ☞A10～

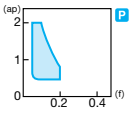
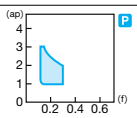
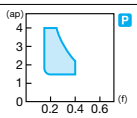
●：连续切削 第一推荐
○：连续切削 第二推荐
◕：一般切削 第一推荐
◔：一般切削 第二推荐
✖：断续切削 第一推荐
✪：断续切削 第二推荐

SP■■1203●●

尺寸 (mm)	切刃长度L	12.7	厚度S	3.18
	内切圆IC	12.7		

住友CBN(CBN)刀片 ☞L79　住友金刚石(PCD)刀片 ☞M14
陶瓷刀片 ☞B128　适用外径刀杆 ☞C27、C28

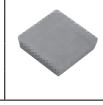
推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◕	✖	○	◔	✪		◔				◔								✪		✪	◕			◕	✖	✪	●	◕							
M 不锈钢			✪				✪	●	◕	✖	○	◔									✪		✪	◕	✪													
K 铸铁			✪			✪							●	◕	✖	○	◔			✪		✪		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◔	✪	✪														
H 高硬度材																		●																				

	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
精切削	FK		SPMR 120304N-FK	0.4																										●			●	●								
			120308N-FK	0.8																										●			●	●								
轻～中切削	SF		SPMR 120304N-SF	0.4			●	●		●	●																															
			120308N-SF	0.8			●	●		●	●																															
			120312N-SF	1.2			●			●																																
	UJ		SPMR 120304N-UJ	0.4			●			●																															
			120308N-UJ	0.8			●	●		●	●																															
中切削			SPMN 120304	0.4													●	●	●	▲	▲													●	●	●		●				
			120308	0.8													●	●	●	▲	▲		●	●	●	●								●	●	●	●	●				
			120312	1.2													●	●	●	▲	▲		●	●	●	●			●					●	●			●	●			
			SPGN 120304	0.4																				●	●	●								●	●			●				
			120308	0.8																				●	●	●								●	●		●	●	●			
			120312	1.2																																		●				

SP■■1204●●

尺寸 (mm)	切刃长度L	12.7	厚度S	4.76
	内切圆IC	12.7		

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◕	✖	○	◔	✪		◔				◔								✪		✪	◕			◕	✖	✪	●	◕							
M 不锈钢			✪				✪	●	◕	✖	○	◔									✪		✪	◕	✪													
K 铸铁			✪			✪							●	◕	✖	○	◔			✪		✪		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◔	✪	✪														
H 高硬度材																		●																				

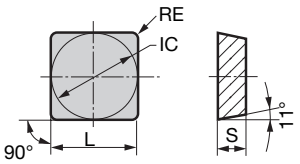
	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
中切削			SPGN 120408	0.8																																						
			120412	1.2																																						
			120416	1.6																																						

▲记号：计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

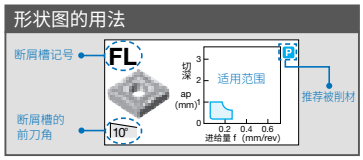
正方形正型刀片

机夹式刀片

SP 正方形 11°正型 无孔



形状图的用法



●：连续切削 第一推荐
○：连续切削 第二推荐
◕：一般切削 第一推荐
◔：一般切削 第二推荐
✖：断续切削 第一推荐
✖：断续切削 第二推荐

SP■■1504●●

尺寸 (mm)	切刃长度L	15.875	厚度S	4.76
	内切圆IC	15.875		

适用外径刀杆 ☞C27、C28

推荐用途	P 钢	M 不锈钢	K 铸铁	N 非铁金属	S 难削材	H 高硬度材
AC8015P	●					
AC8020P	◔					
AC8025P	◕		✪			
AC8035P	✖	✪				
AC810P	○					
AC820P	◔		✪			
AC830P	✪	✪				
AC6020M		●				
AC6030M	◔	◕				
AC6040M		✖				
AC610M		○				
AC630M	◔	◔				
AC4010K			●			
AC4015K			◕			
AC420K			✖			
AC405K			○			
AC415K			◔			
AC503U						●
AC5005S					●	
AC5015S			✪		◕	
AC5025S	✪	✪			✖	
AC510U					◔	
AC520U		✪	✪		✪	
AC1030U		✪	◕		✪	
AC530U		✪	◕		✪	
ACZ150		✪				
T1500Z	◕					
T2500Z	✖					
T3000Z	✪					
T1000A	●		●			
T1500A	◕					
ST10P						
ST20E						
A30						◕
G10E						
EH510						
EH520						
H1						

	形状	适用范围	型 号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
涂层					CVD									PVD	CVD							PVD									PVD											
涂层 金属陶瓷																																										
金属陶瓷																																										
硬质合金																																										
中切削			SPMN 150408	0.8																		—	●	●	●	●	—	—	—									●	●				
			150412	1.2																		—					—	—	—										●	●				
			SPGN 150408	0.8	—	—	—	—	—	—	—	—	—	—	—	—																											
			150412	1.2	—	—	—	—	—	—	—	—	—	—	—	—																											

SP■■1904●●

尺寸 (mm)	切刃长度L	19.05	厚度S	4.76
	内切圆IC	19.05		

推荐用途	P 钢	M 不锈钢	K 铸铁	N 非铁金属	S 难削材	H 高硬度材
AC8015P	●					
AC8020P	◔					
AC8025P	◕		✪			
AC8035P	✖	✪				
AC810P	○					
AC820P	◔		✪			
AC830P	✪	✪				
AC6020M		●				
AC6030M	◔	◕				
AC6040M		✖				
AC610M		○				
AC630M	◔	◔				
AC4010K			●			
AC4015K			◕			
AC420K			✖			
AC405K			○			
AC415K			◔			
AC503U						●
AC5005S					●	
AC5015S			✪		◕	
AC5025S	✪	✪			✖	
AC510U					◔	
AC520U		✪	✪		✪	
AC1030U		✪	◕		✪	
AC530U		✪	◕		✪	
ACZ150		✪				
T1500Z	◕					
T2500Z	✖					
T3000Z	✪					
T1000A	●		●			
T1500A	◕					
ST10P						
ST20E						
A30						◕
G10E						
EH510						
EH520						
H1						

	形状	适用范围	型 号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
涂层					CVD									PVD	CVD							PVD									PVD											
涂层 金属陶瓷																																										
金属陶瓷																																										
硬质合金																																										
中切削			SPMN 190404	0.4																		—									—	—	—	—	—			●					—
			190408	0.8																		—									—	—	—	—	—			●					—
			190412	1.2																		—									—	—	—	—	—			●	●				—
			SPGN 190404	0.4	—	—	—	—	—	—	—			—																													
			190408	0.8	—	—	—	—	—	—	—			—																													
			190412	1.2	—	—	—	—	—	—	—			—																													
			190416	1.6	—	—	—	—	—	—	—			—																													

SP■■2506●●

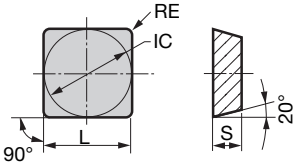
尺寸 (mm)	切刃长度L	25.4	厚度S	6.35
	内切圆IC	25.4		

推荐用途	P 钢	M 不锈钢	K 铸铁	N 非铁金属	S 难削材	H 高硬度材
AC8015P	●					
AC8020P	◔					
AC8025P	◕		✪			
AC8035P	✖	✪				
AC810P	○					
AC820P	◔		✪			
AC830P	✪	✪				
AC6020M		●				
AC6030M	◔	◕				
AC6040M		✖				
AC610M		○				
AC630M	◔	◔				
AC4010K			●			
AC4015K			◕			
AC420K			✖			
AC405K			○			
AC415K			◔			
AC503U						●
AC5005S					●	
AC5015S			✪		◕	
AC5025S	✪	✪			✖	
AC510U					◔	
AC520U		✪	✪		✪	
AC1030U		✪	◕		✪	
AC530U		✪	◕		✪	
ACZ150		✪				
T1500Z	◕					
T2500Z	✖					
T3000Z	✪					
T1000A	●		●			
T1500A	◕					
ST10P						
ST20E						
A30						◕
G10E						
EH510						
EH520						
H1						

	形状	适用范围	型 号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
涂层					CVD									PVD	CVD							PVD									PVD											
涂层 金属陶瓷																																										
金属陶瓷																																										
硬质合金																																										
中切削			SPMN 250620	2.0																		—									—	—	—	—	—								—

整体CBN 陶瓷

SE 正方形 20°正型 无孔



材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4～
按被削材分类的刀片材质选择要领 ☞A10～

●：连续切削 第一推荐
○：连续切削 第二推荐
●：一般切削 第一推荐
○：一般切削 第二推荐
✖：断续切削 第一推荐
✖：断续切削 第二推荐

SE■■0702●●

尺寸 (mm)	切刃长度L	7.94	厚度S	2.38
	内切圆IC	7.94		

推荐用途：P 钢 ●；M 不锈钢 ✖；K 铸铁 ●；N 非铁金属 ●；S 难削材 ●；H 高硬度材 ●

形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
轻切削		SEGN 070202	0.2																																						
		070204	0.4																																						●
		070208	0.8																																						

涂层：CVD / PVD / CVD / PVD；涂层金属陶瓷：PVD；金属陶瓷；硬质合金

SE■■0903●●

尺寸 (mm)	切刃长度L	9.525	厚度S	3.18
	内切圆IC	9.525		

住友金刚石(PCD)刀片 ☞M15

推荐用途：P 钢 ●；M 不锈钢 ✖；K 铸铁 ●；N 非铁金属 ●；S 难削材 ●；H 高硬度材 ●

形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
轻切削		SEGN 090302	0.2																																						
		090304	0.4																																						●
		090308	0.8																																						●

涂层：CVD / PVD / CVD / PVD；涂层金属陶瓷：PVD；金属陶瓷；硬质合金

SE■■1203●●

尺寸 (mm)	切刃长度L	12.7	厚度S	3.18
	内切圆IC	12.7		

住友金刚石(PCD)刀片 ☞M15

推荐用途：P 钢 ●；M 不锈钢 ✖；K 铸铁 ●；N 非铁金属 ●；S 难削材 ●；H 高硬度材 ●

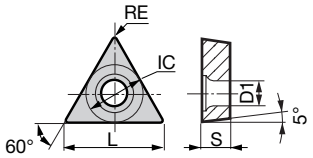
形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
轻切削		SEGN 120304	0.4																																						●
		120308	0.8																																						●

涂层：CVD / PVD / CVD / PVD；涂层金属陶瓷：PVD；金属陶瓷；硬质合金

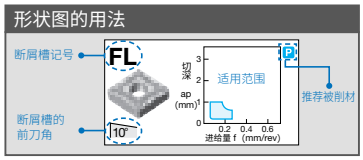
三角形正型刀片

机夹式刀片

TB 三角形 5° 正型 带孔



形状图的用法



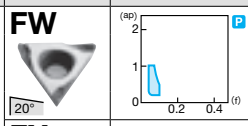
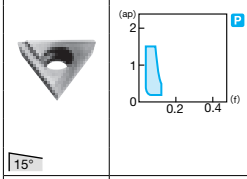
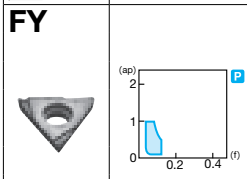
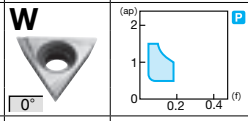
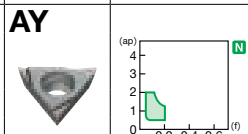
●: 连续切削 第一推荐
○: 连续切削 第二推荐
: 一般切削 第一推荐
: 一般切削 第二推荐
: 断续切削 第一推荐
: 断续切削 第二推荐

TB■■0601●●

尺寸 (mm)	切刃长度L	6.9	厚度S	1.59
	内切圆IC	3.97	孔径D1	2.2

住友 CBN(CBN) 刀片 L87　住友金刚石(PCD) 刀片 M16
适用内径刀杆 E42、E44

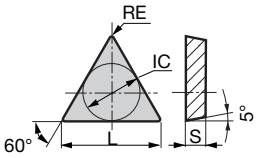
推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
	涂层																									涂层金属陶瓷				金属陶瓷		硬质合金						
	CVD									PVD	CVD							PVD								PVD												
P 钢	●	◐	◒	✖	○	◐	⊕		◐			◐								⊕			⊕	◒		◒	✖	⊕	●	◒								
M 不锈钢				⊕			⊕	●	◒	✖	○	◐								⊕			⊕	◒	⊕												
K 铸铁			⊕			⊕							●	◒	✖	○	◐			⊕		⊕		◒						●								
N 非铁金属																																						◒
S 难削材																			●	◒	✖	◐	⊕	⊕														
H 高硬度材																		●																				

	刀尖半径 RE	型号	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
精切削 FW 	0.2	TBGT 060102R-FW																										●				●								
	0.2	060102L-FW																										●				●								
	0.4	060104R-FW																										●				●								
	0.4	060104L-FW																										●				●								
精切削 FX 	0.03	TBGT 0601003R-FX																																						
	0.03	0601003L-FX																																						
	0.1	060101R-FX																																						
	0.1	060101L-FX																																						
	0.2	060102R-FX																				●	●	●		●	●													
	0.2	060102L-FX																				●	●	●		●	●													
	0.4	060104R-FX																				●	●	●		●	●													
	0.4	060104L-FX																				●	●	●		●	●													
精切削 FY 	0.03	TBGT 0601003R-FY																																						
	0.03	0601003L-FY																																						
	0.1	060101R-FY																				●	●			●	●													
	0.1	060101L-FY																				●	●			●	●													
	0.2	060102R-FY																				●	●			●	●					●	●							
	0.2	060102L-FY																				●	●			●	●					●	●							
	0.4	060104R-FY																				●	●			●	●					●	●							
	0.4	060104L-FY																				●	●			●	●					●	●							
精～轻切削 W 	0.2	TBGT 060102R-W																								●	●	●				●	●				●			
	0.2	060102L-W																								●	●	●	●	▲		●	●				●			
	0.4	060104R-W																								●	●	●				●	●				●			
	0.4	060104L-W																								●	●	●				●	●				●			
轻切削	0.2	TBGW 060102																															●							
	0.4	060104																															●							
铝材用 AY 	0.1	TBGT 060101R-AY																																						●
	0.1	060101L-AY																																						●
	0.2	060102R-AY																																						●
	0.2	060102L-AY																																						●
	0.4	060104R-AY																																						●
	0.4	060104L-AY																																						●

▲记号: 计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

三角形正型刀片

TB 三角形 5° 正型 无孔



材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4～
按被削材分类的刀片材质选择要领 ☞A10～

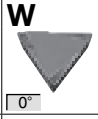
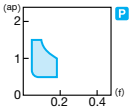
●：连续切削 第一推荐
○：连续切削 第二推荐
●：一般切削 第一推荐
○：一般切削 第二推荐
✖：断续切削 第一推荐
✖：断续切削 第二推荐

TB■■0601●●

尺寸 (mm)	切刃长度L	6.9	厚度S	1.59
	内切圆IC	3.97		

住友CBN(CBN)刀片 ☞L87　住友金刚石(PCD)刀片 ☞M16

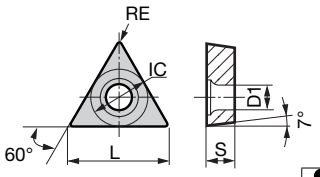
推荐用途	涂层 CVD								PVD	CVD					PVD								涂层 金属陶瓷 PVD			金属陶瓷	硬质合金						
	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	○	◐	✖	○	○	✪		○			○									✪		✪	◐			◐	✖	✪	●	◐							
M 不锈钢			✪			✪		●	◐	✖	○	○									✪		✪	◐	✪													
K 铸铁			✪			✪							●	◐	✖	○	○			✪		✪		◐						●								
N 非铁金属																																						◐
S 难削材																			●	◐	✖	○	✪	✪														
H 高硬度材																		●																				

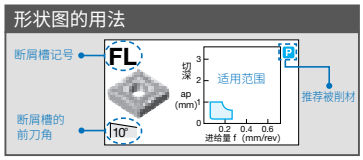
	形状	适用范围	型　号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
精～轻切削	W 		TBGR 060104L-W	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—														●							
轻切削			TBGN 060104	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—														●							●

