

Высокопроизводительный фрезерный инструмент

--Indexable Milling Project Team

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2 Высокопроизводительное фрезерование (3 грани)

3 Высокопроизводительное фрезерование (4 грани)

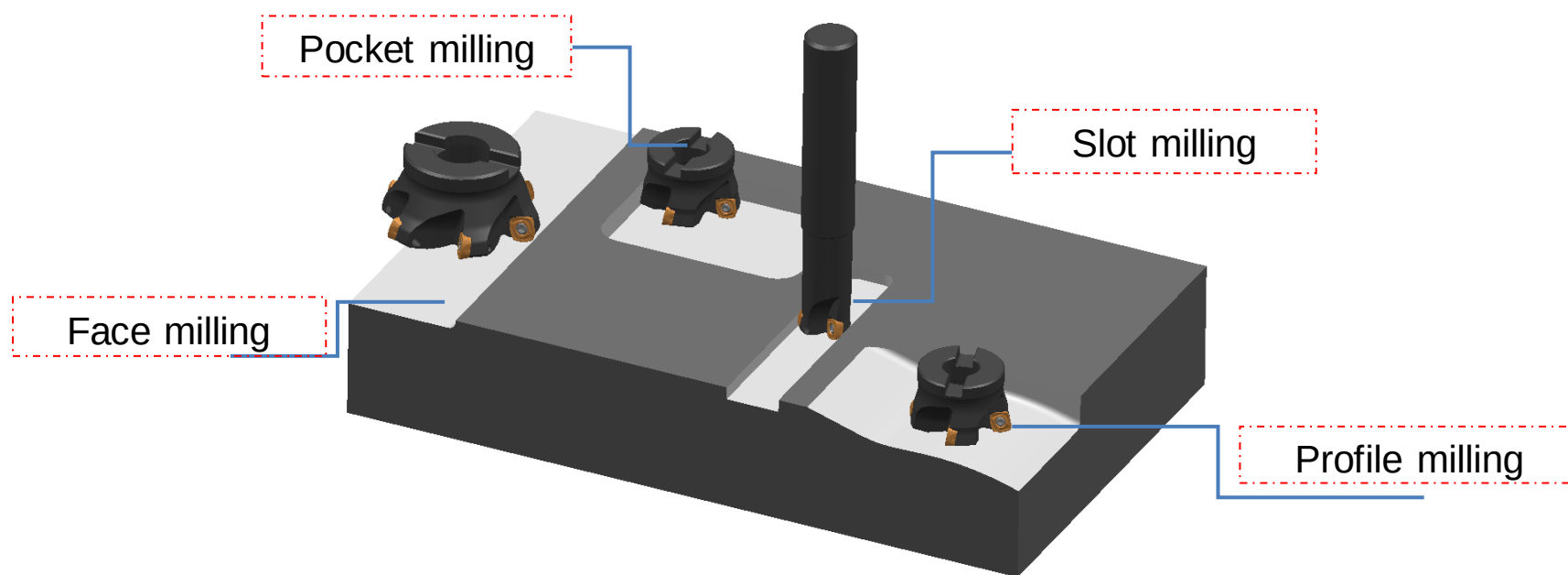
4 Применение





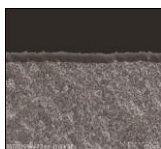
1 Высокопроизводительное фрезерование

» Различное применение



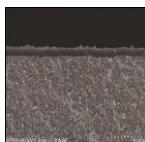
»» Различные сплавы для разного применения

GP4225



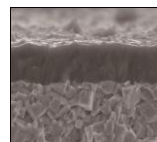
Покрытие
TiAlN

GA4230



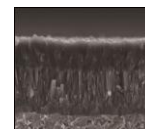
Покрытие
AlCrN

GK4125



Покрытие
TiAlN

GK2115



Покрытие
MT-TiCN
+Al₂O₃

2

Высокопроизводительное фрезерование (3 грани)



