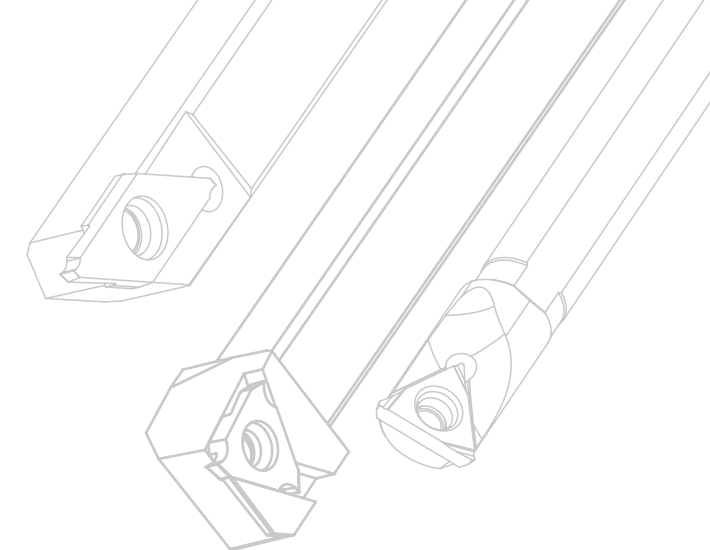




小零件样本册

Small part machining catalog

国内销售服务电话
Domestic Sales Hotline
0731-22673808(数控) (CNC cutting tools)
0731-22673988(锯齿) (Saw tips)

国际销售服务电话
International Sales Hotline
0086-731-27577393

株洲欧科亿数控精密刀具股份有限公司

OKE Precision Cutting Tools Co., Ltd.

总部地址:湖南省株洲市炎陵县中小企业创业园创业路(PC.412500)

Head Office Add: Chuangye Rd, Chuangye Park for SMEs, Yanling County, Zhuzhou, Hunan, China.

分公司地址:湖南省株洲市芦淞区创业四路8号(P.C.412008)

Branch Office Add: #8, Chuangye Rd, Lusong Area, Zhuzhou, Hunan, China.

株洲欧科亿切削工具有限公司

OKE CUTTING TOOLS CO., LTD

子公司地址: 株洲市天元区马家河街道金龙社区马家河路588号

Branch Office Add: 501, Bldg 6, Xinma Innovation Park, 899 Xianyuehuan Rd, Zhuzhou, Hunan, China

电话(Tel): 0731-22673968 传真(Fax): 0731-22673961

邮箱(E-mail): oke_info@oke-carbide.com info@oke-carbide.com(销售)

