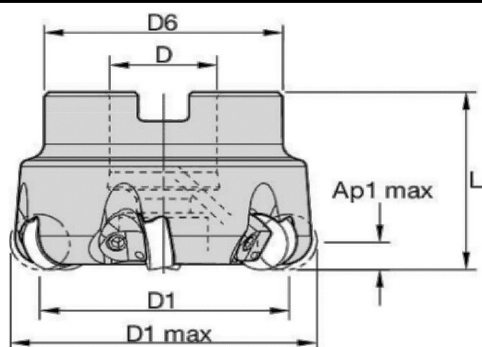
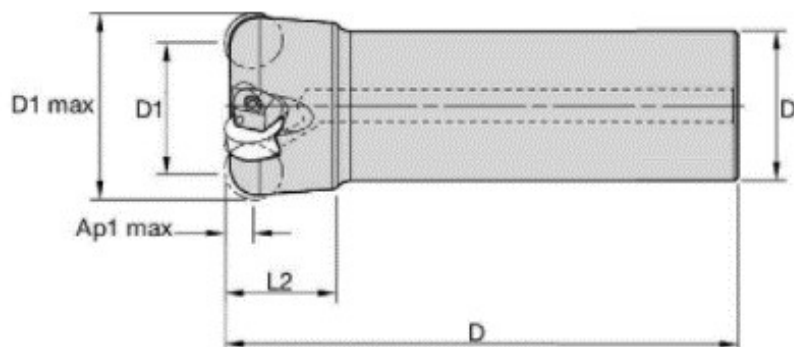


## 可转位R铣刀



| 型号                 | 刀片型号        | 尺寸     |   |    |    |    |        |
|--------------------|-------------|--------|---|----|----|----|--------|
|                    |             | D1 max | Z | D  | D6 | L  | AP1MAX |
| KCRA40Z04S22RN1204 | RNGN-120400 | 40     | 4 | 22 | 38 | 45 | 6.35   |
| KCRA50Z04S22RN1204 | RNGN-120400 | 50     | 4 | 22 | 41 | 45 | 6.35   |
| KCRA50Z06S22RN1204 | RNGN-120400 | 50     | 6 | 22 | 41 | 45 | 6.35   |
| KCRA63Z06S22RN1204 | RNGN-120400 | 63     | 6 | 22 | 49 | 45 | 6.35   |
| KCRA63Z09S22RN1204 | RNGN-120400 | 63     | 9 | 22 | 49 | 45 | 6.35   |
| KCRA80Z08S27RN1204 | RNGN-120400 | 80     | 8 | 27 | 60 | 50 | 6.35   |
| KCRA40Z04S22RN1207 | RNGN-120700 | 40     | 4 | 22 | 38 | 45 | 6.35   |
| KCRA50Z04S22RN1207 | RNGN-120700 | 50     | 4 | 22 | 41 | 45 | 6.35   |
| KCRA50Z06S22RN1207 | RNGN-120700 | 50     | 6 | 22 | 41 | 45 | 6.35   |
| KCRA63Z06S22RN1207 | RNGN-120700 | 63     | 6 | 22 | 49 | 45 | 6.35   |
| KCRA63Z09S22RN1207 | RNGN-120700 | 63     | 9 | 22 | 49 | 45 | 6.35   |
| KCRA80Z08S27RN1207 | RNGN-120700 | 80     | 8 | 27 | 60 | 50 | 6.35   |

