

责任铸就卓越  
Obligation Keeps Excellence



## 2018 新品介绍

*New products introduction*

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

地址(总部): 湖南省株洲市炎陵县中小企业创业园创业路(P.C.412500)

(分公司): 湖南省株洲市芦淞区创业四路8号(P.C.412008)

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

(Branch Office): #8, Chuangye Rd, Lusong area, Zhuzhou, Hunan, China.

电话(Tel): 0731-22673810 22673893 0731-22673895 (English speaking)

传真(fax): 0731-22673970

邮箱(E-mail): Info@oke-carbide.com

网址(Wed): www.oke-carbide.com



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

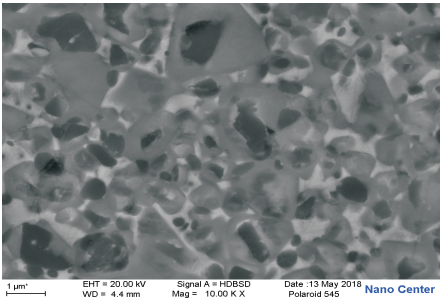


金属陶瓷新牌号  
Cemet Grade

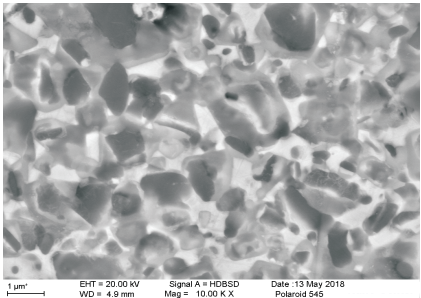
► 牌号及性能 Grade & Features

金属陶瓷牌号 Cemet Grade

| 牌号<br>Grade | 硬度<br>Hardness<br>(HRA) | 抗弯强度<br>Strength<br>(N/mm <sup>2</sup> ) | 比重<br>Density<br>(g/cm <sup>3</sup> ) | 断裂韧性<br>Fracture toughness<br>(MPa·m <sup>1/2</sup> ) | ISO分类<br>ISO classification | 特性<br>Features                                                                                                                            | 推荐用途<br>Recommended applications                                                                                                                  |
|-------------|-------------------------|------------------------------------------|---------------------------------------|-------------------------------------------------------|-----------------------------|-------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------|
| OK6110      | 91.7                    | 2000                                     | 7.2                                   | 8.0                                                   | P05-P25                     | 耐磨性和韧性兼备的一款材质，车削类刀具第一推荐牌号。<br>A material with both abrasive resistance and toughness, It's the first recommended grade for turning tools. | 适合于碳钢、合金钢精--半精加工。<br>It's suitable for semi-finishing and finish of carbon steel, alloy steel.                                                    |
| OK6120      | 90.8                    | 1800                                     | 7.1                                   | 8.8                                                   | P15-P30<br>M15-M25          | 具有优良的韧性和抗热冲击性能，同时具有较好的耐磨损性能。<br>It has good toughness, thermal shock resistance and wear resistance.                                      | 用于钢件车、铣削加工，尤其适合于不稳定工况下对韧性要求较高场合的应用。<br>It's suitable for turning and milling of steel, especially for applications where requires high toughness. |



OK6110 SEM照片



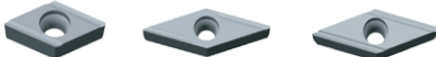
OK6120 SEM照片

涂层金属陶瓷 Coated Cemet

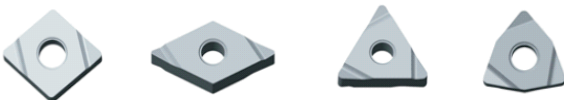
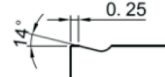
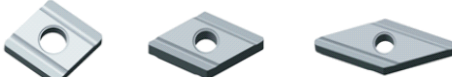
| 牌号<br>Grade | 基本特性 Physical properties |                                          |                                       | 涂层 Coating              |            | ISO分类<br>ISO classification | 特性<br>Features                                                                                                                                                                                                                               | 推荐用途<br>Recommended applications                                                                                                                                                           |
|-------------|--------------------------|------------------------------------------|---------------------------------------|-------------------------|------------|-----------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
|             | 硬度<br>Hardness<br>(HRA)  | 抗弯强度<br>Strength<br>(N/mm <sup>2</sup> ) | 比重<br>Density<br>(g/cm <sup>3</sup> ) | 主要成分<br>Main components | 厚度<br>(μm) |                             |                                                                                                                                                                                                                                              |                                                                                                                                                                                            |
| OP6110C     | 91.7                     | 2000                                     | 7.2                                   | TiCN                    | 2-3        | P05-P20<br>M05-M20          | 强韧化金属陶瓷基体上施加抗磨损性与抗积屑瘤性能优异的PVD涂层，相较于未涂层金属陶瓷刀片具有更好的综合性能。<br>On the matrix of toughened metal ceramics, which apply PVD coating with excellent wear resistance and build-up resistance, better overall performance than uncoated cemet inserts. | 适用于高效率和高表面质量钢件车削加工，也适合于不锈钢的车削加工。<br>It's suitable for turning processing of high efficiency and high surface quality steel parts, also suitable for turning processing of stainless steel. |

