



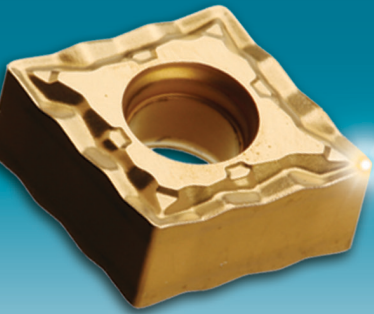
RHINOTURN

极度小巧，极度强悍



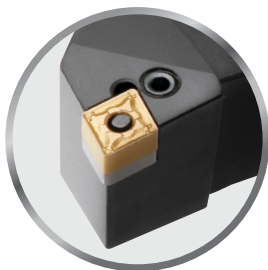
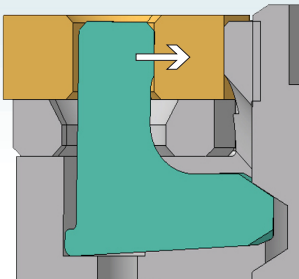


高刚性刀片！高夹持力！ “最新的夹持结构”



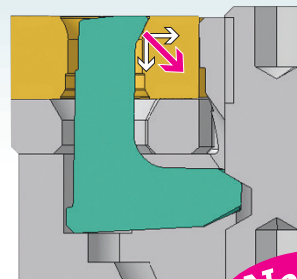
一般ISO夹持结构

刀片锁紧时，受一个方向锁紧力



新刀杆夹持结构

刀片锁紧时，同时受到2个不同方向的锁紧力



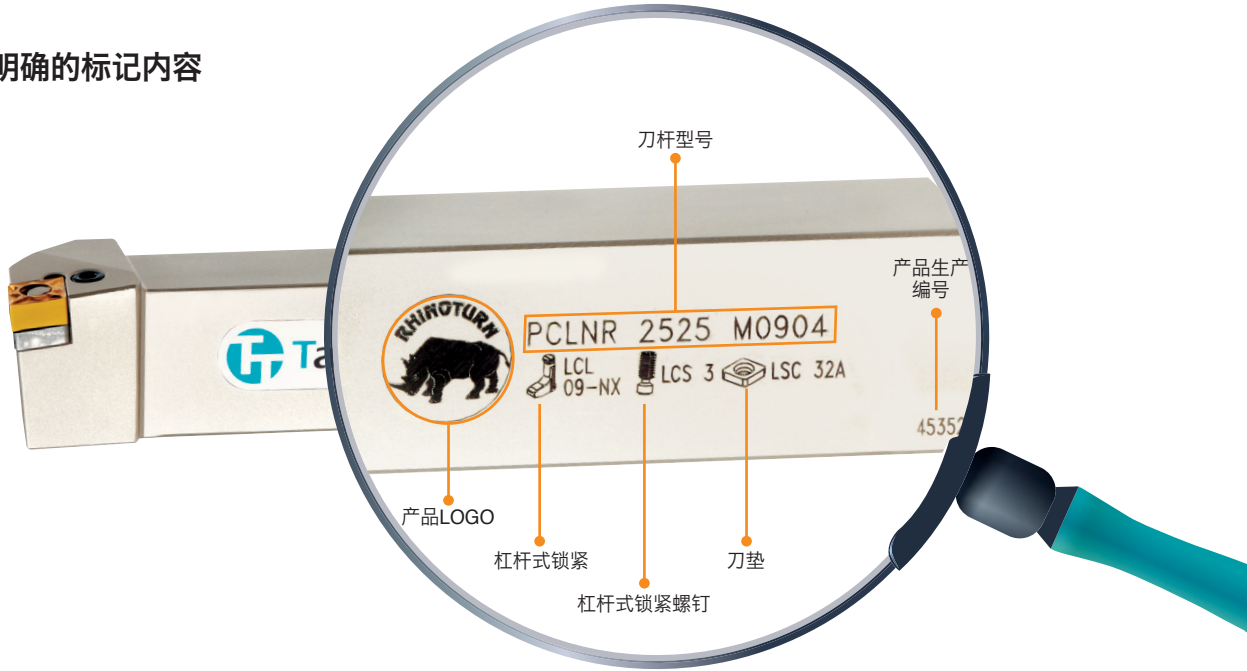
New



特点

- 刀片锁紧时跟一般ISO杠杆式刀杆相比,受到2个不同方向锁紧力
- 高进给及大切深的加工中, 提高了生产效率, 但刀具寿命依然保证
