

THE NEW VALUE FRONTIER

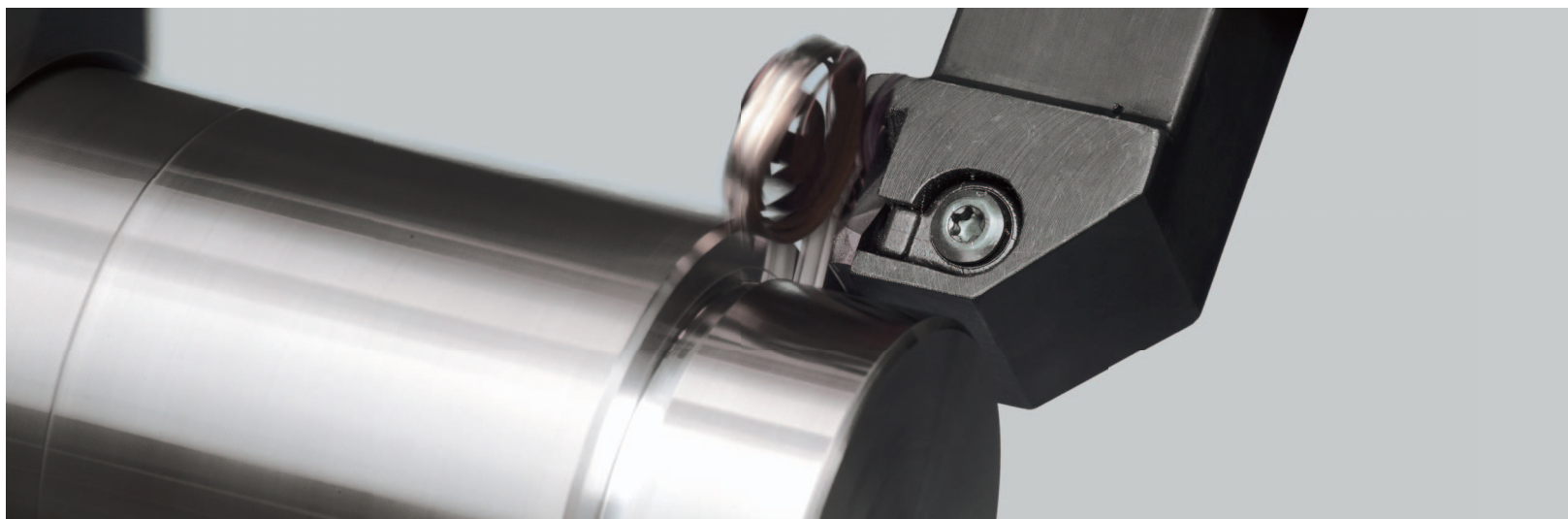
京瓷 创造新价值



3刀尖槽刀 | GBA

3刀尖槽刀

GBA



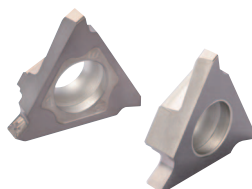
实现优秀的切屑处理和卓越的精加工面

丰富的断屑槽和材质阵容

切屑处理性能优秀的GM断屑槽

混合金属陶瓷 TN620登场

NEW 混合金属陶瓷
TN620



3刀尖槽刀

GBA

实现优秀的切屑处理和卓越的精加工面
追加混合金属陶瓷 TN620、充实产品阵容

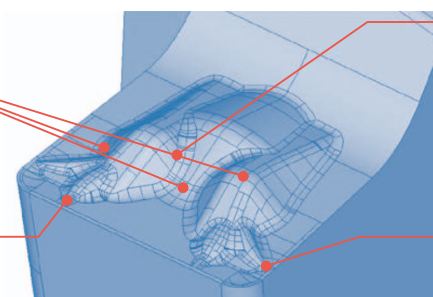
1 通过GM断屑槽确保切屑处理良好

通过优化配置复数凸起控制切屑
宽度1.4mm起对应

多重凸起系统

通过和中央凹陷的组合
控制切屑的排出与卷曲

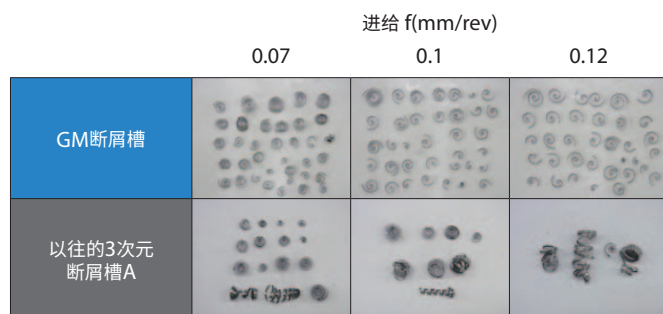
低进给时的切屑处理稳定化



促进切屑变形

台阶加工或C面加工时的
切屑处理稳定化

切屑处理比较 (我司比较)

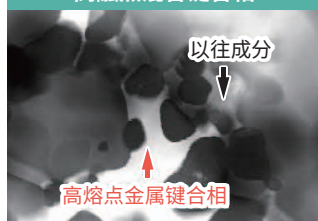


切削参数：Vc = 200 m/min, 刀片刃宽2.0 mm, 槽加工 被加工材料：SCr420(φ40)