三角形正型刀片

机夹式刀片

TC 三角形 7° 正型 带孔



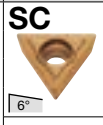
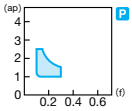


●：连续切削 第一推荐
○：连续切削 第二推荐
◕：一般切削 第一推荐
◔：一般切削 第二推荐
✖：断续切削 第一推荐
✖：断续切削 第二推荐

TC■■0802●●

尺寸 (mm)				
	切刃长度L	8.2	厚度S	2.38
	内切圆IC	4.76	孔径D1	2.3

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◕	✖	○	◔	✖		◔				◔								✖		✖	◕			◕	✖	✖	●	◕							
M 不锈钢				✖			✖	●	◕	✖	○	◔									✖		✖	◕	✖													
K 铸铁			✖			✖							●	◕	✖	○	◔			✖		✖		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◔	✖	✖														
H 高硬度材																		●																				

	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
轻切削	SC  6°		TCGT 080201MN-SC	< 0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●					●	●	—	—	—	—	—	—	—
			080202MN-SC	< 0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●					●	●	—	—	—	—	—	—	—
			TCGW 080200	0	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—													
			080201	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—													

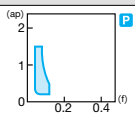
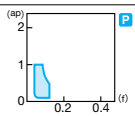
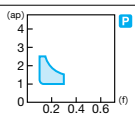
用“<”表示刀尖半径RE的产品，表示其为负公差。

TC■■0902●●

尺寸 (mm)				
	切刃长度L	9.6	厚度S	2.38
	内切圆IC	5.56	孔径D1	2.5

住友金刚石 (PCD) 刀片 M16
适用外径刀杆 D27

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◕	✖	○	◔	✖		◔				◔								✖		✖	◕			◕	✖	✖	●	◕							
M 不锈钢				✖			✖	●	◕	✖	○	◔									✖		✖	◕	✖													
K 铸铁			✖			✖							●	◕	✖	○	◔			✖		✖		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◔	✖	✖														
H 高硬度材																		●																				

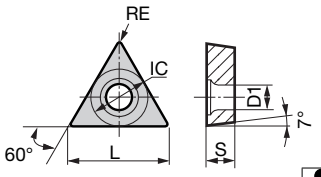
	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
精切削	FX 15°		TCGT 090201R-FX	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●			●	●													
			090201L-FX	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●			●	●													
			090202R-FX	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●			●	●													
			090202L-FX	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●			●	●													
	FY 15°		TCGT 090201R-FY	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●			●	●													
			090201L-FY	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●			●	●													
			090202R-FY	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●			●	●													
			090202L-FY	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●			●	●													
轻切削	SC 6°		TCGT 090201MN-SC	< 0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●					●	●	—	—	—	—	—	—	—
			090202MN-SC	< 0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●					●	●	—	—	—	—	—	—	—
			TCGW 090200	0	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—													
			090201	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—													

用“<”表示刀尖半径 RE 的产品，表示其为负公差。

三角形正型刀片

机夹式刀片

TC 三角形 7° 正型 带孔



材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4～
按被削材分类的刀片材质选择要领 ☞A10～

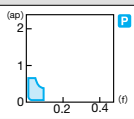
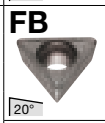
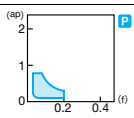
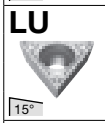
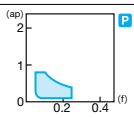
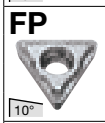
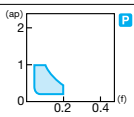
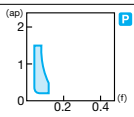
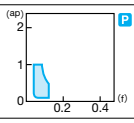
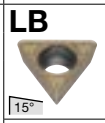
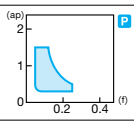
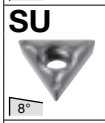
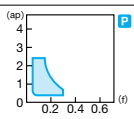
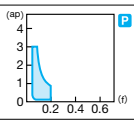
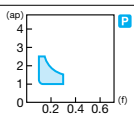
●：连续切削 第一推荐 ○：连续切削 第二推荐 ◐：一般切削 第一推荐 ◔：一般切削 第二推荐 ✖：断续切削 第一推荐 ✪：断续切削 第二推荐

TC■■1102●●

尺寸 (mm)	切刃长度L	11.0	厚度S	2.38
	内切圆IC	6.35	孔径D1	2.8

住友金刚石 (PCD) 刀片 ☞M16
适用外径刀杆 ☞D27

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
	涂层																										涂层金属陶瓷			金属陶瓷		硬质合金						
	CVD									PVD	CVD								PVD								PVD											
P 钢	●	◔	◐	✖	○	◔	✪		◔			◔								✪			✪	◐			◐	✖	✪	●	◐							
M 不锈钢			✪				✪	●	◐	✖	○	◔								✪			✪	◐	✪													
K 铸铁				✪			✪						●	◐	✖	○	◔				✪		✪	◐						●								
N 非铁金属																																						◐
S 难削材																			●	◐	✖	◔	✪	✪														
H 高硬度材																		●																				

	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
微小切削	FF		TCGT 110201MN-FF New	< 0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	●	—	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			110202MN-FF New	< 0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	●	—	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			110204MN-FF New	< 0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	●	—	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—
精切削	FB 		TCMT 110204N-FB	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	●	●	▲	●	●	—	—	—	—	—	—	—
			110208N-FB	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	●	●	▲	●	●	—	—	—	—	—	—	—
	LU 		TCMT 110204N-LU	0.4	●	●	●		●	●			●	●		●						—						—	—	—	●	●	▲	●	●							
			110208N-LU	0.8	●	●	●		●	●			●	●		●						—						—	—	—	●	●	▲	●	●							
	FP 		TCMT 110204N-FP	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	—	—	—	—	—	—
			110208N-FP	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	—	—	—	—	—	—
	FX		TCGT 110201R-FX	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—
			110201L-FX	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—
			110202R-FX	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—
			110202L-FX	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—
	FY		TCGT 110201R-FY	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—
			110201L-FY	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—
			110202R-FY	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—
			110202L-FY	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—
轻切削	LB 		TCMT 110204N-LB	0.4	—	●	●	●	—	●	●	●	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	▲	—	●	—	—	—	—	—	—	—
			110208N-LB	0.8	—	●	●	●	—	●	●	●	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	▲	—	●	—	—	—	—	—	—	—
	SU 		TCMT 110204N-SU	0.4	●	●	●	●	●	●	●	●	●	●	▲	●	—	—	—	—	—	—	●	●	●	—	●	—	●	—	—	●	—	—	—	—	—	—	—	—	—	—
			110208N-SU	0.8	●	●	●	●	●	●	●	●	●	●	▲	●	—	—	—	—	—	—	●	●	●	—	●	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—
	SI		TCGT 110201MN-SI New	< 0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			110202MN-SI New	< 0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	●	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			110204MN-SI	< 0.4	—	—	—	—	—	—	—	—	—	—	▲	●	—	—	—	—	—	—	—	●	●	●	●	●	●	—	●	●	—	—	●	●	—	—	—	—	—	—
	SC		TCGT 110201MN-SC	< 0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	—	—	—	●	●	—	—	—	—	—	—
			110202MN-SC	< 0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	—	—	—	●	●	—	—	—	—	—	—
			TCMW 110204	0.4	—	—	—	—	—	—	—	—	—	—	—	—	●	●	●	▲	▲	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			110208	0.8	—	—	—	—	—	—	—	—	—	—	—	—	●	●	●	▲	▲	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			TCGW 110200	0	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			110201	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—

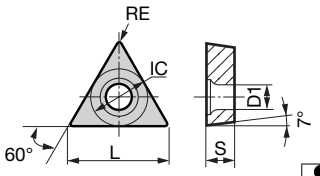
用“<”表示刀尖半径RE的产品，表示其为负公差。

▲记号：计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

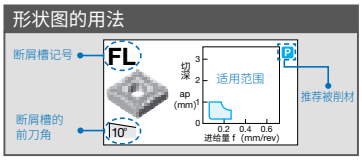
三角形正型刀片

机夹式刀片

TC 三角形 7° 正型 带孔



形状图的用法

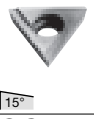
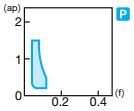
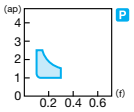


●：连续切削 第一推荐
○：连续切削 第二推荐
◐：一般切削 第一推荐
◔：一般切削 第二推荐
✖：断续切削 第一推荐
✪：断续切削 第二推荐

TC■■1103●●

尺寸 (mm)	切刃长度L	11.0	厚度S	3.18
	内切圆IC	6.35	孔径D1	2.8

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◐	✖	○	◔	✪		◔			◔									✪		✪	◐			◐	✖	✪	●	◐							
M 不锈钢				✪			✪	●	◐	✖	○	◔									✪		✪	◐	✪													
K 铸铁			✪			✪							●	◐	✖	○	◔			✪		✪		◐						●								
N 非铁金属																																						◐
S 难削材																			●	◐	✖	◔	✪	✪														
H 高硬度材																		●																				

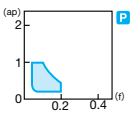
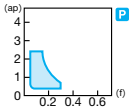
	形状	适用范围	型 号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
精切削	FX  15°		TCGT 110301R-FX	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	—	—	—	—	—	—	—
			110301L-FX	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	—	—	—	—	—	—	—
			110302R-FX	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	—	—	—	—	—	—	—
			110302L-FX	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	—	—	—	—	—	—	—
			110304R-FX	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	—	—	—	—	—	—	—
			110304L-FX	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	—	—	—	—	—	—	—
轻切削	SC 6°		TCGT 110301MN-SC	< 0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	—	—	—	—	—	—
			110302MN-SC	< 0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	—	—	—	—	—
			TCGW 110300	0	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			110301	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—

用“<”表示刀尖半径RE的产品，表示其为负公差。

TC■■16T3●●

尺寸 (mm)	切刃长度L	16.5	厚度S	3.97
	内切圆IC	9.525	孔径D1	4.3

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◐	✖	○	◔	✪		◔			◔									✪		✪	◐			◐	✖	✪	●	◐							
M 不锈钢				✪			✪	●	◐	✖	○	◔									✪		✪	◐	✪													
K 铸铁			✪			✪							●	◐	✖	○	◔			✪		✪		◐						●								
N 非铁金属																																						◐
S 难削材																			●	◐	✖	◔	✪	✪														
H 高硬度材																		●																				

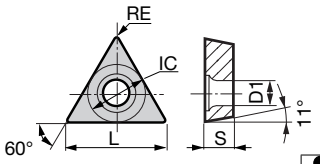
	形状	适用范围	型 号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
精切削	FP 10°		TCMT 16T304N-FP	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	—	—	—	—	—	—	—
			16T308N-FP	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	—	—	—	—	—	—	—
轻切削	SU 8°		TCMT 16T304N-SU	0.4	●	●	●	●	●	●	●	●	●	●	▲	●						—	●	●	●			—		—	—	—	—	—	—	—						—
			16T308N-SU	0.8	●	●	●	●	●	●	●	●	●	●	▲	●						—	●	●	●			—		—	—	—	—	—	—	—						—
			TCMW 16T304	0.4													●	●	●	▲	▲	—						—		—	—	—	—	—	—	—						—
			16T308	0.8													●	●	●	▲	▲	—						—		—	—	—	—	—	—	—						—
			16T312	1.2													●	●	●	▲	▲	—						—		—	—	—	—	—	—	—						—

▲记号：计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

三角形正型刀片

机夹式刀片

TP 三角形 11° 正型 带孔



材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4～
按被削材分类的刀片材质选择要领 ☞A10～

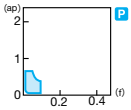
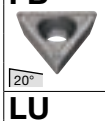
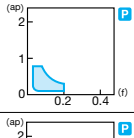
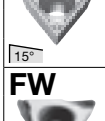
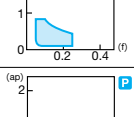
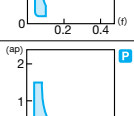
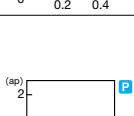
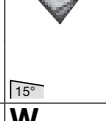
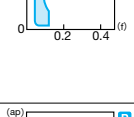
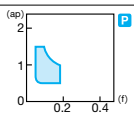
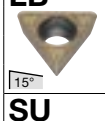
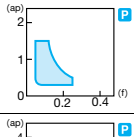
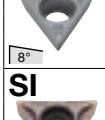
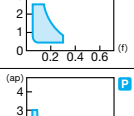
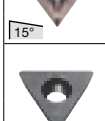
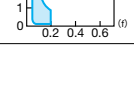
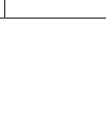
●：连续切削 第一推荐 ○：连续切削 第二推荐
◕：一般切削 第一推荐 ◔：一般切削 第二推荐
✖：断续切削 第一推荐 ✖：断续切削 第二推荐

TP■■0802●●

尺寸 (mm)	切刃长度L	8.2	厚度S	2.38
	内切圆IC	4.76	孔径D1	2.4

住友 CBN(CBN) 刀片☞L88　住友金刚石 (PCD) 刀片☞M17
无粘合剂住友金刚石刀片☞M28　适用内径刀杆 ☞E42～E45

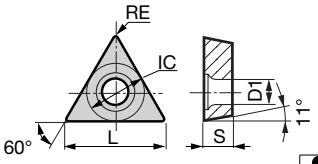
推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
	涂层																										涂层金属陶瓷			金属陶瓷		硬质合金						
	CVD									PVD	CVD								PVD								PVD											
P 钢	●	◔	◕	✖	○	◔	✿		◔				◔								✿		✿	◕			◕	✖	✿	●	◕							
M 不锈钢			✿			✿		●	◕	✖	○	◔									✿		✿	◕	✿													
K 铸铁			✿			✿							●	◕	✖	○	◔			✿		✿		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◔	✿	✿														
H 高硬度材																		●																				

	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
微小切削	FF		TPGT 080201MN-FF New	< 0.1																				●	●			●														
			080202MN-FF New	< 0.2																				●	●			●														
			080204MN-FF New	< 0.4																				●	●			●														
精切削	FB 		TPMT 080202N-FB	0.2																								●		●	●	▲	●	●								
			080204N-FB	0.4																								●		●	●	▲	●	●								
	LU 		TPMT 080202N-LU	0.2									●	●		●												●					●	●								
			080204N-LU	0.4			●						●	●		●		●										●			●		●	●								
	FW		TPGT 080202R-FW	0.2																										●			●	●								
			080202L-FW	0.2																										●			●	●								
			080204R-FW	0.4																										●			●	●								
			080204L-FW	0.4																										●	●		●	●								
	FX		TPGT 080202R-FX	0.2																				●	●		●	●	●													
			080202L-FX	0.2																				●	●		●	●	●														
			080204R-FX	0.4																				●	●		●	●	●														
			080204L-FX	0.4																				●	●		●	●	●														
	FY 		TPGT 0802003R-FY	0.03																				●	●		●	●	●	●													
			0802003L-FY	0.03																				●	●		●	●	●	●													
			080201R-FY	0.1																				●	●		●	●	●	●													
			080201L-FY	0.1																				●	●		●	●	●	●													
			080202R-FY	0.2																				●	●		●	●	●	●				●	●								
			080202L-FY	0.2																				●	●		●	●	●	●				●	●								
			080204R-FY	0.4																				●	●		●	●	●	●				●	●								
			080204L-FY	0.4																				●	●		●	●	●	●				●	●								
精～轻切削	W		TPGT 080202R-W	0.2																							●	●		●	●	▲	●	●				●				
			080202L-W	0.2																							●	●		●	●	▲	●	●	●			●				
			080204R-W	0.4																							●	●		●			●	●								
			080204L-W	0.4																							●	●		●	●	▲	●	●				●				
轻切削	LB 		TPMT 080202N-LB	0.2		●	●	●		●	●	●	●	●																●	●	▲		●								
			080204N-LB	0.4		●	●	●		●	●	●	●	●																●	●	▲		●								
	SU 		TPMT 080202N-SU	0.2								●	●	●		●							●	●	●				●					●	●							
			080204N-SU	0.4			●					●	●	●		●		●					●	●	●				●					●	●							
	SI 		TPGT 080201MN-SI New	< 0.1																				●	●			●														
			080202MN-SI New	< 0.2																				●	●			●														
			080204MN-SI New	< 0.4																				●	●			●														
			TPGW 080202	0.2																													●	●							
			080204	0.4														●																							●
			080208 New	0.8														●																							●