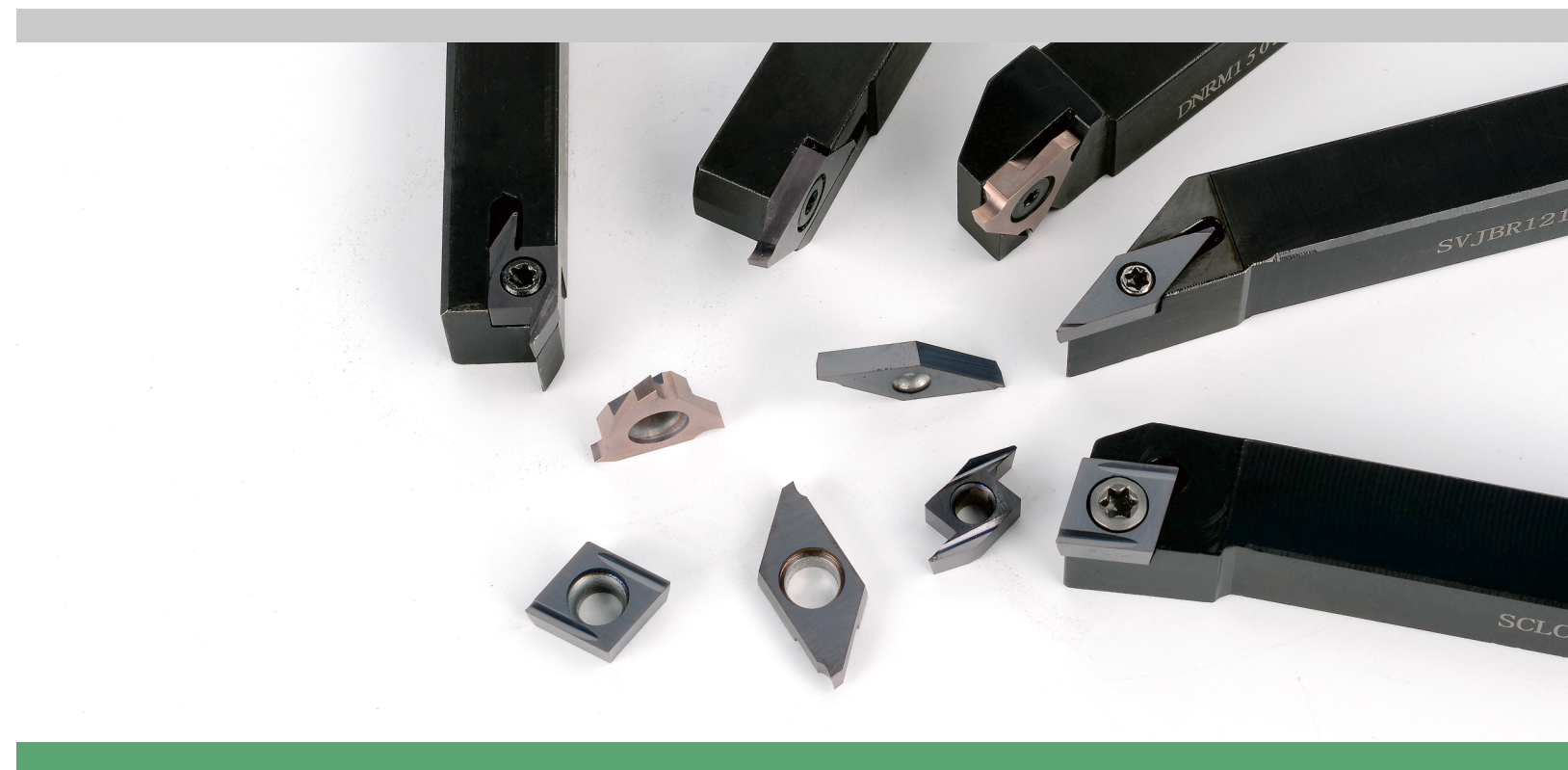
官方网站(Web): www.oke-carbide.com



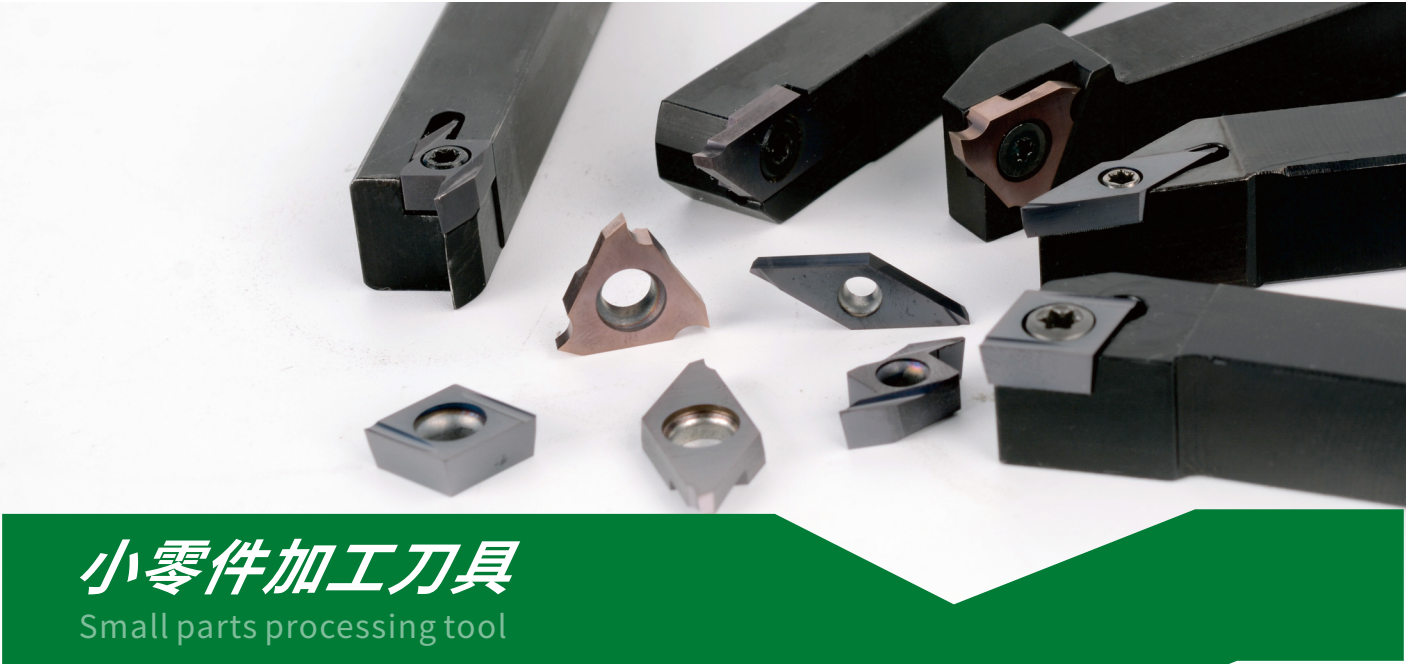
官网 | website



微信公众号 | Wechat



株洲欧科亿数控精密刀具股份有限公司
OKE PRECISION CUTTING TOOLS CO., LTD



小零件加工刀具

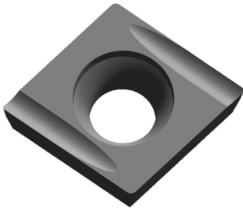
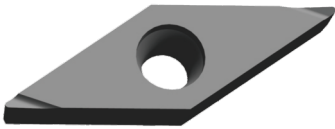
Small parts processing tool

前扫刀具 Front turning tool

精密小零件加工；
4种类型刀具(前扫、后扫、切断、切槽)；
产品性能稳定,用于自动化加工。
Precise small parts processing;
Four types of tools(front turning, back turning, cut-off, grooving);
The products have stable performance and are used for automatic processing.

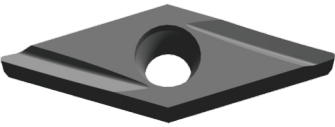
JF槽型 JF chipbreaker

切屑处理能力更好,适用于小切深,进给偏大的加工工况；
切削效果优异获得良好的工件表面质量。
GJF chipbreakerood chip breaking ability, suitable for small cutting depth and large feed;
Excellent cutting effect achieves good workpiece surface quality.



JY槽型 JY chipbreaker

宽的断屑槽可以保证切削流畅排除；
优秀的切屑处理能力可以提高刀具寿命以及切屑性能。