► 车削刀片槽型 Description Of Chip Breaker

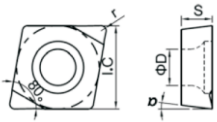
正角刀片 Positive Inserts

| 槽形代码<br>Geometry code | 刃口形状<br>Chip breaker shape                                                        | 推荐切削用量<br>Recommend<br>cutting parameters          | 槽形特点<br>Features of chip breaker                                                                                                                                                                                                                                                                  |
|-----------------------|-----------------------------------------------------------------------------------|----------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| -JHF                  |  | Ap=0.01-0.2mm<br>Fn=0.01-0.2mm/r<br>Vc=50-150m/min | 适用于钢的精加工车削，刃口锋利、抗粘附性强、加工尺寸精度高、表面质量好、排屑流畅。<br>It's suitable for finishing turning steel.A sharp edge, anti strong adhesion, processing high dimension accuracy,good surface quality and smooth ship removal.<br> |
| -JVF                  |  | Ap=0.1-5.0mm<br>Fn=0.01-0.1mm/r<br>Vc=50-150m/min  | 通用平行断屑、精切削用，低、中进给量加工时切屑处理良好，适用于碳合金钢的加工。<br>General parallel cutting, finishing cutting, low/feed processing chip processing, processing is suitable for carbon steel,alloy steel.<br>                           |

负角刀片 Negative Inserts

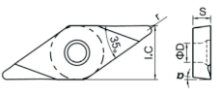
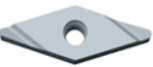
| 槽形代码<br>Geometry code | 刃口形状<br>Chip breaker shape                                                          | 推荐切削用量<br>Recommend<br>cutting parameters          | 槽形特点<br>Features of chip breaker                                                                                                                                                                                                                                                                                                                      |
|-----------------------|-------------------------------------------------------------------------------------|----------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| -JLF                  |  | Ap=0.01~0.5m<br>Fn=0.05~0.25mm/r<br>Vc=50-150m/min | 适用于钢的精加工，刀尖锋利并且切屑阻力小、排屑流畅、切削控制良好、可获得更高的表面光洁度。<br>suitable for fine finishing of steel, with sharp edge and small cutting resistance,smooth ship removal,good surface finis<br>                                                                                    |
| -JTF                  |  | Ap=0.5~2.0m<br>Fn=0.1~0.3mm/r<br>Vc=50-150m/min    | 适用于钢的半精加工，提供了良好的切屑范围，切屑阻力小、刃口锋利、排屑流畅、具有良好的加工尺寸精度和表面质量。<br>Suitable for semi-fine machining of steel, provides a good range of chip cutting, small chip resistance, sharp edge, smooth chip discharge, good machining dimension precision and surface quality.<br> |

► 正角刀片 Positive Inserts

| 刀片形状<br>Inserts Shape                                                               | 型号 Type           | 基本尺寸 Dimension |       |        |       |  |
|-------------------------------------------------------------------------------------|-------------------|----------------|-------|--------|-------|-------------------------------------------------------------------------------------|
|                                                                                     |                   | L.C(mm)        | S(mm) | ΦD(mm) | r(mm) |                                                                                     |
|  | CCGT060201R/L-JHF | 6.35           | 2.38  | 2.8    | 0.1   |                                                                                     |
|                                                                                     | CCGT060202R/L-JHF | 6.35           | 2.38  | 2.8    | 0.2   |                                                                                     |
|                                                                                     | CCGT060204R/L-JHF | 6.35           | 2.38  | 2.8    | 0.4   |                                                                                     |
|                                                                                     | CCGT09T302R/L-JHF | 9.525          | 3.97  | 4.4    | 0.2   |                                                                                     |
|                                                                                     | CCGT09T304R/L-JHF | 9.525          | 3.97  | 4.4    | 0.4   |                                                                                     |
|                                                                                     |                   |                |       |        |       |                                                                                     |

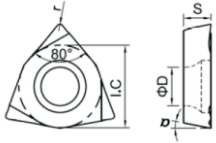
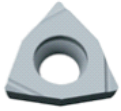
| 刀片形状<br>Inserts Shape                                                                | 型号 Type           | 基本尺寸 Dimension |       |        |       |  |
|--------------------------------------------------------------------------------------|-------------------|----------------|-------|--------|-------|-------------------------------------------------------------------------------------|
|                                                                                      |                   | L.C(mm)        | S(mm) | ΦD(mm) | r(mm) |                                                                                     |
|  | DCGT070202R/L-JHF | 6.35           | 2.38  | 2.8    | 0.2   |                                                                                     |
|                                                                                      | DCGT070204R/L-JHF | 6.35           | 2.38  | 2.8    | 0.4   |                                                                                     |
|                                                                                      | DCGT11T302R/L-JHF | 9.525          | 3.97  | 4.4    | 0.2   |                                                                                     |
|                                                                                      | DCGT11T304R/L-JHF | 9.525          | 3.97  | 4.4    | 0.4   |                                                                                     |
|                                                                                      |                   |                |       |        |       |                                                                                     |
|                                                                                      |                   |                |       |        |       |                                                                                     |

