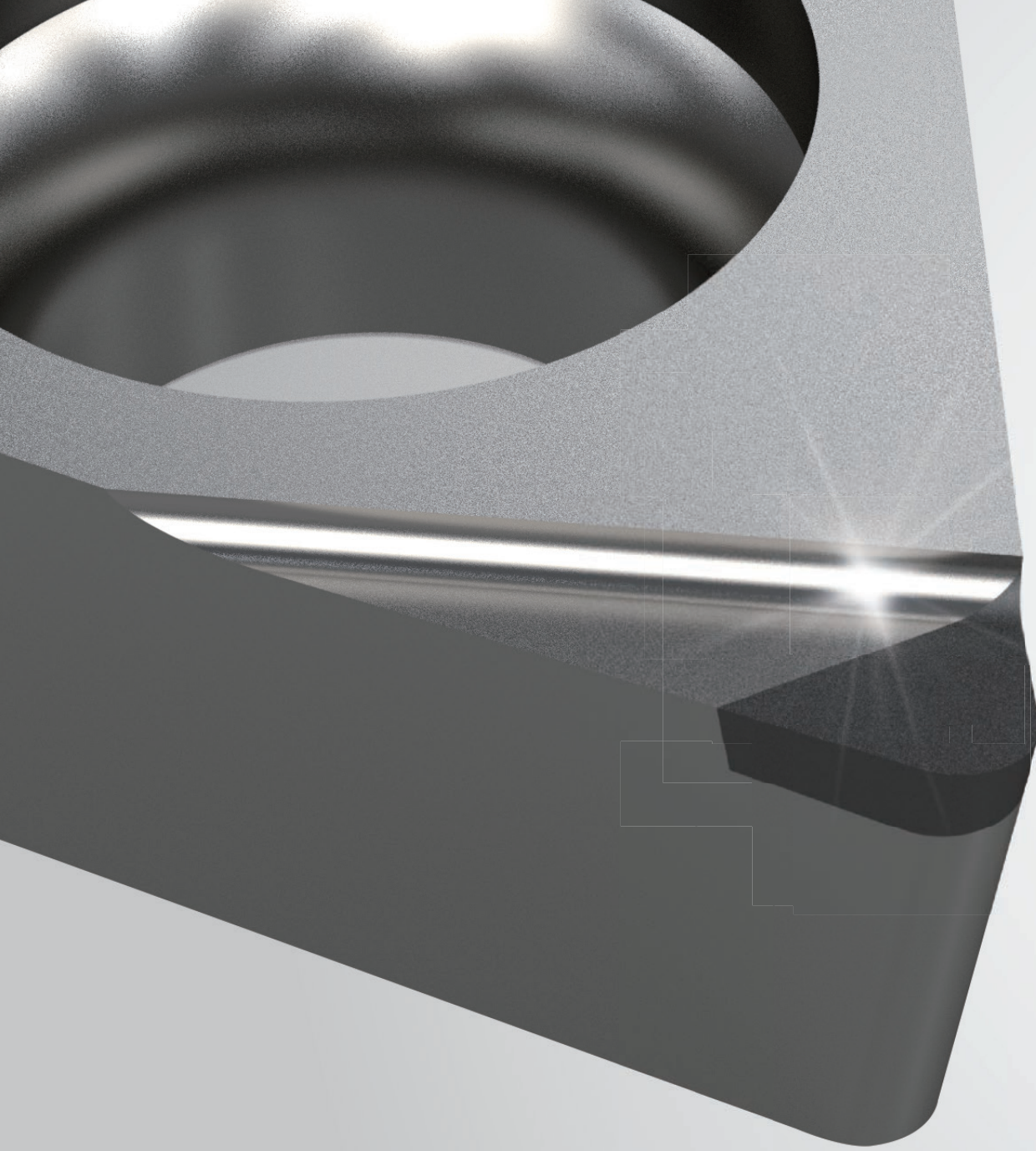


PCD&CBN 精密刀片  
Precision Inserts





富田  
機之  
斷



02- PCD&CBN 精密刀片 PCD&CBN Precision Insert

# 刀片生產

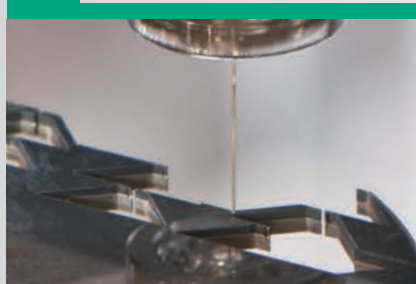
## Insert Produce

1



刀片基座 / PCD毛胚  
(Blank)

2



切割(Cut)

3



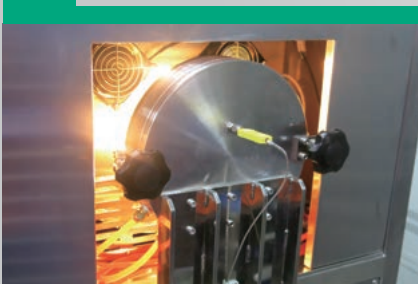
清洗(Clean)

4



焊接(Weld)

5



真空焊接  
(Vacuum welding)

6



研磨(Grind)

7



檢驗(QC)