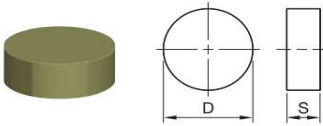
## 可转位R铣刀



| 型号                 | 刀片型号        | 尺寸     |    |   |     |    |        |
|--------------------|-------------|--------|----|---|-----|----|--------|
|                    |             | D1 max | D  | Z | L   | L2 | AP1MAX |
| KCRA25Z02A25RN0903 | RNGN-090300 | 25     | 20 | 2 | 80  | 30 | 4.75   |
| KCRA32Z03A25RN0903 | RNGN-090300 | 32     | 25 | 3 | 86  | 30 | 4.75   |
| KCRA40Z03A32RN1204 | RNGN-120400 | 40     | 32 | 3 | 105 | 45 | 6.35   |
| KCRA50Z03A40RN1204 | RNGN-120400 | 50     | 40 | 3 | 115 | 45 | 6.35   |
| KCRA63Z03A40RN1204 | RNGN-120400 | 63     | 40 | 4 | 115 | 45 | 6.35   |
| KCRA40Z03A32RN1207 | RNGN-120700 | 40     | 32 | 3 | 105 | 45 | 6.35   |
| KCRA50Z03A40RN1207 | RNGN-120700 | 50     | 40 | 3 | 115 | 45 | 6.35   |
| KCRA63Z03A40RN1207 | RNGN-120700 | 63     | 40 | 4 | 115 | 45 | 6.35   |

| 刀片型号        |      |      |      |     |
|-------------|------|------|------|-----|
|             | 压紧楔块 | 楔块螺钉 | 扭力扳手 | 批头杆 |
| RNGN-090300 |      |      |      |     |
| RNGN-120400 |      |      |      |     |
| RNGN-120700 |      |      |      |     |

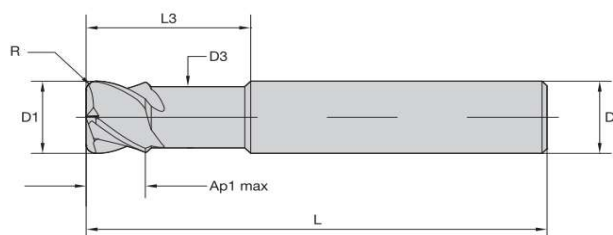
## 刀片材质

| 型号                                                                     | 牌号    |        | 尺寸                                                                                 |      |  | 刀尖圆角 |
|------------------------------------------------------------------------|-------|--------|------------------------------------------------------------------------------------|------|--|------|
|                                                                        | YC605 | YCSA15 | D                                                                                  | S    |  |      |
| RNGN-090300                                                            |       |        | 9.53                                                                               | 3.18 |  | /    |
| RNGN-120400                                                            |       | ●      | 12.7                                                                               | 4.76 |  | /    |
| RNGN-120700                                                            |       | ●      | 12.7                                                                               | 7.94 |  | /    |
| P: 钢                                                                   |       |        |  |      |  |      |
| M: 不锈钢                                                                 |       |        |                                                                                    |      |  |      |
| K: 铸铁                                                                  | ■     |        |                                                                                    |      |  |      |
| N: 有色金属                                                                |       |        |                                                                                    |      |  |      |
| S: 耐热合金                                                                |       | ■      |                                                                                    |      |  |      |
| H: 淬硬材料                                                                |       |        |                                                                                    |      |  |      |
| 备注: ●-常备库存      ■-推荐应用                                                 |       |        |                                                                                    |      |  |      |
| YC605--氮化硅 (Si <sub>3</sub> N <sub>4</sub> )陶瓷    YCSA15--赛龙(SIALON)陶瓷 |       |        |                                                                                    |      |  |      |