- 断续加工及老旧设备上使用时, 加工性能稳定
- 通过使用高刚性的刀片和新型夹持方式大幅提高了刀具寿命

清晰明确的标记内容



使用ISO标准刀杆与新刀杆的刀片寿命比较（内部测试结果）

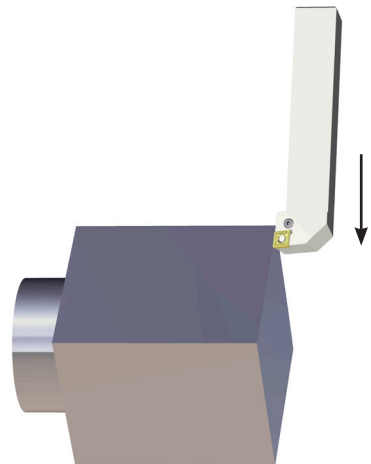
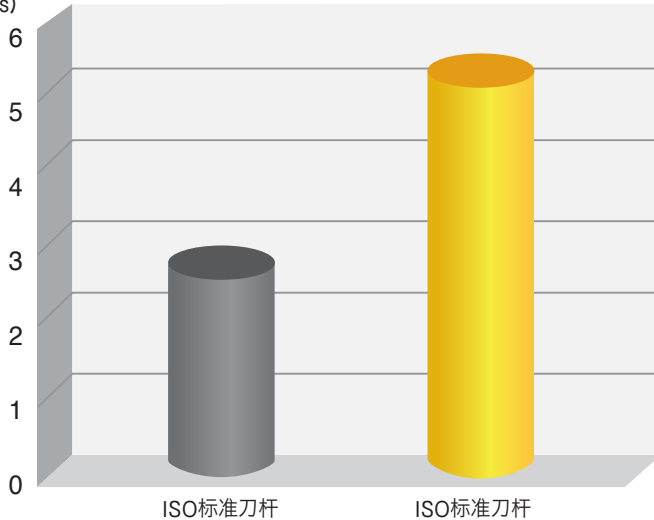
断续加工夹持力比较

- 工件材质 SCM 440
- 加工方式 断续端面加工
- 加工参数 $V=100\text{m/min}$, $f=0.6\text{mm/rev}$, $d=4\text{mm}$, 湿式

测试方法

- ① CNMG 120408 + PCLNR 2525 M12 刀杆
(标准ISO刀杆)
 - ② CNMG 090408 + PCLNR 2525 M0904
(新刀杆)
- * 槽型和材质相同

刀具寿命
(Pass)