The wide chip breaker can ensure the smooth discharge of chips;
Excellent chip breaking ability can improve tool life and cutting performance.

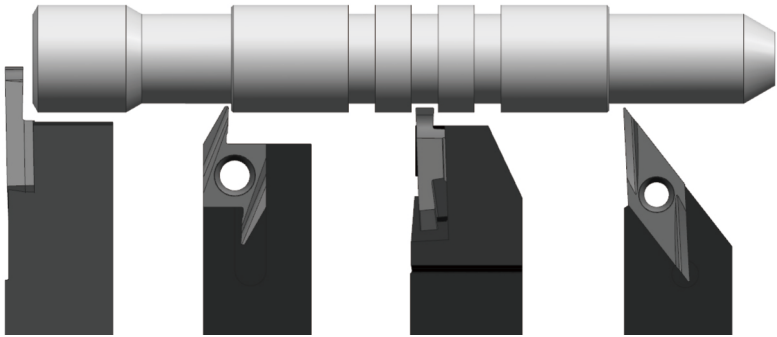
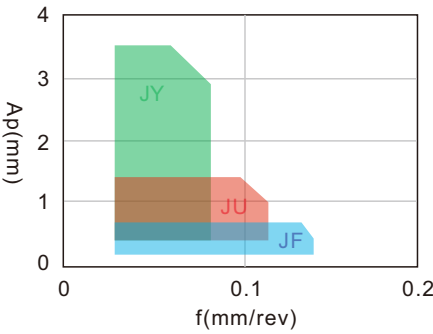


JU槽型 JU chipbreaker

刃口锋利切削阻力小可用于细长轴加工；
切削刃长,最大切深4mm,加工效率高,可以满足“一刀切”的需求。
Sharp cutting edge and small cutting resistance can be used for machining slender shafts;
Long cutting edge, 4mm maximum cutting depth, and high machining efficiency can meet the requirement of "one size fits all"

推荐加工参数

Recommended processing parameters



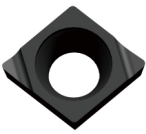
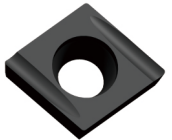
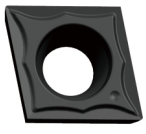
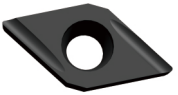
后扫刀具 Back turning tool

图片及外观 Picture and appearance	型号 Type	刀尖半径RE Tool tip radius	推荐加工范围 Recommended processing range
	ABS15R4005 ABS15R4015	0.05 0.15	
	ABW15R4005 ABW15R4015	0.05 0.15	