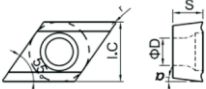
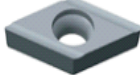
| 刀片形状<br>Inserts Shape                                                                 | 型号 Type           | 基本尺寸 Dimension |       |        |       |  |
|---------------------------------------------------------------------------------------|-------------------|----------------|-------|--------|-------|---------------------------------------------------------------------------------------|
|                                                                                       |                   | L.C(mm)        | S(mm) | ΦD(mm) | r(mm) |                                                                                       |
|  | TPGH090202R/L-JHF | 5.58           | 2.38  | 3      | 0.2   |                                                                                       |
|                                                                                       | TPGH090204R/L-JHF | 5.58           | 2.38  | 3      | 0.4   |                                                                                       |
|                                                                                       | TPGH110301R/L-JHF | 6.35           | 3.18  | 3.3    | 0.1   |                                                                                       |
|                                                                                       | TPGH110302R/L-JHF | 6.35           | 3.18  | 3.3    | 0.2   |                                                                                       |
|                                                                                       | TPGH110304R/L-JHF | 6.35           | 3.18  | 3.3    | 0.4   |                                                                                       |
|                                                                                       |                   |                |       |        |       |                                                                                       |

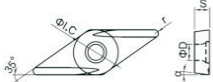
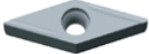
| 刀片形状<br>Inserts Shape                                                                 | 型号 Type           | 基本尺寸 Dimension |       |        |       |  |
|---------------------------------------------------------------------------------------|-------------------|----------------|-------|--------|-------|---------------------------------------------------------------------------------------|
|                                                                                       |                   | L.C(mm)        | S(mm) | ΦD(mm) | r(mm) |                                                                                       |
|  | VBGT110301R/L-JHF | 6.35           | 3.18  | 2.8    | 0.1   |                                                                                       |
|                                                                                       | VBGT110302R/L-JHF | 6.35           | 3.18  | 2.8    | 0.2   |                                                                                       |
|                                                                                       | VBGT110304R/L-JHF | 6.35           | 3.18  | 2.8    | 0.4   |                                                                                       |
|                                                                                       | VBGT160402R/L-JHF | 9.525          | 4.76  | 4.4    | 0.2   |                                                                                       |
|                                                                                       | VBGT160404R/L-JHF | 9.525          | 4.76  | 4.4    | 0.4   |                                                                                       |
|                                                                                       |                   |                |       |        |       |                                                                                       |

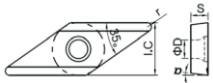
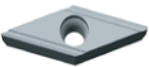


► 正角刀片 Positive Inserts

| 刀片形状<br>Inserts Shape                                                             | 型号 Type           | 基本尺寸 Dimension |       |        |       |  |
|-----------------------------------------------------------------------------------|-------------------|----------------|-------|--------|-------|-------------------------------------------------------------------------------------|
|                                                                                   |                   | I.C(mm)        | S(mm) | ΦD(mm) | r(mm) |                                                                                     |
|  | WPGT060302R/L-JHF | 9.525          | 3.18  | 4.4    | 0.2   |                                                                                     |
|                                                                                   | WPGT060304R/L-JHF | 9.525          | 3.18  | 4.4    | 0.4   |                                                                                     |
|                                                                                   | WPGT060308R/L-JHF | 9.525          | 3.18  | 4.4    | 0.8   |                                                                                     |
|                                                                                   |                   |                |       |        |       |                                                                                     |

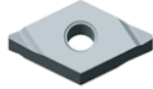
| 刀片形状<br>Inserts Shape                                                             | 型号 Type           | 基本尺寸 Dimension |       |        |       |  |
|-----------------------------------------------------------------------------------|-------------------|----------------|-------|--------|-------|-------------------------------------------------------------------------------------|
|                                                                                   |                   | I.C(mm)        | S(mm) | ΦD(mm) | r(mm) |                                                                                     |
|  | DCGT070201R/L-JVF | 6.35           | 2.38  | 2.8    | 0.1   |                                                                                     |
|                                                                                   | DCGT070202R/L-JVF | 6.35           | 2.38  | 2.8    | 0.2   |                                                                                     |
|                                                                                   | DCGT070204R/L-JVF | 6.35           | 2.38  | 2.8    | 0.4   |                                                                                     |
|                                                                                   | DCGT11T301R/L-JVF | 9.525          | 3.97  | 4.4    | 0.1   |                                                                                     |
|                                                                                   | DCGT11T302R/L-JVF | 9.525          | 3.97  | 4.4    | 0.2   |                                                                                     |
|                                                                                   | DCGT11T304R/L-JVF | 9.525          | 3.97  | 4.4    | 0.4   |                                                                                     |
|                                                                                   |                   |                |       |        |       |                                                                                     |

| 刀片形状<br>Inserts Shape                                                               | 型号 Type           | 基本尺寸 Dimension |       |        |       |  |
|-------------------------------------------------------------------------------------|-------------------|----------------|-------|--------|-------|---------------------------------------------------------------------------------------|
|                                                                                     |                   | I.C(mm)        | S(mm) | ΦD(mm) | r(mm) |                                                                                       |
|  | VBGT110301R/L-JVF | 6.35           | 3.18  | 2.8    | 0.1   |                                                                                       |
|                                                                                     | VBGT110302R/L-JVF | 6.35           | 3.18  | 2.8    | 0.2   |                                                                                       |
|                                                                                     | VBGT110304R/L-JVF | 6.35           | 3.18  | 2.8    | 0.4   |                                                                                       |
|                                                                                     | VCGT160402R/L-JVF | 9.525          | 4.76  | 4.4    | 0.2   |                                                                                       |
|                                                                                     | VCGT160404R/L-JVF | 9.525          | 4.76  | 4.4    | 0.4   |                                                                                       |