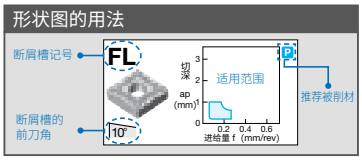
▲记号：计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

三角形正型刀片

TP 三角形 11° 正型 带孔



形状图的用法



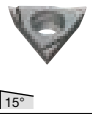
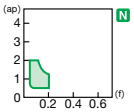
●：连续切削 第一推荐　○：连续切削 第二推荐
◐：一般切削 第一推荐　◔：一般切削 第二推荐
✖：断续切削 第一推荐　✪：断续切削 第二推荐

TP■■0802●●

尺寸 (mm)				
	切刃长度L	8.2	厚度S	2.38
	内切圆IC	4.76	孔径D1	2.4

住友 CBN(CBN) 刀片 L88　住友金刚石 (PCD) 刀片 M17
无粘合剂住友金刚石刀片 M28　适用内径刀杆 E42 ～ E45

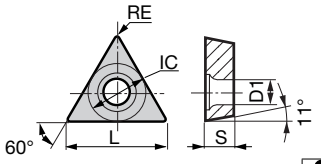
推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
	涂层																									涂层金属陶瓷				金属陶瓷		硬质合金						
	CVD									PVD	CVD							PVD								PVD												
P 钢	●	◔	◐	✖	○	◔	✪		◔			◔									✪		✪	◐		◐	✖	✪	●	◐								
M 不锈钢				✪			✪	●	◐	✖	○	◔									✪		✪	◐	✪												
K 铸铁			✪			✪							●	◐	✖	○	◔			✪		✪		◐						●								
N 非铁金属																																						◐
S 难削材																			●	◐	✖	◔	✪	✪														
H 高硬度材																		●																				

	形状	适用范围	型　号	刀尖半径 RE
铝材用	AY  15°		TPGT 080201R-AY	0.1
			080201L-AY	0.1
			080202R-AY	0.2
			080202L-AY	0.2
			080204R-AY	0.4
			080204L-AY	0.4

三角形正型刀片

机夹式刀片

TP 三角形 11° 正型 带孔



材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4～
按被削材分类的刀片材质选择要领 ☞A10～

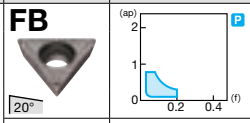
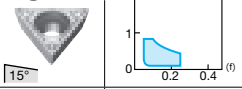
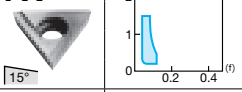
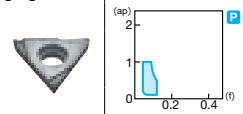
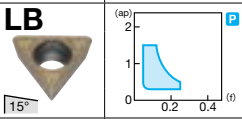
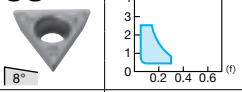
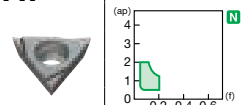
●：连续切削 第一推荐
○：连续切削 第二推荐
◕：一般切削 第一推荐
◔：一般切削 第二推荐
✖：断续切削 第一推荐
✖：断续切削 第二推荐

TP■■0902●●

尺寸 (mm)	切刃长度L	9.6	厚度S	2.38
	内切圆IC	5.56	孔径D1	2.8

住友 CBN(CBN) 刀片☞L90　住友金刚石 (PCD) 刀片☞M17
适用内径刀杆 ☞E42

推荐用途：P 钢 / M 不锈钢 / K 铸铁 / N 非铁金属 / S 难削材 / H 高硬度材

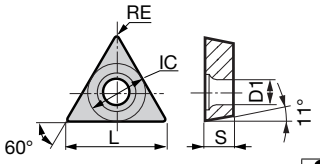
形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
				涂层																									涂层金属陶瓷			金属陶瓷		硬质合金						
				CVD								PVD	CVD								PVD								PVD											
精切削 FB		TPMT 090202N-FB	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	●	●	▲	●	●	—	—	—	—	—	—	—
		090204N-FB	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	●	●	▲	●	●	—	—	—	—	—	—	—
精切削 LU		TPMT 090202N-LU	0.2	●	●	●			●												—						—		—	●	●	▲	●	●							
		090204N-LU	0.4	●	●	●			●												—						—		—	●	●	▲	●	●							
精切削 FX		TPGT 090204L-FX	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—													●	●							
精切削 FY		TPGT 090201R-FY	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—			●	●			●														
		090201L-FY	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—			●	●			●														
		090202R-FY	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—			●	●			●								●						
		090202L-FY	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—			●	●			●								●						
		090204R-FY	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—			●	●			●								●						
		090204L-FY	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—			●	●			●								●						
轻切削 LB		TPMT 090202N-LB	0.2		●	●	●		●	●	●	●	●								—						—		—	●	●	▲		●							
		090204N-LB	0.4		●	●	●		●	●	●	●	●				●				—						—		—	●	●	▲		●							
轻切削 SU		TPMT 090204N-SU	0.4																		—	●	●	●			—		—												
		TPGW 090204 New	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	●																								●
		090208 New	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	●																								●
铝材用 AY		TPGT 090201R-AY	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—																					●
		090201L-AY	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—																					●
		090202R-AY	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—																					●
		090202L-AY	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—																					●
		090204R-AY	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—																					●
		090204L-AY	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—																					●

▲记号：计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

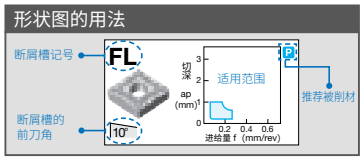
三角形正型刀片

机夹式刀片

TP 三角形 11°正型 带孔



形状图的用法



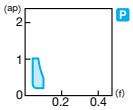
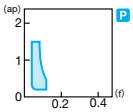
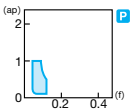
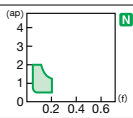
●：连续切削 第一推荐
○：连续切削 第二推荐
◕：一般切削 第一推荐
◔：一般切削 第二推荐
✖：断续切削 第一推荐
✿：断续切削 第二推荐

TP■■1102●●

尺寸 (mm)				
	切刃长度L	11.0	厚度S	2.38
	内切圆IC	6.35	孔径D1	2.8

住友 CBN(CBN) 刀片☞L92　住友金刚石 (PCD) 刀片☞M18
适用内径刀杆 ☞E42

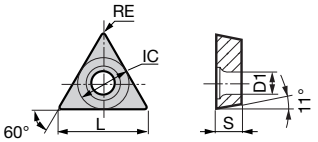
推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
	涂层																										涂层金属陶瓷			金属陶瓷		硬质合金						
	CVD									PVD	CVD							PVD								PVD												
P 钢	●	◔	◕	✖	○	◔	✿		◔			◔								✿		✿	◕	◕			◕	✖	✿	●	◕							
M 不锈钢				✿			✿	●	◕	✖	○	◔								✿		✿	◕	◕	✿													
K 铸铁			✿			✿							●	◕	✖	○	◔			✿		✿		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◔	✿	✿														
H 高硬度材																		●																				

	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
精切削	FW 15°		TPGT 110202R-FW	0.2																										●			●	●								
			110202L-FW	0.2																										●			●	●								
			110204R-FW	0.4																										●			●	●								
			110204L-FW	0.4																										●			●	●								
	FX 15°		TPGT 110202R-FX	0.2																				●	●	●																
			110202L-FX	0.2																				●	●	●																
			110204R-FX	0.4																				●	●	●																
			110204L-FX	0.4																				●	●	●																
			110208R-FX	0.8																				●	●	●																
			110208L-FX	0.8																				●	●	●																
	FY 15°		TPGT 110202R-FY	0.2																													●	●								
			110202L-FY	0.2																													●	●								
			110204R-FY	0.4																													●	●								
			110204L-FY	0.4																													●	●								
			110208R-FY	0.8																														●								
			110208L-FY	0.8																														●								
铝材用	AY 15°		TPGT 110202R-AY	0.2																																						●
			110202L-AY	0.2																																						●
			110204R-AY	0.4																																						●
			110204L-AY	0.4																																						●

三角形正型刀片

机夹式刀片

TP 三角形 11°正型 带孔



材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4～
按被削材分类的刀片材质选择要领 ☞A10～

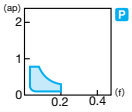
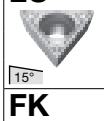
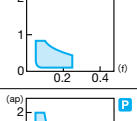
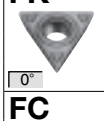
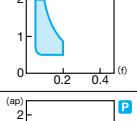
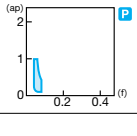
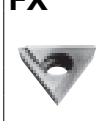
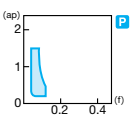
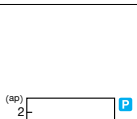
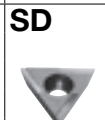
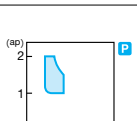
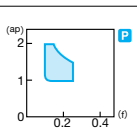
●：连续切削 第一推荐　○：连续切削 第二推荐　◕：一般切削 第一推荐　◔：一般切削 第二推荐　✖：断续切削 第一推荐　✪：断续切削 第二推荐

TP■■1103●●

尺寸(mm)	切刃长度L	11.0	厚度S	3.18
	内切圆IC	6.35	孔径D1	3.4

住友 CBN(CBN) 刀片☞L93～　住友金刚石 (PCD) 刀片☞M19
无粘合剂住友金刚石刀片☞M28　适用内径刀杆 ☞E14、E42～E46

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
	涂层																									涂层金属陶瓷			金属陶瓷		硬质合金						
	CVD									PVD	CVD								PVD							PVD											
P 钢	●	◔	◕	✖	○	◔	✪		◔			◔									✪		✪	◕			◕	✖	✪	●	◕							
M 不锈钢				✪			✪	●	◕	✖	○	◔									✪		✪	◕	✪													
K 铸铁			✪			✪							●	◕	✖	○	◔			✪		✪		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◔	✪	✪														
H 高硬度材																		●																				

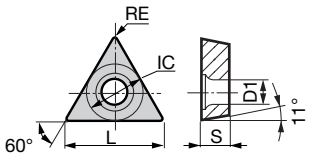
	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
精切削	FB 20°		TPMT 110302N-FB	0.2																								●		●	●	▲	●	●								
			110304N-FB	0.4																								●		●	●	▲	●	●								
			110308N-FB	0.8																								●		●	●	▲	●	●								
	LU  15°		TPMT 110302N-LU	0.2										●														●		●	●		●	●								
			110304N-LU	0.4	●	●	●		●	●			●	●		●												●		●	●	▲	●	●								
			110308N-LU	0.8	●	●	●		●	●			●	●		●												●		●	●	▲	●	●								
	FK  0°		TPMT 110308N-FK	0.8																													●	●								
	FC 15°		TPGT 110302MN-FC	< 0.2																			●	●		●	●	●					●	●								
			110304MN-FC	< 0.4																			●	●		●	●	●					●	●								
	FX  15°		TPGT 110302R-FX	0.2																			●	●		●	●	●														
			110302L-FX	0.2																			●	●		●	●	●														
			110304R-FX	0.4																			●	●		●	●	●														
			110304L-FX	0.4																			●	●		●	●	●														
			110308R-FX	0.8																			●	●		●	●	●														
			110308L-FX	0.8																			●	●		●	●	●														
	FY 15°		TPGT 1103003R-FY	0.03																			●	●		●	●	●	●													
			1103003L-FY	0.03																			●	●		●	●	●	●													
			110301R-FY	0.1																			●	●		●	●	●	●													
			110301L-FY	0.1																			●	●		●	●	●	●													
			110302R-FY	0.2																			●	●		●	●	●	●	●				●	●							
			110302L-FY	0.2																			●	●		●	●	●	●	●	●	▲	●	●							
			110304R-FY	0.4																			●	●		●	●	●	●	●				●							
			110304L-FY	0.4																			●	●		●	●	●	●	●	●	▲	●	●							
			110308R-FY	0.8																			●	●		●	●	●						●							
			110308L-FY	0.8																			●	●		●	●	●						●							
精～轻切削	SD  0°		TPGT 110302R-SD	0.2																							●	●		●			●	●						
			110302L-SD	0.2																							●	●		●	●	▲	●	●				●		
			110304R-SD	0.4																							●	●		●	●	▲	●	●				●		
			110304L-SD	0.4																			●	●	●		●	●		●	●	▲	●	●	●			●		
			110308R-SD	0.8																							●	●		●			●	●						
			110308L-SD	0.8																							●	●		●	●	▲	●	●				●		
	SDW →B131 修光刃 0°		TPGX 110304R-SDW	0.4																											●	▲								
			110304L-SDW	0.4																											●	▲								
			110308R-SDW	0.8																											●	▲								
			110308L-SDW	0.8																											●	▲								

用“<”表示刀尖半径RE的产品，表示其为负公差。

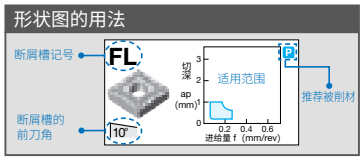
三角形正型刀片

机夹式刀片

TP 三角形 11° 正型 带孔



形状图的用法



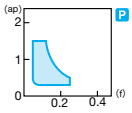
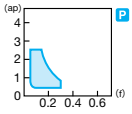
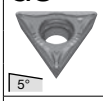
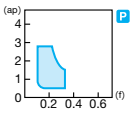
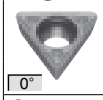
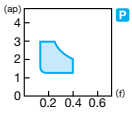
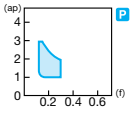
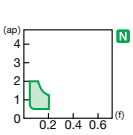
●: 连续切削 第一推荐
○: 连续切削 第二推荐
: 一般切削 第一推荐
: 一般切削 第二推荐
: 断续切削 第一推荐
: 断续切削 第二推荐

TP■■1103●●

尺寸 (mm)	切刃长度L	11.0	厚度S	3.18
	内切圆IC	6.35	孔径D1	3.4

住友 CBN(CBN) 刀片☞L93～ 住友金刚石 (PCD) 刀片☞M19
无粘合剂住友金刚石刀片☞M28 适用内径刀杆 ☞E14、E42～E46

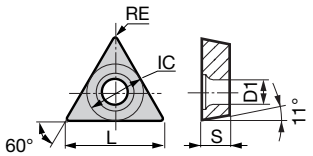
推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◐	◕	✖	○	◐	⊕		◐			◐									⊕		⊕	◕			◕	✖	⊕	●	◕							
M 不锈钢				⊕			⊕	●	◕	✖	○	◐									⊕		⊕	◕	⊕												
K 铸铁			⊕			⊕							●	◕	✖	○	◐			⊕		⊕		◕						●								
N 非铁金属																																					◕
S 难削材																			●	◕	✖	◐	⊕	⊕													
H 高硬度材																		●																			

