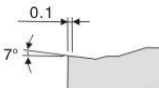
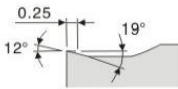
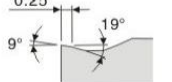


断屑槽的选择基准（负角刀片）

Selection standard of chip breaker groove (negative angle insert)

几何外观 Geometric appearance		切削刃 Cutting edge	应用范围 Application range															特征 Characteristics			
			进给率Feed rate (mm/rev)																		
			切深Cutting depth (mm)																		
			0.04	0.063	0.10	0.16	0.25	0.4	0.63	1.0	1.6	2.5	4.0	6.3							
			0.1	0.16	0.25	0.4	0.63	1.0	1.6	2.5	4.0	6.3	10.0	11.6	13						
精加工~半精加工 Finishing~Semi finishing	CQ			0.15~0.4															进行仿形加工等切深不同的加工时，切屑处理良好。 亦适用与壁面的提拉加工。 Chip treatment is good when performing machining with different cutting depth, such as profiling. It is also suitable for lifting machining with a wall surface.		
		0.05~3.0																			
精加工 Finishing	MQ			0.05~0.2															大前角。低阻力实现良好的切削处理 Large rake angle. Low resistance helps to realize good cutting.		
		0.5~1.5																			
精加工~半精加工 Finishing~Semi finishing	MS			0.1~0.3															正角刀刃保证卓越的锋利度及刀尖的强度。 也有利于防止工件侧壁对于刀刃的损伤。 Positive angle cutting edge ensures outstanding sharpness and tool nose strength. It also is beneficial to preventing the damage of cutting edge by the workpiece side wall.		
		0.5~2.0																			

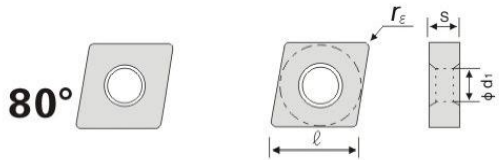
材质 Material	特性 characteristic
LF9008	适合于碳钢、合金钢的精加工和半精加工，耐磨性较9018更好 Suitable for finishing and semi finishing of carbon steel and alloy steel with better wear resistance than 9018
LF9018	广泛用于碳钢、合金钢的加工，加工范围较宽，为钢件加工首选 Widely used in carbon steel and alloy steel machining, wide machining range and first choice for steel part machining
LF9028	适合于碳钢、合金钢。在不利条件下的粗加工、重力切削韧性较9018更好 Suitable for carbon steel and alloy steel. Better roughness than 9018 in roughing and gravity cutting under unfavorable conditions.
LF6011	超细合金牌号，配合涂层具有优异的耐磨性，试用于铝合金、铜等有色金属的加工适合于铸铁的半精加工和精加工，也可以用于加工淬硬钢，用于螺纹及切削槽加工甚佳。 Ultrafine alloy designation combined with the coating has excellent wear resistance, is suitable for nonferrous metal machining such as aluminum alloy and copper, semi finishing and finishing of cast iron and also can be used for quenched steel machining and is especially good for thread and cutting groove machining.
LF6018	不锈钢加工专用牌号，超细合金牌号，配合涂层具有优异的韧性和抗粘结磨损性，适用于不锈钢尤其是奥氏体不锈钢的加工。也适用于低速条件下切削耐热合金钢。 Designation special for stainless steel machining, ultrafine alloy designation, combined with the coating, have excellent toughness and anti-caking and wear resistance, suitable for stainless steel machining, especially austenitic stainless steel. Also suitable for cutting heat-resistant alloy steel under low speed condition.
LF3018	刀片具有优质的耐磨性和强韧性，适用普通铁、球墨铸铁和精加工与半精加工 The insert has excellent wear resistance and toughness, and is suitable for finishing and semi finishing of ordinary iron and ductile cast iron.
LF90	金属陶瓷刀具适合加工各种钢件和铸铁件的半精加工和精加工，硬度高；与被加工工件材料的亲和力低，不易产生积屑瘤；化学稳定性好；耐热性，耐磨性好。 Cermet cutter has high hardness and is suitable for semi finishing and finishing of various steel parts and iron casting; It has low affinity with the machined workpiece material and is not susceptible to build-up edge; Chemical stability is good; Heat resistance and wear resistance are good.
K10	切削锋利性与强度的刃口设计，有效减小了切削与前刀面的摩擦阻力的独特槽型设计使之适合于连续和断续铝合金仿形加工 The cutting edge is designed to consider both cutting sharpness and strength. The unique groove profile is designed to effectively reduce the friction between the cutting and the rake face, so that it is more suitable for continuous and intermittent aluminum alloy profiling.