»» 【UD/UP+MKA110】

Introduction

- Small cutting depth but high feed, low cutting force



Application

- Steel and stainless steel cutting mainly;
- Applicable for mold industry and aerospace profile milling from medium cutting to heavy cutting

Specification

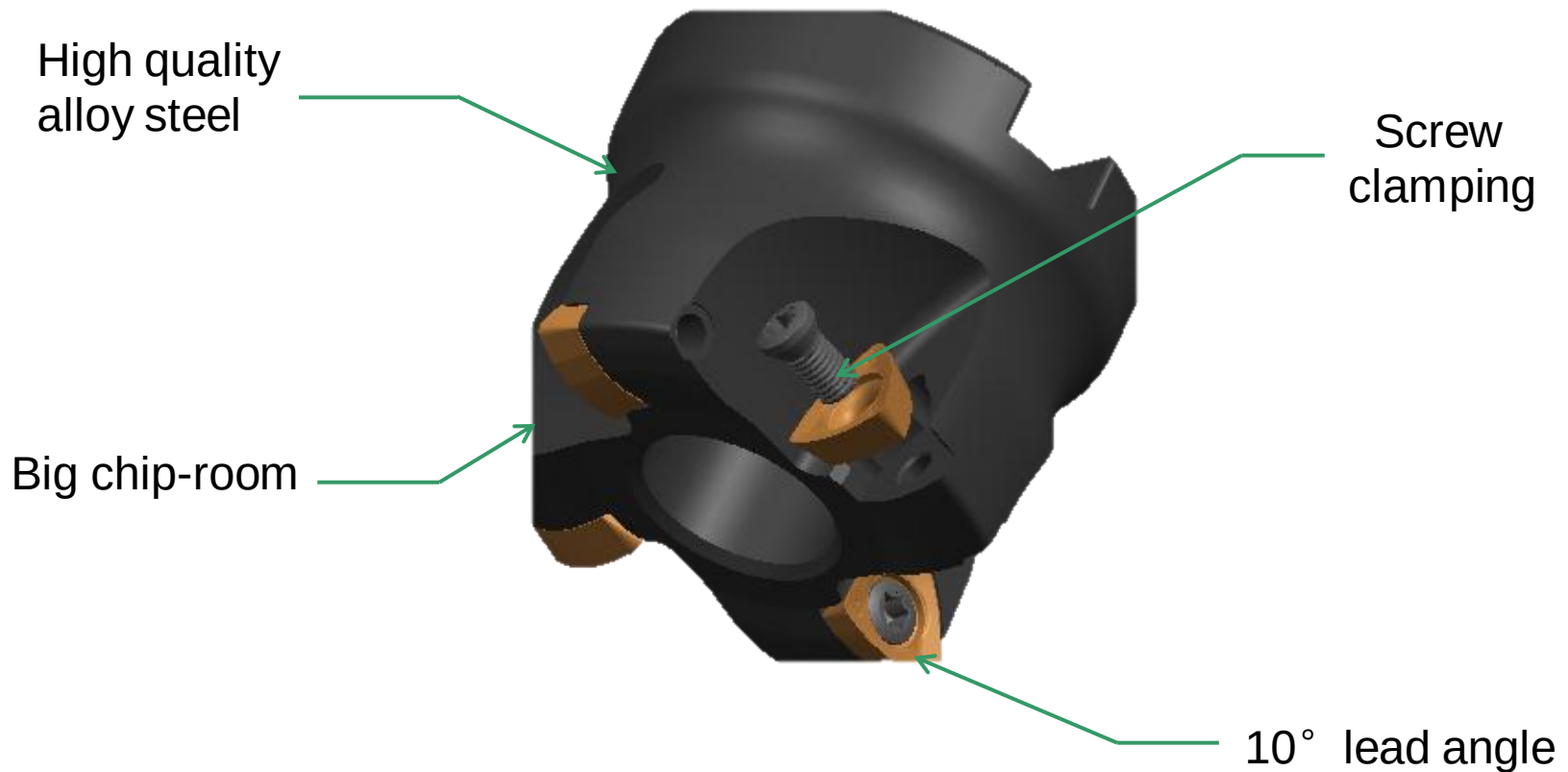
- 4 Grades: GA4230 GA4225 GM2140 GS4130
- 3 Size : UD08 UD12 UP17
- 4 Geometries: MM PM PH 平板
- Cutter diameter : $\Phi 20$ - $\Phi 100$ mm.