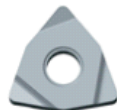
| 刀片形状<br>Inserts Shape                                                               | 型号 Type           | 基本尺寸 Dimension |       |        |       |  |
|-------------------------------------------------------------------------------------|-------------------|----------------|-------|--------|-------|---------------------------------------------------------------------------------------|
|                                                                                     |                   | I.C(mm)        | S(mm) | ΦD(mm) | r(mm) |                                                                                       |
|  | VCGT110301R/L-JVF | 6.35           | 3.18  | 2.8    | 0.1   |                                                                                       |
|                                                                                     | VCGT110302R/L-JVF | 6.35           | 3.18  | 2.8    | 0.2   |                                                                                       |
|                                                                                     | VCGT110304R/L-JVF | 6.35           | 3.18  | 2.8    | 0.4   |                                                                                       |
|                                                                                     | VCGT160402R/L-JVF | 9.525          | 4.76  | 4.4    | 0.2   |                                                                                       |
|                                                                                     | VCGT160404R/L-JVF | 9.525          | 4.76  | 4.4    | 0.4   |                                                                                       |

► 负角刀片 Negative Inserts

| 刀片形状<br>Inserts Shape                                                               | 型号 Type           | 基本尺寸 Dimension |       |        |       |  |
|-------------------------------------------------------------------------------------|-------------------|----------------|-------|--------|-------|-------------------------------------------------------------------------------------|
|                                                                                     |                   | I.C(mm)        | S(mm) | ΦD(mm) | r(mm) |                                                                                     |
|  | CNGG090402R/L-JLF | 9.525          | 4.76  | 3.81   | 0.2   |                                                                                     |
|                                                                                     | CNGG090404R/L-JLF | 9.525          | 4.76  | 3.81   | 0.4   |                                                                                     |
|                                                                                     | CNGG090408R/L-JLF | 9.525          | 4.76  | 3.81   | 0.8   |                                                                                     |
|                                                                                     |                   |                |       |        |       |                                                                                     |

| 刀片形状<br>Inserts Shape                                                               | 型号 Type           | 基本尺寸 Dimension |       |        |       |  |
|-------------------------------------------------------------------------------------|-------------------|----------------|-------|--------|-------|-------------------------------------------------------------------------------------|
|                                                                                     |                   | I.C(mm)        | S(mm) | ΦD(mm) | r(mm) |                                                                                     |
|  | DNGG110402R/L-JLF | 9.525          | 4.76  | 3.81   | 0.2   |                                                                                     |
|                                                                                     | DNGG110404R/L-JLF | 9.525          | 4.76  | 3.81   | 0.4   |                                                                                     |
|                                                                                     | DNGG110408R/L-JLF | 9.525          | 4.76  | 3.81   | 0.8   |                                                                                     |
|                                                                                     |                   |                |       |        |       |                                                                                     |

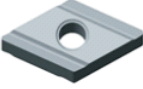
| 刀片形状<br>Inserts Shape                                                                 | 型号 Type           | 基本尺寸 Dimension |       |        |       |  |
|---------------------------------------------------------------------------------------|-------------------|----------------|-------|--------|-------|---------------------------------------------------------------------------------------|
|                                                                                       |                   | I.C(mm)        | S(mm) | ΦD(mm) | r(mm) |                                                                                       |
|  | TNGG110402R/L-JLF | 6.35           | 4.76  | 2.26   | 0.2   |                                                                                       |
|                                                                                       | TNGG110404R/L-JLF | 6.35           | 4.76  | 2.26   | 0.4   |                                                                                       |
|                                                                                       | TNGG110408R/L-JLF | 6.35           | 4.76  | 2.26   | 0.8   |                                                                                       |
|                                                                                       | TNGG160402R/L-JLF | 9.525          | 4.76  | 3.81   | 0.2   |                                                                                       |
|                                                                                       | TNGG160404R/L-JLF | 9.525          | 4.76  | 3.81   | 0.4   |                                                                                       |
|                                                                                       | TNGG160408R/L-JLF | 9.525          | 4.76  | 3.81   | 0.8   |                                                                                       |