8

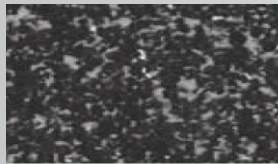


成品(Product)

# PCD 粒度及特性

## Grain Size & Feature for PCD

PCD010

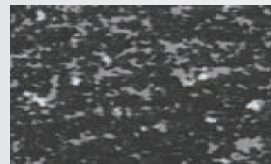


粒度  
1 $\mu$ m  
硬度  
7000~8000Hv  
切削速度  
300~3000 Vc(m/min)

超細晶粒結構擁有極強的刃口鋒利度和刃口耐用度，適用於需要鏡面拋光效果的應用場合。

鋁合金的銑削和粗切，也適用於鈦及鈦合金和複合材料的機加工。

PCD020

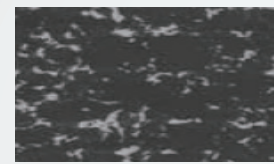


粒度  
2 $\mu$ m  
硬度  
8000~9000Hv  
切削速度  
200~3000 Vc(m/min)

鈷含量更高，便於加工，適用於需要重  
度加工的複雜工具。

非鐵金屬的一般精加工、壓模成形表面  
加工、ERP、硬質橡膠、木材、無機板  
材等的切割及端面加工。

PCD100



粒度  
10 $\mu$ m  
硬度  
9000~10000Hv  
切削速度  
100~2500 Vc(m/min)

平均粒徑為 10 $\mu$ m，廣泛適用於需要良  
好的韌性和較高的耐磨性的情況。

非鐵金屬的一般加工、陶瓷燒結品、壓  
模成形表面加工、ERP、硬質橡膠、石  
墨加工、木材、無機板材等的切割及端  
面加工。

PCD250



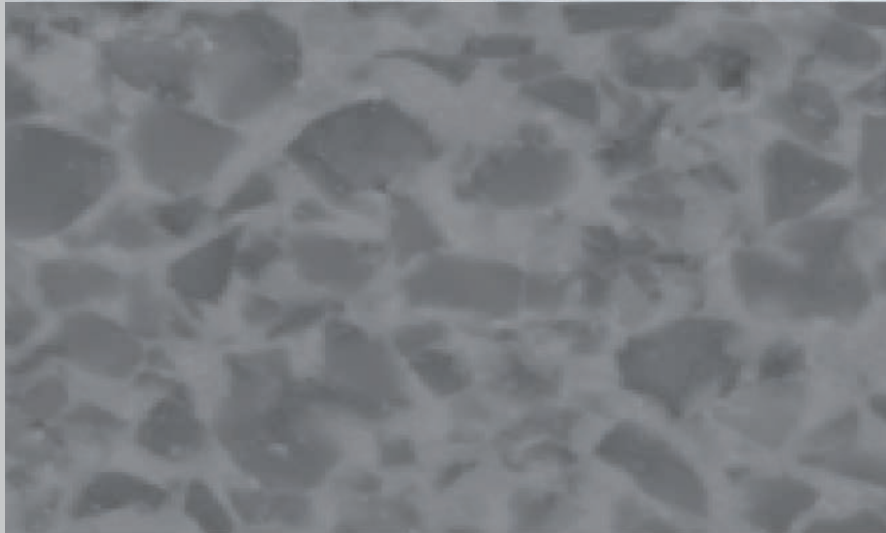
粒度  
25 $\mu$ m  
硬度  
10000~11000Hv  
切削速度  
50~2000 Vc(m/min)

平均粒徑為 25 $\mu$ m，適用於需要高耐磨  
性的加工場合。

高矽鋁合金加工、鋁複合材料的加工、  
硬質合金、陶瓷半燒結品、壓模成形的  
粗加工、陶瓷燒結加工、石材、岩石加  
工。

# PCD 適用材料

## Suitable Materials for PCD



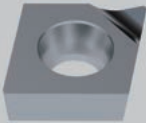
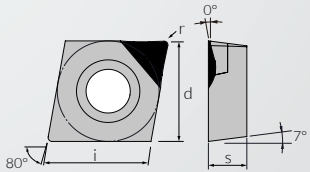
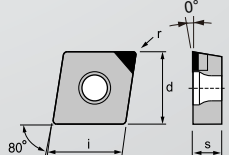
微粒金剛石

Micro-diamond

塑膠 Plastic	石墨 Graphite
黃銅青銅合金 Brass&Bronze Alloys	氧基樹脂 Epoxy Resins
矽鋁合金 Silicon-Aluminum Alloys	木材、複合木材 Wood,compound Wood
銅合金 Copper Alloys	硬質橡膠 Hard Rubber
鎂合金 Magnesium Alloy	玻璃纖維 Fibre Glass Composites
鋁合金 Aluminum Alloys	陶瓷 Ceramics
預燒結或全燒結碳化鎢 Presintered or Sintered Tungsten Carbide	碳、石碳酸 Carbon-Phenolic


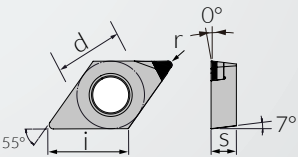
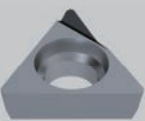
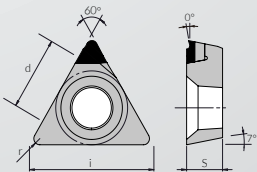
# PCD-CB 聚晶鑽石斷屑槽刀片