	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
轻切削	LB 15°		TPMT 110302N-LB	0.2		●	●	●		●	●	●	●	●								—					—		—	●	●	▲		●							
			110304N-LB	0.4		●	●	●		●	●	●	●	●								—					—		—	●	●	▲		●							
			110308N-LB	0.8		●	●	●		●	●	●	●	●								—					—		—	●	●	▲		●							
	SU 8°		TPMT 110302N-SU	0.2	●	●	●	●		●	●	●	●	●	▲	●						—	●	●	●			—	●	—	●	●		●	●							
			110304N-SU	0.4	●	●	●	●	●	●	●	●	●	●	▲	●		●				—	●	●	●			—	●	—	●	●	▲	●	●							
			110308N-SU	0.8	●	●	●	●	●	●	●	●	●	●	▲	●						—	●	●	●			—	●	—	●	●	▲	●	●							
			TPGW 110302	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●																				
			110304	0.4	—	—	—	—	—	—	—	—	—	—	—	—		●				●		●	●	●									●	●			●			●
			110308	0.8	—	—	—	—	—	—	—	—	—	—	—	—		●				●													●	●						●
轻～中切削	GU  5°		TPMT 110304N-GU	0.4	●	●	●	●				●	●	●								—					—		—	●	●			●							
			110308N-GU	0.8	●	●	●	●				●	●	●								—					—		—	●	●			●							
	MU  0°		TPMT 110304N-MU	0.4	●	●	●		●	●		●	●			●	●	●	●	▲	▲	—						—		—	—	—	—	—	—							—
			110308N-MU	0.8	●	●	●		●	●		●	●			●	●	●	●	▲	▲	—						—		—	—	—	—	—	—							—
	SF 0°		TPMH 110304N-SF	0.4			●	●		●	●											—						—		—	—	—	—	—	—							—
			110308N-SF	0.8			●	●		●	●											—						—		—	—	—	—	—	—							—
铝材用	AY 15°		TPGT 110301R-AY	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●
			110301L-AY	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●
			110302R-AY	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●
			110302L-AY	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●
			110304R-AY	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●
			110304L-AY	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●

▲记号: 计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

三角形正型刀片

TP 三角形 11° 正型 带孔



材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4～
按被削材分类的刀片材质选择要领 ☞A10～

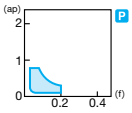
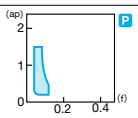
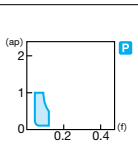
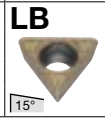
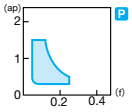
●：连续切削 第一推荐　○：连续切削 第二推荐　◕：一般切削 第一推荐　◔：一般切削 第二推荐　✖：断续切削 第一推荐　✪：断续切削 第二推荐

TP■■1603●●

尺寸 (mm)	切刃长度L	16.5	厚度S	3.18
	内切圆IC	9.525	孔径D1	4.4

住友 CBN(CBN) 刀片☞L96　住友金刚石 (PCD) 刀片☞M20
适用内径刀杆 ☞E42、E46

推荐用途	涂层 CVD									PVD		CVD						PVD							PVD													
	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◕	✖	○	◔	✪		◔			◔								✪		✪	◕			◕	✖	✪	●	◕								
M 不锈钢			✪			✪	●	◕	✖	○	◔									✪		✪	◕	✪														
K 铸铁			✪			✪							●	◕	✖	○	◔			✪		✪		◕					●									
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◔	✪	✪														
H 高硬度材																		●																				

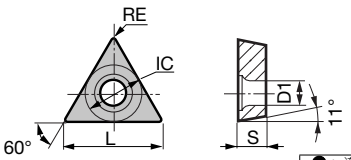
	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
精切削	FB 20°		TPMT 160304N-FB	0.4																									●	—	●	●	▲	●	●							
			160308N-FB	0.8																									●	—	●	●	▲	●	●							
	FX 15°		TPGT 160304R-FX	0.4																			●	●			●														
			160304L-FX	0.4																			●	●			●														
			160308R-FX	0.8																			●	●			●														
			160308L-FX	0.8																			●	●			●														
	FY 15°		TPGT 160302R-FY	0.2																			●	●			●														
			160302L-FY	0.2																			●	●			●														
			160304R-FY	0.4																			●	●			●														
			160304L-FY	0.4																			●	●			●														
			160308R-FY	0.8																			●	●			●														
			160308L-FY	0.8																			●	●			●														
轻切削	LB  15°		TPMT 160304N-LB	0.4		●	●	●		●	●	●	●	●								—					—	—	—	●	●	▲		●							
			160308N-LB	0.8		●	●	●		●	●	●	●	●								—					—	—	—	●	●	▲		●							

▲记号：计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

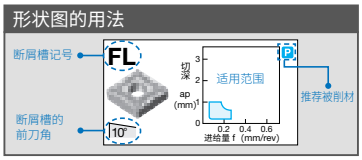
三角形正型刀片

机夹式刀片

TP 三角形 11° 正型 带孔



形状图的用法



●：连续切削 第一推荐
○：连续切削 第二推荐
◐：一般切削 第一推荐
◔：一般切削 第二推荐
✖：断续切削 第一推荐
✖：断续切削 第二推荐

TP■■1604●●

尺寸 (mm)	切刃长度L	16.5	厚度S	4.76
	内切圆IC	9.525	孔径D1	4.4

住友 CBN(CBN) 刀片☞L96～　住友金刚石 (PCD) 刀片☞M20
无粘合剂住友金刚石刀片☞M28　适用内径刀杆 ☞E14、E42～E44

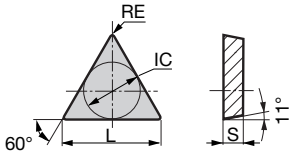
推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◐	✖	○	◔	⊕		◔			◔									⊕		◐	◐			◐	✖	⊕	●	◐							
M 不锈钢				⊕			⊕	●	◐	✖	○	◔									⊕		⊕	◐	⊕													
K 铸铁			⊕			⊕							●	◐	✖	○	◔			⊕		⊕		◐						●								
N 非铁金属																																						◐
S 难削材																			●	◐	✖	◔	⊕	⊕														
H 高硬度材																		●																				

	形状	适用范围	型号	刀尖半径 RE	涂层 CVD								PVD	CVD							PVD					涂层金属陶瓷 PVD			金属陶瓷		硬质合金						
					AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
精切削	FB 20°		TPMT 160404N-FB	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	●	●	▲	●	●	—	—	—	—	—	—	—
			160408N-FB	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	●	●	▲	●	●	—	—	—	—	—	—	—
	FK 0°		TPMT 160404N-FK	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	—	—	—	—	—
			160408N-FK	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	—	—	—	—	—	—
精～轻切削	SD 0°		TPGT 160402R-SD	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	●	—	—	—	—
			160402L-SD	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	●	—	—	—	—
			160404R-SD	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	▲	●	●	●	—	—	●	—	—	—	—
			160404L-SD	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	●	—	—	●	●	▲	●	●	●	●	—	●	—	—	—	—
			160408R-SD	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	—	●	●	—	—	—	●	—	—	—	—
			160408L-SD	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	—	●	●	●	—	—	●	—	—	—	—
	SDW 0° →B131 修光刃		TPGX 160404R-SDW	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	—	●	—	—	—	—	—	—	—
			160404L-SDW	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	—	●	—	—	—	—	—	—	—
			160408R-SDW	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	—	●	—	—	—	—	—	—	—
			160408L-SDW	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	—	●	—	—	—	—	—	—	—
轻切削	LB 15°		TPMT 160404N-LB	0.4		●	●	●		●	●	●	●	●								—					—	—	—	●	●	▲		●						
			160408N-LB	0.8		●	●	●		●	●	●	●	●								—					—	—	—	●	●	▲		●						
	SU 8°		TPMT 160404N-SU	0.4	●	●	●	●	●	●	●	●	●	●	▲	●		●				—	●	●	●			—	—	●	●	▲	●	●						
			160408N-SU	0.8	●	●	●	●	●	●	●	●	●	●	▲	●		●				—	●	●	●			—	—	●	●	▲	●	●						
			TPGW 160400	0	—	—	—	—	—	—	—	—	—	—	—	—																								
			160404	0.4	—	—	—	—	—	—	—	—	—	—	—	—		●						●	●	●												●		●
			160408 New	0.8	—	—	—	—	—	—	—	—	—	—	—	—		●																						●
轻～中切削	GU 5°		TPMT 160404N-GU	0.4	●	●	●	●				●	●	●								—					—	—	—	●	●			●						
			160408N-GU	0.8	●	●	●	●				●	●	●								—					—	—	—	●	●			●						
整体CBN 陶瓷	MU 0°		TPMT 160404N-MU	0.4	●	●	●		●	●		●	●			●	●	●	●	▲	▲	—					—	—	—	—	—	—	—	—	—	—	—	—	—	—
			160408N-MU	0.8	●	●	●		●	●		●	●			●	●	●	●	▲	▲	—					—	—	—	—	—	—	—	—	—	—	—	—	—	—
	SF 0°		TPMT 160404N-SF	0.4			●	●		●	●											—					—	—	—	—	—	—	—	—	—	—	—	—	—	—
			160408N-SF	0.8			●	●		●	●											—					—	—	—	—	—	—	—	—	—	—	—	—	—	—

▲记号：计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

三角形正型刀片

TP 三角形 11° 正型 无孔



材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4～
按被削材分类的刀片材质选择要领 ☞A10～

●：连续切削 第一推荐
○：连续切削 第二推荐
◕：一般切削 第一推荐
◔：一般切削 第二推荐
✖：断续切削 第一推荐
✪：断续切削 第二推荐

TP■■0902●●

尺寸 (mm)	切刃长度L	9.6	厚度S	2.38
	内切圆IC	5.56		

住友 CBN(CBN) 刀片 ☞L99　住友金刚石 (PCD) 刀片 ☞M21

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
	涂层																										涂层金属陶瓷			金属陶瓷		硬质合金						
	CVD									PVD			CVD									PVD					PVD											
P 钢	●	○	◕	✖	○	○	✪		◔				◔								✪		✪	◕			◕	✖	✪	●	◕							
M 不锈钢			✪				✪	●	◕	✖	○	◔									✪		✪	◕	✪													
K 铸铁			✪			✪							●	◕	✖	○	◔			✪		✪		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◔	✪	✪														
H 高硬度材																		●																				

	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
精切削	FK		TPMR 090204N-FK	0.4																															●							
精～轻切削	W		TPGR 090202R-W	0.2																															●							
			090202L-W	0.2																															●							
			090204R-W	0.4																															●							
			090204L-W	0.4																															●	●						
			090208R-W	0.8																															●							
			090208L-W	0.8																															●							
轻切削			TPGN 090202	0.2																															●							
			090204	0.4																															●							●
			090208	0.8																															●							●

TP■■1103●●

尺寸 (mm)	切刃长度L	11.0	厚度S	3.18
	内切圆IC	6.35		

住友 CBN(CBN) 刀片 ☞L99～　住友金刚石 (PCD) 刀片 ☞M21
陶瓷刀片 ☞B128　适用内径刀杆 ☞E46

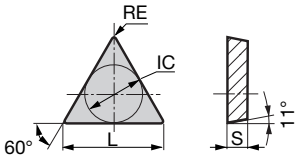
推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
	涂层																										涂层金属陶瓷			金属陶瓷		硬质合金						
	CVD									PVD			CVD									PVD					PVD											
P 钢	●	○	◕	✖	○	○	✪		◔				◔								✪		✪	◕			◕	✖	✪	●	◕							
M 不锈钢			✪				✪	●	◕	✖	○	◔									✪		✪	◕	✪													
K 铸铁			✪			✪							●	◕	✖	○	◔			✪		✪		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◔	✪	✪														
H 高硬度材																		●																				

	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
精切削	FK		TPMR 110302N-FK	0.2																													●	●								
			110304N-FK	0.4																										●	●	▲	●	●								
			110308N-FK	0.8																										●			●	●								
精～轻切削	W		TPGR 110302R-W	0.2																										●			●	●								
			110302L-W	0.2																										●			●	●								
			110304R-W	0.4																										●			●	●								
			110304L-W	0.4																										●			●	●	●							
			110308L-W	0.8																										●			●	●								
轻～中切削	SF		TPMR 110304N-SF	0.4			●	●		●	●																								●							
			110308N-SF	0.8			●	●		●	●																															
	UJ		TPMR 110304N-UJ	0.4			●	●		●	●																															
			110308N-UJ	0.8			●	●		●	●																															
中切削			TPMN 110304	0.4													●	●	●	▲	▲		●	●	●	●												●	●				
			110308	0.8													●	●	●	▲	▲		●	●	●	●												●	●				

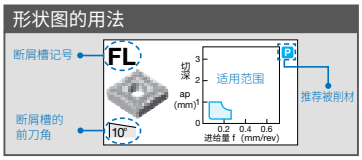
▲记号：计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

三角形正型刀片

TP 三角形 11° 正型 无孔



形状图的用法



●: 连续切削 第一推荐
○: 连续切削 第二推荐
●: 一般切削 第一推荐
○: 一般切削 第二推荐
✖: 断续切削 第一推荐
✖: 断续切削 第二推荐

TP■■1103●●

尺寸 (mm)	切刃长度L	11.0	厚度S	3.18
	内切圆IC	6.35		

住友 CBN(CBN) 刀片 ☞L99～ 住友金刚石 (PCD) 刀片 ☞M21
陶瓷刀片 ☞B128 适用内径刀杆 ☞E46

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
	涂层																										涂层金属陶瓷			金属陶瓷		硬质合金						
	CVD									PVD	CVD							PVD								PVD												
P 钢	●	◐	●	✖	○	◐	⚙		◐			◐								⚙			⚙	●			●	✖	⚙	●	●							
M 不锈钢				⚙			⚙	●	●	✖	○	◐								⚙			⚙	●	⚙													
K 铸铁			⚙			⚙							●	●	✖	○	◐			⚙		⚙		●						●								
N 非铁金属																																						●
S 难削材																			●	●	✖	◐	⚙	⚙														
H 高硬度材																		●																				

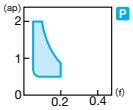
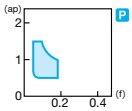
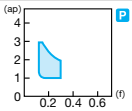
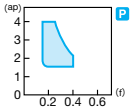
	形状	适用范围	型 号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
中切削			TPGN 110302	0.2	—	—	—	—	—	—	—			—																				●	●							●
			110304	0.4	—	—	—	—	—	—	—			—											●	●	●								●	●				●			●
			110308	0.8	—	—	—	—	—	—	—			—																					●	●				●			●
			110312	1.2	—	—	—	—	—	—	—			—																													

TP■■1603●●

尺寸 (mm)	切刃长度L	16.5	厚度S	3.18
	内切圆IC	9.525		

住友 CBN(CBN) 刀片 ☞L101 住友金刚石 (PCD) 刀片 ☞M20
陶瓷刀片 ☞B128
适用外径刀杆 ☞C36、C37 适用内径刀杆 ☞E46

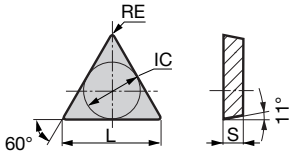
推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
	涂层																										涂层金属陶瓷			金属陶瓷		硬质合金						
	CVD									PVD	CVD							PVD								PVD												
P 钢	●	◐	●	✖	○	◐	⚙		◐			◐								⚙			⚙	●			●	✖	⚙	●	●							
M 不锈钢				⚙			⚙	●	●	✖	○	◐								⚙			⚙	●	⚙													
K 铸铁			⚙			⚙							●	●	✖	○	◐			⚙		⚙		●						●								
N 非铁金属																																						●
S 难削材																			●	●	✖	◐	⚙	⚙														
H 高硬度材																		●																				