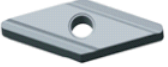
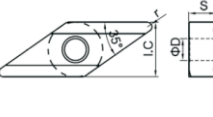
| 刀片形状<br>Inserts Shape                                                                 | 型号 Type           | 基本尺寸 Dimension |       |        |       |  |
|---------------------------------------------------------------------------------------|-------------------|----------------|-------|--------|-------|---------------------------------------------------------------------------------------|
|                                                                                       |                   | I.C(mm)        | S(mm) | ΦD(mm) | r(mm) |                                                                                       |
|  | WNGG060402R/L-JLF | 9.525          | 4.76  | 3.81   | 0.2   |                                                                                       |
|                                                                                       | WNGG060404R/L-JLF | 9.525          | 4.76  | 3.81   | 0.4   |                                                                                       |
|                                                                                       | WNGG060408R/L-JLF | 9.525          | 4.76  | 3.81   | 0.8   |                                                                                       |
|                                                                                       |                   |                |       |        |       |                                                                                       |



► 负角刀片 Negative Inserts

| 刀片形状<br>Inserts Shape                                                             | 型号 Type           | 基本尺寸 Dimension |       |        |       |                                                                                     |
|-----------------------------------------------------------------------------------|-------------------|----------------|-------|--------|-------|-------------------------------------------------------------------------------------|
|                                                                                   |                   | I.C(mm)        | S(mm) | ΦD(mm) | r(mm) |                                                                                     |
|  | CNGG090404R/L-JTF | 9.525          | 4.76  | 3.81   | 0.4   |  |
|                                                                                   | CNGG090408R/L-JTF | 9.525          | 4.76  | 3.81   | 0.8   |                                                                                     |
|                                                                                   | CNGG120404R/L-JTF | 12.7           | 4.76  | 5.16   | 0.4   |                                                                                     |
|                                                                                   | CNGG120408R/L-JTF | 12.7           | 4.76  | 5.16   | 0.8   |                                                                                     |

| 刀片形状<br>Inserts Shape                                                             | 型号 Type           | 基本尺寸 Dimension |       |        |       |                                                                                     |
|-----------------------------------------------------------------------------------|-------------------|----------------|-------|--------|-------|-------------------------------------------------------------------------------------|
|                                                                                   |                   | I.C(mm)        | S(mm) | ΦD(mm) | r(mm) |                                                                                     |
|  | DNNG110404R/L-JTF | 9.525          | 4.76  | 3.81   | 0.4   |  |
|                                                                                   | DNNG110408R/L-JTF | 9.525          | 4.76  | 3.81   | 0.8   |                                                                                     |
|                                                                                   | DNNG150404R/L-JTF | 12.7           | 4.76  | 5.16   | 0.4   |                                                                                     |
|                                                                                   | DNNG150408R/L-JTF | 12.7           | 4.76  | 5.16   | 0.8   |                                                                                     |

| 刀片形状<br>Inserts Shape                                                               | 型号 Type           | 基本尺寸 Dimension |       |        |       |                                                                                       |
|-------------------------------------------------------------------------------------|-------------------|----------------|-------|--------|-------|---------------------------------------------------------------------------------------|
|                                                                                     |                   | I.C(mm)        | S(mm) | ΦD(mm) | r(mm) |                                                                                       |
|  | VNGG160402R/L-JTF | 9.525          | 4.76  | 3.81   | 0.2   |  |
|                                                                                     | VNGG160404R/L-JTF | 9.525          | 4.76  | 3.81   | 0.4   |                                                                                       |
|                                                                                     | VNGG160408R/L-JTF | 9.525          | 4.76  | 3.81   | 0.8   |                                                                                       |
|                                                                                     |                   |                |       |        |       |                                                                                       |

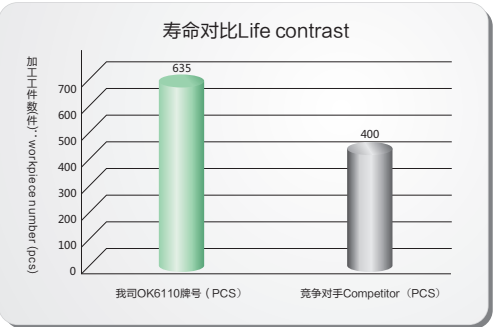
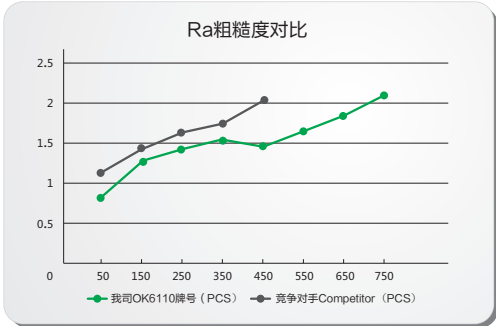
► 使用案例 Application

OK6110

新一代金属陶瓷牌号 New generation cerment grade

案例1 Case 1

客户名称(Customer):  
国内某机械厂 Domestic machinery factory  
被加工材料(Material to be processed):  
S45C  
加工设备(lath type):  
数控车床 CNC lathe  
使用刀片(OKE insert):  
TNGG160404-JLF OK6110  
对比刀片(Compare insert):  
国外某知名厂家刀片 Foreign well-known manufacturers inserts  
冷却方式(Cooling method):  
水冷 Water cooling  
加工内容(Processing content):  
外圆车削加工 External turning  
加工参数(Cutting parameters):  
Vc=76~130m/min Fn=0.08mm/r Ap=0.10mm