## Poly Crystalline Diamond Chipbreaker Type Insert

ISO 分類	P	合金鋼 Alloyed Steels					切削狀態 Cutting Condition : ● 連續切削 Continuous Cutting ○ 一般切削 General Cutting ■ 斷續切削 Interrupted Cutting			
	M	不鏽鋼 Stainless Steels								
	K	鑄鐵 Cast Iron								
N	鋁及鋁合金 Aluminum&Al	●	●	●	●					
S	高溫合金 Refractory Alloys									
H	高硬度材 Hard Material									
形狀 Form	規格 Spec.	聚晶鑽石 Polycrystalline diamond				尺寸 (mm)				圖形 Drawing
		DP				Size				
		PCD010	PCD020	PCD100	PCD250	d	i	s	r	
	CCEW060202-CB		●			6.35	6.5	2.38	0.2	
	CCEW060204-CB		●			6.35	6.5	2.38	0.4	
	CCEW09T304-CB		●			9.525	9.7	3.97	0.4	
	CCEW120404-CB		●			12.7	12.9	4.76	0.4	
	CNEW120404-CB		●			12.7	12.9	4.76	0.4	


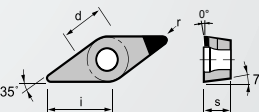

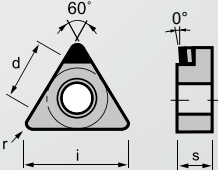
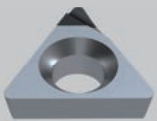
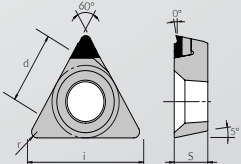
# PCD-CB 聚晶鑽石斷屑槽刀片

## Poly Crystalline Diamond Chipbreaker Type Insert

ISO 分類	P	合金鋼 Alloyed Steels					切削狀態 Cutting Condition : ● 連續切削 Continuous Cutting ○ 一般切削 General Cutting ■ 斷續切削 Interrupted Cutting			
	M	不鏽鋼 Stainless Steels								
	K	鑄鐵 Cast Iron								
N	鋁及鋁合金 Aluminum&Al	●	●	●	●					
S	高溫合金 Refractory Alloys									
H	高硬度材 Hard Material									
形狀 Form	規格 Spec.	聚晶鑽石 Polycrystalline diamond				尺寸 (mm)				圖形 Drawing
		DP				Size				
		PCD010	PCD020	PCD100	PCD250	d	i	s	r	
	DCEW070202-CB		●			6.35	7.8	2.38	0.2	
	DCEW070204-CB		●			6.35	7.8	2.38	0.4	
	DCEW11T302-CB		●			9.525	11.6	3.97	0.2	
	DCEW11T304-CB		●			9.525	11.6	3.97	0.4	
	TCEW110202-CB		●			6.35	11	2.38	0.2	
	TCEW110204-CB		●			6.35	11	2.38	0.4	
	TCEW16T304-CB		●			9.525	16.5	3.97	0.4	

# PCD-CB 聚晶鑽石斷屑槽刀片

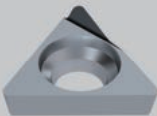
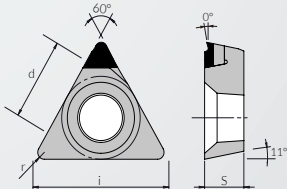
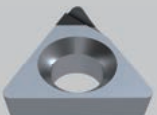
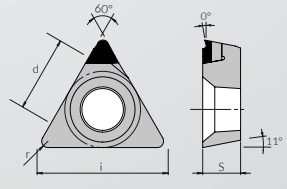
## Poly Crystalline Diamond Chipbreaker Type Insert

ISO 分類	P	合金鋼 Alloyed Steels					切削狀態 Cutting Condition: ● 連續切削 Continuous Cutting ○ 一般切削 General Cutting ■ 斷續切削 Interrupted Cutting			
	M	不鏽鋼 Stainless Steels								
	K	鑄鐵 Cast Iron								
	N	鋁及鋁合金 Aluminum&Al	●	●	●	●				
	S	高溫合金 Refractory Alloys								
H	高硬度材 Hard Material									
形狀 Form	規格 Spec.	聚晶鑽石 Polycrystalline diamond				尺寸 (mm)				圖形 Drawing
		DP				Size				
		PCD010	PCD020	PCD100	PCD250	d	i	s	r	
	VCEW160402-CB		●			9.525	16.5	4.76	0.2	
	VCEW160404-CB		●			9.525	16.5	4.76	0.4	
	VCEW160408-CB		●			9.525	16.5	4.76	0.8	
	TNEW160402-CB		●			9.525	16.5	4.76	0.2	
	TNEW160404-CB		●			9.525	16.5	4.76	0.4	
	TBEW060102-CB		●			3.97	6.4	1.59	0.2	
	TBEW060104-CB		●			3.97	6.4	1.59	0.4	