	形状	适用范围	型 号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
精切削	FK 0°		TPMR 160304N-FK	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	▲	●	●	—	—	—	—	—	—	—	—
			160308N-FK	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	▲	●	●	—	—	—	—	—	—	—	—
			160312N-FK	1.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	—	—	—	—	—	—	—
精～轻切削	W 0°		TPGR 160302R-W	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●			●	●		—	—	—	—	—	—	—
			160302L-W	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●			●	●		—	—	—	—	—	—	—
			160304R-W	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●			●	●		—	—	—	—	—	—	—
			160304L-W	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●			●	●	●	—	—	—	—	—	—	—
			160308R-W	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●			●	●		—	—	—	—	—	—	—
			160308L-W	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●			●	●		—	—	—	—	—	—	—
轻～中切削	SF 0°		TPMR 160304N-SF	0.4			●	●		●	●											—	—	—	—	—	—	—	—	—	—	—	—	—	—	●					—
			160308N-SF	0.8			●	●		●	●											—	—	—	—	—	—	—	—	—	—	—	—	—	—	●					—
			160312N-SF	1.2			●			●												—	—	—	—	—	—	—	—	—	—	—	—	—	—	—					—
轻～中切削	UJ 0°		TPMR 160304N-UJ	0.4			●	●		●	●											—	—	—	—	—	—	—	—	—	—	—	—	—	—	—					—
			160308N-UJ	0.8			●	●		●	●											—	—	—	—	—	—	—	—	—	—	—	—	—	—	—					—
中切削			TPMN 160304	0.4													●	●	●	▲	▲	—	●	●	●	●	—	—	—	—							●	●	●	●			
			160308	0.8													●	●	●	▲	▲	—	●	●	●	●	—	—	—	—				●	●		●	●	●			
			160312	1.2													●	●	●	▲	▲	—					—	—	—	—								●	●			
中切削			TPGN 160302	0.2	—	—	—	—	—	—	—	—	—	—	—	—																		●	●				●			
			160304	0.4	—	—	—	—	—	—	—	—	—	—	—	—									●	●	●								●	●		●		●			●
			160308	0.8	—	—	—	—	—	—	—	—	—	—	—	—									●	●	●								●	●		●	●	●			●
			160312	1.2	—	—	—	—	—	—	—	—	—	—	—	—																								●			
			160316	1.6	—	—	—	—	—	—	—	—	—	—	—	—																											

▲记号: 计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

三角形正型刀片

TP 三角形 11° 正型 无孔



材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4～
按被削材分类的刀片材质选择要领 ☞A10～

●：连续切削 第一推荐
○：连续切削 第二推荐
◕：一般切削 第一推荐
◔：一般切削 第二推荐
✖：断续切削 第一推荐
✪：断续切削 第二推荐

TP■■1604●●

尺寸 (mm)	切刃长度L	16.5	厚度S	4.76
	内切圆IC	9.525		

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
	涂层																										涂层金属陶瓷			金属陶瓷		硬质合金						
	CVD									PVD	CVD							PVD									PVD											
P 钢	●	◔	◕	✖	○	◔	✪		◔			◔									✪		✪	◕			◕	✖	✪	●	◕							
M 不锈钢			✪				✪	●	◕	✖	○	◔									✪		✪	◕	✪													
K 铸铁			✪			✪							●	◕	✖	○	◔			✪		✪		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◔	✪	✪														
H 高硬度材																		●																				

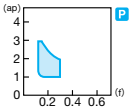
	形状	适用范围	型 号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
中切削			TPGN 160404	0.4	—	—	—	—	—	—	—	—	—	—	—	—																											
			160408	0.8	—	—	—	—	—	—	—	—	—	—	—	—																							●				
			160412	1.2	—	—	—	—	—	—	—	—	—	—	—	—																											
			160416	1.6	—	—	—	—	—	—	—	—	—	—	—	—																											

TP■■2204●●

尺寸 (mm)	切刃长度L	22.0	厚度S	4.76
	内切圆IC	12.7		

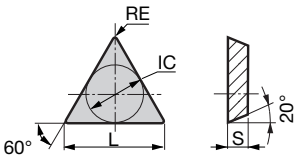
住友 CBN(CBN) 刀片 ☞L102
适用外径刀杆 ☞C36、C37

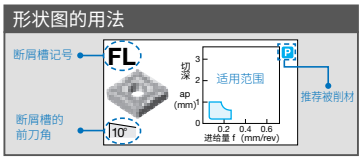
推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
	涂层																										涂层金属陶瓷			金属陶瓷		硬质合金						
	CVD									PVD	CVD							PVD									PVD											
P 钢	●	◔	◕	✖	○	◔	✪		◔			◔									✪		✪	◕			◕	✖	✪	●	◕							
M 不锈钢			✪				✪	●	◕	✖	○	◔									✪		✪	◕	✪													
K 铸铁			✪			✪							●	◕	✖	○	◔			✪		✪		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◔	✪	✪														
H 高硬度材																		●																				

	形状	适用范围	型 号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
轻～中切削	SF 0°		TPMR 220408N-SF	0.8																		—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			220412N-SF	1.2																		—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
中切削			TPMN 220404	0.4																		—					—		—						●			●	●				
			220408	0.8																		—	●	●	●	●		—	—					●	●		●	●	●			
			220412	1.2																		—	●	●	●	●		—	—									●	●			
			220416	1.6																		—						—	—								●	●				
			TPGN 220404	0.4	—	—	—	—	—	—	—	—	—	—	—	—																								●			
			220408	0.8	—	—	—	—	—	—	—	—	—	—	—	—								●	●	●													●	●			
			220412	1.2	—	—	—	—	—	—	—	—	—	—	—	—																											
			220416	1.6	—	—	—	—	—	—	—	—	—	—	—	—																											

三角形正型刀片

TE 三角形 20° 正型 无孔





●：连续切削 第一推荐
○：连续切削 第二推荐
●：一般切削 第一推荐
○：一般切削 第二推荐
✖：断续切削 第一推荐
✖：断续切削 第二推荐

TE■■1102●●

尺寸 (mm)				
	切刃长度L	11.0	厚度S	2.38
	内切圆IC	6.35		

住友金刚石 (PCD) 刀片 ☞M22

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◐	◕	✖	○	◐	✪			◐				◐							✪		✪	◕			◕	✖	✪	●	◕							
M 不锈钢				✪			✪	●	◕	✖	○	◐									✪		✪	◕	✪													
K 铸铁			✪			✪							●	◕	✖	○	◐			✪		✪		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◐	✪	✪														
H 高硬度材																		●																				

	形状	适用范围	型 号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
轻切削			TEGN 110202	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●
			110204	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●
			110208	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	

TE■■1103●●

尺寸 (mm)				
	切刃长度L	11.0	厚度S	3.18
	内切圆IC	6.35		

住友金刚石 (PCD) 刀片 ☞M22

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◐	◕	✖	○	◐	✪			◐				◐							✪		✪	◕			◕	✖	✪	●	◕							
M 不锈钢				✪			✪	●	◕	✖	○	◐									✪		✪	◕	✪													
K 铸铁			✪			✪							●	◕	✖	○	◐			✪		✪		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◐	✪	✪														
H 高硬度材																		●																				

	形状	适用范围	型 号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
轻切削			TEGN 110302	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●
			110304	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●
			110308	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●

TE■■1603●●

尺寸 (mm)				
	切刃长度L	16.5	厚度S	3.18
	内切圆IC	9.525		

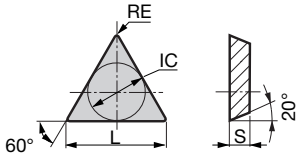
住友金刚石 (PCD) 刀片 ☞M22

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◐	◕	✖	○	◐	✪			◐				◐							✪		✪	◕			◕	✖	✪	●	◕							
M 不锈钢				✪			✪	●	◕	✖	○	◐									✪		✪	◕	✪													
K 铸铁			✪			✪							●	◕	✖	○	◐			✪		✪		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◐	✪	✪														
H 高硬度材																		●																				

	形状	适用范围	型 号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
轻～中切削			TEGN 160302	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●
			160304	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●
			160308	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	—	—	—	—	—	●

三角形正型刀片

TE 三角形 20° 正型 无孔



材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4～
按被削材分类的刀片材质选择要领 ☞A10～

●：连续切削 第一推荐
○：连续切削 第二推荐
●：一般切削 第一推荐
○：一般切削 第二推荐
✖：断续切削 第一推荐
✖：断续切削 第二推荐

TE■■2204●●

尺寸 (mm)	切刃长度L	22.0	厚度S	4.76
	内切圆IC	12.7		

住友金刚石 (PCD) 刀片 ☞M22

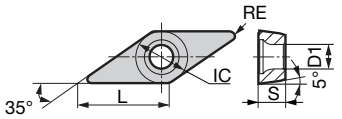
推荐用途	涂层 CVD									PVD	CVD					PVD									涂层 金属陶瓷 PVD			金属陶瓷	硬质合金						
	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	○	◐	✖	○	○	✪		○			○								✪			✪	◐			◐	✖	✪	●	◐							
M 不锈钢			✪			✪		●	◐	✖	○	○								✪			✪	◐	✪													
K 铸铁			✪			✪							●	◐	✖	○	○			✪		✪		◐						●								
N 非铁金属																																						◐
S 难削材																			●	◐	✖	○	✪	✪														
H 高硬度材																		●																				

	形状	适用范围	型 号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
轻～中切削			TEGN 220404	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●
			220408	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	
			220412	1.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	

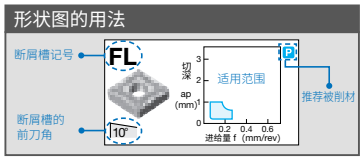
35° 菱形正型刀片

机夹式刀片

VB 35°菱形 5° 正型 带孔



形状图的用法



●: 连续切削 第一推荐
○: 连续切削 第二推荐
: 一般切削 第一推荐
: 一般切削 第二推荐
: 断续切削 第一推荐
: 断续切削 第二推荐

VB■■1103●●

尺寸 (mm)				
	切刃长度L	11.1	厚度S	3.18
	内切圆IC	6.35	孔径D1	2.8

住友 CBN(CBN) 刀片 L106、L107

适用内径刀杆 E50、E52、E53、E55、E56、E58、E59

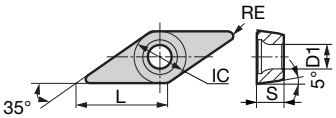
推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◐	◕	✖	○	◐	⊕		◐			◐								⊕			⊕	◕		◕	✖	⊕	●	◕								
M 不锈钢				⊕			⊕	●	◕	✖	○	◐								⊕			⊕	◕	⊕												
K 铸铁			⊕			⊕							●	◕	✖	○	◐			⊕		⊕		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◐	⊕	⊕														
H 高硬度材																		●																				

	涂层																									涂层金属陶瓷			金属陶瓷		硬质合金						
	CVD									PVD	CVD							PVD								PVD											
形状	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
FB 型号 / 刀尖半径 RE																																					
VBMT 110302N-FB 0.2																									●		●	●	▲	●	●						
110304N-FB 0.4																									●		●	●	▲	●	●						
110308N-FB 0.8																									●		●	●	▲	●	●						
LU																																					
VBMT 110302N-LU 0.2																									●		●	●		●	●						
110304N-LU 0.4	●	●	●		●	●				●		●													●		●	●	▲	●	●						
110308N-LU 0.8	●	●	●						●	●		●													●												
FX																																					
VBGT 110301R-FX 0.1																				●	●			●	●		●			●	●						
110301L-FX 0.1																				●	●			●	●		●			●	●						
110302R-FX 0.2																				●	●			●	●		●			●	●						
110302L-FX 0.2																				●	●			●	●		●			●	●						
110304R-FX 0.4																				●	●			●	●		●			●	●						
110304L-FX 0.4																				●	●			●	●		●			●	●						
FYS																																					
VBGT 1103003R-FYS 0.03																				●	●			●													
1103003L-FYS 0.03																				●	●			●													
110301R-FYS 0.1																				●	●			●													
110301L-FYS 0.1																				●	●			●													
110302R-FYS 0.2																				●	●			●													
110302L-FYS 0.2																				●	●			●													
110304R-FYS 0.4																				●	●			●													
110304L-FYS 0.4																				●	●			●													
110308R-FYS 0.8																				●	●			●													
110308L-FYS 0.8																				●	●			●													
FYS																																					
VBET 1103003R-FYS 0.03																								●													
1103003L-FYS 0.03																								●													
110301R-FYS 0.1																								●													
110301L-FYS 0.1																								●													
110302R-FYS 0.2																								●													
110302L-FYS 0.2																								●													
110304R-FYS 0.4																								●													
110304L-FYS 0.4																								●													
110308R-FYS 0.8																								●													
110308L-FYS 0.8																								●													
FY																																					
VBGT 110301R-FY 0.1																				●	●			●	●		●			●	●						
110301L-FY 0.1																				●	●			●	●		●			●	●						
110302R-FY 0.2																				●	●			●	●		●			●	●						
110302L-FY 0.2																				●	●			●	●		●			●	●						
110304R-FY 0.4																				●	●			●	●												
110304L-FY 0.4																				●	●			●	●												

▲记号: 计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

35° 菱形正型刀片

VB 35°菱形 5° 正型 带孔



材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4～
按被削材分类的刀片材质选择要领 ☞A10～

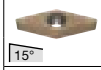
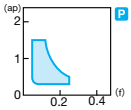
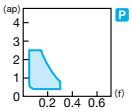
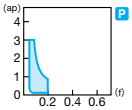
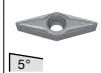
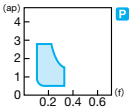
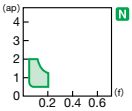
●：连续切削 第一推荐　○：连续切削 第二推荐　●：一般切削 第一推荐　○：一般切削 第二推荐　✖：断续切削 第一推荐　✖：断续切削 第二推荐

VB■■1103●●

尺寸 (mm)	切刃长度L	11.1	厚度S	3.18
	内切圆IC	6.35	孔径D1	2.8

住友 CBN(CBN) 刀片 ☞L106、L107
适用内径刀杆 ☞E50、E52、E53、E55、E56、E58、E59

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
	涂层																										涂层金属陶瓷			金属陶瓷		硬质合金						
	CVD									PVD	CVD							PVD								PVD												
P 钢	●	○	●	✖	○	○	✖		○				○								✖		✖	●			●	✖	✖	●	●							
M 不锈钢			✖				✖														✖		✖	●	✖													
K 铸铁				✖			✖	●	●	✖	○	○		●	●	✖	○	○			✖		✖	●						●								
N 非铁金属																																						●
S 难削材																			●	●	✖	○	✖	✖														
H 高硬度材																		●																				

	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
轻切削	LB  15°		VBMT 110302N-LB	0.2		●	●	●		●	●	●	●	●																●	●	▲		●							
			110304N-LB	0.4		●	●	●		●	●	●	●	●																●	●	▲		●							
			110308N-LB	0.8		●	●	●		●	●	●	●	●																●	●	▲		●							
	SU 8°		VBMT 110302N-SU	0.2																			●	●	●				●													
			110304N-SU	0.4		●	●							●	▲	●							●	●	●				●			●	▲									
			110308N-SU	0.8		●	●					●	●	●	▲	●							●	●	●				●													
	SI 15°		VBGT 110301MN-SI	< 0.1																			●	●	●	●	●	●													
			110302MN-SI	< 0.2																			●	●	●	●	●	●														
			110304MN-SI	< 0.4																			●	●	●	●	●	●														
			110308MN-SI	< 0.8																			●	●	●	●	●	●														
轻～中切削	GU  5°		VBMT 110304N-GU	0.4	●	●	●	●				●	●	●																●	●			●							
			110308N-GU	0.8	●	●	●	●				●	●	●																●	●			●							
铝材用	AY 15°		VBGT 110301R-AY	0.1																																				●
			110301L-AY	0.1																																				●
			110302R-AY	0.2																																				●
			110302L-AY	0.2																																				●
			110304R-AY	0.4																																				●
			110304L-AY	0.4																																				●

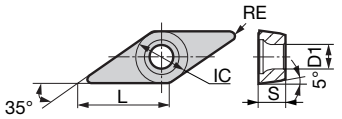
用“<”表示刀尖半径RE的产品，表示其为负公差。

▲记号：计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

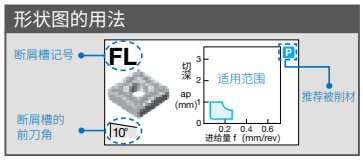
35° 菱形正型刀片

机夹式刀片

VB 35°菱形 5° 正型 带孔



形状图的用法



●: 连续切削 第一推荐
○: 连续切削 第二推荐
: 一般切削 第一推荐
: 一般切削 第二推荐
: 断续切削 第一推荐
: 断续切削 第二推荐

VB■■1604●●

尺寸 (mm)	切刃长度L	16.6	厚度S	4.76
	内切圆IC	9.525	孔径D1	4.4

住友 CBN(CBN) 刀片 L108、L109

适用内径刀杆 E14、E50、E52、E55、E58

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◐	◕	✖	○	◐	⊕		◐			◐									⊕		⊕	◕		◕	✖	⊕	●	◕								
M 不锈钢				⊕			⊕	●	◕	✖	○	◐									⊕		⊕	◕	⊕													
K 铸铁			⊕			⊕							●	◕	✖	○	◐			⊕		⊕		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◐	⊕	⊕														
H 高硬度材																		●																				

