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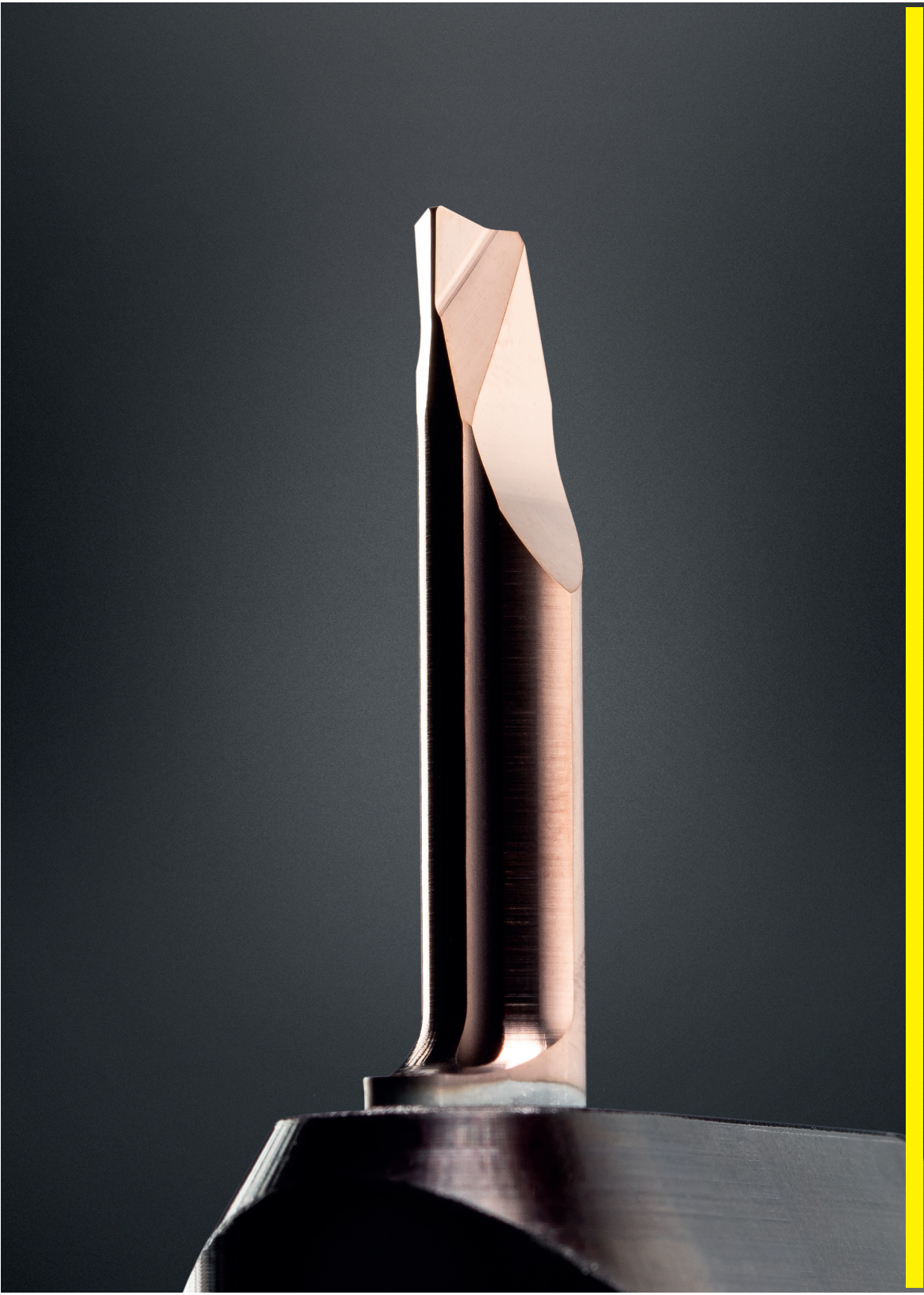
NEW

新硬质合金材质 SG3_

用于淬硬钢和难加工材料

NEW CARBIDE GRADE SG3_

The choice for machining hardened steel and difficult-to-machine materials



不同之处： 更多可能

THE DIFFERENCE: MORE POSSIBILITIES

- **使用带涂层的硬质合金进行硬加工, 最高可达58 HRC**
Hard machining up to 58 HRC with coated carbide
- **高效加工难加工材料**
Efficient machining of difficult-to-machine materials
- **内部涂层, 交货时间快**
Fast delivery times due to in-house coating

