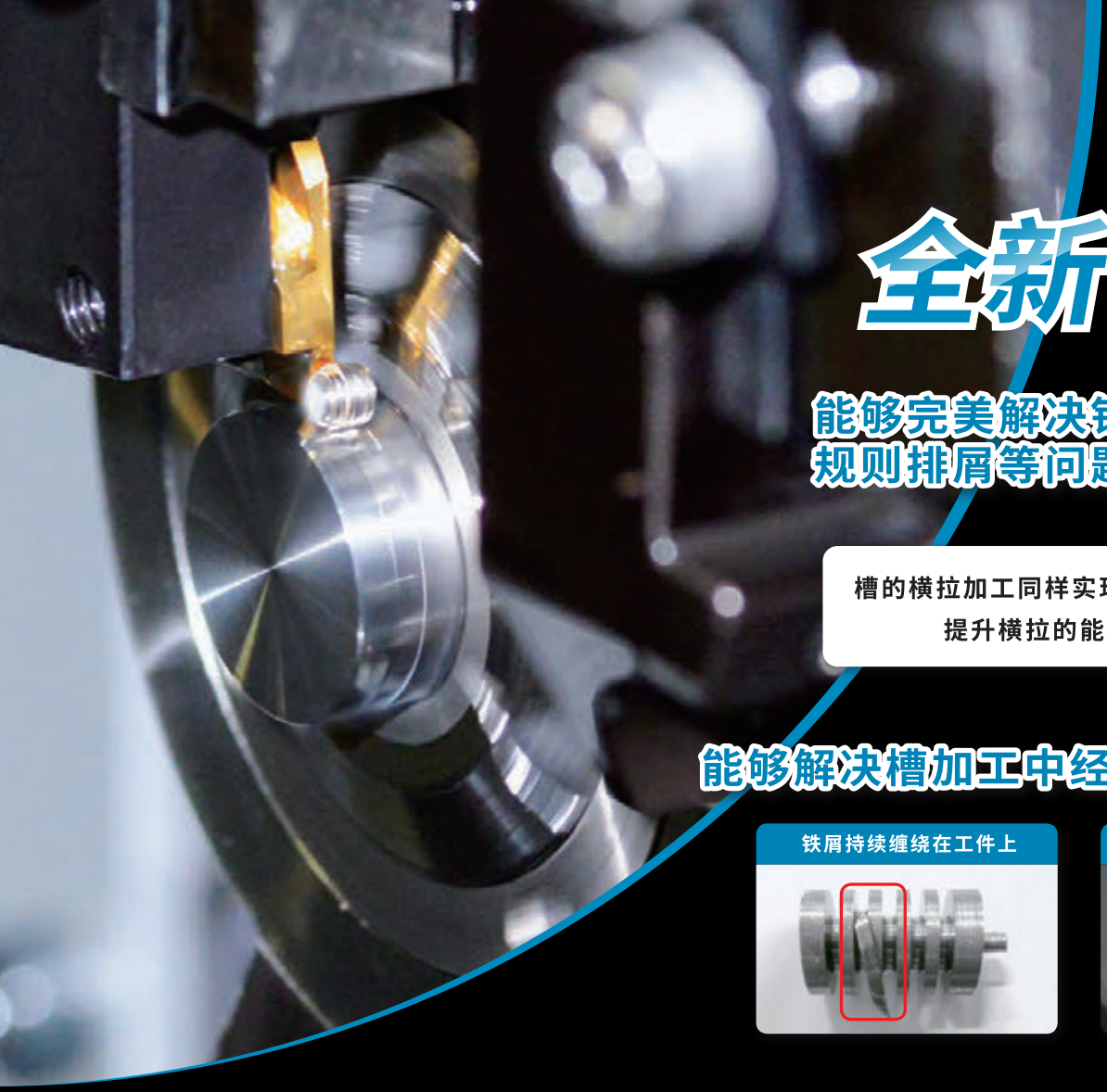
NTK CUTTING TOOLS

全新

切槽加工解决方案

小型自动车床用槽加工刀具

GX排屑槽



全新 切槽加工解决方案

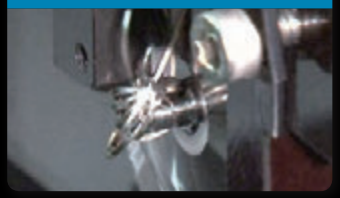
能够完美解决铁屑缠绕以及不规则排屑等问题

槽的横拉加工同样实现**良好**的精加工表面
提升横拉的能力至**2.0**mm

能够解决槽加工中经常出现的问题！

铁屑持续缠绕在工件上

形成不规则的铁屑



排屑槽的比较

GTMH-GX

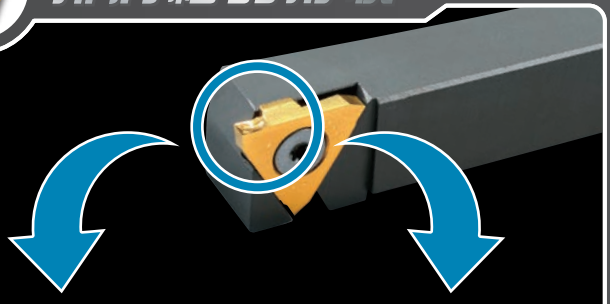
不会发生卷屑

其他公司的槽刀

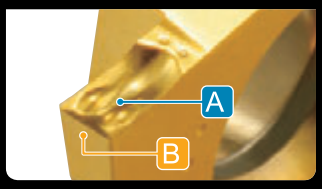
发生卷屑

【切削条件】 加工材：S45C
Vc = 80m/min
f =0.05mm/rev
刀片：DM4 GTMH32075RGX

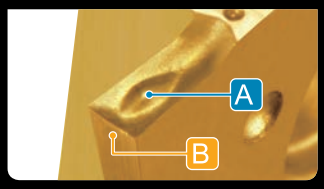
排屑槽的形状



刀片宽度 1.5mm~ 的排屑槽形状