2 混合金属陶瓷 TN620 产品阵容扩充

通过锋利刀尖规格(研磨断屑槽)实现良好精加工面

高熔点混合键合相



以往金属陶瓷键合相(Ni, Co)和
特殊高熔点金属键合相的复合化

通过提高耐热温度实现高耐溶性
与优异的完成面品质

标准库存型号

| 型号 | A | T | φd | (mm) | P | | | | | | | | | | | 使用分类标准 | | | | | | | | |
|--|-------|------|-----|------|--------|--|--|---------------|---|-------|---|----------|---|--------|--------|--------|---|-------|---|--------|-------|---|------|---|
| | | | | | M | | | | | | | | | | | | | | | | | | | |
| | | | | | K | | | | | | | | | | | | | | | | | | | |
| 型号 | A | T | φd | N | | | | | | | | | | | 适用刀杆型号 | | | | | | | | | |
| GBA32_ | 9.525 | 3.18 | 4.4 | S | | | | | | | | | | | | | | | | | | | | |
| GBA43_ | 12.70 | 4.76 | 5.5 | H | | | | | | | | | | | | | | | | | | | | |
| GBA43 R/L480 | 12.70 | 5.00 | 5.5 | H | | | | | | | | | | | | | | | | | | | | |
| 形状 | | 型号 | | | 尺寸(mm) | | | MEGACOAT 金属陶瓷 | | 金属陶瓷 | | MEGACOAT | | PVD涂层 | | | | 硬质合金 | | 适用刀杆型号 | | | | |
| | | | | | | | | PV7040 | | TC40N | | TN90 | | PR1215 | | PR1115 | | PR905 | | | PR930 | | KW10 | |
| | | | | | | | | R | L | R | L | R | L | R | L | R | L | R | L | | R | L | R | L |
| | | | | | | | | | | | | | | | | | | | | | | | | |
| ●: 连续~轻断续/第1选择 ◐: 连续~轻断续/第2选择 ●: 连续/第1选择 ○: 连续/第2选择 | | | | | | | | | | | | | | | | | | | | | | | | |
| ●: 标准库存 | | | | | | | | | | | | | | | | | | | | | | | | |

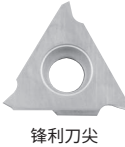
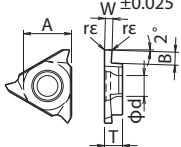
B: 加工可能槽深

※1. GBA32 R/L 033-005的刃宽公差: 0.33^{+0.05}

※2. GBA32 R/L 050-005的刃宽公差: 0.50^{+0.05}

- ★适用刀杆型号
- 1: KGBA R/L...22-25T5, KGBAS L/R...22-25T5, KIGBA L/R...22
- 2: KGBA R/L...22-25T5, KGBAS L/R...22-25T5, KGBA R/L...22-25, KGBAS L/R...22-25, KIGBA L/R...22

