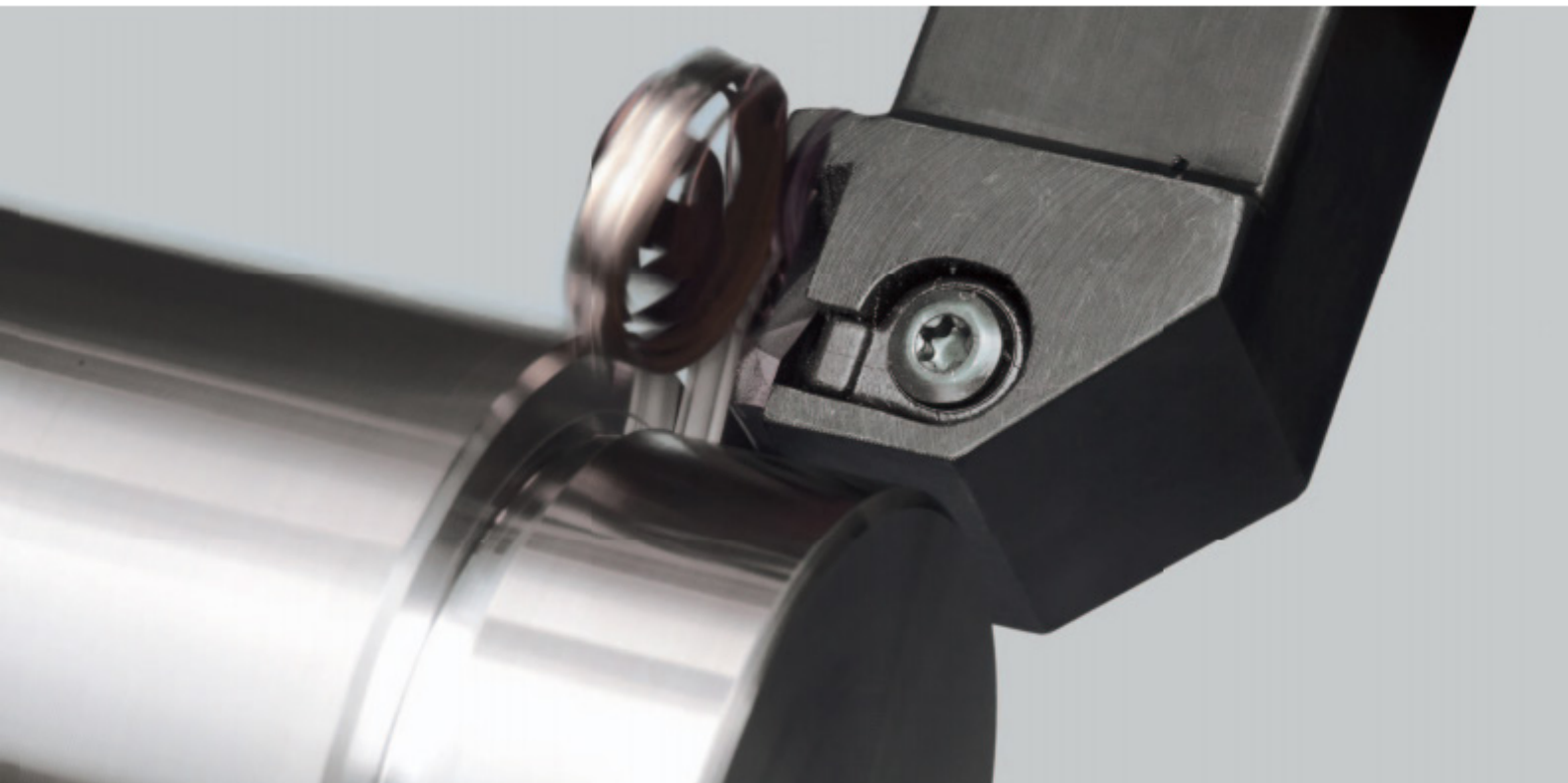


**NEW
PRODUCT!**


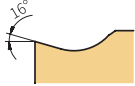
外径、内径 浅槽加工用刀具 ATG 三角槽刀











高精度公差宽度， $\pm 0.025\text{mm}$
搭配 AP301U 牌号，实现稳定、
长寿命、高效加工。



槽型信息

槽型	刀片	刃口图示	特点	各槽型宽度 (mm)								
				外径加工					端面加工		内径加工	
				切槽	切断	车削	仿形	越程槽	切槽	车削	切槽	车削
ATG			<ul style="list-style-type: none"> ● 采用精密级刀片 ● 正前角不易产生震动 ● 三刃设计并且扩展性好 	0.33 4.8	-	-	0.5 1.0 1.5 2.0 3.0 4.0	-	-	-	0.33 4.8	-