切断切槽刀具 Cut-off and grooving tool

切断刀 (TKF系列) Cut-off tool (TKF series)	切槽刀 (GBA系列) Grooving tool (GBA series)	切槽刀 (TGF系列) Grooving tool (TGF series)
-切削宽度: Cutting width 最大加工直径: Max. machining diameter	-切削宽度: Cutting width 最大切深: Max. cutting depth	-切削宽度: Cutting width 最大切深: Max. cutting depth
0.5-2 16	1.25-4.5 5	0.5-2.5 2.5
刀尖R角: Tool tip radius	刀尖R角: Tool tip radius	刀尖R角: Tool tip radius
0.03、0.05	0.1、0.2、0.3、0.4	0.1

前扫系列常备库存表 Front turning series stock list

刀片外形 Insert Shape	型号 Type	尺寸 Dimension					P/M
		LE	IC	S	D1	RE	OP1305
	CCGT030101R/L-JF	1	3.5	1.37	1.9	0.1	●
	CCGT030102R/L-JF	1	3.5	1.37	1.9	0.2	●
	CCGT030104R/L-JF	1	3.5	1.37	1.9	0.4	●
	CCGT040101R/L-JF	1	4.3	1.77	2.3	0.1	●
	CCGT040102R/L-JF	1	4.3	1.77	2.3	0.2	●
	CCGT040104R/L-JF	1	4.3	1.77	2.3	0.4	●
	CCGT0602003R/L-JU	2.5	6.35	2.38	2.8	0.03	○
	CCGT0602005R/L-JU	2.5	6.35	2.38	2.8	0.05	○
	CCGT060201R/L-JU	2.5	6.35	2.38	2.8	0.1	●
	CCGT060202R/L-JU	2.5	6.35	2.38	2.8	0.2	●
	CCGT060204R/L-JU	2.5	6.35	2.38	2.8	0.4	○
	CCGT09T3003R/L-JU	4	9.525	3.97	4.4	0.03	○
	CCGT09T3005R/L-JU	4	9.525	3.97	4.4	0.05	●
	CCGT09T301R/L-JU	4	9.525	3.97	4.4	0.1	●
	CCGT09T302R/L-JU	4	9.525	3.97	4.4	0.2	●
	CCGT09T304R/L-JU	4	9.525	3.97	4.4	0.4	●
	CCGT060201-JGQ	4	6.35	2.38	2.8	0.1	●
	CCGT060202-JGQ	4	6.35	2.38	2.8	0.2	●
	CCGT060204-JGQ	4	6.35	2.38	2.8	0.4	●
	CCGT09T301-JGQ	4	9.525	3.97	4.4	0.1	●
	CCGT09T302-JGQ	4	9.525	3.97	4.4	0.2	●
	CCGT09T304-JGQ	4	9.525	3.97	4.4	0.4	●
	DCGT0702003R/L-JU	2.5	6.35	2.38	2.8	0.03	○
	DCGT0702005R/L-JU	2.5	6.35	2.38	2.8	0.05	○
	DCGT070201R/L-JU	2.5	6.35	2.38	2.8	0.1	●
	DCGT070202R/L-JU	2.5	6.35	2.38	2.8	0.2	●
	DCGT070204R/L-JU	2.5	6.35	2.38	2.8	0.4	●
	DCGT11T3003R/L-JU	4	9.525	3.97	4.4	0.03	○
	DCGT11T3005R/L-JU	4	9.525	3.97	4.4	0.05	○
	DCGT11T301R/L-JU	4	9.525	3.97	4.4	0.1	●
	DCGT11T302R/L-JU	4	9.525	3.97	4.4	0.2	●
	DCGT11T304R/L-JU	4	9.525	3.97	4.4	0.4	●