标准库存型号

| | | | | NEW | | | | | | | | | | 使用分类标准 | | | | | |
|---|---|-----------|------------------------|----------|------|------|-------|--------|-----------|--------|-------|------------------|---|---|---|--|--|--|---|
| | | | | P | M | K | N | S | H | | | | | | | | | | |
| | | | | (mm) | | | | | | | | | | | | | | | |
| 型号 | A | T | φd | | | | | | | | | | | | | | | | |
| GBA32_ | 9.525 | 3.18 | 4.4 | | | | | | | | | | | | | | | | |
| GBA43_ | 12.70 | 4.76 | 5.5 | | | | | | | | | | | | | | | | |
| GBA43 R/L480 | 12.70 | 5.00 | 5.5 | | | | | | | | | | | | | | | | |
| 形状 | | 型号 | | 尺寸(mm) | | | 金属陶瓷 | | MEGA COAT | | PVD涂层 | | | 适用刀杆型号 | | | | | |
| 有方向区分的刀片的图示为右手刀(R) | | | | W | B | re | TN620 | TN6020 | PR1215 | PR1115 | PR930 | | | | | | | | |
| | | | | R | L | R | R | L | R | L | R | L | R | L | | | | | |
|  <p>锋利刀尖</p> |  | GBA32 R/L | 050-005F ^{※1} | 0.50 | 1.0 | 0.05 | ● | ● | | | | | | | KGBA R/L...16 KGBAS L/R...16 KIGBA L/R...16(内径) | | | | |
| | | | 075-005F | 0.75 | ● | | ● | | | | | | | | | | | | |
| | | | 095-005F | 0.95 | ● | | ● | | | | | | | | | | | | |
| | | | 100-005F | 1.00 | ● | | ● | | | | | | | | | | | | |
| | | | 125-020F | 1.25 | 2.0 | | ● | ● | | | | | | | | | | | |
| | | | 145-020F | 1.45 | | | ● | ● | | | | | | | | | | | |
| | | | 150-020F | 1.50 | | | ● | ● | | | | | | | | | | | |
| | | | 175-020F | 1.75 | | | ● | ● | | | | | | | | | | | |
| | | | 200-020F | 2.00 | | | ● | ● | | | | | | | | | | | |
| | | | 250-020F | 2.50 | | | ● | ● | | | | | | | | | | | |
| | | | GBA43 R/L | 125-020F | 1.25 | | 2.0 | ● | ● | | | | | | | | | | KGBA R/L...22-15 KGBAS L/R...22-15 KIGBA L/R...22(内径) |
| | | | | 145-020F | 1.45 | | | ● | ● | | | | | | | | | | |
| | | 150-020F | | 1.50 | ● | ● | | | | | | | | | | | | | |
| | | 175-020F | | 1.75 | ● | ● | | | | | | | | | | | | | |
| | | 185-020F | | 1.85 | 3.5 | ● | | ● | | | | | | | | | | | |
| | | 200-020F | | 2.00 | | ● | | ● | | | | | | | | | | | |
| | | 230-020F | | 2.30 | 4.0 | ● | ● | | | | | | | | KGBA R/L...22-25T5 KGBAS L/R...22-25T5 KIGBA L/R...22(内径) | | | | |
| | | 250-030F | | 2.50 | | ● | ● | | | | | | | | | | | | |
| | | 265-030F | | 2.65 | | ● | ● | | | | | | | | | | | | |
| | | 280-030F | | 2.80 | | ● | ● | | | | | | | | | | | | |
| | | 300-030F | | 3.00 | | ● | ● | | | | | | | | | | | | |
| | | 330-030F | | 3.30 | | ● | ● | | | | | | | | | | | | |
| | | GBA43 R/L | 350-030F | 3.50 | 5.0 | ● | ● | | | | | | | | KGBA R/L...22-35 KGBAS L/R...22-35 KIGBA L/R...22(内径) | | | | |
| | | | 400-040F | 4.00 | | ● | ● | | | | | | | | | | | | |
| 430-040F | 4.30 | | ● | ● | | | | | | | | | | | | | | | |
| 450-040F | 4.50 | | ● | ● | | | | | | | | | | | | | | | |
| 480-040F | 4.80 | | ● | ● | | | | | | | | | | | | | | | |
| GBA43 R/L | 140-010GM | | 1.40 | 3.5 | ● | ● | | ● | ● | | | | | KGBA R/L...22-15 KGBAS L/R...22-15 KIGBA L/R...22(内径) | | | | | |
| | 150-020GM | | 1.50 | | ● | ● | | ● | ● | | | | | | | | | | |
| | 175-020GM | | 1.75 | | ● | ● | | ● | ● | | | | | | | | | | |
| | 185-020GM | 1.85 | ● | | ● | | ● | ● | | | | | | | | | | | |
| | 200-020GM | 2.00 | ● | | ● | | ● | ● | | | | | | | | | | | |
| | 230-020GM | 2.30 | ● | | ● | | ● | ● | | | | | | | | | | | |
| | GBA43 R/L | 250-030GM | 2.50 | 5.0 | ● | ● | | ● | ● | | | | | | KGBA R/L...22-25T5 KGBAS L/R...22-25T5 KIGBA L/R...22(内径) | | | | |
| | | 265-030GM | 2.65 | | ● | ● | | ● | ● | | | | | | | | | | |
| | | 300-030GM | 3.00 | | ● | ● | | ● | ● | | | | | | | | | | |
| | | 330-030GM | 3.30 | | ● | ● | | ● | ● | | | | | | | | | | |
| | | 350-030GM | 3.50 | | ● | ● | | ● | ● | | | | | | | | | | |
| | | 400-040GM | 4.00 | | ● | ● | | ● | ● | | | | | | | | | | |
| GBA43 R/L | 175-020MY | 1.75 | 3.5 | | | ● | ● | ● | ● | ● | ● | ● | KGBA R/L...22-15 KGBAS L/R...22-15 KIGBA L/R...22(内径) | | | | | | |
| | 185-020MY | 1.85 | | | | ● | ● | ● | ● | ● | ● | ● | | | | | | | |
| | 200-020MY | 2.00 | | | | ● | ● | ● | ● | ● | ● | ● | | | | | | | |
| | 230-020MY | 2.30 | | | | ● | ● | ● | ● | ● | ● | ● | | | | | | | |
| | 250-030MY | 2.50 | | 4.0 | | | ● | ● | | | | | | | ★2 ^{※2} | | | | |
| | | 5.0 | | | | | ● | ● | | | | | | | ★1 ^{※2} | | | | |
| | 265-030MY | 2.65 | 4.0 | | | ● | ● | | | | | | | ★2 ^{※2} | | | | | |
| | | 5.0 | | | | ● | ● | | | | | | | ★1 ^{※2} | | | | | |
| | 300-030MY | 3.00 | 4.0 | | | ● | ● | | | | | | | ★2 ^{※2} | | | | | |
| | | 5.0 | | | | ● | ● | | | | | | | ★1 ^{※2} | | | | | |
| | 330-030MY | 3.30 | 4.0 | | | ● | ● | | | | | | | ★2 ^{※2} | | | | | |
| | | 5.0 | | | | ● | ● | | | | | | | ★1 ^{※2} | | | | | |
| 350-030MY | 3.50 | 5.0 | | | ● | ● | | | | | | ★2 ^{※2} | | | | | | | |
| | 4.00 | | | | ● | ● | | | | | | ★1 ^{※2} | | | | | | | |
| 400-040MY | 4.00 | 5.0 | | | ● | ● | | | | | | ★2 ^{※2} | | | | | | | |
| | 4.00 | | | | ● | ● | | | | | | ★1 ^{※2} | | | | | | | |

B: 加工可能槽深

※1. GBA32 R/L 050-005F的刀宽公差: 0.50^{±0.05}
 ※2. ★1★2参考P2下部

●: 标准库存

GBA-GM刀片安装时的前角(α) (外径槽刀杆)

| α | 刀片型号 | α | 刀片型号 |
|-----|--------------------|-----|---|
| 10° | GBA43 R/L150-020GM | 12° | GBA43 R/L300-030GM } GBA43 R/L400-040GM |
| 15° | GBA43 R/L175-020GM | | |
| | GBA43 R/L265-030GM | | |