刀杆信息

刀杆型号		刀方 (mm)	切深 (mm)	配合刀片 (ASG)	刀片宽度 (mm)	切深 (mm)
ASGHR/L		10	2.5		0.33	0.8
S...ASGHL		25	2.5		2.5	2.5
S...ASGHL		12	2.5		0.33	0.8
S...ASGHL		25.4	2.5		2.5	2.5

适用范围及切削条件

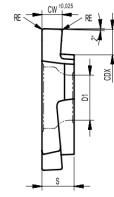
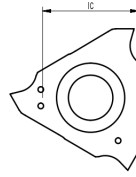
加工工件材料		硬度	切削速度 (m/min)
P	非合金钢	HB 125-350	80-200
	低合金钢		
	高合金钢 / 工具钢		
M	奥氏体, 淬火	HB 200-300	60-180
	奥氏体 - 铁素体, 双相不锈钢		

加工材料	钢件					不锈钢				
切削领域	精加工 ← → 粗加工					精加工 ← → 粗加工				
ISO 分类	P01	P10	P20	P30	P40	M01	M10	M20	M30	M40
AP301U		AP301U					AP301U			

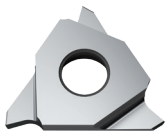


◆ 刀片型号

型号	IC	S	D1
ATG 32-	9.525	3.18	4.4
ATG 43-	12.7	4.76	5.5
ATG 43R/L480	12.7	5	5.5



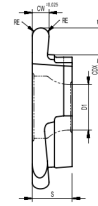
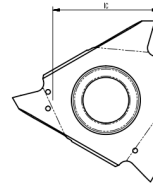
刀片	型号	切削参数		尺寸			P
		切槽	CDX	CW	RE	AP301U	
		进给 f (mm/rev)					
	ATG 32R/L033T08-R005	0.03-0.08	0.8	0.33	0.05	●	
	ATG 32R/L050T12-R005	0.03-0.08	1.2	0.50	0.05	●	
	ATG 32R/L075T20-R005	0.03-0.08	2.0	0.75	0.05	●	
	ATG 32R/L095T20-R005	0.03-0.08	2.0	0.95	0.05	●	
	ATG 32R/L100T20-R005	0.03-0.08	2.0	1.00	0.05	●	
	ATG 32R/L110T20-R005	0.03-0.08	2.0	1.10	0.05	●	
	ATG 32R/L120T20-R005	0.03-0.08	2.0	1.20	0.05	●	
	ATG 32R/L125T20-R020	0.04-0.09	2.0	1.25	0.20	●	
	ATG 32R/L130T20-R020	0.04-0.09	2.0	1.30	0.20	●	
	ATG 32R/L140T25-R020	0.04-0.09	2.5	1.40	0.20	●	
	ATG 32R/L145T25-R020	0.04-0.09	2.5	1.45	0.20	●	
	ATG 32R/L150T25-R020	0.04-0.09	2.5	1.50	0.20	●	
	ATG 32R/L160T25-R020	0.04-0.09	2.5	1.60	0.20	●	
	ATG 32R/L170T25-R020	0.04-0.09	2.5	1.70	0.20	●	
	ATG 32R/L175T25-R020	0.04-0.09	2.5	1.75	0.20	●	
	ATG 32R/L200T25-R020	0.04-0.09	2.5	2.00	0.20	●	
	ATG 32R/L225T25-R020	0.04-0.09	2.5	2.25	0.20	●	
	ATG 32R/L250T25-R020	0.05-0.10	2.5	2.50	0.20	●	
	ATG 32R/L300T25-R020	0.05-0.10	2.5	3.00	0.20	●	
	ATG 43R/L100T20-R010	0.03-0.08	2.0	1.00	0.10	●	
	ATG 43R/L125T20-R010	0.04-0.09	2.0	1.25	0.10	●	
	ATG 43R/L125T20-R020	0.04-0.09	2.0	1.25	0.20	●	
	ATG 43R/L130T30-R010	0.04-0.09	3.0	1.30	0.10	●	
	ATG 43R/L130T30-R020	0.04-0.09	3.0	1.30	0.20	●	
	ATG 43R/L140T35-R020	0.04-0.09	3.5	1.40	0.20	●	
	ATG 43R/L145T35-R020	0.04-0.09	3.5	1.45	0.20	●	
	ATG 43R/L150T35-R010	0.04-0.09	3.5	1.50	0.10	●	
	ATG 43R/L150T35-R020	0.04-0.09	3.5	1.50	0.20	●	
	ATG 43R/L170T35-R020	0.04-0.09	3.5	1.70	0.20	●	
	ATG 43R/L175T35-R020	0.04-0.09	3.5	1.75	0.20	●	
	ATG 43R/L185T35-R020	0.04-0.09	3.5	1.85	0.20	●	
	ATG 43R/L195T35-R020	0.04-0.09	3.5	1.95	0.20	●	
	ATG 43R/L200T35-R010	0.04-0.09	3.5	2.00	0.10	●	
	ATG 43R/L200T35-R020	0.04-0.09	3.5	2.00	0.20	●	
	ATG 43R/L225T35-R020	0.04-0.09	3.5	2.25	0.20	●	
	ATG 43R/L230T35-R020	0.05-0.10	3.5	2.30	0.20	●	
	ATG 43R/L250T50-R010	0.05-0.10	5.0	2.50	0.10	●	
	ATG 43R/L250T50-R030	0.05-0.10	5.0	2.50	0.30	●	
	ATG 43R/L265T50-R030	0.05-0.10	5.0	2.65	0.30	●	
	ATG 43R/L280T50-R030	0.05-0.10	5.0	2.80	0.30	●	
	ATG 43R/L300T50-R010	0.05-0.10	5.0	3.00	0.10	●	
	ATG 43R/L300T50-R030	0.05-0.10	5.0	3.00	0.30	●	
	ATG 43R/L325T50-R030	0.05-0.10	5.0	3.50	0.30	●	
	ATG 43R/L330T50-R030	0.05-0.12	5.0	3.30	0.30	●	
	ATG 43R/L350T50-R010	0.05-0.12	5.0	3.50	0.10	●	
	ATG 43R/L350T50-R030	0.05-0.12	5.0	3.50	0.30	●	
	ATG 43R/L400T50-R010	0.05-0.12	5.0	4.00	0.10	●	
	ATG 43R/L400T50-R040	0.05-0.12	5.0	4.00	0.40	●	
	ATG 43R/L430T50-R040	0.05-0.12	5.0	4.30	0.40	●	
	ATG 43R/L450T50-R040	0.05-0.12	5.0	4.50	0.40	●	
	ATG 43R/L480T50-R040	0.05-0.12	5.0	4.80	0.40	●	