● 有标准库存 ○ 请确认库存
● We have standard stock ○ Please confirm the stock

前扫系列常备库存表 Front turning series stock list

刀片外形 Insert Shape	型号 Type	尺寸 Dimension					P/M
		LE	IC	S	D1	RE	OP1305
	DCGT0702003R/L-JF	1	6.35	2.38	2.8	0.03	○
	DCGT0702005R/L-JF	1	6.35	2.38	2.8	0.05	○
	DCGT070201R/L-JF	1	6.35	2.38	2.8	0.1	●
	DCGT070202R/L-JF	1	6.35	2.38	2.8	0.2	●
	DCGT070204R/L-JF	1	6.35	2.38	2.8	0.4	●
	DCGT11T3003R/L-JF	1	9.525	3.97	4.4	0.03	○
	DCGT11T3005R/L-JF	1	9.525	3.97	4.4	0.05	○
	DCGT11T301R/L-JF	1	9.525	3.97	4.4	0.1	●
	DCGT11T302R/L-JF	1	9.525	3.97	4.4	0.2	●
	DCGT11T304R/L-JF	1	9.525	3.97	4.4	0.4	●
	DCGT0702003R/L-JJ	2.5	6.35	2.38	2.8	0.03	○
	DCGT0702005R/L-JJ	2.5	6.35	2.38	2.8	0.05	○
	DCGT070201R/L-JJ	2.5	6.35	2.38	2.8	0.1	●
	DCGT070202R/L-JJ	2.5	6.35	2.38	2.8	0.2	●
	DCGT070204R/L-JJ	2.5	6.35	2.38	2.8	0.4	●
	DCGT11T3003R/L-JJ	4	9.525	3.97	4.4	0.03	○
	DCGT11T3005R/L-JJ	4	9.525	3.97	4.4	0.05	○
	DCGT11T301R/L-JJ	4	9.525	3.97	4.4	0.1	●
	DCGT11T302R/L-JJ	4	9.525	3.97	4.4	0.2	●
	DCGT11T304R/L-JJ	4	9.525	3.97	4.4	0.4	●
	DCGT070201-JCK	1	6.35	2.38	2.8	0.1	●
	DCGT070202-JCK	1	6.35	2.38	2.8	0.2	●
	DCGT070204-JCK	1	6.35	2.38	2.8	0.4	●
	DCGT11T301-JCK	1	9.525	4.76	4.4	0.1	●
	DCGT11T302-JCK	1	9.525	4.76	4.4	0.2	●
	DCGT11T304-JCK	1	9.525	4.76	4.4	0.4	●
	DCGT070201-JGQ	4	6.35	2.38	2.8	0.1	●
	DCGT070202-JGQ	4	6.35	2.38	2.8	0.2	●
	DCGT070204-JGQ	4	6.35	2.38	2.8	0.4	●
	DCGT11T301-JGQ	4	9.525	3.97	4.4	0.1	●
	DCGT11T302-JGQ	4	9.525	3.97	4.4	0.2	●
	DCGT11T304-JGQ	4	9.525	3.97	4.4	0.4	●

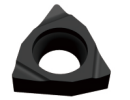
● 有标准库存 ○ 请确认库存
● We have standard stock ○ Please confirm the stock

前扫系列常备库存表 Front turning series stock list

刀片外形 Insert Shape	型号 Type	尺寸 Dimension					P/M
		LE	IC	S	D1	RE	OP1305
	VBGT1103003R/L-JF	1	6.35	3.18	2.8	0.03	○
	VBGT1103005R/L-JF	1	6.35	3.18	2.8	0.05	○
	VBGT110301R/L-JF	1	6.35	3.18	2.8	0.1	●
	VBGT110302R/L-JF	1	6.35	3.18	2.8	0.2	●
	VBGT110304R/L-JF	1	6.35	3.18	2.8	0.4	●
	VCGT1103003R/L-JF	1	6.35	3.18	2.8	0.03	○
	VCGT1103005R/L-JF	1	6.35	3.18	2.8	0.05	○
	VCGT110301R/L-JF	1	6.35	3.18	2.8	0.1	●
	VCGT110302R/L-JF	1	6.35	3.18	2.8	0.2	●
	VCGT110304R/L-JF	1	6.35	3.18	2.8	0.4	●
	VPET1103003R/L-JF	1	6.35	3.18	2.8	0.03	○
	VPET1103005R/L-JF	1	6.35	3.18	2.8	0.05	○
	VPET110301R/L-JF	1	6.35	3.18	2.8	0.1	●
	VPET110302R/L-JF	1	6.35	3.18	2.8	0.2	●
	VPET110304R/L-JF	1	6.35	3.18	2.8	0.4	●
	VBGT1103003R/L-JY	1.5	6.35	3.18	2.8	0.03	○
	VBGT1103005R/L-JY	1.5	6.35	3.18	2.8	0.05	○
	VBGT110301R/L-JY	1.5	6.35	3.18	2.8	0.1	●
	VBGT110302R/L-JY	1.5	6.35	3.18	2.8	0.2	●
	VBGT110304R/L-JY	1.5	6.35	3.18	2.8	0.4	●
	VCGT1103003R/L-JY	1.5	6.35	3.18	2.8	0.03	○
	VCGT1103005R/L-JY	1.5	6.35	3.18	2.8	0.05	○
	VCGT110301R/L-JY	1.5	6.35	3.18	2.8	0.1	●
	VCGT110302R/L-JY	1.5	6.35	3.18	2.8	0.2	●
	VCGT110304R/L-JY	1.5	6.35	3.18	2.8	0.4	●
	VPGT110301-JCK	1	6.45	3.18	2.8	0.1	●
	VPGT110302-JCK	1	6.45	3.18	2.8	0.2	●
	VPGT110304-JCK	1	6.45	3.18	2.8	0.4	●
	VCGT110301-JCK	1	6.45	3.18	2.8	0.1	●
	VCGT110302-JCK	1	6.45	3.18	2.8	0.2	●
	VCGT110304-JCK	1	6.45	3.18	2.8	0.4	●