α为刀片安装时的槽宽中央部前角

GBA-MY刀片安装时的前角(α) (外径槽刀杆)

| α | 刀片型号 |
|-----|---|
| 15° | GBA43 R/L175-020MY } GBA43 R/L350-030MY |
| 14° | GBA43 R/L400-040MY |

α为刀片安装时的槽宽中央部前角

标准库存型号

| | | | | NEW | | | | | | | | | | | | | |
|--------------|-------|------|-----|-----------------|------|---------------|--------|-------|------|--------|--------|-------|-------|--------|---|--|--|
| | | | | P 炭素钢·合金钢 | | | | | | | | | | | | | |
| | | | | M 不锈钢 | | | | | | | | | | | | | |
| | | | | K 铸铁 | | | | | | | | | | | | | |
| | | | | N 有色金属 | | | | | | | | | | | | | |
| | | | | S 钛合金 | | | | | | | | | | | | | |
| | | | | H 高硬度材(40HRC以下) | | | | | | | | | | | | | |
| | | | | H 高硬度材(40HRC以上) | | | | | | | | | | | | | |
| 型号 | A | T | φd | 尺寸(mm) | | MEGACOAT 金属陶瓷 | | | | PVD涂层 | | 硬质合金 | | 适用刀杆型号 | | | |
| | | | | W | B | re | PV7040 | TN620 | TN90 | PR1215 | PR1115 | PR905 | PR930 | | KW10 | | |
| GBA32 | 9.525 | 3.18 | 4.4 | 2.00 | 2.5 | 1.00 | | | | | ● | ○ | | | KGBA R/L...16 KGBAS R/L...16 KIGBA L/R...16(内径) | | |
| GBA43 | 12.70 | 4.76 | 5.5 | 3.00 | 1.50 | | | | | | ● | ○ | | | | | |
| GBA43 R/L480 | 12.70 | 5.00 | 5.5 | 1.00 | 2.0 | 0.50 | ● | ● | ● | ● | ● | ● | ● | ● | KGBA R/L...22-15 KGBAS L/R...22-15 KIGBA L/R...22(内径) | | |
| | | | | 1.50 | 3.5 | 0.75 | ● | ● | ● | ● | ● | ● | ● | ● | | | |
| | | | | 2.00 | 2.0 | 1.00 | ● | ● | ● | ● | ● | ● | ● | ● | ★2 | | |
| | | | | 2.50 | 2.50 | 1.25 | ● | ● | ● | ● | ● | ● | ● | ● | | | |
| | | | | 3.00 | 4.0 | 1.50 | ● | ● | ● | ● | ● | ● | ● | ● | KGBA R/L...22-35 KGBAS L/R...22-35 KIGBA L/R...22(内径) | | |
| | | | | 4.00 | 5.0 | 2.00 | | ● | ● | ● | ● | ● | ● | ● | | | |
| | | | | 1.00 | 2.0 | 0.50 | ● | ● | | | | | | | KGBA R/L...22-15 KGBAS L/R...22-15 KIGBA L/R...22(内径) | | |
| | | | | 1.50 | 3.5 | 0.75 | ● | ● | | | | | | | | | |
| | | | | 2.00 | 2.0 | 1.00 | ● | ● | | | | | | | ★2 | | |
| | | | | 2.50 | 2.50 | 1.25 | ● | ● | | | | | | | | | |
| | | | | 3.00 | 4.0 | 1.50 | ● | ● | | | | | | | KGBA R/L...22-35 KGBAS L/R...22-35 KIGBA L/R...22(内径) | | |
| | | | | 4.00 | 5.0 | 2.00 | | ● | | | | | | | | | |

B: 加工可能槽深

GBA43 R/L...RF为锋利刀尖规格

★适用刀杆型号

2: KGBA R/L...22-25T5, KGBAS L/R...22-25T5, KGBA R/L...22-25, KGBAS L/R...22-25, KIGBA L/R...22

| | | | | NEW | | | | | | | | | | | | | |
|--------------|-------|------|-----|-----------------|------|-----|--------|--------|--------|----------|--|--|--|---|--|--|--|
| | | | | P 炭素钢·合金钢 | | | | | | | | | | | | | |
| | | | | M 不锈钢 | | | | | | | | | | | | | |
| | | | | K 铸铁 | | | | | | | | | | | | | |
| | | | | N 有色金属 | | | | | | | | | | | | | |
| | | | | S 钛合金 | | | | | | | | | | | | | |
| | | | | H 高硬度材(40HRC以下) | | | | | | | | | | | | | |
| | | | | H 高硬度材(40HRC以上) | | | | | | | | | | | | | |
| 型号 | A | T | φd | 尺寸(mm) | | CBN | | | | PCD(金刚石) | | | | 适用刀杆型号 | | | |
| | | | | W | B | re | KBN510 | KBN525 | KPD001 | KPD010 | | | | | | | |
| GBA32 | 9.525 | 3.18 | 4.4 | 1.25 | 2.0 | 0.1 | | | | | | | | KGBA R/L...16 KGBAS R/L...16 KIGBA L/R...16(内径) | | | |
| GBA43 | 12.70 | 4.76 | 5.5 | 1.50 | 1.50 | 0.1 | | | | | | | | | | | |
| GBA43 R/L480 | 12.70 | 5.00 | 5.5 | 1.25 | 2.0 | 0.1 | ● | ● | ● | ● | | | | KGBA R/L...22-15 KGBAS L/R...22-15 KIGBA L/R...22(内径) | | | |
| | | | | 1.50 | 1.50 | 0.2 | ● | ● | ● | ● | | | | | | | |
| | | | | 2.00 | 2.00 | 0.1 | ● | ● | ● | ● | | | | ★2 | | | |
| | | | | 2.00 | 2.00 | 0.2 | ● | ● | ● | ● | | | | | | | |
| | | | | 2.50 | 2.50 | 0.1 | ● | ● | ● | ● | | | | ★2 | | | |
| | | | | 2.50 | 2.50 | 0.2 | ● | ● | ● | ● | | | | | | | |
| | | | | 3.00 | 3.00 | 0.1 | ● | ● | ● | ● | | | | ★2 | | | |
| | | | | 3.00 | 3.00 | 0.2 | ● | ● | ● | ● | | | | | | | |