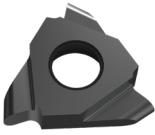




◆ 刀片型号

型号	IC	S	D1
ATG 32-	9.525	3.18	4.4
ATG 43-	12.7	4.76	5.5

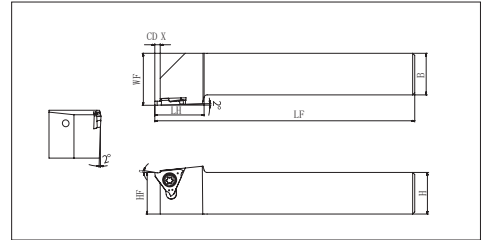
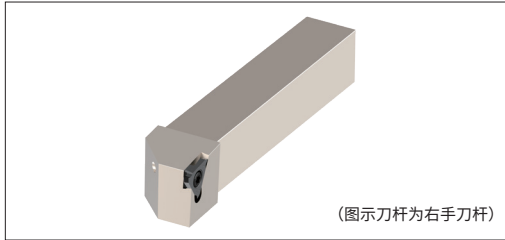


刀片	型号	切削参数		尺寸			P
		切槽	CDX	CW	RE	AP301U	
		进给 f (mm/rev)					
	ATG 32R/L050T20-R025	0.03-0.08	1.2	0.50	0.25	●	
	ATG 32R/L100T20-R050	0.03-0.08	2.0	1.00	0.50	●	
	ATG 32R/L150T25-R075	0.04-0.09	2.5	1.50	0.75	●	
	ATG 32R/L200T25-R100	0.04-0.09	2.5	2.00	1.00	●	
	ATG 32R/L300T25-R150	0.05-0.10	2.5	3.00	1.50	●	
	ATG 43R/L100T20-R050	0.03-0.08	2.0	1.00	0.50	●	
	ATG 43R/L150T35-R075	0.04-0.09	3.5	1.50	0.75	●	
	ATG 43R/L200T35-R100	0.04-0.09	3.5	2.00	1.00	●	
	ATG 43R/L250T40-R125	0.05-0.10	5.0	2.50	1.25	●	
	ATG 43R/L300T40-R150	0.05-0.10	5.0	3.00	1.50	●	
	ATG 43R/L400T50-R200	0.05-0.12	5.0	4.00	2.00	●	