刀片宽度 ~1.0mm 的排屑槽形状



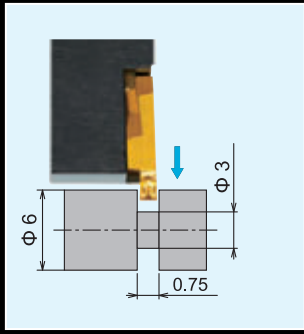
A.独立设计3次元排屑槽
纵向进给，横向进给均可实现切屑卷曲半径缩小，获得优秀的加工表面。

B.外表面四周研磨级别规格
强度较高的后角和研磨级别的表面实现较高加工品质。
实现有效抑制毛刺的发生和获得稳定的加工寿命。

切屑的比较

切槽加工(E环加工的假想)

切屑卷曲半径小 稳定的切屑排出

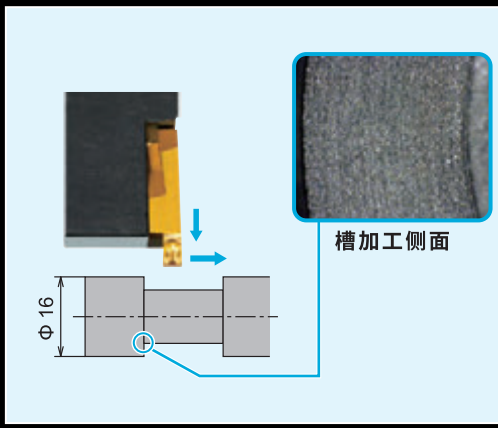


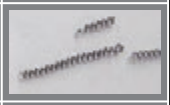
	进给 (mm/rev)		
	0.01	0.03	0.05
GTMH-GX			
其他公司的槽刀			

被削材:SUS304 Vc =80m/min ar =1.5mm 槽宽:0.75mm

横拉加工

可完美对应横扫加工 出色的切屑处理能力



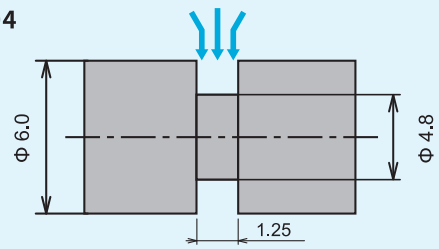
切深(mm)	进给(mm/rev)			
	0.01	0.03	0.05	0.08
0.25				
0.5				
1.5				