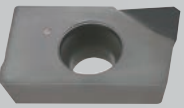
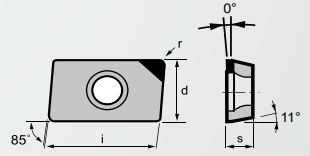
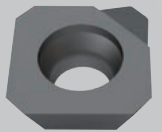
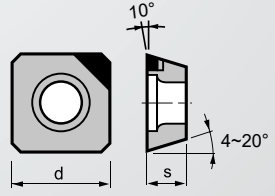
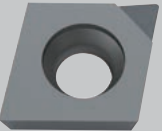
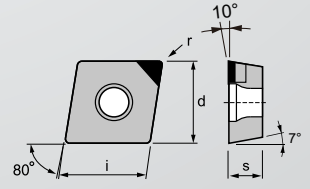
# PCD-CB 聚晶鑽石斷屑槽刀片

## Poly Crystalline Diamond Chipbreaker Type Insert

ISO 分類	P	合金鋼 Alloyed Steels								切削狀態 Cutting Condition : ● 連續切削 Continuous Cutting ○ 一般切削 General Cutting ■ 斷續切削 Interrupted Cutting
	M	不鏽鋼 Stainless Steels								
	K	鑄鐵 Cast Iron								
	N	鋁及鋁合金 Aluminum&Al	●	●	●	●				
	S	高溫合金 Refractory Alloys								
H	高硬度材 Hard Material									
形狀 Form	規格 Spec.	聚晶鑽石 Polycrystalline diamond				尺寸 (mm)				圖形 Drawing
		DP				Size				
		PCD010	PCD020	PCD100	PCD250	d	i	s	r	
	TPEW090202-CB		●			5.56	9.6	2.38	0.2	
	TPEW090204-CB		●			5.56	9.6	2.38	0.4	
	TPEW110302-CB		●			6.35	11	3.18	0.2	
	TPEW110304-CB		●			6.35	11	3.18	0.4	
	TPEW080202-CB		●			4.76	8.2	2.38	0.2	
	TPEW080204-CB		●			4.76	8.2	2.38	0.4	

# PCD 聚晶鑽石刀片

## Poly Crystalline Diamond Insert

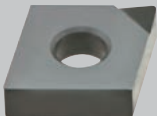
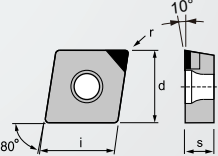
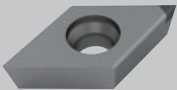
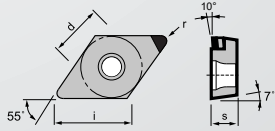
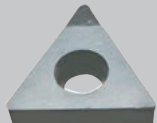
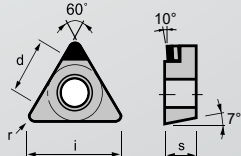
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	M	不鏽鋼 Stainless Steels								
	K	鑄鐵 Cast Iron								
N	鋁及鋁合金 Aluminum&Al	●	●	●	●					
S	高溫合金 Refractory Alloys									
H	高硬度材 Hard Material									
形狀 Form	規格 Spec.	聚晶鑽石 Polycrystalline diamond				尺寸 (mm)				圖形 Drawing
		DP				Size				
		PCD010	PCD020	PCD100	PCD250	d	i	s	r	
	APEW160404		●			9.525	16.5	4.76	-	
	APEW1604PDER		●			9.525	16.5	4.76	-	
	SEEW120404		●			12.7	-	4.76	-	
	SEEW1204APAN		●			12.7	-	4.76	-	
	CCEW060202		●			6.35	6.5	2.38	0.2	
	CCEW060204		●			6.35	6.5	2.38	0.4	
	CCEW09T304		●			9.525	9.7	3.97	0.4	
	CCEW120404		●			12.7	12.9	4.76	0.4	

● - 標準庫存 Standard stock



# PCD 聚晶鑽石刀片

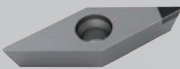
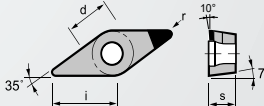
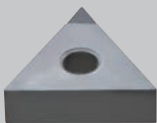
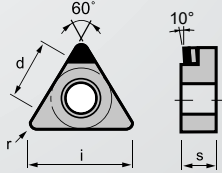
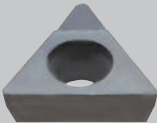
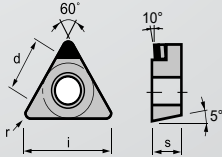
## Poly Crystalline Diamond Insert

ISO 分類	P	合金鋼 Alloyed Steels					切削狀態 Cutting Condition : ● 連續切削 Continuous Cutting ○ 一般切削 General Cutting ■ 斷續切削 Interrupted Cutting			
	M	不鏽鋼 Stainless Steels								
	K	鑄鐵 Cast Iron								
ISO 分類	N	鋁及鋁合金 Aluminum&Al	●	●	●	●				
	S	高溫合金 Refractory Alloys								
ISO 分類	H	高硬度材 Hard Material								
形狀 Form	規格 Spec.	聚晶鑽石 Polycrystalline diamond				尺寸 (mm)				圖形 Drawing
		DP				Size				
		PCD010	PCD020	PCD100	PCD250	d	i	s	r	
	CNEW120404		●			12.7	12.9	4.76	0.4	
	DCEW070202		●			6.35	7.8	2.38	0.2	
	DCEW070204		●			6.35	7.8	2.38	0.4	
	DCEW11T302		●			9.525	11.6	3.97	0.2	
	DCEW11T304		●			9.525	11.6	3.97	0.4	
	TCEW110202		●			6.35	11	2.38	0.2	
	TCEW110204		●			6.35	11	2.38	0.4	
	TCEW16T304		●			9.525	16.5	3.97	0.4	