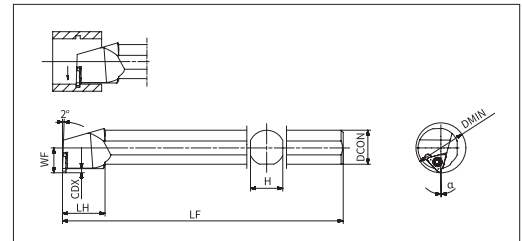
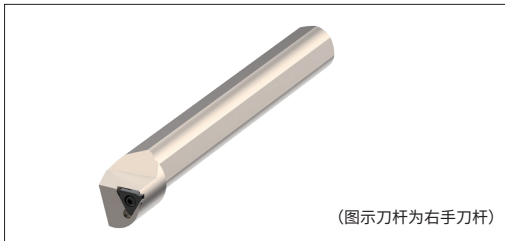
◆ 刀杆型号

ATGHR/L 外径浅槽刀杆



型号		尺寸 (mm)						零件	
		H	B	LF	LH	WF	CDX	螺钉型号	扳手型号
ATGHR/L	2020K32-T25	20	20	20	125	24	2.5	SP040085	FT-TP15
	2525M32-T25	25	25	25	150	24	2.5		
	2020K43-10T40	20	20	20	125	25.5	4.0	SP05008550	FT-TP20
	2525M43-10T40	25	25	25	150	25.5	4.0		
	2020K43-20T45	20	20	20	125	25.5	4.5		
	2525M43-20T45	25	25	25	150	25.5	4.5		
	2020K43-20T55	20	20	20	125	25.5	5.5		
	2525M43-20T55	25	25	25	150	25.5	5.5		
	2020K43-30T55	20	20	20	125	25.5	5.5		
2525M43-30T55	25	25	25	150	25.5	5.5			

ATGIR/L 内径浅槽刀杆

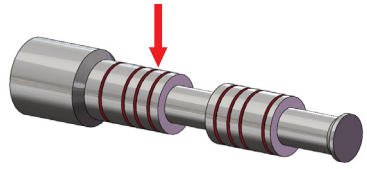
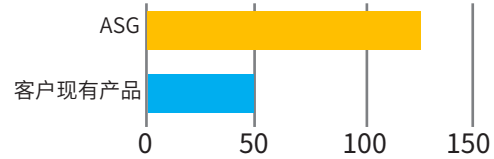


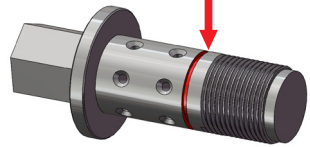
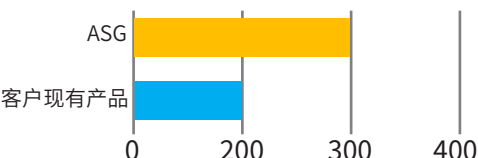
型号		尺寸 (mm)						零件	
		DMIN	DCON	LF	LH	WF	CDX	螺钉型号	扳手型号
ATGIR/L	25R32-35T28	35	25	220	30	17.5	2.8	SP040085	FT-TP15
	32S43-40T30	40	32	250	30	23.0	3.0	SP05008550	FT-TP20


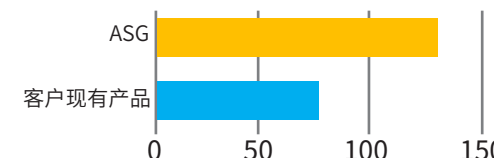


● **加工案例**

刀具型号	ASG 32R150T20-R010 AP301U
加工零件	内座管 
加工材料	SUS316
切削速度	70m/min
进 给	0.05mm/rev
切 深	0.5mm
冷 却	油性
结 果	 ASG 加工稳定, 实现刀具寿命增长 +25%

刀具型号	ASG 32R033T08-R005 AP301U
加工零件	阀杆 
加工材料	42CrMn
切削速度	92m/min
进 给	0.03mm/rev
切 深	0.5mm
冷 却	油性
结 果	 ASG 加工稳定, 实现刀具寿命增长 +140%

刀具型号	ASG 32R200T25-R010 AP301U
加工零件	螺栓体 
加工材料	35CrMn
切削速度	100m/min
进 给	0.05mm/rev
切 深	1mm
冷 却	油性
结 果	 ASG 加工稳定, 实现刀具寿命增长 +17%

刀具型号	ASG 32R150T20-R010 AP301U
加工零件	轴 
加工材料	20CrMnTi
切削速度	113m/min
进 给	0.05mm/rev
切 深	1.5mm
冷 却	油性
结 果	 ASG 加工稳定, 实现刀具寿命增长 +47%