	形状	适用范围	型 号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
					涂层																									涂层金属陶瓷				金属陶瓷	硬质合金							
					CVD									PVD	CVD							PVD								PVD												
精切削	FB 20°	P	VBMT 160404N-FB	0.4																									●		●	●	▲	●	●							
			160408N-FB	0.8																									●		●	●	▲	●	●							
	LU 15°	P	VBMT 160404N-LU	0.4	●	●	●		●	●			●	●		●													●		●	●	▲	●	●							
			160408N-LU	0.8	●	●	●		●	●			●	●		●													●		●	●	▲	●	●							
	FX 15°	P	VBGT 160402R-FX	0.2																														●	●							
			160402L-FX	0.2																														●	●							
			160404R-FX	0.4																														●	●							
			160404L-FX	0.4																														●	●							
轻切削	LB 15°	P	VBMT 160404N-LB	0.4		●	●	●		●	●	●	●	●																	●	●	▲		●							
			160408N-LB	0.8		●	●	●		●	●	●	●	●																	●	●	▲		●							
			160412N-LB	1.2		●	●	●		●	●	●	●	●																	●	●	▲		●							
	SU 8°	P	VBMT 160404N-SU	0.4	●	●	●	●	●	●	●	●	●	●	▲	●							●	●	●						●	●	▲	●	●							
			160408N-SU	0.8	●	●	●	●	●	●	●	●	●	●	▲	●							●	●	●						●	●	▲	●	●							
			160412N-SU	1.2	●	●	●			●																																
	SI 15°	P	VBGT 160401MN-SI	< 0.1																				●	●	●	●	●	●													
			160402MN-SI	< 0.2																				●	●	●	●	●	●													
			160404MN-SI	< 0.4																				●	●	●	●	●	●													
			160408MN-SI	< 0.8																				●	●	●	●	●	●													
轻～中切削			VBMW 160404	0.4													●	●	●	▲	▲																					
			160408	0.8													●	●	●	▲	▲																					
	GU 5°	P	VBMT 160404N-GU	0.4	●	●	●	●				●	●	●																	●	●			●							
			160408N-GU	0.8	●	●	●	●				●	●	●																	●	●			●							
铝材用	AY 15°	N	VBGT 160402R-AY	0.2																																					●
			160402L-AY	0.2																																					●
			160404R-AY	0.4																																					●
			160404L-AY	0.4																																					●

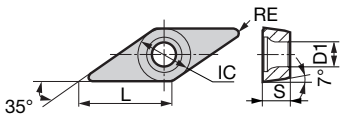
用“<”表示刀尖半径 RE 的产品，表示其为负公差。

▲记号: 计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

35° 菱形正型刀片

机夹式刀片

VC 35°菱形 7° 正型 带孔



材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4～
按被削材分类的刀片材质选择要领 ☞A10～

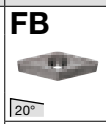
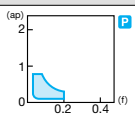
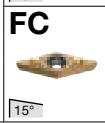
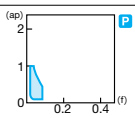
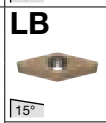
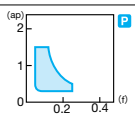
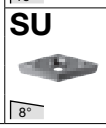
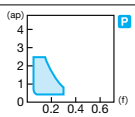
●：连续切削 第一推荐　○：连续切削 第二推荐　◐：一般切削 第一推荐　◔：一般切削 第二推荐　✖：断续切削 第一推荐　✪：断续切削 第二推荐

VC■■0802●●

尺寸 (mm)	切刃长度L	8.3	厚度S	2.38
	内切圆IC	4.76	孔径D1	2.3

住友 CBN(CBN) 刀片 ☞L110　无粘合剂住友金刚石刀片 ☞M28
适用内径刀杆 ☞E51、E54、E57、E60

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
	涂层																									涂层金属陶瓷			金属陶瓷		硬质合金						
	CVD									PVD	CVD							PVD								PVD											
P 钢	●	◔	◐	✖	○	◔	✪		◔				◔								✪		✪	◐			◐	✖	✪	●	◐							
M 不锈钢				✪			✪	●	◐	✖	○	◔									✪		✪	◐	✪													
K 铸铁			✪			✪							●	◐	✖	○	◔			✪		✪		◐						●								
N 非铁金属																																						◐
S 难削材																			●	◐	✖	◔	✪	✪														
H 高硬度材																		●																				

	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
精切削	FB  20°		VCMT 080202N-FB	0.2																									●	—	●	●	▲	●	●	—	—	—	—	—	—	—
			080204N-FB	0.4																									●	—	●	●	▲	●	●	—	—	—	—	—	—	—
	FC  15°		VCGT 080204MN-FC	< 0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●		●	●	●	●						—	—	—	—	—	—	—
轻切削	LB  15°		VCMT 080202N-LB	0.2		●	●	●		●	●	●	●	●								—								—	●	●	▲		●							
			080204N-LB	0.4		●	●	●		●	●	●	●	●								—								—	●	●	▲		●							
	SU  8°		VCMT 080204N-SU	0.4								●	●	●		●						—	●	●	●				●	—	—	—	—	—	—							—

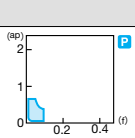
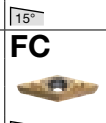
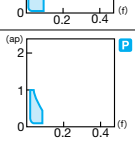
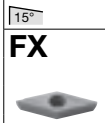
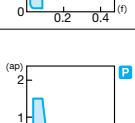
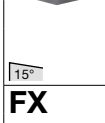
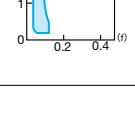
用“<”表示刀尖半径 RE 的产品，表示其为负公差。

VC■■1103●●

尺寸 (mm)	切刃长度L	11.1	厚度S	3.18
	内切圆IC	6.35	孔径D1	2.8

住友 CBN(CBN) 刀片 ☞L111　住友金刚石 (PCD) 刀片 ☞M23　无粘合剂住友金刚石刀片 ☞M28
适用外径刀杆 ☞C40、C41、D15、D28　适用内径刀杆 ☞E54、E57、E60

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
	涂层																									涂层金属陶瓷			金属陶瓷		硬质合金						
	CVD									PVD	CVD							PVD								PVD											
P 钢	●	◔	◐	✖	○	◔	✪		◔				◔								✪		✪	◐			◐	✖	✪	●	◐							
M 不锈钢				✪			✪	●	◐	✖	○	◔									✪		✪	◐	✪													
K 铸铁			✪			✪							●	◐	✖	○	◔			✪		✪		◐						●								
N 非铁金属																																						◐
S 难削材																			●	◐	✖	◔	✪	✪														
H 高硬度材																		●																				

	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
微小切削	FF 15°		VCGT 110301MN-FF New	< 0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●			●														—
			110302MN-FF New	< 0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●			●															—
			110304MN-FF New	< 0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●			●															—
精切削	FC  15°		VCGT 110301MN-FC	< 0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●		●	●	●	●				●	●	—	—	—	—	—	—	—
			110302MN-FC	< 0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●		●	●	●	●				●	●	—	—	—	—	—	—	—
			110304MN-FC	< 0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●		●	●	●	●				●	●	—	—	—	—	—	—	—
	FX  15°		VCGT 110301R-FX	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●		●	●	●					●	●							
			110301L-FX	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●		●	●	●					●	●							
			110302R-FX	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●		●	●	●					●	●							
			110302L-FX	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●		●	●	●					●	●							
			110304R-FX	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●			●	●													
			110304L-FX	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●			●	●													
	FX  15°		VCET 1103008R-FX	0.08	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—					●		●												
			1103008L-FX	0.08	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—					●		●												
			110301R-FX	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—					●		●												
			110301L-FX	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—					●		●												
			1103018R-FX	0.18	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—					●		●												
			1103018L-FX	0.18	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—					●		●												

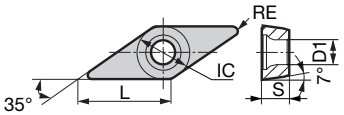
用“<”表示刀尖半径 RE 的产品，表示其为负公差。

▲记号：计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

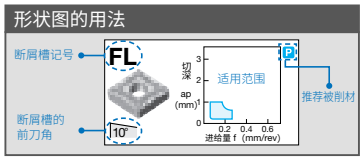
35° 菱形正型刀片

机夹式刀片

VC 35°菱形 7° 正型 带孔



形状图的用法



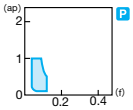
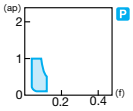
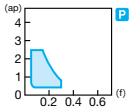
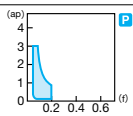
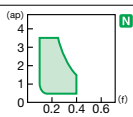
●：连续切削 第一推荐　○：连续切削 第二推荐　◆：一般切削 第一推荐　◔：一般切削 第二推荐　✖：断续切削 第一推荐　✪：断续切削 第二推荐

VC■■1103●●

尺寸 (mm)				
	切刃长度L	11.1	厚度S	3.18
	内切圆IC	6.35	孔径D1	2.8

住友 CBN(CBN) 刀片 L111　住友金刚石 (PCD) 刀片 M23　无粘合剂住友金刚石刀片 M28
适用外径刀杆 C40、C41、D15、D28　适用内径刀杆 E54、E57、E60

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◆	✖	○	◔	✪			◔				◔							✪		✪	◆			◆	✖	✪	●	◆							
M 不锈钢				✪			✪	●	◆	✖	○	◔									✪		✪	◆	✪													
K 铸铁			✪			✪							●	◆	✖	○	◔			✪		✪		◆						●								
N 非铁金属																																						◆
S 难削材																			●	◆	✖	◔	✪	✪														
H 高硬度材																		●																				

	形状	适用范围	型 号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
精切削	FY 15°		VCGT 110301R-FY	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	●	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—
			110301L-FY	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	●	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—
			110302R-FY	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	●	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—
			110302L-FY	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	●	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—
			110304R-FY	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—
			110304L-FY	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	●	●	—	—	—	—	—	—	—	—	—	—	—	—	—
	FY 15°		VCET 1103008R-FY	0.08	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	●	—	—	—	—	—	—	—	—	—	—	—	—
			1103008L-FY	0.08	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	●	—	—	—	—	—	—	—	—	—	—	—	—
			110301R-FY	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	●	—	—	—	—	—	—	—	—	—	—	—	—
			110301L-FY	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	●	—	—	—	—	—	—	—	—	—	—	—	—
			1103018R-FY	0.18	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	●	—	—	—	—	—	—	—	—	—	—	—	—
			1103018L-FY	0.18	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	●	—	—	—	—	—	—	—	—	—	—	—	—
轻切削	SU 8°		VCMT 110302N-SU	0.2								●	●	●		●						—	●	●	●		—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			110304N-SU	0.4		●	●					●	●	●		●						—	●	●	●		—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			110308N-SU	0.8		●	●					●	●	●		●						—	●	●	●		—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
轻切削	SI 15°		VCGT 110301MN-SI	< 0.1	—	—	—	—	—	—	—	—	—	▲	●	—	—	—	—	—	—	—	—	●	●	●	●	●	●	—	—	●	●	—	●	●	—	—	—	—	—	—
			110302MN-SI	< 0.2	—	—	—	—	—	—	—	—	—	▲	●	—	—	—	—	—	—	—	—	●	●	●	●	●	●	—	—	●	●	—	●	●	—	—	—	—	—	—
			110304MN-SI	< 0.4	—	—	—	—	—	—	—	—	—	▲	●	—	—	—	—	—	—	—	—	●	●	●	●	●	●	—	—	●	●	—	●	●	—	—	—	—	—	—
			110308MN-SI	< 0.8	—	—	—	—	—	—	—	—	—	▲	●	—	—	—	—	—	—	—	—	●	●	●	●	●	●	—	—	●	●	—	●	●	—	—	—	—	—	—
铝材用	AG 20°		VCGT 110302N-AG	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●
			110304N-AG	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●

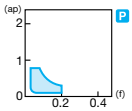
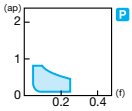
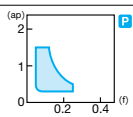
用“<”表示刀尖半径 RE 的产品，表示其为负公差。

VC■■1604●●

尺寸 (mm)				
	切刃长度L	16.6	厚度S	4.76
	内切圆IC	9.525	孔径D1	4.4

住友CBN(CBN)刀片 L112　住友金刚石(PCD)刀片 M23、M24　无粘合剂住友金刚石刀片 M28
适用外径刀杆 C40、C41　适用内径刀杆 E54、E57

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◆	✖	○	◔	✪			◔				◔							✪		✪	◆			◆	✖	✪	●	◆							
M 不锈钢				✪			✪	●	◆	✖	○	◔									✪		✪	◆	✪													
K 铸铁			✪			✪							●	◆	✖	○	◔			✪		✪		◆						●								
N 非铁金属																																						◆
S 难削材																			●	◆	✖	◔	✪	✪														
H 高硬度材																		●																				

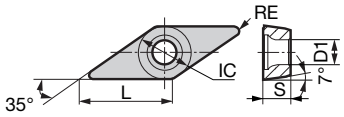
	形状	适用范围	型 号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
精切削	FB 20°		VCMT 160404N-FB	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	●	●	▲	●	●	—	—	—	—	—	—	—
			160408N-FB	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	—	●	●	▲	●	●	—	—	—	—	—	—	—
精切削	LU 15°		VCMT 160404N-LU	0.4	●	●	●		●	●			●	●		●						—					—	—	—	—	●	●	▲	●	●						
			160408N-LU	0.8	●	●	●		●	●			●	●		●						—					—	—	—	—	●	●	▲	●	●						
轻切削	LB 15°		VCMT 160404N-LB	0.4		●	●	●		●	●	●	●	●								—					—	—	—	—	●	●	▲		●						
			160408N-LB	0.8		●	●	●		●	●	●	●	●								—					—	—	—	—	●	●	▲		●						

▲记号：计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

35° 菱形正型刀片

机夹式刀片

VC 35°菱形 7° 正型 带孔



材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4～
按被削材分类的刀片材质选择要领 ☞A10～

●：连续切削 第一推荐　○：连续切削 第二推荐　◐：一般切削 第一推荐　◔：一般切削 第二推荐　✖：断续切削 第一推荐　✖：断续切削 第二推荐

VC■■1604●●

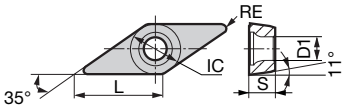
尺寸 (mm)	切刃长度L	16.6	厚度S	4.76
	内切圆IC	9.525	孔径D1	4.4

住友 CBN(CBN) 刀片 ☞L112　住友金刚石 (PCD) 刀片 ☞M23、M24
无粘合剂住友金刚石刀片 ☞M28　适用外径刀杆 ☞C40、C41
适用内径刀杆 ☞E54、E57

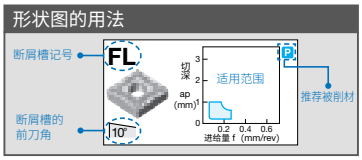
| 推荐用途 | 涂层 | | |

35° 菱形正型刀片

VP 35°菱形 11° 正型 带孔



形状图的用法

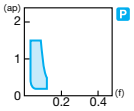
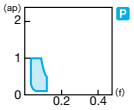


●: 连续切削 第一推荐
○: 连续切削 第二推荐
: 一般切削 第一推荐
: 一般切削 第二推荐
: 断续切削 第一推荐
: 断续切削 第二推荐

VP■■0802●●

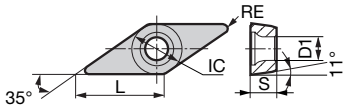
尺寸 (mm)				
	切刃长度L	8.3	厚度S	2.38
	内切圆IC	4.76	孔径D1	2.4

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◕	✖	○	◔	✪		◔			◔									✪		✪	◕			◕	✖	✪	●	◕							
M 不锈钢				✪			✪	●	◕	✖	○	◔									✪		✪	◕	✪													
K 铸铁			✪			✪							●	◕	✖	○	◔			✪		✪		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◔	✪	✪														
H 高硬度材																		●																				