● - 標準庫存 Standard stock

# PCD 聚晶鑽石刀片

## Poly Crystalline Diamond Insert

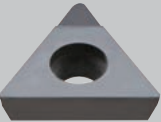
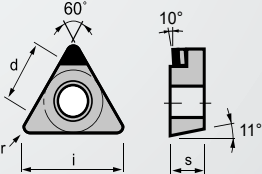
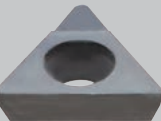
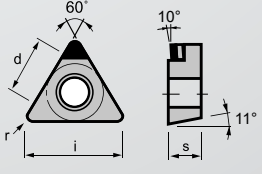
ISO 分類	P	合金鋼 Alloyed Steels					切削狀態 Cutting Condition: ● 連續切削 Continuous Cutting ○ 一般切削 General Cutting ■ 斷續切削 Interrupted Cutting			
	M	不鏽鋼 Stainless Steels								
	K	鑄鐵 Cast Iron								
N	鋁及鋁合金 Aluminum&Al	●	●	●	●					
S	高溫合金 Refractory Alloys									
H	高硬度材 Hard Material									
形狀 Form	規格 Spec.	聚晶鑽石 Polycrystalline diamond				尺寸 (mm)				圖形 Drawing
		DP				Size				
		PCD010	PCD020	PCD100	PCD250	d	i	s	r	
	VCEW160402		●			9.525	16.5	4.76	0.2	
	VCEW160404		●			9.525	16.5	4.76	0.4	
	VCEW160408		●			9.525	16.5	4.76	0.8	
	TNEW160402		●			9.525	16.5	4.76	0.2	
	TNEW160404		●			9.525	16.5	4.76	0.4	
	TBEW060102		●			3.97	6.4	1.59	0.2	
	TBEW060104		●			3.97	6.4	1.59	0.4	

● - 標準庫存 Standard stock



# PCD 聚晶鑽石刀片

## Poly Crystalline Diamond Insert

ISO 分類	P	合金鋼 Alloyed Steels					切削狀態 Cutting Condition : ● 連續切削 Continuous Cutting ○ 一般切削 General Cutting ■ 斷續切削 Interrupted Cutting			
	M	不鏽鋼 Stainless Steels								
	K	鑄鐵 Cast Iron								
N	鋁及鋁合金 Aluminum&Al	●	●	●	●					
S	高溫合金 Refractory Alloys									
H	高硬度材 Hard Material									
形狀 Form	規格 Spec.	聚晶鑽石 Polycrystalline diamond				尺寸 (mm)				圖形 Drawing
		DP				Size				
		PCD010	PCD020	PCD100	PCD250	d	i	s	r	
	TPEW090202		●			5.56	9.6	2.38	0.2	
	TPEW090204		●			5.56	9.6	2.38	0.4	
	TPEW110302		●			6.35	11	3.18	0.2	
	TPEW110304		●			6.35	11	3.18	0.4	
	TPEW080202		●			4.76	8.2	2.38	0.2	
	TPEW080204		●			4.76	8.2	2.38	0.4	

● - 標準庫存 Standard stock

# 聚晶鑽石刀片切削標準

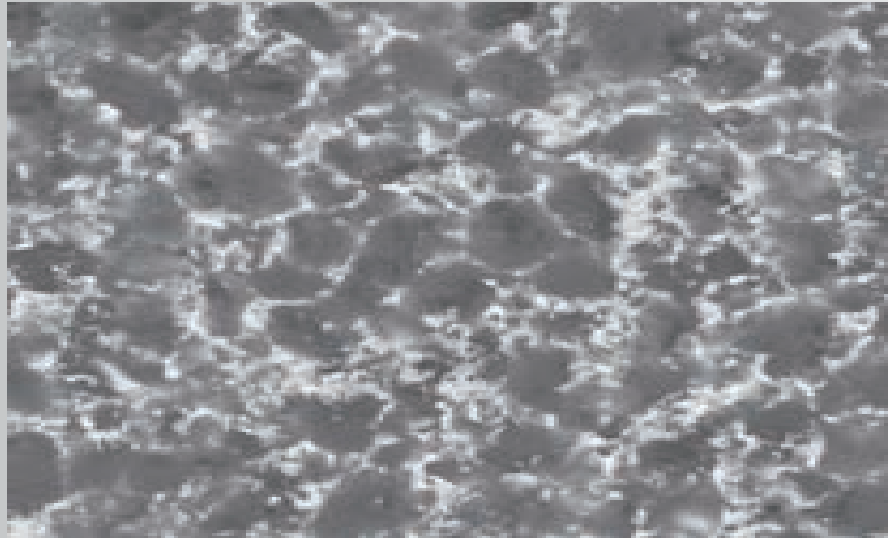
## Poly Crystalline Diamond Insert Cutting Standard

