





NEW

100 系列的扩展

高进给率的切槽槽型

EXTENSION TO SYSTEM 100

Grooving geometry for high feed rates



СВЕТЛО

不同之处： 更多可能

THE DIFFERENCE: MORE POSSIBILITIES

- **高进给的切槽切断槽型**
Geometry for grooving and parting off with high feed rates
- **安全的排屑,优化的铁屑控制**
Safe chip removal and optimal chip control
- **稳定的切削刃**
Stable cutting edge

切槽和切断

Grooving and Parting Off



刀片
Insert

S100

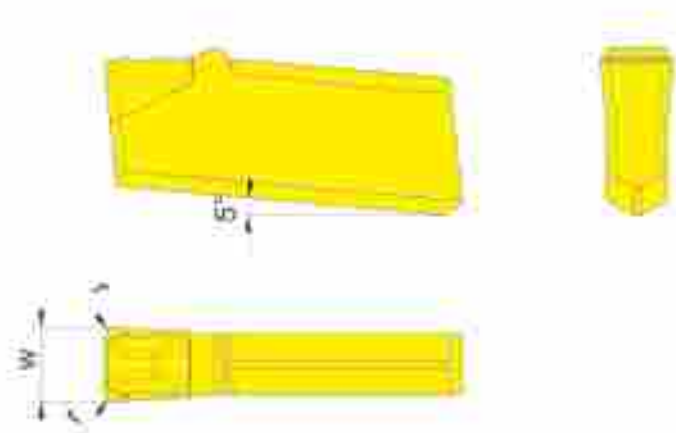
带卷屑器
with chip forming



| | | |
|----|-----------------|--------|
| 槽宽 | Width of groove | 3-4 mm |
|----|-----------------|--------|

配刀杆/刀夹
for Toolholder / Cassette

型号 H100
Type NK100...



| 产品型号 Part number | w | r | 尺寸规格 Size | IG6G |
|----------------------|---|-----|--------------|------|
| S100.0300.EH4 | 3 | 0.4 | 03 | ▲ |
| S100.0400.EH6 | 4 | 0.6 | 04 | ▲ |
| | | | | P ● |
| | | | | M ○ |
| | | | | K ○ |
| | | | | N - |
| | | | | S - |
| | | | | H - |

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

Indexable inserts can be used in right and left hand toolholders.

硬质合金牌号

Carbide grades

切槽和切断 (外圆)

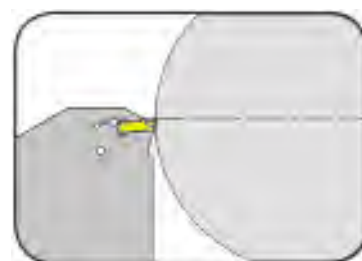
Grooving and Parting off (external)



刀夹
Cassette

NK100

842 接口
Interface 842



槽深可达
槽宽

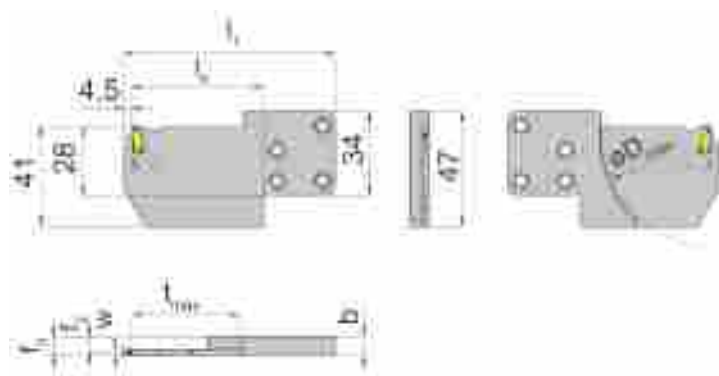
Depth of groove up to
Width of groove

34 mm
3-4 mm

直接冷却液供应
with through coolant supply

配合刀片
for Insert

型号 S100
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

| 产品型号 Part number | t_{max} | b | f_2 | f_3 | w | D_{max} | l_1 | l_K |
|-----------------------------------|-----------|-------|-------|-----------|---|-----------|-------|-------|
| R/LNK100.0842.Y.34.4.83.IK | 34 | 10.25 | 8.7 | $f_2+w/2$ | 3 | 68 | 86.5 | 46 |
| R/LNK100.0842.Y.34.4.84.IK | 34 | 10.55 | 8.7 | $f_2+w/2$ | 4 | 68 | 86.5 | 46 |

按需提供更多尺寸
Further sizes upon request

尺寸单位 : mm
Dimensions in mm

扳手P101.02不包含在刀板中，需单独订购！
Wrench P101.02 is not combined with tool holder - separate order required!