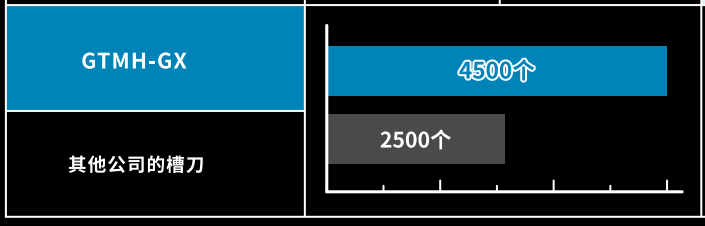
被削材:SUS304 Vc =80m/min 槽宽:0.75mm

加工实用例

	GTMH-GX	其他公司的槽刀
切削速度 (mm/min)	80	←
进给 (mm/rev)	0.02	←
切深 (mm)	0.6	←
切削油	湿式	←

SUS304

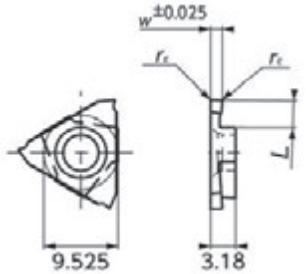




GTMH-GX 拥有良好的切屑处理能力，槽侧面和底面的加工面光洁度良好。并且具有良好的尺寸稳定性能，比其他公司同类产品寿命提高1.8倍。

适用刀片

形状	型号		尺寸(mm) W	L	rε	有效加工深度	横向加工时最大切深量	PVD图层硬质合金 TM4	DM4
对应横拉加工	GTMH32	075R GX	0.75	2.0	0.05	1.6	0.75	●	●
		095R GX	0.95	2.0	0.05	1.6	1.50	●	●
		100R GX	1.00	2.0	0.05	1.6	1.50	●	●
		100R GX01	1.00	2.0	0.1	1.6	1.50	●	●
		150R GX	1.50	3.0	0.05	2.7	2.00	●	●
		150R GX01	1.50	3.0	0.1	2.7	2.00	●	●
		150R GX02	1.50	3.0	0.2	2.7	2.00	●	●
		200R GX	2.00	3.0	0.05	2.7	2.00	●	●
		200R GX01	2.00	3.0	0.1	2.7	2.00	●	●
		200R GX02	2.00	3.0	0.2	2.7	2.00	●	●
		300R GX	3.00	3.0	0.05	2.7	2.00	●	●
		300R GX02	3.00	3.0	0.2	2.7	2.00	●	●

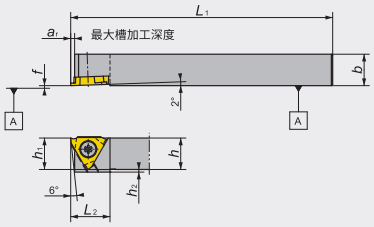


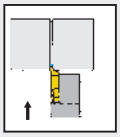
● 图示为右手刀

适用刀杆

GTT型

表里共同拧紧





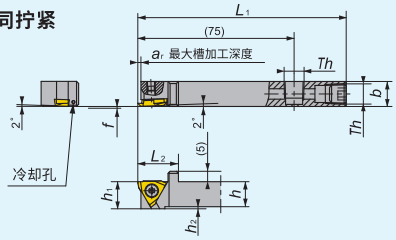
图—1

● 图示为右手刀

GTT-OH型 内部给油式*

表里共同拧紧

Th:螺纹规格
1012刀杆：M6
□12刀杆：Rc1/8 (PT1/8)
□16刀杆：Rc1/8 (PT1/8)

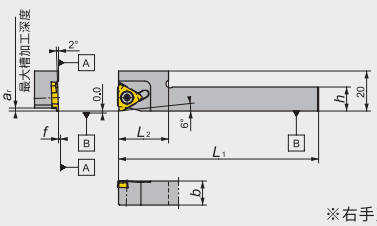


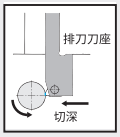
图—2

● 图示为右手刀

Y-GTT型

表里共同拧紧
Y轴刀杆





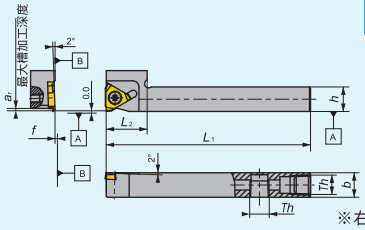
图—3

● 图示为右手刀
※右手刀杆使用右手刀片

Y-GTT-OH型 内部给油式*

表里共同拧紧

Th:螺纹规格
Rc1/8 (PT1/8)