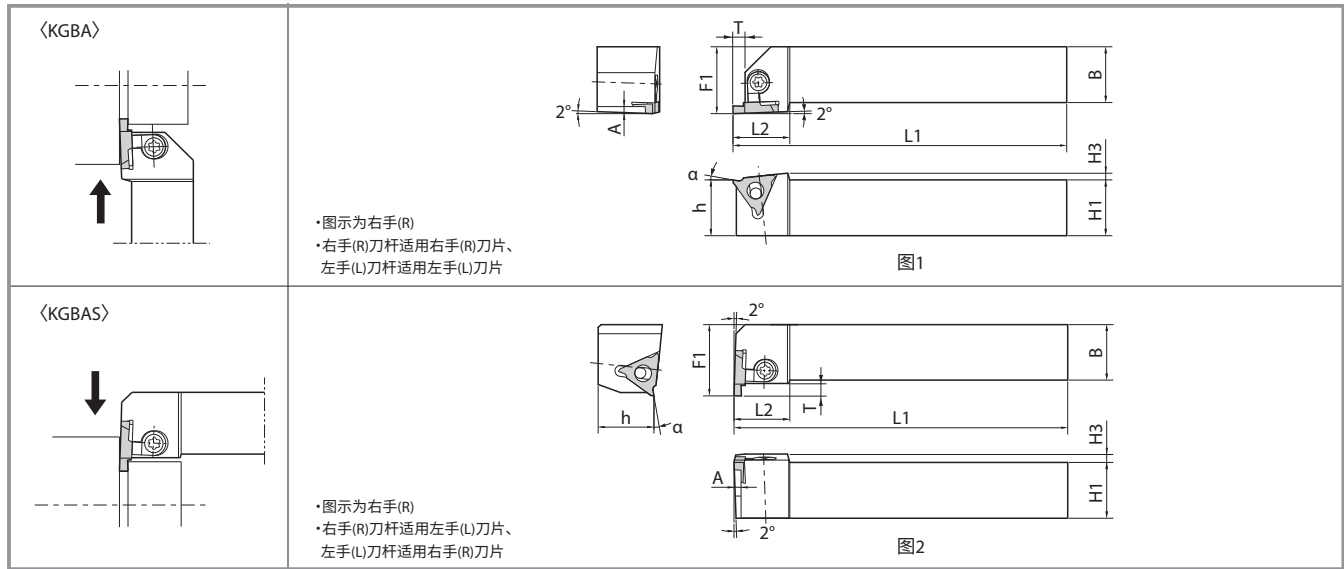
B: 加工可能槽深

★适用刀杆型号

2: KGBA R/L...22-25T5, KGBAS L/R...22-25T5, KGBA R/L...22-25, KGBAS L/R...22-25, KIGBA L/R...22

GBA刀片安装时的前角(α) (外径槽刀杆)

| GBA32 R/L○○○-○○○安装时 | | GBA43 R/L○○○-○○○安装时 | | GBA43 R/L○○○-○○○R(圆头)安装时 | |
|---------------------|---|---------------------|--|--------------------------|--|
| α | 刀片型号 | α | 刀片型号 | α | 刀片型号 |
| 10° | TN620,TN90,PV7040,PR930 PR1115,PR1215,PR905 KPD001,KPD010 | 0° | KBN510, KBN525 | 10° | TN620,TN90,PV7040,PR930 PR1115,PR1215,PR905 |
| | | 10° | TN620,TC40N,TN90,PV7040 PR930,PR1115,PR1215,PR905 KPD001, KPD010 | | TN620,TN90,PV7040,PR930 PR1115,PR1215,PR905 |
| 20° | KW10 | 20° | KW10 | 14° | TN620,TN90,PV7040,PR930 PR1115,PR1215,PR905 |
| | | | | | KW10 |