鋁合金Aluminum 4~8% SI		鋁合金Aluminum 9~13% SI	
車削 線速度 900~3500(m/min) 進給 0.1~0.4(mm/rev) 切削深度 Ap 0.1~0.4(mm)	銑削 線速度 1000~5000(m/min) 進給 0.1~0.3(mm/rev) 切削深度 Ap 0.1~0.3(mm)	車削 線速度 600~2400(m/min) 進給 0.1~0.4(mm/rev) 切削深度 Ap 0.1~0.4(mm)	銑削 線速度 1000~5000(m/min) 進給 0.1~0.3(mm/rev) 切削深度 Ap 0.1~0.3(mm)
銅合金Copper Alloy 銅、鋅、黃銅Copper, zinc, brass		木材Wood	
車削 線速度 900~3500(m/min) 進給 0.1~0.4(mm/rev) 切削深度 Ap 0.1~0.4(mm)	銑削 線速度 1000~5000(m/min) 進給 0.1~0.3(mm/rev) 切削深度 Ap 0.1~0.3(mm)	車削 線速度 400~1260(m/min) 進給 0.03~0.3(mm/rev) 切削深度 Ap 0.1~0.4(mm)	銑削 線速度 1000~5000(m/min) 進給 0.05~2.0(mm/rev) 切削深度 Ap 0.1~0.4(mm)



# CBN 適用材料

Suitable Materials for CBN



粗細微粒底材

Various size substrate

工具鋼 Tool steel	硬鎳鑄鐵 Hardened ni cast iron
合金鋼 Alloy steel	高溫合金 HRC35 以上 Epoxy Resins
鑄鐵 Cast iron	鈷基合金 Cobalt-based alloy
冷激鑄鐵 Chilled cast iron	鎳基合金 Nickel-based alloy
高鈷粉末金屬 Poedered metal with more cobalt	

# CBN 粒度及特性

## Grain Size & Feature for CBN

CBN250



粒度

1 $\mu$ m

硬度

2400Hv

切削速度

100~400 Vc(m/min)

是耐磨與耐崩刃性的通用材質。適合刀具使用壽命更長的應用。在對灰鑄鐵和硬鑄鐵進行斷續加工、淬硬鋼銑削對大多數鐵基閥座環加工時表現優異。是大多數鐵基粉末金屬的優先選擇材質。

超硬燒結合金

CBN300



粒度

2 $\mu$ m

硬度

2400Hv

切削速度

100~400 Vc(m/min)

提高了粒子間的結合強度，是切刃強度最高的材質。適用於所有常見硬化鋼的中度到重度斷續車削。在韌性、月牙灣和後刀面耐磨性之間實現很好的平衡。還可用於鐵基閥座環的插銑加工。

中切削硬化鋼

CBN400



粒度

3 $\mu$ m

硬度

2400Hv

切削速度

800~220 Vc(m/min)

適用於汽車用鋼的輕度斷續切削，由於具有較優的耐磨性，所以非常適用在冷作工具鋼和某些閥座用合金。還建議用於拋光粗糙的高強度鑄鐵。

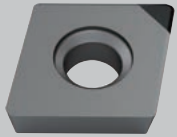
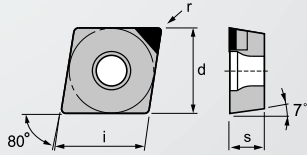
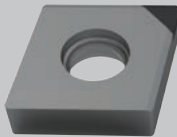
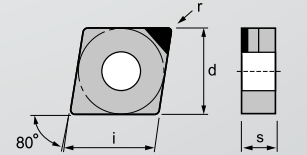
連續~輕切削加工





# CBN 氮化硼刀片

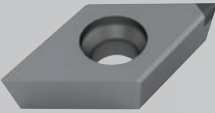
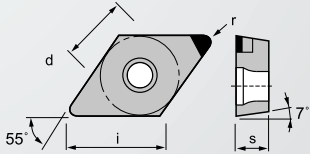
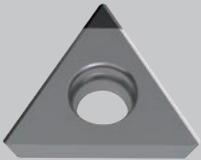
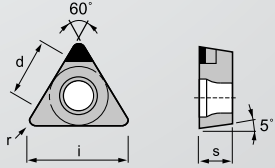
## Cubic Boron Nitride Insert

ISO 分類	P	合金鋼 Alloyed Steels				切削狀態 Cutting Condition : ● 連續切削 Continuous Cutting ○ 一般切削 General Cutting ■ 斷續切削 Interrupted Cutting			
	M	不鏽鋼 Stainless Steels							
	K	鑄鐵 Cast Iron							
	N	鋁及鋁合金 Aluminum&Al							
S	高溫合金 Refractory Alloys								
H	高硬度材 Hard Material		●	●	●				
形狀 Form	規格 Spec.	氮化硼 BN			尺寸 (mm)				圖形 Drawing
		BN			Size				
		CBN250	CBN300	CBN400	d	i	s	r	
	CCEW060202	●			6.35	6.5	2.38	0.2	
	CCEW060204	●			6.35	6.5	2.38	0.4	
	CCEW060208	●			6.35	6.5	2.38	0.8	
	CCEW09T302	●			9.525	9.7	3.97	0.2	
	CCEW09T304	●			9.525	9.7	3.97	0.4	
	CCEW09T308	●			9.525	9.7	3.97	0.8	
	CCEW120404	●			12.7	12.9	4.76	0.4	
	CNEW120404	●			12.7	12.9	4.76	0.4	
	CNEW120408	●			12.7	12.9	4.76	0.8	