» High Feed Milling (3 Edges) **Insert features**

Medium		Heavy	
			
MM	PM	MH	Flat
			
◆ Low cutting force ◆ straight cutting edges	◆ Rake angle & chamfer ◆ Excellent chip evacuation ◆ Large radius edge	◆ Effective geometry & antifriction point ◆ Small rake angle & chamfer	◆ High strength cutting edge

» Cutter body features-MKA110

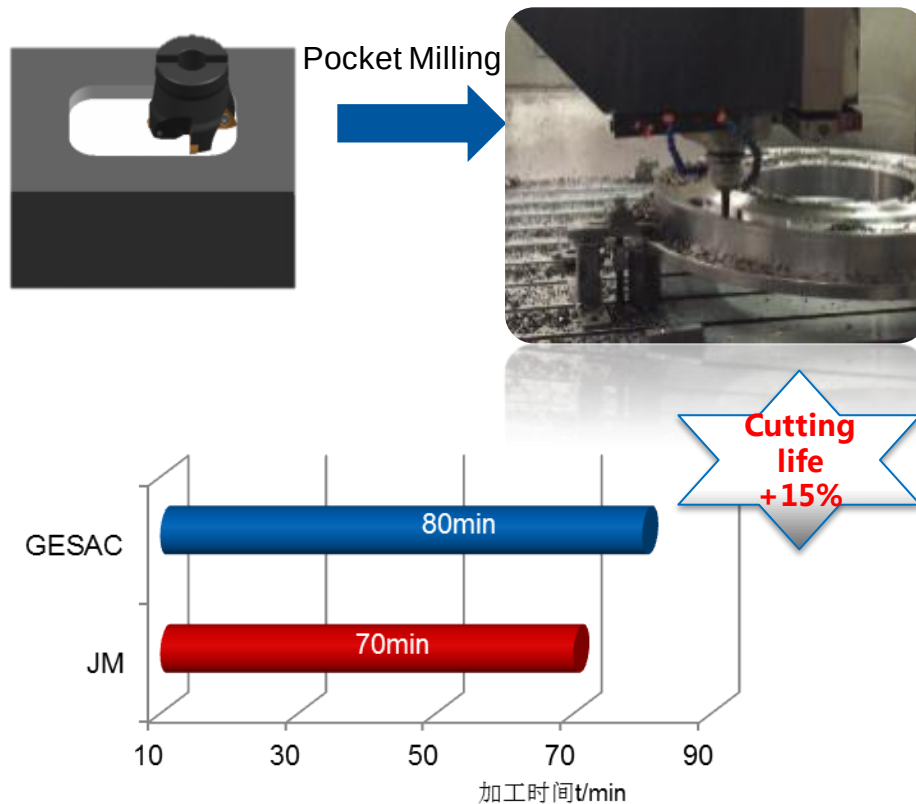


2.2

High-feed milling with 3 cutting edges

» Cutting Case : Rough pocket milling

Tools	High Feed Milling (3 Edges)
Specification	MKA110-063R04A22-UP17 UPET170520-PM-GA4225
Workpiece	P20(35HRC)
Vc	138.5m/min
Fz	1.6mm/z
Ap	0.8mm
Cutting type	Rough pocket milling
Coolant	air cooling
Description	Tool life have been improved by 15%