刀杆尺寸

| 型号 | 库存 | | 尺寸 (mm) | | | | | | | | | | 部品 | | 适用刀片 | | |
|-------------|--------------|-----|---------|-----|-----|-----|------|-----|-----|-----|----|--------------|-------|-------------|--------------|-------------|-------------|
| | R | L | H1=h | H3 | B | L1 | L2 | F1 | A | T | 形状 | 压板组 | 扳手 | | | | |
| KGBA R/L | 2020K-16 | ● ● | 20 | 4.0 | 20 | 125 | 24 | 25 | - | 2.5 | 图1 | LGBA-16 R/LS | FT-15 | GBA32 R/L规格 | | | |
| | 2525M-16 | ● ● | 25 | 4.0 | 25 | 150 | 25.5 | 30 | 1.0 | 4.0 | | | | | | | |
| | 2020K22-15 | ● ● | 20 | 4.0 | 20 | 125 | 25.5 | 25 | 2.0 | 4.5 | | | | | | | |
| | 2525M22-15 | ● ● | 25 | 4.0 | 25 | 150 | 25.5 | 30 | 3.0 | 5.5 | | LGBA-22 R/LS | | | GBA43 R/L规格 | | |
| | 2020K22-25 | ● ● | 20 | 4.0 | 20 | 125 | 25.5 | 25 | 2.0 | 4.5 | | | | | | | |
| | 2525M22-25 | ● ● | 25 | 4.0 | 25 | 150 | 25.5 | 30 | 3.0 | 5.5 | | | | | | | |
| | 2020K22-25T5 | ● ● | 20 | 4.0 | 20 | 125 | 25.5 | 25 | 2.0 | 4.5 | | 图2 | | | LGBA-22 L/RS | FT-15 | GBA43 L/R规格 |
| | 2525M22-25T5 | ● ● | 25 | 4.0 | 25 | 150 | 25.5 | 30 | 2.0 | 4.5 | | | | | | | |
| | 2020K22-35 | ● ● | 20 | 4.0 | 20 | 125 | 25.5 | 25 | 3.0 | 5.5 | | | | | | | |
| | 2525M22-35 | ● ● | 25 | 4.0 | 25 | 150 | 25.5 | 30 | 3.0 | 5.5 | | 图2 | | | LGBA-22 L/RS | FT-15 | GBA43 L/R规格 |
| 2020H22-15* | ● | | | | | | | 1.0 | 4.0 | | | | | | | | |
| 2020H22-25* | ● | | 20 | 4.0 | 20 | 100 | 25.5 | 25 | 2.0 | 4.5 | | | | | | | |
| 2020H22-35* | ● | | | | | | | 3.0 | 5.5 | | | | | | | | |
| KGBAS R/L | 2020K-16 | ● ● | 20 | 4.0 | 20 | 125 | 25 | 25 | - | 2.5 | 图2 | LGBA-16 L/RS | FT-15 | GBA32 L/R规格 | | | |
| | 2525M-16 | ● ● | 25 | 4.5 | 25 | 150 | 25 | 27 | 1.0 | 4.0 | | | | | | | |
| | 2020K22-15 | ● ● | 20 | 4.5 | 20 | 125 | 25 | 27 | 2.0 | 4.5 | | | | | | | |
| | 2525M22-15 | ● ● | 25 | 5.0 | 25 | 150 | 25 | 32 | 2.0 | 4.5 | | LGBA-22 L/RS | | | FT-15 | GBA43 L/R规格 | |
| | 2020K22-25 | ● ● | 20 | 4.5 | 20 | 125 | 25 | 27 | 2.0 | 4.5 | | | | | | | |
| | 2525M22-25 | ● ● | 25 | 5.0 | 25 | 150 | 25 | 32 | 2.0 | 4.5 | | | | | | | |
| | 2020K22-25T5 | ● ● | 20 | 4.5 | 20 | 125 | 25 | 27 | 2.0 | 4.5 | | 图2 | | | LGBA-22 L/RS | FT-15 | GBA43 L/R规格 |
| | 2525M22-25T5 | ● ● | 25 | 5.0 | 25 | 150 | 25 | 32 | 2.0 | 4.5 | | | | | | | |
| | 2020K22-35 | ● ● | 20 | 4.5 | 20 | 125 | 25 | 27 | 3.0 | 5.5 | | | | | | | |
| | 2525M22-35 | ● ● | 25 | 5.0 | 25 | 150 | 25 | 32 | 3.0 | 5.5 | | 图2 | | | LGBA-22 L/RS | FT-15 | GBA43 L/R规格 |
| 2020K22-35 | ● ● | 20 | 4.5 | 20 | 125 | 25 | 27 | 3.0 | 5.5 | | | | | | | | |
| 2525M22-35 | ● ● | 25 | 5.0 | 25 | 150 | 25 | 32 | 3.0 | 5.5 | | | | | | | | |

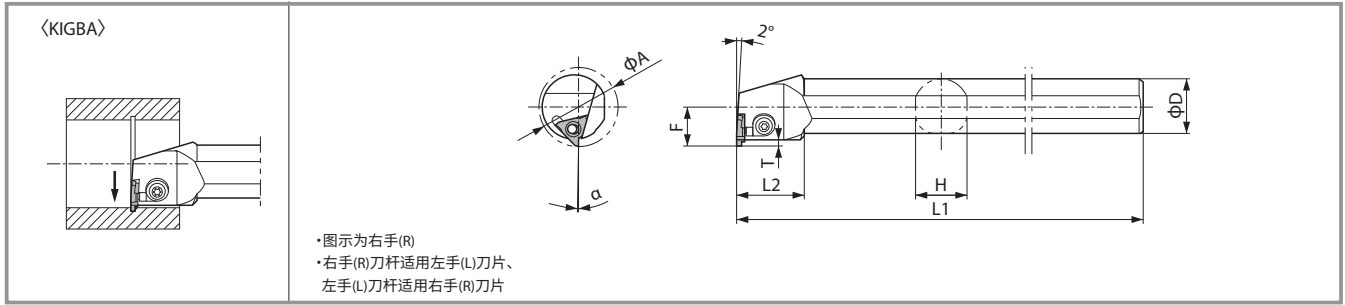
T: 刀杆面至刀尖为止的距离。实际加工可对应深度为刀片的B尺寸

压板组: KGBA R/L ... 右手(R)刀杆适用LGBA-○○RS、左手(L)刀杆适用LGBA-○○LS
KGBAS R/L ... 右手(R)刀杆适用LGBA-○○LS、左手(L)刀杆适用LGBA-○○RS

*表示短刀柄型
●: 标准库存

外径槽刀杆 KGBA的短柄规格系列化

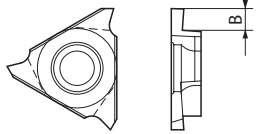
针对小型NC车床或HSK配刀、KGBAR2020K22-○○(全长125 mm)的短柄规格KGBAR2020H22-○○(全长100 mm)产品系列化。省去客户自己截断刀杆的麻烦



刀杆尺寸

| 型号 | 库存 | | 最小加工径 | 尺寸 (mm) | | | | | | | 零件 | | 适用刀片 | | |
|-------------------|----|---|-------|---------|----|-----|----|------|-----|----|-----|----|---------------|-------|--------------|
| | R | L | | φA | φD | H | L1 | L2 | F | *T | 压板组 | 扳手 | | | |
| KIGBA R/L 3525-16 | ● | ● | 35 | 25 | 23 | 220 | 30 | 17.5 | 2.8 | | | | LGBA-16 L/R S | FT-15 | GBA32 L/R 规格 |
| 4032-22 | ● | ● | 40 | 32 | 30 | 250 | 30 | 23.0 | 3.0 | | | | LGBA-22 L/R S | FT-15 | GBA43 L/R 规格 |