● - 標準庫存 Standard stock

# CBN 氮化硼刀片

## Cubic Boron Nitride Insert

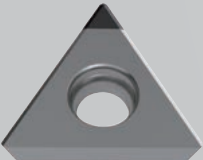
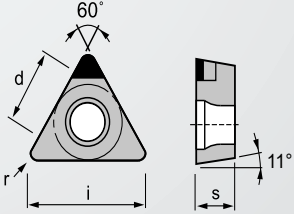
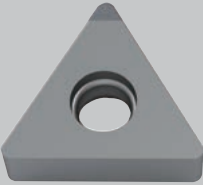
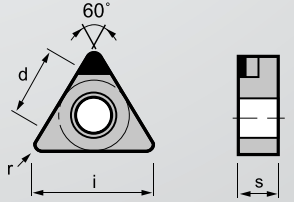
ISO 分類	P	合金鋼 Alloyed Steels				切削狀態 Cutting Condition: ● 連續切削 Continuous Cutting ○ 一般切削 General Cutting ■ 斷續切削 Interrupted Cutting			
	M	不鏽鋼 Stainless Steels							
	K	鑄鐵 Cast Iron							
N	鋁及鋁合金 Aluminum&Al								
S	高溫合金 Refractory Alloys								
H	高硬度材 Hard Material	●	●	●					
形狀 Form	規格 Spec.	氮化硼 BN			尺寸 (mm)				圖形 Drawing
		BN			Size				
		CBN250	CBN300	CBN400	d	i	s	r	
	DCEW070202	●			6.35	7.8	2.38	0.2	
	DCEW070204	●			6.35	7.8	2.38	0.4	
	DCEW070208	●			6.35	7.8	2.38	0.8	
	DCEW11T302	●			9.525	11.6	3.97	0.2	
	DCEW11T304	●			9.525	11.6	3.97	0.4	
	TBEW060104	●			3.97	6.4	1.59	0.4	

● - 標準庫存 Standard stock



# CBN 氮化硼刀片

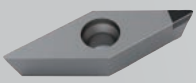
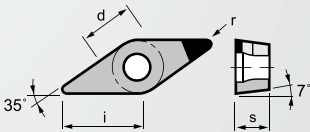
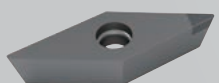
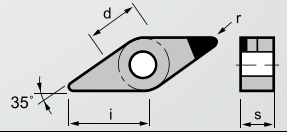

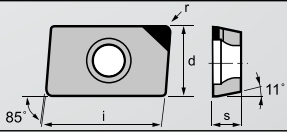
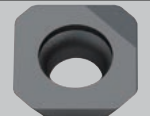
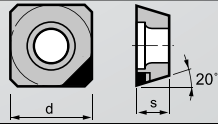
## Cubic Boron Nitride Insert

ISO 分類	P	合金鋼 Alloyed Steels				切削狀態 Cutting Condition : ● 連續切削 Continuous Cutting ○ 一般切削 General Cutting ■ 斷續切削 Interrupted Cutting			
	M	不鏽鋼 Stainless Steels							
	K	鑄鐵 Cast Iron							
N	鋁及鋁合金 Aluminum&Al								
S	高溫合金 Refractory Alloys								
H	高硬度材 Hard Material	●	●	●					
形狀 Form	規格 Spec.	氮化硼 BN			尺寸 (mm)				圖形 Drawing
		BN			Size				
		CBN250	CBN300	CBN400	d	i	s	r	
	TPEW080202	●			4.76	8.2	2.38	0.2	
	TPEW080204	●			4.76	8.2	2.38	0.4	
	TPEW090202	●			5.56	9.6	2.38	0.2	
	TPEW090204	●			5.56	9.6	2.38	0.4	
	TPEW110302	●			6.35	11	3.18	0.2	
	TPEW110304	●			6.35	11	3.18	0.4	
	TPEW110308	●			6.35	11	3.18	0.8	
	TPEW16T302	●			9.525	16.5	3.97	0.2	
	TPEW16T304	●			9.525	16.5	3.97	0.4	
	TNEW160402	●			9.525	16.5	4.76	0.2	
	TNEW160404	●			9.525	16.5	4.76	0.4	
	TNEW160408	●			9.525	16.5	4.76	0.8	

● - 標準庫存 Standard stock

# CBN 氮化硼刀片

## Cubic Boron Nitride Insert

形狀 Form	規格 Spec.	氮化硼 BN			尺寸 (mm)				圖形 Drawing
		BN			Size				
		CBN250	CBN300	CBN400	d	i	s	r	
	VCEW110302	●			6.35	11	3.18	0.2	
	VCEW110304	●			6.35	11	3.18	0.4	
	VCEW160402	●			9.525	16.5	4.76	0.2	
	VCEW160404	●			9.525	16.5	4.76	0.4	
	VCEW160408	●			9.525	16.5	4.76	0.8	
	VNEW160404	●			9.525	16.5	4.76	0.4	
	VNEW160408	●			9.525	16.5	4.76	0.8	
	APEW1604PDER	●			9.525	16.5	4.76	-	
	SEEW1204APAN	●			12.7	-	4.76	-	