	形状	适用范围	型 号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
精切削	FX 15°		VPET 0802008R-FX	0.08																								●		●												
			0802008L-FX	0.08																								●		●												
			0802015R-FX	0.15																								●		●												
			0802015L-FX	0.15																								●		●												
			0802018R-FX	0.18																								●		●												
			0802018L-FX	0.18																								●		●												
	FY 15°		VPET 0802008R-FY	0.08																								●		●												
			0802008L-FY	0.08																								●		●												
			0802015R-FY	0.15																								●		●												
			0802015L-FY	0.15																								●		●												
			0802018R-FY	0.18																								●		●												
			0802018L-FY	0.18																								●		●												

35° 菱形正型刀片

VP 35°菱形 11° 正型 带孔



材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4～
按被削材分类的刀片材质选择要领 ☞A10～

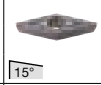
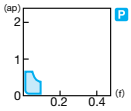
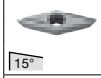
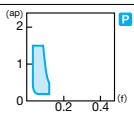
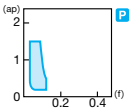
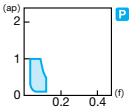
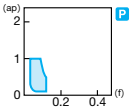
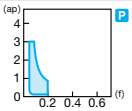
●：连续切削 第一推荐
○：连续切削 第二推荐
：一般切削 第一推荐
：一般切削 第二推荐
：断续切削 第一推荐
：断续切削 第二推荐

VP■■1103●●

尺寸 (mm)	切刃长度L	11.1	厚度S	3.18
	内切圆IC	6.35	孔径D1	2.8

适用外径刀杆 ☞D15、D29

推荐用途	涂层 CVD									PVD															涂层 金属陶瓷 PVD			金属陶瓷		硬质合金						
	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◐	◕	✖	○	◐	✪		◐				◐								✪			✪	◕		◕	✖	✪	●	◕							
M 不锈钢				✪			✪	●	◕	✖	○	◐									✪			✪	◕	✪												
K 铸铁			✪			✪							●	◕	✖	○	◐			✪		✪			◕					●								
N 非铁金属																																					◕
S 难削材																			●	◕	✖	◐	✪	✪													
H 高硬度材																		●																			

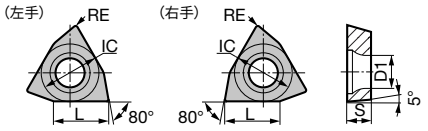
	形状	适用范围	型 号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	AC Z150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
微小切削	FF  15°		VPGT 110301MN-FF New	< 0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	●			—	—	—	—	—	—	—	—	—	—	—	—
			110302MN-FF New	< 0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	●			—	—	—	—	—	—	—	—	—	—	—	—
精切削	FX  15°		VPGT 110301R-FX	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			110301L-FX	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			110302R-FX	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			110302L-FX	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	FX 15°		VPET 1103003R-FX	0.03	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●		●	—	—	—	—	—	—	—	—	—	—	—	—
			1103003L-FX	0.03	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●		●	—	—	—	—	—	—	—	—	—	—	—	—
			110301R-FX	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●		●	—	—	—	—	—	—	—	—	—	—	—	—
			110301L-FX	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●		●	—	—	—	—	—	—	—	—	—	—	—	—
			110302R-FX	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●		●	—	—	—	—	—	—	—	—	—	—	—	—
			110302L-FX	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●		●	—	—	—	—	—	—	—	—	—	—	—	—
	FY 15°		VPGT 110301R-FY	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			110301L-FY	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			110302R-FY	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
			110302L-FY	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	FY 15°		VPET 1103003R-FY	0.03	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●		●	—	—	—	—	—	—	—	—	—	—	—	—
			1103003L-FY	0.03	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●		●	—	—	—	—	—	—	—	—	—	—	—	—
			110301R-FY	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●		●	—	—	—	—	—	—	—	—	—	—	—	—
			110301L-FY	0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●		●	—	—	—	—	—	—	—	—	—	—	—	—
			110302R-FY	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●		●	—	—	—	—	—	—	—	—	—	—	—	—
			110302L-FY	0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●		●	—	—	—	—	—	—	—	—	—	—	—	—
轻切削	SI 15°		VPGT 110301MN-SI New	< 0.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	●			—	—	—	—	—	—	—	—	—	—	—	—
			110302MN-SI New	< 0.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	●	●	—	—	●			—	—	—	—	—	—	—	—	—	—	—	—

用“<”表示刀尖半径RE的产品，表示其为负公差。

六角形正型刀片

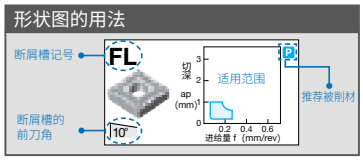
机夹式刀片

WB 六角形 5° 正型 带孔



※不等角六角形

形状图的用法



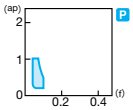
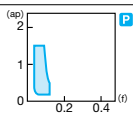
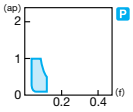
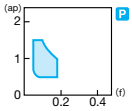
●：连续切削 第一推荐
○：连续切削 第二推荐
◕：一般切削 第一推荐
◔：一般切削 第二推荐
✖：断续切削 第一推荐
✪：断续切削 第二推荐

WB■■0601●●

尺寸 (mm)	切刃长度L	3.2	厚度S	1.59
	内切圆IC	3.97	孔径D1	2.2

住友 CBN(CBN) 刀片 L116　住友金刚石 (PCD) 刀片 M25
适用内径刀杆 E62

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
	涂层																										涂层金属陶瓷			金属陶瓷		硬质合金						
	CVD									PVD	CVD							PVD									PVD											
P 钢	●	◔	◕	✖	○	◔	✪		◔			◔								✪			✪	◕			◕	✖	✪	●	◕							
M 不锈钢				✪			✪	●	◕	✖	○	◔								✪			✪	◕	✪													
K 铸铁			✪			✪							●	◕	✖	○	◔			✪		✪		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◔	✪	✪														
H 高硬度材																		●																				

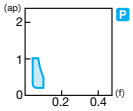
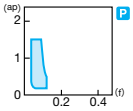
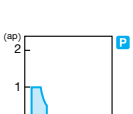
	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
精切削	FW 20°		WBGT 060102R-FW	0.2																										●				●								
			060102L-FW	0.2																										●	●			●								
			060104R-FW	0.4																										●				●								
			060104L-FW	0.4																										●	●			●								
	FX 15°		WBGT 060102R-FX	0.2																				●	●			●	●													
			060102L-FX	0.2																				●	●	●		●	●													
			060104R-FX	0.4																				●	●			●	●													
			060104L-FX	0.4																				●	●	●		●	●													
	FY 15°		WBGT 0601003L-FY	0.03																														●								
			060101R-FY	0.1																														●								
			060101L-FY	0.1																														●								
			060102R-FY	0.2																				●	●			●	●					●	●							
			060102L-FY	0.2																				●	●			●	●					●	●							
			060104R-FY	0.4																				●	●			●	●					●	●							
			060104L-FY	0.4																				●	●			●	●					●	●							
精〜轻切削	W 0°		WBGT 060102R-W	0.2																														●	●							
			060102L-W	0.2																														●	●							
			060104R-W	0.4																														●	●							
			060104L-W	0.4																														●	●							

WB■■0802●●

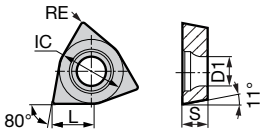
尺寸 (mm)	切刃长度L	4.6	厚度S	2.38
	内切圆IC	4.76	孔径D1	2.4

住友 CBN(CBN) 刀片 L117
适用内径刀杆 E62

推荐用途	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
	涂层																										涂层金属陶瓷			金属陶瓷		硬质合金						
	CVD									PVD	CVD							PVD									PVD											
P 钢	●	◔	◕	✖	○	◔	✪		◔			◔								✪			✪	◕			◕	✖	✪	●	◕							
M 不锈钢				✪			✪	●	◕	✖	○	◔								✪			✪	◕	✪													
K 铸铁			✪			✪							●	◕	✖	○	◔			✪		✪		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◔	✪	✪														
H 高硬度材																		●																				

	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
精切削	FW 15°		WBGT 080202R-FW	0.2																										●				●								
			080202L-FW	0.2																										●	●			●								
			080204R-FW	0.4																										●				●								
			080204L-FW	0.4																										●	●			●								
	FX 15°		WBGT 080202R-FX	0.2																				●	●			●	●													
			080202L-FX	0.2																				●	●			●	●													
			080204R-FX	0.4																				●	●			●	●													
			080204L-FX	0.4																				●	●			●	●													
	FY 15°		WBGT 080201R-FY	0.1																														●	●							
			080201L-FY	0.1																														●	●							
			080202R-FY	0.2																														●	●							
			080202L-FY	0.2																														●	●							
			080204R-FY	0.4																														●	●							
			080204L-FY	0.4																														●	●							

WP 六角形 11° 正型 带孔



材质选择要领 ☞A2
刀片断屑槽选择要领 ☞B4～
按被削材分类的刀片材质选择要领 ☞A10～

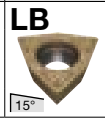
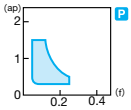
●：连续切削 第一推荐　○：连续切削 第二推荐　◕：一般切削 第一推荐　◔：一般切削 第二推荐　✖：断续切削 第一推荐　✪：断续切削 第二推荐

WP■■1102●●

尺寸 (mm)	切刃长度L	4.3	厚度S	2.38
	内切圆IC	6.35	孔径D1	2.8

适用内径刀杆 ☞E63

推荐用途	涂层 CVD									PVD															涂层 金属陶瓷 PVD			金属陶瓷	硬质合金					
	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◕	✖	○	◔	✪		◔			◔									✪		✪	◕			◕	✖	✪	●	◕							
M 不锈钢			✪				✪	●	◕	✖	○	◔									✪		✪	◕	✪													
K 铸铁			✪			✪							●	◕	✖	○	◔			✪		✪		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◔	✪	✪														
H 高硬度材																		●																				

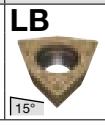
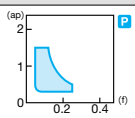
	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
轻切削	LB 		WPMT 110204N-LB	0.4		●	●	●		●	●	●	●	●																●	●	▲		●								

WP■■1603●●

尺寸 (mm)	切刃长度L	6.5	厚度S	3.18
	内切圆IC	9.525	孔径D1	4.4

适用内径刀杆 ☞E63

推荐用途	涂层 CVD									PVD															涂层 金属陶瓷 PVD			金属陶瓷	硬质合金					
	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
P 钢	●	◔	◕	✖	○	◔	✪		◔			◔									✪		✪	◕			◕	✖	✪	●	◕							
M 不锈钢			✪				✪	●	◕	✖	○	◔									✪		✪	◕	✪													
K 铸铁			✪			✪							●	◕	✖	○	◔			✪		✪		◕						●								
N 非铁金属																																						◕
S 难削材																			●	◕	✖	◔	✪	✪														
H 高硬度材																		●																				

	形状	适用范围	型号	刀尖半径 RE	AC8015P	AC8020P	AC8025P	AC8035P	AC810P	AC820P	AC830P	AC6020M	AC6030M	AC6040M	AC610M	AC630M	AC4010K	AC4015K	AC420K	AC405K	AC415K	AC503U	AC5005S	AC5015S	AC5025S	AC510U	AC520U	AC1030U	AC530U	ACZ150	T1500Z	T2500Z	T3000Z	T1000A	T1500A	ST10P	ST20E	A30	G10E	EH510	EH520	H1
轻切削	LB 		WPMT 160308N-LB	0.8		●	●	●		●	●	●	●	●																●	●	▲		●								

▲记号：计划在将来被新产品替换、改为接单生产或停止生产(请确认有无库存)

负型 带孔

(推荐用途通用例) 连续切削 ●：第一推荐 ○：第二推荐 / 一般切削 ●：第一推荐 ○：第二推荐 / 断续切削 ✖：第一推荐 ✖：第二推荐

推荐用途	WX120	NB90S	NB100C
P 钢			
M 不锈钢			
K 铸铁			
N 非铁金属			
S 难削材	○		
H 高硬度材			○

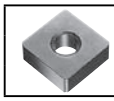
80°菱形

形状	型号	WX120	NB90S	NB100C	内切圆	厚度	刀尖半径	孔径
	CNGA 120404	—	●	●	12.70	4.76	0.4	5.16
	CNGA 120408	—	●	●	12.70	4.76	0.8	5.16
	CNGA 120412	—	●	●	12.70	4.76	1.2	5.16

55°菱形

	DNGA 150404	—		●	12.70	4.76	0.4	5.16
	DNGA 150408	—		●	12.70	4.76	0.8	5.16
	DNGA 150412	—		●	12.70	4.76	1.2	5.16

正方形

	SNGA 120404	—		●	12.70	4.76	0.4	5.16
	SNGA 120408	—		●	12.70	4.76	0.8	5.16
	SNGA 120412	—		●	12.70	4.76	1.2	5.16

三角形

	TNGA 160404	—		●	9.525	4.76	0.4	3.81
	TNGA 160408	—	●	●	9.525	4.76	0.8	3.81
	TNGA 160412	—			9.525	4.76	1.2	3.81
	TNGA 160416	—		—	9.525	4.76	1.6	3.81

35°菱形

	VNGA 160404	—		●	9.525	4.76	0.4	3.81
	VNGA 160408	—		●	9.525	4.76	0.8	3.81

负型 无孔

(推荐用途通用例) 连续切削 ●：第一推荐 ○：第二推荐 / 一般切削 ●：第一推荐 ○：第二推荐 / 断续切削 ✖：第一推荐 ✖：第二推荐

推荐用途	WX120	NB90S	NB100C
P 钢			
M 不锈钢			
K 铸铁			
N 非铁金属			
S 难削材	○		
H 高硬度材			○

80°菱形

形状	型号	WX120	NB90S	NB100C	内切圆	厚度	刀尖半径	孔径
	CNGN 120408	●	●	—	12.70	4.76	0.8	—
	CNGN 120412		●	—	12.70	4.76	1.2	—
	CNGN 120416	●		—	12.70	4.76	1.6	—
	CNGN 120712			—	12.70	7.94	1.2	—

55°菱形

	DNGN 150408		●	—	12.70	4.76	0.8	—
	DNGN 150412			—	12.70	4.76	1.2	—
	DNGN 150416			—	12.70	4.76	0.8	—
	DNGN 150712		●	—	12.70	7.94	1.2	—

75°菱形

	ENGN 130408			—	12.70	4.76	0.8	—
	ENGN 130412			—	12.70	4.76	1.2	—
	ENGN 130708		●	—	12.70	7.94	0.8	—
	ENGN 130712		●	—	12.70	7.94	1.2	—

圆形

	RNGN 120400	●		—	12.70	4.76	—	—
	RNGN 120700	●	●	—	12.70	7.94	—	—
	RNGN 150700			—	15.875	7.94	—	—

正方形

	SNGN 120408	●	●	—	12.70	4.76	0.8	—
	SNGN 120412	●	●	—	12.70	4.76	1.2	—
	SNGN 120416	●	●	—	12.70	4.76	1.6	—
	SNGN 120420			—	12.70	4.76	2.0	—
	SNGN 120708			—	12.70	7.94	0.8	—
	SNGN 120712		●	—	12.70	7.94	1.2	—
	SNGN 120716			—	12.70	7.94	1.6	—
	SNGN 120720		●	—	12.70	7.94	2.0	—

三角形

	TNGN 160404		●	—	9.525	4.76	0.4	—
	TNGN 160408	●	●	—	9.525	4.76	0.8	—
	TNGN 160412	●	●	—	9.525	4.76	1.2	—
	TNGN 160712	—		—	9.525	7.94	1.2	—