3

Высокопроизводительное фрезерование (4 грани)



»» 【SDMT+MKB113】

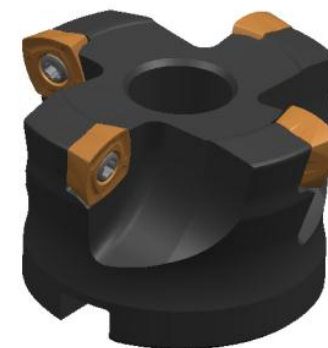
Introduction

- 4 cutting edges, achieve high economy milling
- Small cutting depth but high feed



Application

- General purpose material machining in different applications.



Specification

- 4 grades: GA4230 GA4225 GK4125 GK2115
- Insert size :SD12 SD15
- 2 Geometries :GM GH
- Cutter diameter : Ø32-Ø125mm.

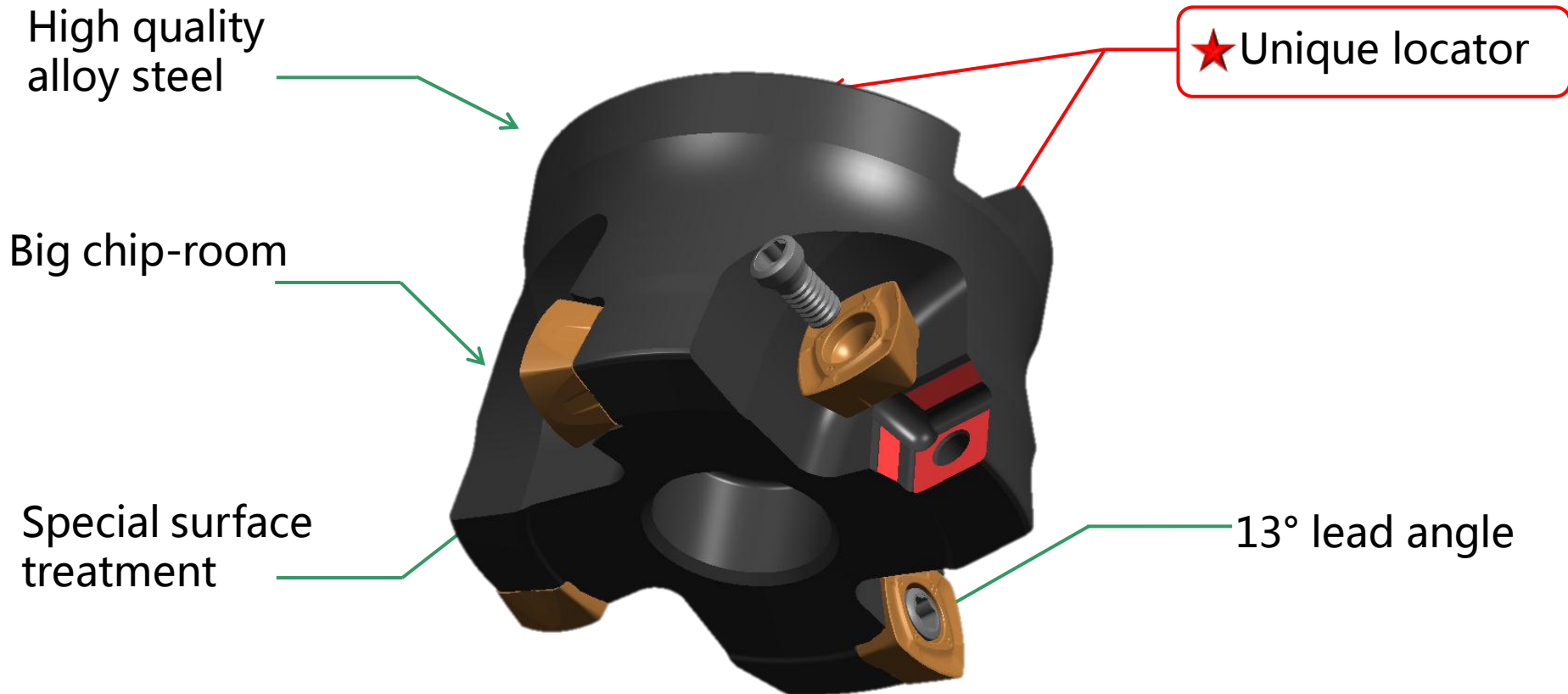
3.1

High-feed milling with 4 cutting edges

» High Feed Milling (4 Edges) **Insert features**

Medium Cutting	Heavy Cutting
	
GM	GH
	
◆ Variable rake angle ◆ Special geometry ◆ Raised surface in rake face	◆ Strongest Edge ◆ Special geometry

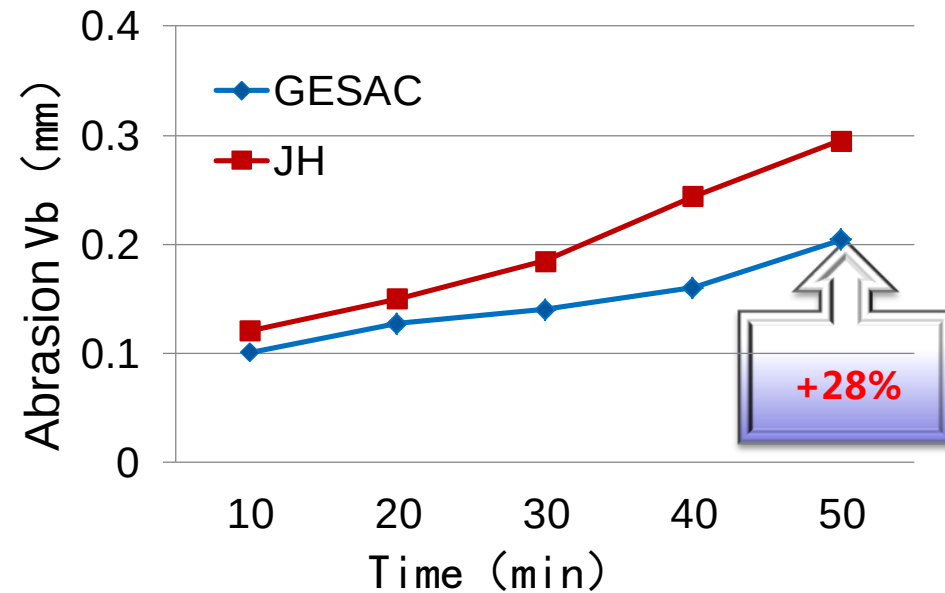
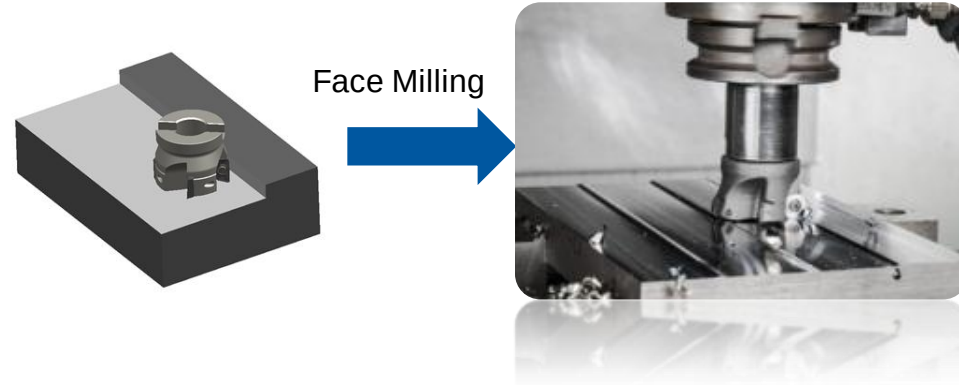
» Cutter body features-MKB113