※T: 刀杆面至刀尖为止的距离
 加工可对应深度基于使用刀片的不同可能会有所不同
 KIGBA R/L 3525-16: 基于适用刀片(GBA32规格)的B尺寸
 4032-22: 适用刀片(GBA43规格)的B尺寸
 ① 2.0 mm (B < 2.8 mm时)
 ② 2.8 mm (B ≥ 2.8 mm时)



●: 标准库存

压板组: 右手(R)刀杆适用LGBA-○○LS、左手(L)刀杆适用LGBA-○○RS适用

GBA刀片安装时的前角(α)

| GBA32 R/L○○○-○○○安装时 | | GBA43 R/L○○○-○○○安装时 | | GBA43 R/L○○○-○○○R(圆头)安装时 | | |
|---------------------|--|---------------------|--|--------------------------|--|-------------|
| α | 刀片型号 | α | 刀片型号 | α | 刀片型号 | 圆头槽型号 |
| +1° | TN620,TN90,PV7040,PR930 PR1115,PR1215,PR905 KPD001, KPD010 | -9° | KBN510, KBN525 | +1° | TN620,TN90,PV7040,PR930 PR1115,PR1215,PR905 | 050R ~ 150R |
| | | +1° | TN620,TC40N,TN90,PV7040 PR930,PR1115,PR1215,PR905 KPD001, KPD010 | | | |
| +11° | KW10 | +11° | KW10 | +5° | TN620,TN90,PV7040,PR930 PR1115,PR1215,PR905 | 200R |
| | | | | | KW10 | 050R ~ 200R |

GBA-GM刀片安装时的前角(α)

| α | 刀片型号 |
|-----|--------------------|
| +1° | GBA43 R/L150-020GM |
| +6° | GBA43 R/L175-020GM |
| | GBA43 R/L265-030GM |
| +3° | GBA43 R/L300-030GM |
| | GBA43 R/L400-040GM |

α为刀片安装时的槽宽中央部前角

GBA-MY刀片安装时的前角(α)

| α | 刀片型号 |
|-----|--------------------|
| +6° | GBA43 R/L175-020MY |
| +5° | GBA43 R/L350-030MY |
| | GBA43 R/L400-040MY |

α为刀片安装时的槽宽中央部前角

推荐切削参数表 ★第1推荐 ☆第2推荐

GBA刀片(研磨断屑槽)

| 被加工材料 | 推荐刀片材质(切削速度 m/min) | | | | | | | | | | ①槽加工时的进给(mm/rev) ②横进给加工时的进给(mm/rev) ③ // 切深(mm) | | | | | 备注 |
|-------|--------------------|-------------|--------------|--------------|-------------|-------------|-------------|-------------|--------------|--------------|---|----------------------------------|--------------------------------------|--------------------------------------|--------------------------------------|--------------------------------------|
| | MC PV7040 | 金属陶瓷 | | | MEGA | PVD涂层 | | | 硬质合金 | CBN | PCD(金刚石) | GBA○○R/L 033-100-... | GBA○○R/L 125-200-... | GBA○○R/L 230-300-... | GBA○○R/L 330-400-... | |
| 炭素钢 | ☆ 150-240 | ★ 80-220 | ☆ 150-220 | ☆ 150-220 | ★ 80-200 | ☆ 80-180 | ☆ 80-180 | — | — | — | — | ①0.03-0.08 ②禁止横向进给 ③禁止横向进给 | ①0.04-0.09 ②0.04-0.09 ③Max.0.3 | ①0.05-0.1 ②0.05-0.1 ③Max.0.5 | ①0.05-0.12 ②0.05-0.1 ③Max.0.5 | ①0.05-0.12 ②0.05-0.1 ③Max.0.8 |
| 合金钢 | ☆ 130-220 | ★ 80-200 | ☆ 130-200 | ☆ 130-200 | ★ 80-180 | ☆ 80-160 | ☆ 80-160 | — | — | — | — | ①0.03-0.07 ②禁止横向进给 ③禁止横向进给 | ①0.04-0.08 ②0.04-0.08 ③Max.0.3 | ①0.05-0.09 ②0.05-0.09 ③Max.0.5 | ①0.05-0.1 ②0.05-0.1 ③Max.0.5 | ①0.05-0.1 ②0.05-0.1 ③Max.0.8 |
| 不锈钢 | — | — | — | ☆ 70-150 | ☆ 60-150 | ☆ 60-130 | ★ 60-130 | — | — | — | — | ①0.03-0.07 ②禁止横向进给 ③禁止横向进给 | ①0.04-0.08 ②0.04-0.08 ③Max.0.3 | ①0.05-0.09 ②0.05-0.09 ③Max.0.5 | ①0.05-0.1 ②0.05-0.1 ③Max.0.5 | ①0.05-0.1 ②0.05-0.1 ③Max.0.8 |
| 铸铁 | — | — | — | — | — | — | — | ★ 80-180 | ☆ 60-120 | ★ 150-400 | — | ①0.03-0.08 ②禁止横向进给 ③禁止横向进给 | ①0.04-0.09 ②0.04-0.09 ③Max.0.3 | ①0.05-0.1 ②0.05-0.1 ③Max.0.5 | ①0.05-0.12 ②0.05-0.1 ③Max.0.5 | ①0.05-0.12 ②0.05-0.1 ③Max.0.8 |
| 铝 | — | — | — | — | — | — | — | — | ★ 150-400 | — | ★ 150-2,000 | ①0.05-0.12 ②禁止横向进给 ③禁止横向进给 | ①0.05-0.15 ②0.05-0.15 ③Max.0.5 | ①0.05-0.15 ②0.05-0.15 ③Max.0.8 | ①0.08-0.15 ②0.08-0.15 ③Max.0.8 | ①0.08-0.15 ②0.08-0.15 ③Max.0.8 |
| 黄铜 | — | — | — | — | — | — | — | — | ★ 150-300 | — | ★ 200-800 | ①0.05-0.12 ②禁止横向进给 ③禁止横向进给 | ①0.05-0.15 ②0.05-0.15 ③Max.0.5 | ①0.05-0.15 ②0.05-0.15 ③Max.0.8 | ①0.08-0.15 ②0.08-0.15 ③Max.0.8 | ①0.08-0.15 ②0.08-0.15 ③Max.0.8 |
| 高硬度材 | — | — | — | — | — | — | — | — | — | ★ 80-120 | — | — | ①0.02-0.05 ②禁止横向进给 ③禁止横向进给 | ①0.03-0.07 ②0.01-0.04 ③Max.0.1 | — | — |