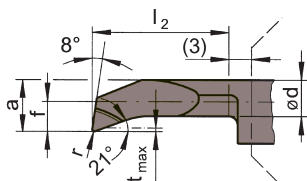
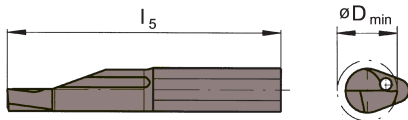
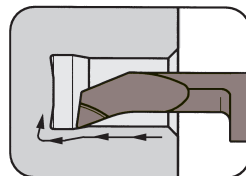
刀片
Insert

105

孔径 \varnothing 自

Bore \varnothing from

4 mm



配合刀杆
for Toolholder

型号 H105
Type HC105
B/BU105
VDI
B105C
B105TS
IR105
962
AIH
963
N

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	r	f	a	d	b	l_2	l_5	t_{max}	D_{min}	SC36
R/L105.1819.01.1.4F	0,10	1,9	3,7	2,9	6,4	10	25	0,3	4	▲/▲
R/L105.1819.01.2.4F	0,10	1,9	3,7	2,9	6,4	15	30	0,3	4	▲/▲
R/L105.1823.15.2.5F	0,15	2,3	4,7	4,0	7,0	15	30	0,5	5	▲/▲
R/L105.1823.15.3.5F	0,15	2,3	4,7	4,0	7,0	20	35	0,5	5	▲/▲

▲ 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

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

P	-
M	-
K	-
N	-
S	•
H	•

硬质合金牌号
Carbide grades

ISO	材料 Material	硬度 Brinell Hardness Brinell	进给率 f (mm/U) / Feed rate f (mm/rev)							
			Supermini®				Mini			
			MG12	EG55/35 ES15/1P	TH35*	AN25	IG35/36*	SG3_	DD25	DD25
P	碳钢 Carbon steel	C < 0,4%	125							
		C > 0,4% < 0,6 %	150	160 200 - 14	170 210 - 14	160 200 - 14				
		C > 0,4% < 0,6 %	200							
	低合金钢 low alloyed steel	退火 annealed	180							
		调质 quenched	275	140 180 - 16	160 200 - 16	160 200 - 16				
		调质 quenched	300							
	高合金钢 high alloyed steel	退火 annealed	200							
		调质 quenched	325	80 120 - 19	100 140 - 19	100 140 - 19				
	铸钢 Cast steel	非合金 unalloyed	180							
低合金 low alloyed		220	120 160 - 19	140 180 - 19	140 180 - 19					
高合金 high alloyed		225								
M	不锈钢 Stainless steel	马氏体, 铁素体 martensitic, ferritic	200	70 90 - 19			80 100 - 19			
		奥氏体 austenitic	180				70 80 - 16			
K	灰铸铁 Grey cast iron		180-260	120 160 - 16	120 160 - 16					
	球墨铸铁 Spheroidal graphite cast iron		180-260	100 140 - 16	120 160 - 18					
	可锻铸铁 Malleable cast iron		130-230	120 160 - 18	140 180 - 16					
S	耐热合金 Heat resistant alloy	NiFe				70 75 - 18	70 75 - 18			
		NiCo				35 40 - 18	35 40 - 18			
	Titan rein Titan pure	100				70 75 - 18				
	Titanlegierungen Titan alloys	266				70 75 - 18				
N	铝合金 Al-alloys		14-220					180 220 - 14		
	铜和黄铜合金类 Copper and brass alloys		14-220					180 220 - 14		
H	硬化材料 hardened material	> 54 HRC					50 60 - 30			

v_c 决定于刀具直径和机床的最大转速。
 v_c is depending on the tool diameter and therefore of the maximum numbers of revolutions of the machine.

如果没有合适的, 请使用 T125 或 T126

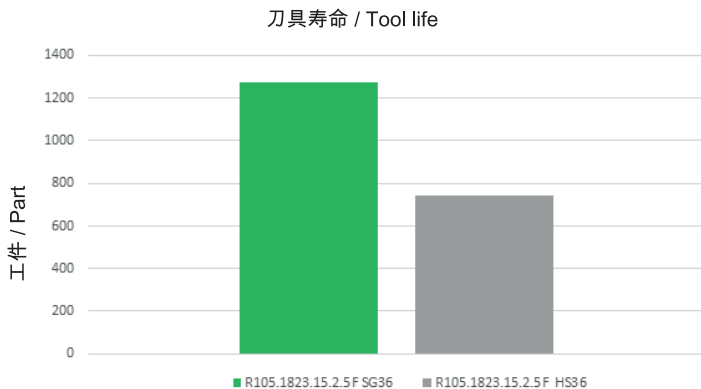
* If not available, please use T125 or T126

刀具寿命

工件: 管类零件
 机床: Traub TNL 32
 工件材质: 1.3505 (100Cr6) 56-58RC
 冷却: 干式
 v_c (m/min): 60
 f (mm/U): 0,02
 a_p (mm): 0,03