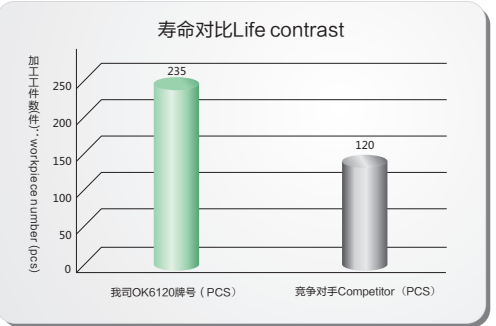
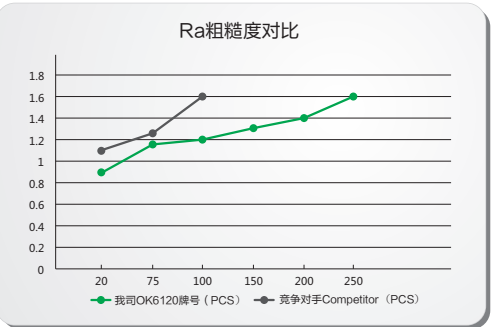


OK6120

新一代金属陶瓷牌号 New generation cerment grade

案例2 Case 2

客户名称 (Customer):  
国内某机械厂 Domestic machinery factory  
被加工材料 (Work piece material):  
12L15  
加工设备 (Lath type):  
数控车床 CNC lathe  
使用刀片 (OKE insert):  
TNGG160402-JLF OK6120  
对比刀片 (Compare insert):  
国外某知名厂家刀片 Foreign well-known manufacturers inserts  
冷却方式 (Cooling method):  
油冷 Oil cooling  
加工内容 (Processing content):  
端面车削 End face turning  
加工参数 (Cutting parameters):  
Vc=220m/min Fn=0.05mm/r Ap=0.6mm





钢件新牌号  
New Grade For Steel Turning

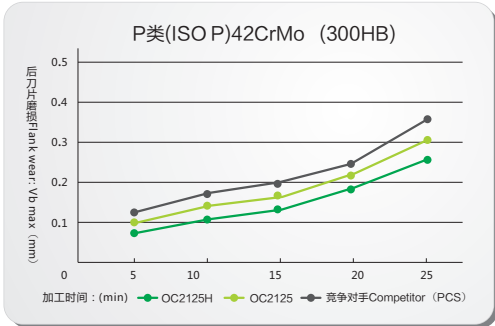
▶ 牌号描述 Chip Breaker Description

| 牌号<br>Grade | 金相照片<br>Metallograph | ISO分类<br>ISO classification | 特性<br>Features                                                                                                                                                                                                                                                                                                                                                                                         | 推荐用途<br>Recommended applications                                              |
|-------------|----------------------|-----------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------|
| OC2115H     |                      | P10-P20                     | 低Co中粗颗粒高立方相含量的梯度层硬质合金基体，具有很好的抗塑性变形能力和优异的高温性能，搭配MT-TiCN+细柱状 $\alpha$ - $Al_2O_3$ ， $Al_2O_3$ 为织构化涂层，具有极低的摩擦阻力。<br>Low Co content, medium grain, high cubic content gradient cemented carbide substrate. Which has good plastic deformation resistance and high temperature performance, match with MT-TiCN + fine columnar $\alpha$ - $Al_2O_3$ , $Al_2O_3$ coating provides very low surface friction. | 适用于钢材精加工到粗加工的通用牌号。<br>Suitable for steel finishing to roughing cutting.       |
| OC2125H     |                      | P20-P30                     | 中等Co含量的中粗颗粒高立方相含量的梯度层硬质合金基体，具有很好的抗塑性变形能力和韧性，搭配MT-TiCN+细柱状 $\alpha$ - $Al_2O_3$ ， $Al_2O_3$ 为织构化涂层，具有极低的摩擦阻力。<br>Medium Co content, medium grain, high cubic content gradient cemented carbide substrate which has good plastic deformation resistance and good toughness, match with MT-TiCN + fine columnar $\alpha$ - $Al_2O_3$ , $Al_2O_3$ coating provides very low surface friction.              | 适用于钢材半精加工到粗加工的通用牌号。<br>Suitable for steel semi-finishing to roughing cutting. |

▶ 使用案例 Application

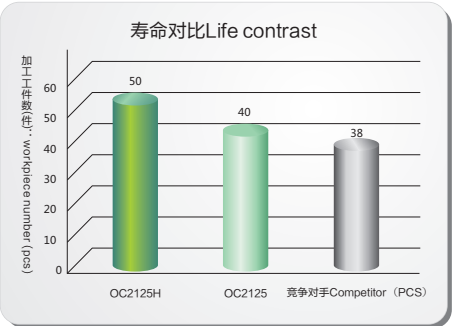
案例1 Case 1

使用刀片 (OKE insert) : WNMG080408-\*\*  
加工参数 (Cutting parameters) :  
Vc=320m/min Fn=0.3mm/r Ap=2.0mm  
加工内容 (Processing content):  
湿式连续切削 Continue cutting, fluid cooling