切削狀態 Cutting Condition:


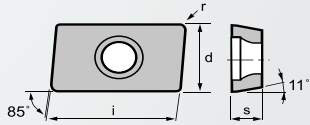
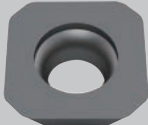
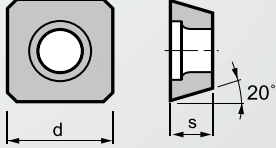
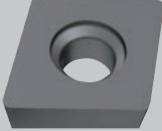
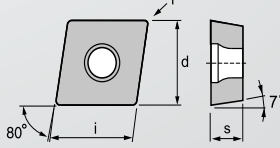
- 連續切削 Continuous Cutting
- 一般切削 General Cutting
- 斷續切削 Interrupted Cutting

● - 標準庫存 Standard stock



# BM 毛胚刀片

## Blank Insert

形狀 Form	規格 Spec.	硬質合金 Carbide			尺寸 (mm)				圖形 Drawing
		HC			Size				
		BM			d	i	s	r	
	APEW1003	●			6.68	10.5	3.18	-	
	APEW1604	●			9.525	16.5	4.76	-	
	SEEW1204	●			12.7	-	4.76	-	
	CCEW0602	●			6.35	6.5	2.38	-	
	CCEW09T3	●			9.525	9.7	3.97	-	
	CCEW1204	●			12.7	12.9	4.76	-	

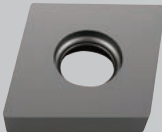
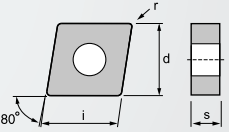
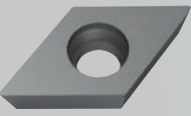
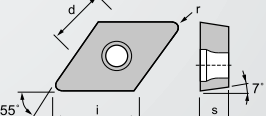

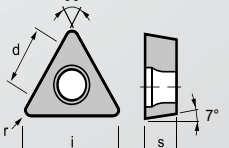
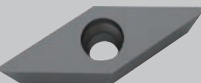

切削狀態 Cutting Condition:

- 連續切削 Continuous Cutting
- 一般切削 General Cutting
- 斷續切削 Interrupted Cutting

● - 標準庫存 Standard stock

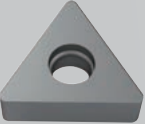
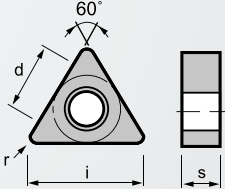

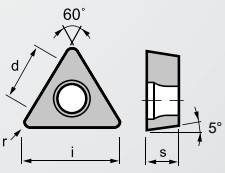

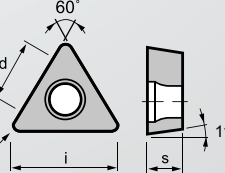
# BM 毛胚刀片

## Blank Insert

ISO 分類	P	合金鋼 Alloyed Steels				切削狀態 Cutting Condition : ● 連續切削 Continuous Cutting ○ 一般切削 General Cutting ■ 斷續切削 Interrupted Cutting			
	M	不鏽鋼 Stainless Steels							
	K	鑄鐵 Cast Iron							
N	鋁及鋁合金 Aluminum&Al								
S	高溫合金 Refractory Alloys								
H	高硬度材 Hard Material								
形狀 Form	規格 Spec.	硬質合金 Carbide			尺寸 (mm)				圖形 Drawing
		HC			Size				
		BM			d	i	s	r	
	CNEW1204	●			12.7	12.9	4.76	-	
	DCEW0702	●			6.35	7.8	2.38	-	
	DCEW11T3	●			9.525	11.6	3.97	-	
	TCEW0902	●			5.56	9.6	2.38	-	
	TCEW1102	●			6.35	11	2.38	-	
	TCEW16T3	●			9.525	16.5	3.97	-	
	VCEW1103	●			6.35	11.2	3.78	-	
	VCEW1604	●			9.525	16.5	4.76	-	

# BM 毛胚刀片

## Blank Insert

ISO 分類	P	合金鋼 Alloyed Steels				切削狀態 Cutting Condition : ● 連續切削 Continuous Cutting ○ 一般切削 General Cutting ■ 斷續切削 Interrupted Cutting			
	M	不鏽鋼 Stainless Steels							
	K	鑄鐵 Cast Iron							
N	鋁及鋁合金 Aluminum&Al								
S	高溫合金 Refractory Alloys								
H	高硬度材 Hard Material								
形狀 Form	規格 Spec.	硬質合金 Carbide			尺寸 (mm)				圖形 Drawing
		HC			Size				
		BM			d	i	s	r	
	TNEW1604	●			9.525	16.5	4.76	-	
	TBEW0601	●			3.97	6.4	1.59	-	
	TPEW0802	●			4.76	8.2	2.38	-	
	TPEW0902	●			5.56	9.6	2.38	-	
	TPEW1103	●			6.35	11	3.18	-	
	TPEW16T3	●			9.525	16.5	3.97	-	



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