3.3 Cutting Performance

» Cutting Case : Face milling

Tools	High Feed Milling (4 Edges)
Specification	MKB113-063R04A22-SD12 SDMT120512-GM-GA4225
Workpiece	P20(37HRC)
Vc	160m/min
Fz	1.5mm/z
Ap	1.0mm
Cutting type	pocket milling
Coolant	air cooling
Description	Tool life have been improved by 28%



4

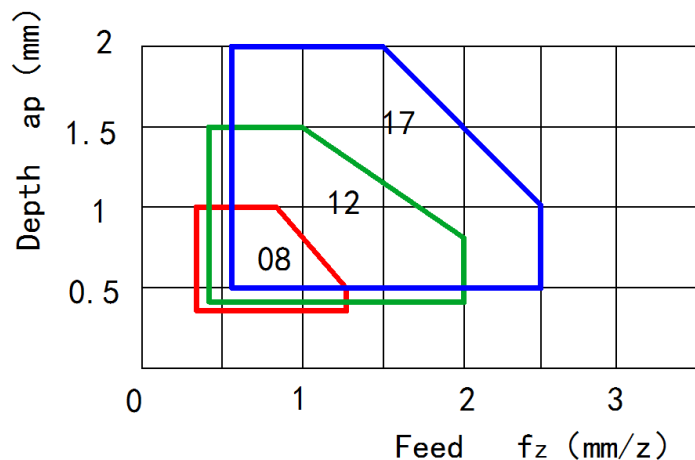
Высокопроизводительное фрезерование - Применение



» Application(3 edges OR 4 edges)

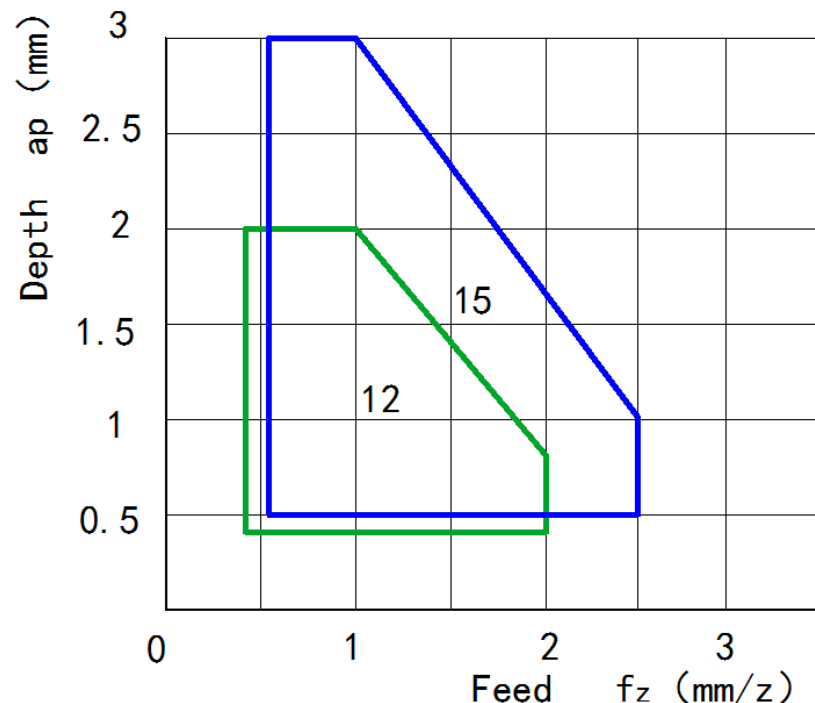


MKA110 Feed-Depth



➤ Especially for CNC machine with lower power and for Aerospace Alloys

MKB113 Feed-Depth



➤ Especially for CNC machine with higher power, eg: 50 Taper, HSK 100

Благодарим за внимание!

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