● 有标准库存 ○ 请确认库存
● We have standard stock ○ Please confirm the stock

前扫系列常备库存表 Front turning series stock list

刀片外形 Insert Shape	型号 Type	尺寸 Dimension					P/M
		LE	IC	S	D1	RE	OP1305
	VBGT110301-SE	1	6.35	3.18	2.8	0.1	●
	VBGT110302-SE	1	6.35	3.18	2.8	0.2	●
	VBGT110304-SE	1	6.35	3.18	2.8	0.4	●
	VNGG160401-SE	4	9.525	4.76	3.81	0.1	●
	VNGG160402-SE	4	9.525	4.76	3.81	0.2	●
	VNGG160404-SE	4	9.525	4.76	3.81	0.4	●
	WBG060101R/L-JF	1	3.97	1.59	2.3	0.1	●
	WBG060102R/L-JF	1	3.97	1.59	2.3	0.2	●
	WBG060104R/L-JF	1	3.97	1.59	2.3	0.4	●
	TBGT060101R/L	1	3.97	1.59	2.3	0.1	●
	TBGT060102R/L	1	3.97	1.59	2.3	0.2	●
	TBGT060104R/L	1	3.97	1.59	2.3	0.4	●
	TPGH080201R/L-F	1	4.76	2.38	2.3	0.1	●
	TPGH080202R/L-F	1	4.76	2.38	2.3	0.2	●
	TPGH080204R/L-F	1	4.76	2.38	2.3	0.4	●
	TPGH090201R/L-F	1	5.56	2.38	3.2	0.1	●
	TPGH090202R/L-F	1	5.56	2.38	3.2	0.2	●
	TPGH090204R/L-F	1	5.56	2.38	3.2	0.4	●
	TPGH110302R/L-F	1	6.35	3.18	3.3	0.2	●
	TPGH110304R/L-F	1	6.35	3.18	3.3	0.4	●
	TPGH110302R/L-JU	2.5	6.35	3.18	3.2	0.2	●
	TNGG160401R/L-JS	1	9.525	4.76	3.81	0.1	●
	TNGG160402R/L-JS	1	9.525	4.76	3.81	0.2	●
	TNGG160404R/L-JS	1	9.525	4.76	3.81	0.4	●
	TNGG160401-SE	2	9.525	4.76	3.81	0.1	●
	TNGG160402-SE	2	9.525	4.76	3.81	0.2	●
	TNGG160404-SE	2	9.525	4.76	3.81	0.4	●

● 有标准库存 ○ 请确认库存
● We have standard stock ○ Please confirm the stock

浅槽系列常备库存表 Shallow grooving stock list

刀片外形 Insert Shape	型号 Type		尺寸 Dimension					P/M
			IC	S	D1	RE	CW	CDX OP1305
	GBA43R/L	125-010	12.7	4.76	5.5	0.1	1.25	●
		125-020				0.2	1.3	●
		130-020					1.35	●
		135-020					1.4	●
		140-020					1.45	●
		145-020					1.5	●
		150-010				0.1	1.55	●
		150-020				0.2	1.6	●
		155-020					1.65	●
		160-020					1.7	●
		165-020					1.75	●
		170-020					1.8	●
		175-020					1.85	●
		180-020					1.9	●
		185-020					1.95	●
		190-020					2	●
		195-020				0.2	2.05	●
		200-010					2.1	●
		200-020					2.15	●
		205-020					2.2	●
		210-020					2.25	●
		215-020					2.3	●
		220-020					2.35	●
		225-020					2.4	●
		230-020					2.45	●
		235-020				0.1	2.5	●
		240-020				0.3	2.55	●
		245-020					2.6	●
		250-010					2.65	●
		250-030					2.7	●
		255-030					2.75	●
		260-030					2.8	●
		265-030					2.85	●
		270-030					2.9	●
		275-030					2.95	●
		280-030				0.1	3	●
		285-030					3.05	●
		290-030						●
		295-030						●
		300-010						●
		300-030						●
		305-030						●