WX120仅在日本销售。

正型　无孔

(推荐用途通用例)
连续切削 ●：第一推荐 ○：第二推荐
一般切削 ●：第一推荐 ○：第二推荐
断续切削 ●：第一推荐 ○：第二推荐

推荐用途	WX120	NB90S	NB100C
P 钢			
M 不锈钢			
K 铸铁			
N 非铁金属			
S 难削材	○		
H 高硬度材			○

圆形

形状	型号	陶瓷 WX120	陶瓷 NB90S	陶瓷 NB100C	尺寸(mm) 内切圆	厚度	刀尖半径	孔径
	RBGN 120700			—	12.70	7.94	—	—
	RBGN 150700			—	15.875	7.94	—	—
	RBGN 250900			—	25.40	9.52	—	—
	RBG 12S			—	12.00	11.0	—	—
	RBG 16S		●	—	16.00	13.0	—	—
	RBG 20S		●	—	20.00	15.0	—	—
	RBG 26S			—	26.00	16.0	—	—
	RBG 32S			—	32.00	21.0	—	—
	RCGX 090700	●		—	9.525	7.94	—	—
	RCGX 120700			—	12.70	7.94	—	—

正方形

	SPGN 090308			—	9.525	3.18	0.8	—
	SPGN 120308		●	—	12.70	3.18	0.8	—

三角形

	TPGN 110304		●	●	6.35	3.18	0.4	—
	TPGN 110308		●		6.35	3.18	0.8	—
	TPGN 160304		●	●	9.525	3.18	0.4	—
	TPGN 160308		●	●	9.525	3.18	0.8	—

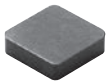
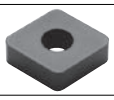
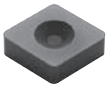
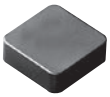
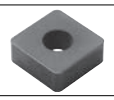
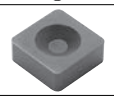
WX120仅在日本销售。

整体式住友 CBN

机夹式刀片(整体CBN烧结体)

整体式住友 CBN 专用的各种车刀杆请参照 L122 ～ L125。

用途分类 K 铸铁 H 高硬度材

形状	型号	BNC8115	BNS8125	尺寸(mm) 内切圆	厚度	刀尖半径	孔	适用刀杆
	CNGN 090308	●	●	9.525	3.18	0.8	无	外径 L123
	CNGN 090308LF			9.525	3.18	0.8	无	
	CNGN 090312	●	●	9.525	3.18	1.2	无	
	CNGN 090312LF			9.525	3.18	1.2	无	
	CNGN 120408	●	●	12.70	4.76	0.8	无	外径 L123
	CNGN 120412	●	●	12.70	4.76	1.2	无	
	CNGN 120416	●	●	12.70	4.76	1.6	无	
	CNGA 120408	●	●	12.70	4.76	0.8	有	外径 C10 ～ C12 内径 E15、E23 ～ E25
	CNGA 120412	●	●	12.70	4.76	1.2	有	
	CNGX 120408			12.70	4.76	0.8	倒锥	外径 L125
	CNGX 120412	●	●	12.70	4.76	1.2	倒锥	
	CNGX 120416	●	●	12.70	4.76	1.6	倒锥	
	DNGN 110308	●	●	9.525	3.18	0.8	无	外径 L123
	DNGN 110308LF			9.525	3.18	0.8	无	
	DNGN 110312	●	●	9.525	3.18	1.2	无	
	DNGN 110312LF			9.525	3.18	1.2	无	
	RNGN 090300	●	●	9.525	3.18		无	外径 L124
	RNGN 090300LF			9.525	3.18		无	
	RNGN 120300	●	●	12.70	3.18		无	外径 L124
	RNGN 120300LF			12.70	3.18		无	
	RNGN 120400	●	●	12.70	4.76		无	
	SNGN 090308	●	●	9.525	3.18	0.8	无	外径 L122 铣刀 H251 L145
	SNGN 090308LF			9.525	3.18	0.8	无	
	SNEN 090308W	●	●	9.525	3.18	0.8	无	
	SNEN 090308LFW			9.525	3.18	0.8	无	
	SNGN 090312	●	●	9.525	3.18	1.2	无	
	SNGN 090312LF			9.525	3.18	1.2	无	
	SNGN 120308	●	●	12.70	3.18	0.8	无	外径 L122
	SNGN 120308LF			12.70	3.18	0.8	无	
	SNGN 120312	●	●	12.70	3.18	1.2	无	
	SNGN 120312LF			12.70	3.18	1.2	无	
	SNGN 120408	●	●	12.70	4.76	0.8	无	外径 L122
	SNGN 120412	●	●	12.70	4.76	1.2	无	
	SNGN 120416	●	●	12.70	4.76	1.6	无	
	SNGN 120420	●	●	12.70	4.76	2.0	无	
	SNGA 120408	●	●	12.70	4.76	0.8	有	外径 C21 ～ C26 内径 E39 ～ E41
	SNGA 120412	●	●	12.70	4.76	1.2	有	
	SNGX 120408			12.70	4.76	0.8	倒锥	外径 L125
	SNGX 120412	●	●	12.70	4.76	1.2	倒锥	
	SNGX 120416	●	●	12.70	4.76	1.6	倒锥	
	TNGN 110308	●	●	6.35	3.18	0.8	无	外径 L122
	TNGN 110308LF			6.35	3.18	0.8	无	
	TNGN 110312	●	●	6.35	3.18	1.2	无	
	TNGN 110312LF			6.35	3.18	1.2	无	
	TNGN 160408	●	●	9.525	4.76	0.8	无	外径 L122
	TNGN 160412	●	●	9.525	4.76	1.2	无	
	TNGN 160416	●	●	9.525	4.76	1.6	无	
	TNGN 160420	●	●	9.525	4.76	2.0	无	
	TNGA 160408	●	●	9.525	4.76	0.8	有	外径 C29 ～ C35 外径 D16 D20 内径 E15、E47 ～ E49
	TNGA 160412	●	●	9.525	4.76	1.2	有	

※ 型号末尾 LF：尖刃型 W：修光刃型 LFW：修光刃尖刃型

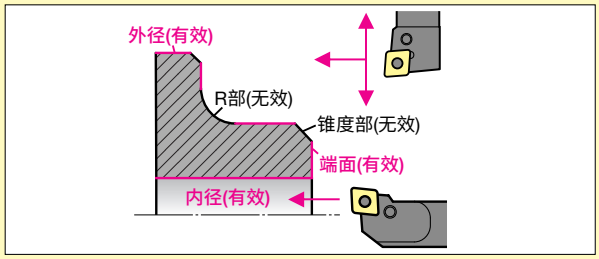
●记号：标准库存品(新产品、扩充品)

使用修光刃刀片的注意事项

关于修光刃刀片的效果

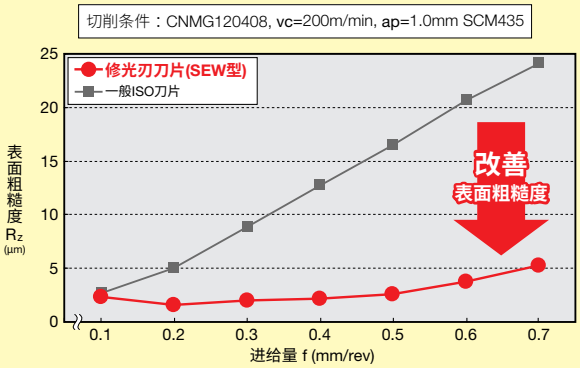
修光刃刀片在加工下图所示的内外径和端面时，可充分发挥其效果，即使在高进给加工中，也能保持加工面的粗糙度。

■ 修光刃刀片效果范围



※锥面和R部的加工面粗糙度与普通刀片相同。
※根据刀片形状的不同，需要进行刀头位置修正(偏置)，请参阅如下的修正表。

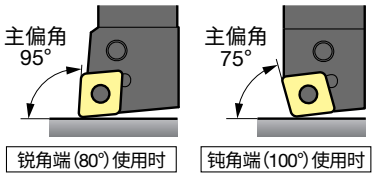
■ 加工面粗糙度(实测值)



涂层硬质合金/涂层金属陶瓷/金属陶瓷

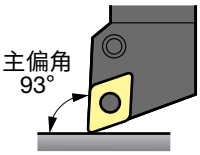
CNMG型/WNMG型/CCMT型/CPMT型　LUW型/GUW型/SEW型断屑槽(CCMT型/CPMT型仅限于LUW型断屑槽)

- 请使用主偏角95°的刀杆。
- 不需修正加工程序
  CNMG型/WNMG型/CCMT型/CPMT型修光刃刀片依据的是ISO标准，使用时不需修正加工程序。
- CNMG型即使带有钝角侧刀角(100°)，也可获得修光效果。



DNMX型　SEW型断屑槽

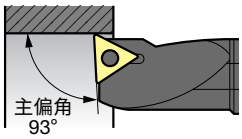
- 请使用主偏角93°的刀杆。
- 需要修正加工程序
  DNMX型修光刃刀片没有遵循ISO标准，使用时需要修正次页(B132)的加工程序。



DNMX型
加工程序修正要领
(→B132)

TPGX型　SDW型断屑槽

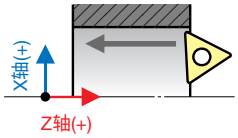
- 请使用主偏角93°的镗孔刀。
- 需要修正加工程序
  TPGX型修光刃刀片没有遵循ISO标准，使用时需要修正右侧的刀头位置(刀具偏置)。



注意：与其他轮廓形状不同，TPGX型仅限于内径切削加工时才能获得修光效果。

TPGX型断屑槽刀头位置修正量(SDW型)

内径加工时

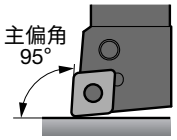


刀尖半径	X 轴方向	Z 轴方向
R0.4	0.12	-0.02
R0.8	0.12	-0.02

CBN(住友CBN/涂层住友CBN)

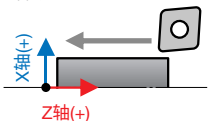
CNGA型/CCGW型/WNGA型　WG型/WH型修光刃刀片

- 请使用主偏角95°的刀杆。
- 需要修正加工程序
  CNGA型/CCGW型/WNGA型修光刃刀片未执行ISO标准，使用时需进行如右所示的刃尖位置修正(刀具偏置)。



CNGA型/CCGW型/WNGA型修光刃刀片刀头位置修正量(WG型/WH型)

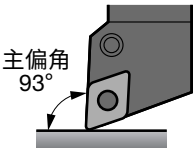
外径加工时



刀尖半径	类型	X 轴方向	Z 轴方向
R0.4	WG型	-0.02	-0.02
	WH型	-0.06	-0.06
R0.8/R1.2	WG型	-0.01	-0.01
	WH型	-0.06	-0.06

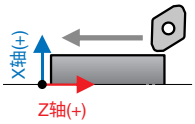
DNGA型/DCGW型　WG型/WH型修光刃刀片

- 请使用主偏角93°的刀杆。
- 需要修正加工程序
  DNGA型/DCGW型修光刃刀片未执行ISO标准，使用时需进行如右所示的刀头位置修正(刀具偏置)。



DNGA型/DCGW型修光刃刀片刀头位置修正量(WG型/WH型)

外径加工时



刀尖半径	类型	X 轴方向	Z 轴方向
R0.4	WG型	-0.17	-0.01
	WH型	-0.70	-0.06
R0.8	WG型	-0.05	0
	WH型	-0.58	-0.05

注意：与其他轮廓形状不同，DNGA型/DCGW型仅限于外径和内径切削加工时才能获得修光效果。

使用修光刃刀片的注意事项

DNMX型加工程序修正要领 (修正量单位：mm)

①X轴、Z轴方向刀头位置修正(刀具偏置)

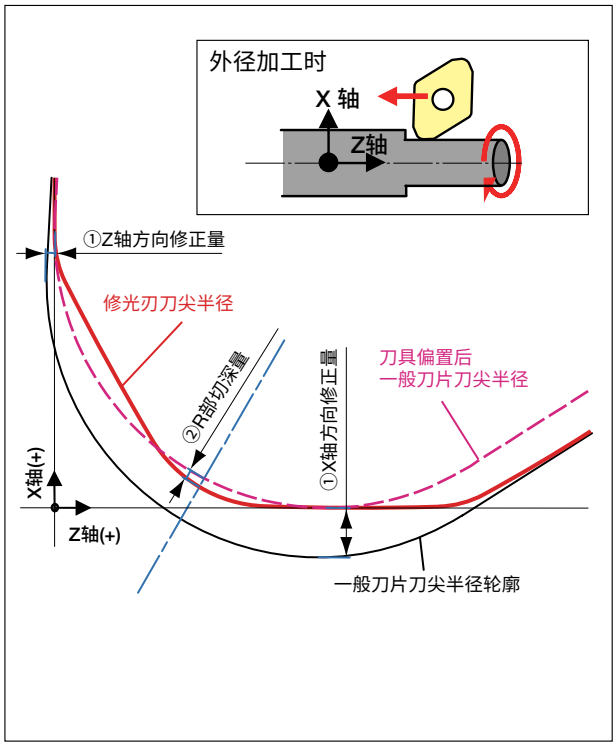
相对于标准ISO刀片，因刀头位置不同，
请按右表所示X轴/Z轴方向的尺寸修正。

※内径切削时，X轴修正为+。

外径加工时

刀尖半径	X 轴方向	Z 轴方向
R0.4	-0.14	-0.02
R0.8	-0.14	-0.02
R1.2	-0.1	-0.03

● 刀尖半径先端图

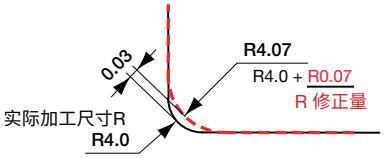


②R部的加工程序修正(以实施①修正为前提)

对于加工程序形状，因要产生切深，请进行R部半径的修正。

程序加工尺寸R = 实际加工尺寸R+R修正量

例)R4.0加工(使用刀尖半径0.8刀片)时



刀尖半径	切深量	R 修正量
R0.4	0.02	+R0.04
R0.8	**0.03**	**+R0.07**
R1.2	0.08	+R0.18

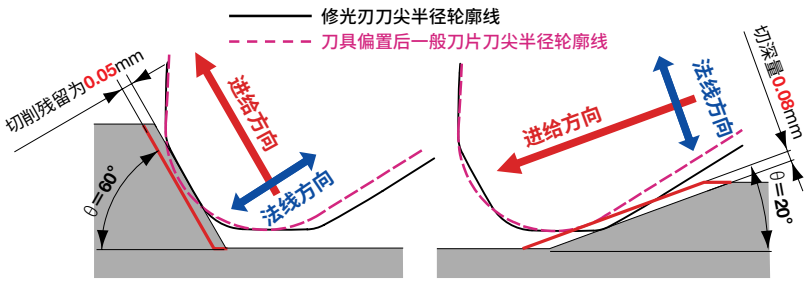
③锥度部的加工程序修正(以实施①修正为前提)

在锥度加工中，相对于加工程序形状，要产生过切、切削残留。
请按照下表在法线方向进行修正。

修正量+表示切深
修正量-表示切削残留。

刀尖半径	锥度角度 (θ)				
	-25°	**-20°**	-15°	-10°	-5°
R0.4	0.08	0.07	0.05	0.04	0.02
R0.8	0.09	**0.08**	0.06	0.05	0.02
R1.2	0.05	0.05	0.05	0.03	0.02

例) 刀尖半径 R0.8 、锥度角度(θ)60°/-20°加工时



刀尖半径	锥度角度 (θ)																		
	0°	5°	10°	15°	20°	25°	30°	35°	40°	45°	50°	55°	**60°**	65°	70°	75°	80°	85°	90°
R0.4	0.00	0.00	0.00	-0.01	-0.01	-0.01	-0.02	-0.02	-0.03	-0.03	-0.04	-0.05	-0.05	-0.05	-0.03	-0.02	-0.02	-0.01	0.00
R0.8	0.00	0.01	0.02	0.03	0.03	0.03	0.03	0.02	0.01	0.00	-0.02	-0.03	**-0.05**	-0.04	-0.03	-0.02	-0.01	0.00	0.00
R1.2	0.00	0.02	0.04	0.06	0.07	0.08	0.08	0.07	0.06	0.05	0.03	0.00	-0.03	-0.02	-0.01	0.00	0.01	0.00	0.00