案例2 Case 2

客户名称 (Customer) :  
山东某轴承股份有限公司  
Shandong bearing company  
工件名称 (Work piece) :  
轴承内圈Bearing inner turning  
被加工材料 (Work piece material) :  
GGr15  
加工设备 (Lath type) :  
数控车床CNC lathe  
使用刀片 (OKE insert) :  
WNMG080412-\*\*  
对比刀片 (Compare insert) :  
公司OC2125、国内某知名厂家刀片  
OKE OC2125, Chinese famous insert  
加工内容 (Processing content) :  
端面、外圆车削加工  
End face turning, external turning  
加工参数 (Cutting parameters) :  
端面End face turning  
Vc=228m/min Fn=0.13mm/r Ap=1.5mm  
外圆External turning  
Vc=318m/min Fn=0.16mm/r Ap=2.0mm



◆ 极低的表面摩擦系数

Very low surface friction coefficient

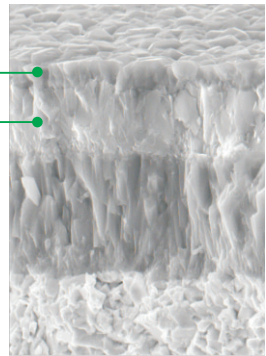
高硬度低摩擦系数全新表面涂层，具有良好的切削寿命和加工表面光洁度，以及优异的耐融着性能。  
Hard but smooth new coting, give longer tool life time and bitter surface quality.

◆ 全新织构 $Al_2O_3$ 涂层

New structure  $Al_2O_3$  coating.

具有良好的耐高温性和抗磨损性，适用于高效、高速加工。

Better high temperature performance and wear resistance, suitable for high speed, and high efficient processing.



◆ 出色的抗月牙洼磨损能力

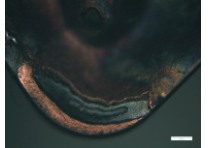
Good anti crater wear ability.

大大提高了抗月牙洼磨损能力，延长了刀具寿命。

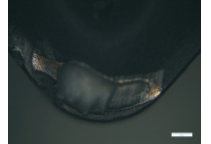
Greatly enhance the ability of anti-crater wear, prolong tool life time.

◆ 涂层易于识别磨损

Easy to recognize wear.



OC2125H



原OC2125





# 不锈钢新牌号

New Grade For Stainless Steel

## 牌号描述 Chip Breaker Description

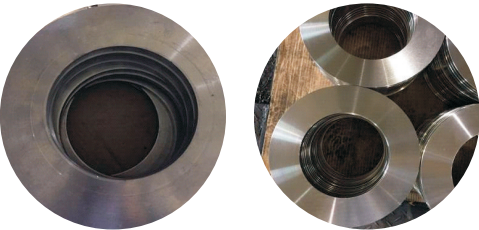
| 牌号<br>Grade | 金相照片<br>Metallograph | ISO分类<br>ISO classification | 特性<br>Features                                                                                                                                                                                                                                                                                                                                                                  | 推荐用途<br>Recommended applications                                                                                                                    |
|-------------|----------------------|-----------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------|
| OC4315      |                      | M15-M25                     | <p>基体为中粗颗粒WC及高立方相含量的梯度层硬质合金，涂层为薄的CVD氧化铝涂层，具有很好的抗塑性变形能力，通过特殊的表面处理，使表面光滑，具有极低的摩擦阻力。</p> <p>Medium size WC grain in high cubic content gradient cementedcarbide substrate combine with thin CVD AL<sub>2</sub>O<sub>3</sub> coating contribute wonderful plastic deformation resistance. Special surface treatment makes smooth surface which has lower frictional resistance.</p> | <p>适合于稳定工况的奥氏体不锈钢的高速连续车削，适合加工较大零件。</p> <p>Suitable for austenitic stainless steel high speed continue cutting, also good in big part machining.</p> |

## 使用案例 Application

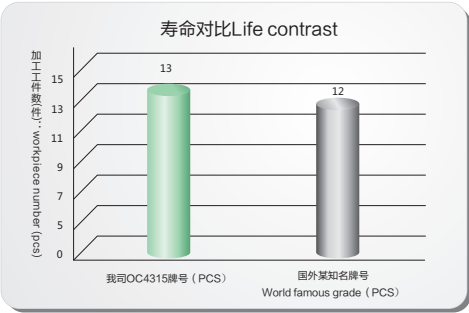
### OC4315

#### 案例1 Case 1

客户名称(Customer): 苏州某法兰加工有限公司 Suzhou flange company  
工件名称(Work piece): 法兰盘 Flange  
被加工材料(Work piece material): SUS316Ti  
加工设备(Lath type): 数控车床 CNC lathe  
使用刀片 (OKE insert): WNMG060412-OMM OC4315



对比刀片 (Compare insert): 国外某知名厂家刀片 World famous insert company  
加工内容 (Processing content): 端面车削加工 End facing turning  
加工参数 (Cutting parameters): Vc=224m/min Fn=0.3mm/r Ap=1.5mm