车削刀片(负前角型) Cutting insert (negative rake angle type)

CN□□

菱形有孔 Rhomb with hole
负前角 Negative rake angle

CNMG 12 04 04-



切削刃长度(ℓ) Cutting edge length	厚度(S) Thickness	刀尖圆弧半径(ℓ _ε) Corner arc radius	断屑槽代号 Chip breaker groove code
CN□□ 0903□□ 1204□□ 1606□□ 1906□□ 2509□□			
φ d ₁ (mm)	3.81	5.16	6.35 7.93 9.12

刀片外形 Insert appearance		型号 Model	尺寸 Dimension					P					M					K		
			L	φ I.C	S	φ d	r	LF9008	LF9018	LF9028	LF9218	LF9118	LF918	LF6008	LF6018	LF6028	LF6118	LF618	LF3018	LF3028
精加工、半精加工 Finishing ~ Semi finishing		CNMG090404-HQ	9.7	9.525	3.18	3.81	0.4	○	○											
		CNMG090408-HQ	9.7	9.525	3.18	3.81	0.8	○	○											
		CNMG120404-HQ	12.9	12.7	4.76	5.16	0.4	▲	▲											
		CNMG120408-HQ	12.9	12.7	4.76	5.16	0.8	▲	▲											
		CNMG120412-HQ	12.9	12.7	4.76	5.16	1.2	○	○											
		CNMG120404-CQ	12.9	12.7	4.76	5.16	0.4	▲	▲											
		CNMG120408-CQ	12.9	12.7	4.76	5.16	0.8	▲	▲											
		CNMG120412-CQ	12.9	12.7	4.76	5.16	1.2	○	○											
		CNMG160608-CQ	16.1	15.875	6.35	6.35	0.8	○	○											
		CNMG160612-CQ	16.1	15.875	6.35	6.35	1.2	○	○											
		CNMG120404-CQ	12.9	12.7	4.76	5.16	0.4				▲									
		CNMG120408-CQ	12.9	12.7	4.76	5.16	0.8				▲									
		CNMG120412-CQ	12.9	12.7	4.76	5.16	1.2				▲									
		CNMG120408-CQ	12.9	12.7	4.76	5.16	0.4					▲								
		CNMG120408-CQ	12.9	12.7	4.76	5.16	0.8					▲								
		CNMG120404-TF	12.9	12.7	4.76	5.16	0.4						▲							
CNMG120408-TF		12.9	12.7	4.76	5.16	0.8						▲								
半精切削 Semi finishing cutting		CNMG120404-TM	12.9	12.7	4.76	5.16	0.4	▲	▲											
		CNMG120408-TM	12.9	12.7	4.76	5.16	0.8	▲	▲											
		CNMG120412-TM	12.9	12.7	4.76	5.16	1.2	○	○											
		CNMG120416-TM	12.9	12.7	4.76	5.16	1.6	○	○											
		CNMG160612-TM	16.1	15.875	6.35	6.35	1.2	○	○											
		CNMG190608-TM	19.3	19.05	6.35	7.94	0.8	○	○											
		CNMG190612-TM	19.3	19.05	6.35	7.94	1.2	○	○											

产品库存 Product stock ▲ 主推牌号库存 Main designation reserve stock ○ 按订单生产 Make-to-order