上述为外径槽加工的参数。内径槽加工时、切削速度·进给都请降低10%左右
MEGA为MEGACOAT
MC为MEGACOAT金属陶瓷

GBA刀片(GM断屑槽)

| 被加工材料 | 推荐刀片材质 (切削速度 m/min) | | ①槽加工时的进给(mm/rev) ②横进给加工时的进给(mm/rev) ③ // 切深(mm) | | | | | 备注 |
|--------------|------------------------|-------------|---|--------------------------------------|---------------------------------------|---------------------------------------|-------------------------------------|----|
| | 金属陶瓷 | MEGACOAT | GBA43 R/L 140-010GM | GBA43 R/L 150-020GM | GBA43 R/L 175-020GM - 230-020GM | GBA43 R/L 250-030GM - 350-030GM | GBA43 R/L 400-040GM | |
| 炭素钢(SxxC等) | ★ 80-240 | ☆ 80-220 | ①0.03-0.1 ②0.03-0.08 ③Max.0.2 | ①0.03-0.12 ②0.03-0.08 ③Max.0.3 | ①0.03-0.12 ②0.03-0.09 ③Max.0.3 | ①0.04-0.15 ②0.05-0.1 ③Max.0.5 | ①0.05-0.15 ②0.05-0.1 ③Max.0.8 | |
| 合金钢(SCM等) | ★ 80-220 | ☆ 80-200 | ①0.03-0.1 ②0.03-0.08 ③Max.0.2 | ①0.03-0.12 ②0.03-0.08 ③Max.0.3 | ①0.03-0.12 ②0.03-0.09 ③Max.0.3 | ①0.04-0.15 ②0.05-0.1 ③Max.0.5 | ①0.05-0.15 ②0.05-0.1 ③Max.0.8 | |
| 不锈钢(SUS304等) | — | ★ 60-150 | ①0.03-0.1 ②0.03-0.08 ③Max.0.2 | ①0.03-0.1 ②0.03-0.08 ③Max.0.3 | ①0.03-0.1 ②0.03-0.09 ③Max.0.3 | ①0.04-0.12 ②0.05-0.1 ③Max.0.5 | ①0.04-0.12 ②0.05-0.1 ③Max.0.8 | |

上述为外径槽加工的参数。内径槽加工时、切削速度、进给都请降低20%左右

GBA刀片(MY断屑槽)

| 被加工材料 | 推荐刀片材质(切削速度 m/min) | | | | | | | ①槽加工时的进给(mm/rev) ②横进给加工时的进给(mm/rev) ③ // 切深(mm) | | | | | 备注 |
|--------------|--------------------|---|-------------|-------------|-------------|------|-----|---|---------------------------------------|---------------------------------------|--------------------------------------|---------------------------------------|-------------------------------------|
| | 金属陶瓷 | | MEGA | PVD涂层 | | 硬质合金 | CBN | PCD(金刚石) | GBA43 R/L 175-020MY - 200-020MY | GBA43 R/L 230-020MY - 265-030MY | GBA43 R/L 300-030MY | GBA43 R/L 330-030MY - 350-030MY | |
| 炭素钢(SxxC等) | ☆ 150-220 | — | ★ 80-200 | ☆ 80-200 | ☆ 80-200 | — | — | — | ①0.03-0.08 ②0.03-0.08 ③Max.0.3 | ①0.04-0.09 ②0.04-0.09 ③Max.0.3 | ①0.05-0.1 ②0.05-0.1 ③Max.0.5 | ①0.05-0.12 ②0.05-0.1 ③Max.0.5 | ①0.05-0.12 ②0.05-0.1 ③Max.0.8 |
| 合金钢(SCM等) | ☆ 130-200 | — | ★ 80-180 | ☆ 80-180 | ☆ 80-180 | — | — | — | ①0.03-0.07 ②0.03-0.1 ③Max.0.3 | ①0.04-0.08 ②0.04-0.08 ③Max.0.3 | ①0.05-0.09 ②0.05-0.09 ③Max.0.5 | ①0.05-0.1 ②0.05-0.1 ③Max.0.5 | ①0.05-0.1 ②0.05-0.1 ③Max.0.8 |
| 不锈钢(SUS304等) | ☆ 70-150 | — | ☆ 60-150 | ☆ 60-150 | ★ 60-150 | — | — | — | ①0.03-0.07 ②0.03-0.1 ③Max.0.3 | ①0.04-0.08 ②0.04-0.08 ③Max.0.3 | ①0.05-0.09 ②0.05-0.09 ③Max.0.5 | ①0.05-0.1 ②0.05-0.1 ③Max.0.5 | ①0.05-0.1 ②0.05-0.1 ③Max.0.8 |

上述为外径槽加工的参数。内径槽加工时、切削速度·进给都请降低10%左右
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