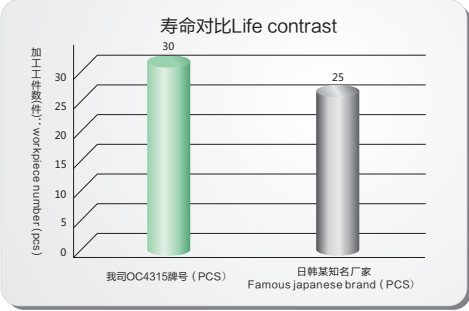


#### 案例2 Case 2

客户名称 (Customer): 温州某密封件厂 Wenzhou seal ring company  
工件名称 (Work piece): 密封圈 Seal ring  
被加工材料 (Work piece material): SUS304  
加工设备 (Lath type): 数控车床 CNC lathe  
使用刀片 (OKE insert): WNMG080408-MF OC4315  
对比刀片 (Compare insert): 日韩某知名厂家 Famous japanese brand  
加工内容 (Processing content): 外圆，端面车削 External, end facing turning



加工参数 (Cutting parameter): Vc=300 m/min Fn=0.3 mm/r Ap=1 mm







GM槽型  
GM Chip Breaker

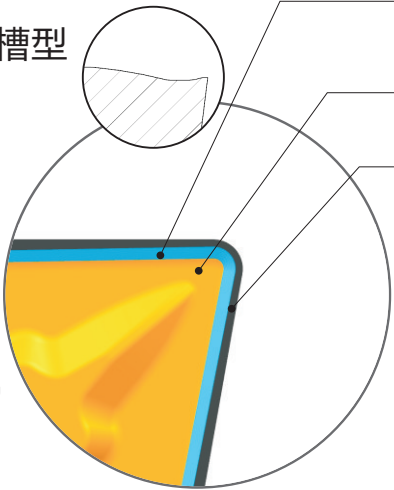
槽型描述 Chip Breaker Description

—GM

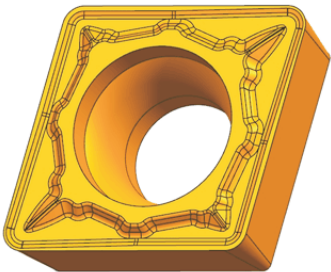
新一代正刀片通用加工槽型  
New generation universal

大前角和变刃宽设计，保证刀尖锋利的同时也兼顾了切削刃的强度，配合排屑流畅的断屑槽，进一步降低切削阻力;刀片具备较强的通用性，搭配不同的材质可适用于钢类、不锈钢类半精至精加工。

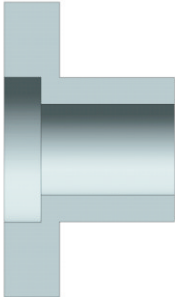
large rake angle and changing width of edge, keeps both sharp and strength of cutting edge. Cooperate with smooth discharge channel, further on reducing the cutting resistance force; insert has good universality, it is suitable in semi-finishing to finishing cutting for steel and stainless steel.



- ◆ 大前角设计，切削轻快，配合变化的刃宽，获得极好的通用性  
The large rake angle design contribute to smooth and quick cutting, and coordinates with changing width of cutting edge. It gives very good universality.
- ◆ 排屑流畅的断屑槽，减小排屑阻力  
The smooth chip discharge channel reduces chip discharge resistance force.
- ◆ 变刃宽设计，保证刀尖锋利的同时，提高切削刃强度  
Changing width of cutting edge, gives sharp edge also guarantee the strength of cutting edges.



使用案例 Application



工件名称 (Work piece) : 套筒工件 Casing  
被加工材料 (Work piece material) : 45号钢#45 Steel  
加工参数 (Cutting parameters) :  
Vc=180m/min Fn=0.2mm/r Ap=1mm  
加工内容 (Processing content) :  
内孔车削、干切 Inner turning, dry cutting

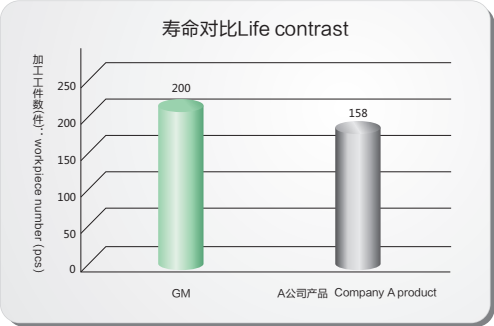


GM



A公司产品  
Company A Product

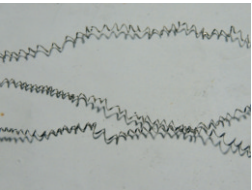
使用刀片 (OKE insert) : CCMT09T308-GM OC2125  
对比刀片 (Compare insert) :  
A公司产品 Company A product



工件名称 (Work piece) : 衬套 Bush  
被加工材料 (Work piece material) : SUS304  
加工参数 (Cutting parameters) :  
Vc=100m/min Fn=0.18mm/r Ap=0.4mm  
加工内容 (Processing content) :  
内孔车削、湿切 Inner turning, fluid cooling



GM



A公司产品  
Company A Product

使用刀片 (OKE insert) : CCMT09T304-GM OP1215  
对比刀片 (Compare insert) :  
A公司产品 Company A product