配件
Spare Parts

| 刀夹 Cassette | 销 Threaded Pin |
|----------------------------|-------------------|
| R/LNK100.0842.Y.34.4.83.IK | 1.6.04.913 |
| R/LNK100.0842.Y.34.4.84.IK | 2.03.913 |

切槽和切断 (外圆)

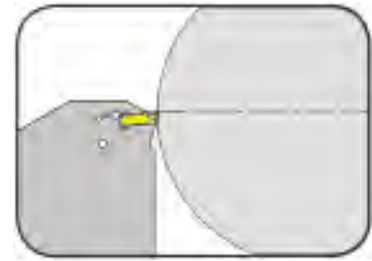
Grooving and Parting off (external)



刀夹
Cassette

NK100

845 接口
Interface 845



槽深可达
槽宽

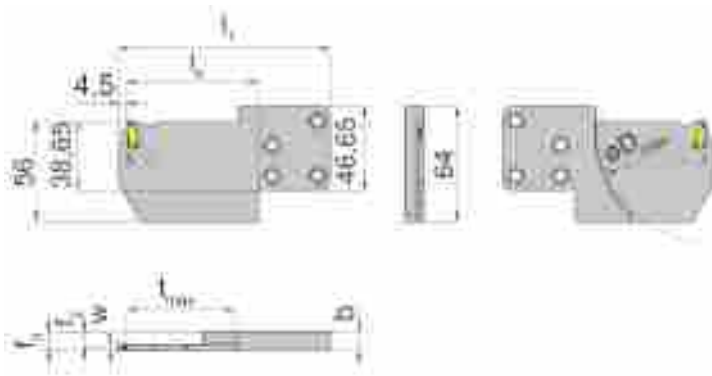
Depth of groove up to
Width of groove

60 mm
3-4 mm

直接冷却液供应
with through coolant supply

配合刀片
for Insert

型号 S100
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

| 产品型号 Part number | t_{max} | b | f_2 | f_3 | w | D_{max} | l_1 | l_k |
|----------------------------|-----------|-------|-------|-----------|---|-----------|-------|-------|
| R/LNK100.0845.Y.34.4.83.IK | 34 | 10.25 | 8.7 | $f_2+w/2$ | 3 | 68 | 90.5 | 46 |
| R/LNK100.0845.Y.34.4.84.IK | 34 | 10.55 | 8.7 | $f_2+w/2$ | 4 | 68 | 90.5 | 46 |
| R/LNK100.0845.Y.60.4.83.IK | 60 | 10.25 | 8.7 | $f_2+w/2$ | 3 | 120 | 117.5 | 73 |
| R/LNK100.0845.Y.60.4.84.IK | 60 | 10.55 | 8.7 | $f_2+w/2$ | 4 | 120 | 117.5 | 73 |


按需提供更多尺寸
Further sizes upon request

尺寸单位 : mm
Dimensions in mm

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Wrench P101.02 is not combined with tool holder - separate order required!

配件
Spare Parts

| 刀夹 Cassette | 销 Threaded Pin |
|---------------------|-------------------|
| R/LNK100.08...83.IK | 1.6.04.913 |
| R/LNK100.08...84.IK | 2.03.913 |

| 槽型 Geometry | 应用 Applications | 进给率 f (mm/U) Feed rate f (mm/rev) |
|--|---|--------------------------------------|
| .EH  | 切槽, 切断, 高进给率 Grooving and parting off, high feed rates | ↓ 0,25 - 0,4 mm |
| | | ↓ 切槽 Grooving |

提示 Hints

- 高进给切槽及切断, 需要稳定的机床及夹紧状态
 - 当切槽及切断进给率 > 0.3mm/r, 推荐在期初的3-4mm降低进给率
 - 将高进给刀具和刀夹作为Y轴切槽和切断的首选
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- High feed rates for grooving and parting off requires stable machine and clamping conditions
 - When grooving and parting off with feed rates > 0.30 mm/rev, it is recommended to reduce the feed rate for the first 3 - 4 mm grooving depth
 - Toolholders and cassettes for parting off in the Y axis are the first choice for parting off and grooving at high feed rates