## 推荐加工参数

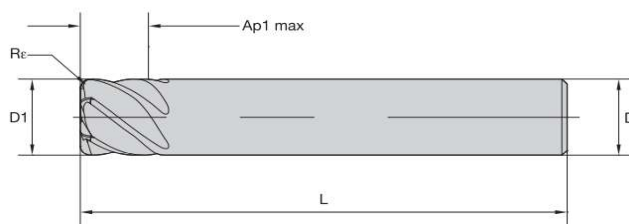
| 工件材料 | 热处理/合金类型     | 硬度      | 切削参数      |           |
|------|--------------|---------|-----------|-----------|
|      |              |         | Vc(m/min) | Fz (mm/z) |
| 钢    | 非合金钢0-0.45%C | 150-250 | -         | -         |
|      | 低合金钢         | 250-300 | -         | -         |
|      | 高合金钢         | 200     | -         | -         |
|      | 耐蚀钢          | 200     | -         | -         |
| 不锈钢  | 铁素体          | 200     | -         | -         |
|      | 奥氏体          | 180     | -         | -         |
|      | 双相           | 230-260 | -         | -         |
|      | 马氏体          | 180     | -         | -         |
| 铸铁   | 灰铸铁          | 160     | 600~1500  | 0.07~0.4  |
|      | 球墨铸铁         | 130     | 600-1500  | 0.07~0.4  |
|      | 可锻/淬火铸铁      | 200     | 600-1500  | 0.07~0.4  |
| 耐热合金 | 铁基Fe-        | 200     | 600-1500  | 0.07~0.4  |
|      | 镍或钴Ni-/Co-   | 280     | 600-1500  | 0.07~0.4  |
|      | 镍或钴Ni-/Co-   | 250     | 600-1500  | 0.07~0.4  |
|      | 镍或钴Ni-/Co-   |         | 600-1500  | 0.07~0.4  |
|      | 钛Ti-         | Rm440°  | 600-1500  | 0.07~0.4  |

## 整体陶瓷铣刀-4刃



| 型号                  | 尺寸       |    |    |       | 齿数 | 牌号     |       |
|---------------------|----------|----|----|-------|----|--------|-------|
|                     | D1*R     | L  | D  | Apmax |    | YCSA15 | YC605 |
| D6*4.5*60*R0.5*4T   | 6*R0.5   | 60 | 6  | 4.5   | 4  | ●      |       |
| D8*6.0*60*R1.0*4T   | 8*R1.0   | 60 | 8  | 6     | 4  | ●      |       |
| D10*7.5*65*R1.25*4T | 10*R1.25 | 65 | 10 | 7.5   | 4  | ●      |       |
| D12*9.0*70*R1.5*4T  | 12*R1.5  | 70 | 12 | 9     | 4  | ●      |       |

## 整体陶瓷铣刀-6刃



| 型号                  | 尺寸       |    |    |       | 齿数 | 牌号     |       |
|---------------------|----------|----|----|-------|----|--------|-------|
|                     | D1*R     | L  | D  | Apmax |    | YCSA15 | YC605 |
| D6*4.5*60*R0.5*6T   | 6*R0.5   | 60 | 6  | 4.5   | 6  | ●      |       |
| D8*6.0*60*R1.0*6T   | 8*R1.0   | 60 | 8  | 6     | 6  | ●      |       |
| D10*7.5*65*R1.25*6T | 10*R1.25 | 65 | 10 | 7.5   | 6  | ●      |       |
| D12*9.0*70*R1.5*6T  | 12*R1.5  | 70 | 12 | 9     | 6  | ●      |       |

## 刀具材质

| 材质                                                                  | 牌号    |        |
|---------------------------------------------------------------------|-------|--------|
|                                                                     | YC605 | YCSA15 |
| P: 钢                                                                |       |        |
| M: 不锈钢                                                              |       |        |
| K: 铸铁                                                               | ■     |        |
| N: 有色金属                                                             |       |        |
| S: 耐热合金                                                             |       | ■      |
| H: 淬硬材料                                                             |       |        |
| 备注: ■-推荐应用                                                          |       |        |
| YC605--氮化硅 (Si <sub>3</sub> N <sub>4</sub> )陶瓷 YCSA15--赛龙(SIALON)陶瓷 |       |        |

## 推荐加工参数

| 加工材料 | 切削参数       |            |            |              |                            |
|------|------------|------------|------------|--------------|----------------------------|
|      | ap<br>(侧铣) | ae<br>(侧铣) | ap<br>(槽铣) | VC<br>(mm/s) | Fz(mm/z)<br>侧铣的F,对于开槽减少20% |
| 高温合金 | AP1 max    | 0.1*D1     | 0.5*D1     | 825~3300     | 0.25~0.35                  |