Tool life

Part: Sleeve
 Machine: Traub TNL 32
 Material: 1.3505 (100Cr 6) 56-58RC
 Coolant: dry
 v_c (m/min): 60
 f (mm/U): 0,02
 a_p (mm): 0,03

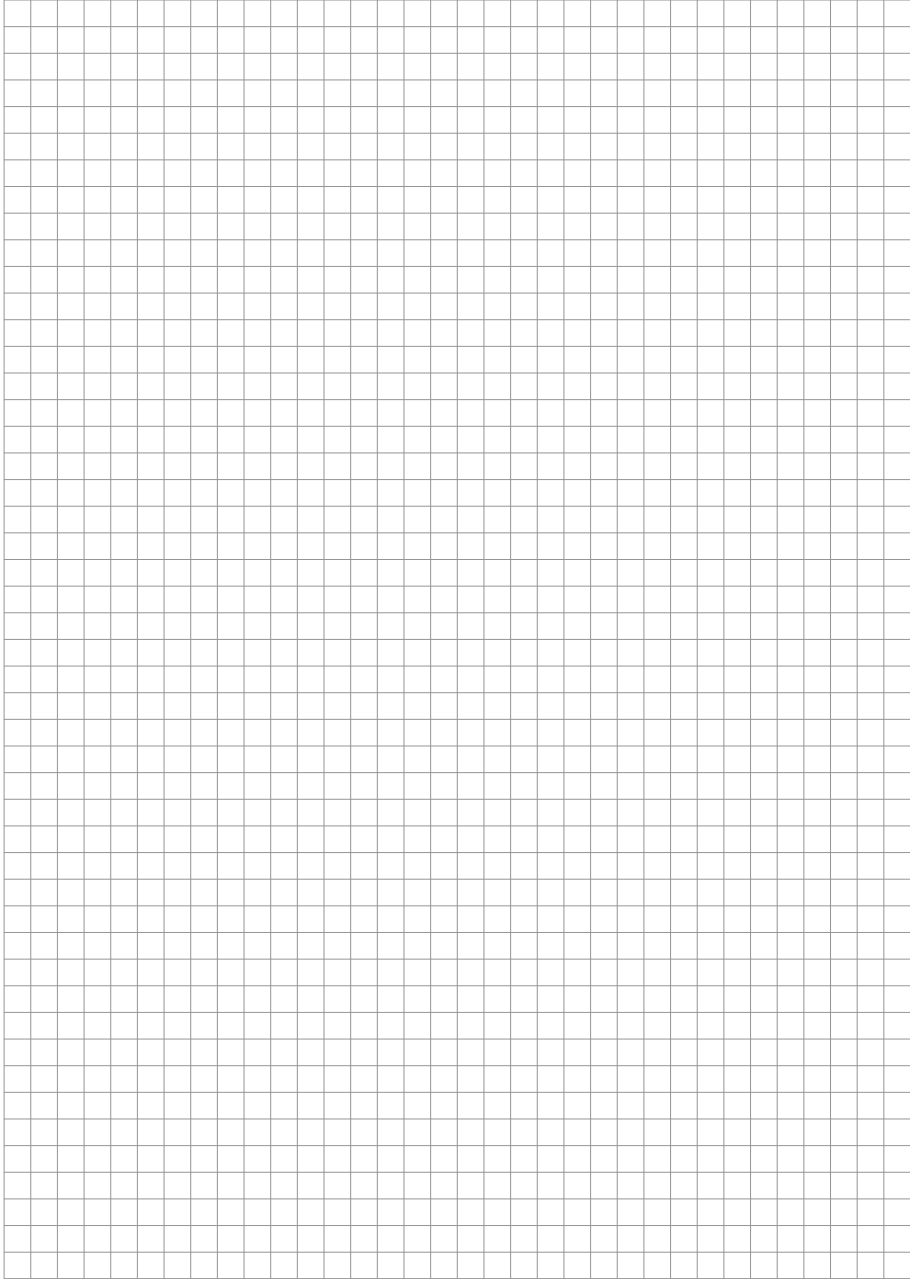


SG3_硬质合金牌号的其他应用范围

- 铣削超级双相钢
- 旋风铣5级钛合金
- 铣槽5级钛合金
- 各种钛合金的轴向槽加工
- 用Supermini进行硬车削(56 HRC)
- 硬车

Further applications of the SG3_ carbide grade

- Milling Super Duplex
- Whirling of titanium grade 5
- Slot milling in titanium grade 5
- Face grooving in various titanium alloys
- Hard turning with Supermini (56 HRC)
- Hard turning





找到您合适的刀具解决方案.

FIND YOUR RIGHT
TOOLING SOLUTION NOW.

www.PHorn.de

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