可接受定制不同圆弧的产品

● 有标准库存 ○ 请确认库存
● We have standard stock ○ Please confirm the stock

浅槽系列常备库存表 Shallow grooving stock list

刀片外形 Insert Shape	型号 Type		尺寸 Dimension						P/M						
			IC	S	D1	RE	CW	CDX	OP1305						
	GBA43R/L	310-030	12.7	4.76	5.5	0.3	3.1	1.2	●						
		315-030					3.15		●						
		320-030					3.2		●						
		325-030					3.25		●						
		330-030					3.3		●						
		335-030					3.35		●						
		340-030					3.4		●						
		345-030					3.45		●						
		350-010				0.1	3.5		●						
		350-030				0.3	3.55		●						
		355-030					3.6		●						
		360-030					3.65		●						
		365-030					3.7		●						
		370-030					3.75		●						
		375-030					3.8		●						
		380-030					3.85		●						
		385-030					3.9		●						
		390-030					3.95		●						
		395-030					0.1		4	●					
		400-010					0.4		4.05	●					
		400-040							4.1	●					
		405-040				4.15			●						
		410-040				4.2			●						
		415-040				4.25			●						
		420-040				4.3			●						
		425-040				4.35			●						
		430-040				4.4			●						
		435-040				4.45			●						
		440-040				4.5			●						
		445-040				4.55			●						
		450-040				4.6			●						
		455-040				4.65			●						
		460-040				4.7			●						
		465-040				4.75			●						
		470-040				4.8			●						
		475-040													
		480-040													
						TGF32R/L	033-005					0.05	0.33	1.2	●
							050-005						0.5		●
							070-010						0.7		●
							075-010						0.75		●
							080-010						0.8		●

● 有标准库存 ○ 请确认库存
● We have standard stock ○ Please confirm the stock

浅槽系列常备库存表 Shallow grooving stock list

刀片外形 Insert Shape	型号 Type		尺寸 Dimension						P/M
			IC	S	D1	RE	CW	CDX	OP1305
	TGF32R/L	085-010	9.525	3.18	4.4	0.1	0.85	2.0	●
		090-010					0.9		●
		095-010					0.95		●
		100-010					1		●
		105-010					1.05		●
		110-010					1.1		●
		115-010					1.15		●
		120-010					1.2		●
		125-010					1.25		●
		130-010					1.3		●
		135-010					1.35		●
		140-010					1.4		●
		145-010					1.45		●
		150-010					1.5		●
		155-010					1.55		●
		160-010					1.6		●
		165-010					1.65		●
		170-010					1.7		●
		175-010					1.75		●
		180-010					1.8		●
		185-010					1.85		●
		190-010					1.9		●
		195-010					1.95		●
		200-010					2		●
		205-010					2.05		●
		210-010					2.1	2.5	●
		215-010					2.15		●
		220-010					2.2		●
		225-010					2.25		●
		230-010					2.3		●
		235-010					2.35		●
		240-010					2.4		●
		245-010					2.45		●
		250-010					2.5		●

● 有标准库存 ○ 请确认库存
● We have standard stock ○ Please confirm the stock

切断系列常备库存表 Cut-off series stock list

刀片外形 Insert Shape	型号 Type		尺寸 Dimension						角度 PSIRR	P/M
			CW	CDX	RE	W1	S	D1		OP1305
	TKF12R/L	050-S	0.5	2.8	0.03	3	8.7	5	1°	●
		070-S	0.7	4.3						●
		100-S	1	6.3						●
		125-S	1.25							●
		150-S	1.5							●
		200-S	2							●
	TKF12R/L	050-S-16DR	0.5	2.8	0.03	3	8.7	5	15°	●
		070-S-16DR	0.7	4.3						●
		100-S-16DR	1	6.3						●
		125-S-16DR	1.25							●
		150-S-16DR	1.5							●
		200-S-16DR	2							●
	TKF16R/L	150-S	1.5	8.4	0.05	4	9.5	5	1°	●
		200-S	2							●
		●								
	TKF16R/L	150-S-16DR	1.5	8.4	0.05	4	9.5	5	15°	●
		●								
		200-S-16DR	2							●
		●								

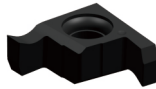
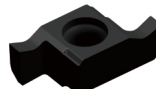
● 有标准库存 ○ 请确认库存
● We have standard stock ○ Please confirm the stock