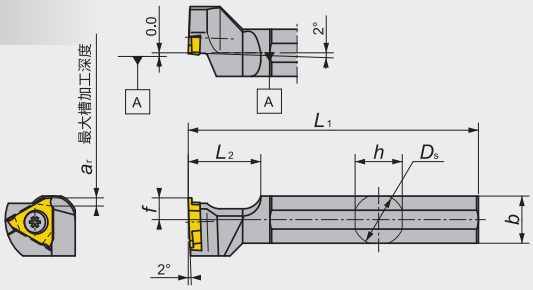


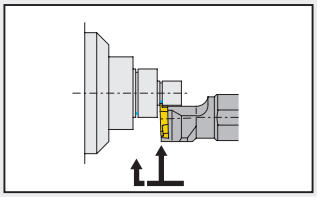
图—4

● 图示为右手刀
※右手刀杆使用右手刀片

DS-GTT型

DS刀杆

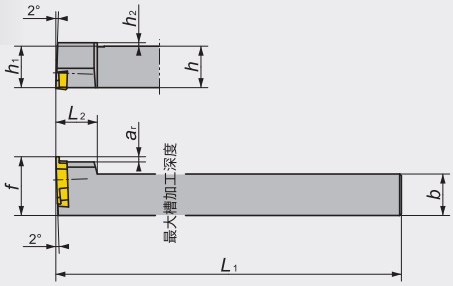


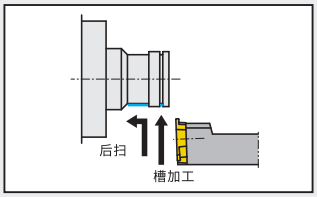


图—5

● 图示为左手刀
※左手刀杆使用右手刀片

CH-GTT型



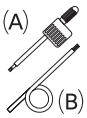


图—6

● 图示为左手刀
※左手刀杆使用右手刀片

*内部冷却用的连接部件，连接方法请参考产品目录的相关内容填写

刀杆尺寸

刀杆样式	槽宽 W (mm)	刀杆型号		在库 R	在库 L	尺寸(mm) h	b	L_1	h_1	f	L_2	a_2	h_2	D_s	部品 螺丝	部品 扳手
																
图-1	0.3~3.00	GTT$^{R}/_{L}$	08 F00	●	●	8	8	80	8	0	15	1.6	5	—	右手刀:LR-S-4 * 10PW(A) 左手刀:LR-S-4 * 5.8(B)	CLR-15S(A)
			08 K00	●	●	8	8	120	8	0	15	1.6	5	—		
			0810 F00	●		8	10	80	8	0	15	1.6	5	—	LR-S-4 * 10PW(A)	
			0810 K00	●		8	10	120	8	0	15	1.6	5	—		
			10 F00	●	●	10	10	80	10	0	15	1.6	3	—		
			10 K00	●	●	10	10	120	10	0	15	1.6	3	—		
			12 F00	●	●	12	12	80	12	0	15	1.6	1	—		
			12 K00	●	●	12	12	120	12	0	15	1.6	1	—		
			16 H00	●	●	16	16	100	16	0	15	1.6	0	—		
			16 K00	●	●	16	16	120	16	0	15	1.6	0	—		
			20 K00	●	●	20	20	125	20	0	15	2.7	0	—		
			25 M00	●	●	25	25	150	25	0	15	2.7	0	—		
	1.45~3.00	GTT$^{R}/_{L}$	10 F15	●	●	10	10	80	10	0	15	2.7	3	—		
			10 K15	●	●	10	10	120	10	0	15	2.7	3	—		
			12 F15	●	●	12	12	80	12	0	15	2.7	1	—		
			12 K15	●	●	12	12	120	12	0	15	2.7	1	—		
			16 H15	●	●	16	16	100	16	0	15	2.7	0	—		
			16 K15	●	●	16	16	120	16	0	15	2.7	0	—		
	2.5~3.00	GTT$^{R}/_{L}$	10 F25	●	●	10	10	80	10	0	15	2.7	3	—		
			10 K25	●	●	10	10	120	10	0	15	2.7	3	—		
			12 F25	●	●	12	12	80	12	0	15	2.7	1	—		
			12 K25	●	●	12	12	120	12	0	15	2.7	1	—		
			16 H25	●	●	16	16	100	16	0	15	2.7	0	—		
			16 K25	●	●	16	16	120	16	0	15	2.7	0	—		
图-2	0.3~3.00	GTT$^{R}/_{L}$	1012 H00-OH	●		10	12	100	10	0	19.5	1.6	1	—	LR-S-4 * 10PW(A)	CLR-15S(A)
			12 H00-OH	●		12	12	100	12	0	19.5	1.6	1	—		
			16 H00-OH	●		16	16	100	16	0	19.5	1.6	0	—		
图-3	0.3~3.00	Y-GTT$^{R}/_{L}$	10 S	●		10	10	120	—	0	20	1.6	—	—	LR-S-4 * 10PW(A)	CLR-15S(A)
			12 S	●		12	12	120	—	0	20	1.6	—	—		
图-4	0.3~3.00	Y-GTTR	12 H00S-OH	●		12	12	100	12	0	20	1.6	—	—	LR-S-4 * 10PW(A)	CLR-15S(A)
			16 H00-OH	●		16	16	100	16	0	25	1.6	—	—		
图-5	0.3~3.00	DS-GTT$^{R}/_{L}$	14 F		●	13	13	80	—	6	20	1.6	—	14.000	LR-S-4 * 9(B)	RLR-20S(B)
			15 H		●	15	15	100	—	6	20	1.6	—	15.875		
			16 X		●	15	15	95	—	6	20	1.6	—	16.000		
			19		●	18	18	120	—	6	20	1.6	—	19.050		
			20		●	19	19	120	—	6	20	1.6	—	20.000		
			22		●	21	21	120	—	6	20	1.6	—	22.000		
			25		●	24	24	120	—	10	20	1.6	—	25.400		
图-6	0.3~3.00	CH-GTT$^{R}/_{L}$	10 H00		●	10	10	100	10	15	12	1.5	3	—	LR-S-4 * 9(B)	RLR-20S(B)
			12 H00		●	12	12	100	12	17	12	1.5	1	—		