后扫刀系列常备库存表 Back turning series stock list

刀片外形 Insert Shape	型号 Type		尺寸	P/M
			RE	OP1305
	ABS	15R4005	0.05	●
		15R4010	0.1	●
		15R4015	0.15	●
		15R4020	0.2	●
	ABW	15R4005	0.05	●
		15R4010	0.15	●
		15R4015	0.15	●
		15R4020	0.15	●

● 有标准库存 ○ 请确认库存
● We have standard stock ○ Please confirm the stock

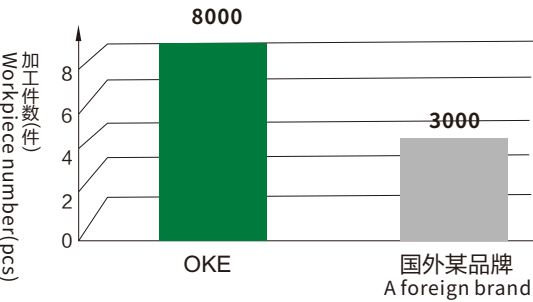
内径槽刀系列常备库存表 Inner Dia. Grooving series stock list

刀片外形 Insert Shape	型号 Type		尺寸 Dimension					P/M	
			CW	CDX	RE	S	D1	OP1305	
	GER/L	100-005B	1	2.2	0.05	3.18	2.7	●	
		120-005B	1.2					●	
		125-005B	1.25					●	
		145-010B	1.45					●	
		150-010B	1.5		0.1			●	
		200-010B	2					●	
		250-020B	2.5					●	
		300-020B	3					●	
	GER/L	100-005C	1	2.5	0.05	4.05	3.1	●	
		120-005C	1.2					●	
		125-005C	1.25					●	
		140-005C	1.4					●	
		145-010C	1.45		0.1			●	
		150-010C	1.5					●	
		170-010C	1.7					●	
		185-010C	1.85					●	
		195-010C	1.95					●	
		200-010C	2					●	
		250-020C	2.5		0.2			●	
		300-020C	3					●	
		350-020C	3.5					●	
								●	
	GER/L	100-005D	1	2.5	0.05	5.05	3.6	●	
		140-005D	1.4					●	
		145-010D	1.45		3			0.1	●
		150-010D	1.5						●
		170-010D	1.7	●					
		185-010D	1.85	●					
		195-010D	1.95	●					
		200-010D	2	●					
		225-010D	2.25	3.2	0.2				●
		230-020D	2.3						●
		250-020D	2.5						●
		275-020D	2.75						●
		280-020D	2.8					●	
		300-020D	3					●	
		330-020D	3.3					●	
		350-020D	3.5					●	
		400-020D	4	●					
				4.5					●

● 有标准库存 ○ 请确认库存
● We have standard stock ○ Please confirm the stock

切削案例 1
Cutting case 1

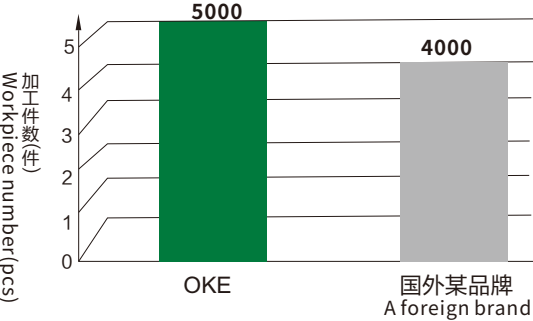
被加工材料 Workpiece material	SUS316L
刀具信息 Tool/insert	ABS15R4015/OP1305 VBGT110302R-XX
冷却方式 Cooling	油冷 Oil cooling
失效形式 Failure mode	表面质量变化 Surface quality change
切削参数 Cutting parameter	Vc=100m/min Fz=0.05mm/rev Ap=0.1mm



- 使用OKE产品有效改善了刀具的补刀情况, 确保产品加工后尺寸精度, 加工寿命达到原产品的2.5倍。
- The use of OKE products effectively improves the filling of the tool, ensures the dimensional accuracy of the product after processing, and the processing life reaches 2.5 times that of the original product.

切削案例 2
Cutting case 2

被加工材料 Workpiece material	40Cr
刀具信息 Tool/insert	TGF32R100-010/OP1305 TGF32R100-010
冷却方式 Cooling	油冷 Oil cooling
失效形式 Failure mode	刀具磨损 Tool wear
切削参数 Cutting parameter	Vc=100m/min Fz=0.04mm/rev Ap=2mm



- OKE产品刃口更锋利, 加工时刀具振动更小, 产品加工寿命更好。
- The cutting edge of OKE products is sharper, the tool vibration is smaller during processing, and the product processing life is better.