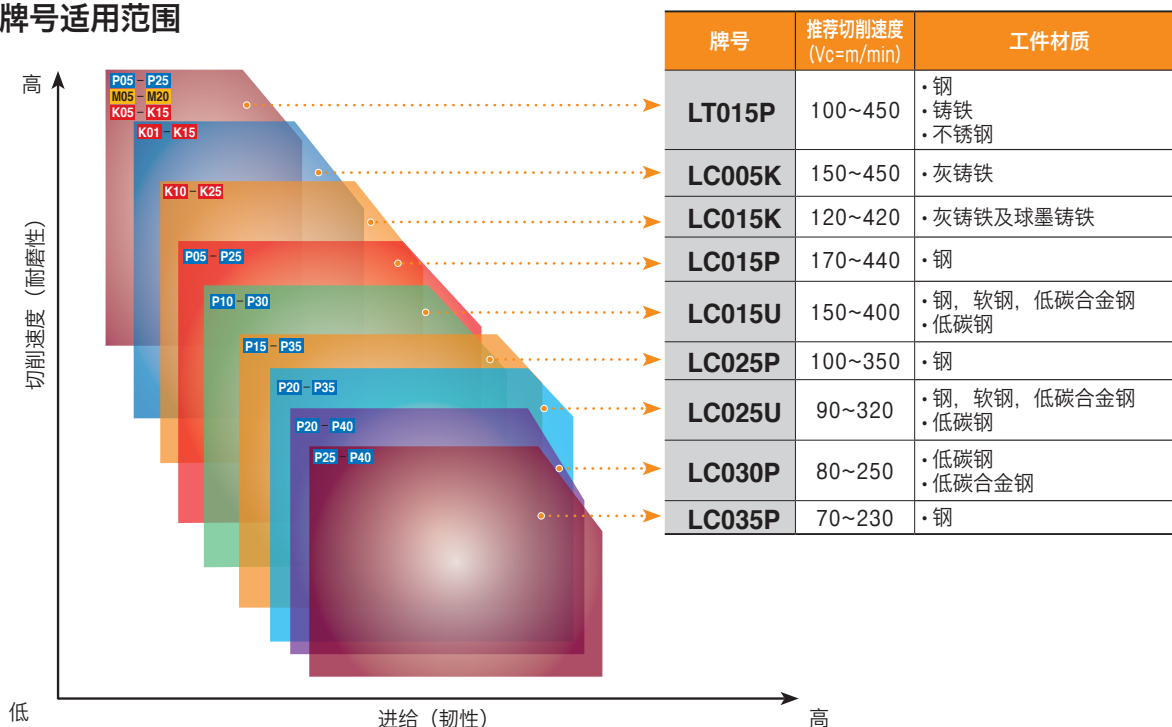


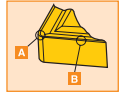


牌号表


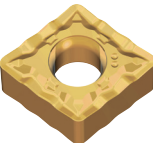
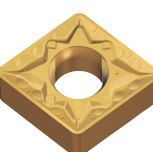

牌号	ISO	特点及应用范围
LT015P 金属陶瓷	P05 - P25 M05 - M20 K05 - K15	<ul style="list-style-type: none"> 钢, 不锈钢, 铸铁高速加工 耐磨性好 钢件精加工时高表面光洁度要求的首选
LC005K CVD 涂层	K01 - K15	<ul style="list-style-type: none"> 灰铁及球墨铸铁的高速连续加工 耐磨性好
LC015K CVD 涂层	K10 - K25	<ul style="list-style-type: none"> 灰铁及球墨铸铁的首选牌号 在灰铸铁及球墨铸铁的断续加工中性能依然强劲 优越的抗崩刃性
LC015P CVD 涂层	P05 - P25	<ul style="list-style-type: none"> 钢件高速连续加工 耐磨性好, 钢件粗精加工时寿命优
LC025P CVD 涂层	P15 - P35	<ul style="list-style-type: none"> 钢件加工的首选牌号, 通用性强 耐磨性和抗崩刃性的最佳组合, 可用于断续切削
LC030P CVD 涂层	P20 - P40	<ul style="list-style-type: none"> 强抗崩刃基体, 耐磨性好 基体韧性好, 可用于钢件的断续加工
LC035P CVD 涂层	P25 - P40	<ul style="list-style-type: none"> 韧性好的基体及耐磨性好 钢件的低速及断续加工
LC015U CVD 涂层	P10 - P30	<ul style="list-style-type: none"> 高耐磨性的基体和涂层组合, 适合普通钢件加工 适合软钢, 低碳钢, 低碳合金钢 LC015P牌号的辅助牌号
LC025U CVD 涂层	P20 - P35	<ul style="list-style-type: none"> 耐磨性及抗崩刃性好的基体与涂层结合, 适合钢件低速加工 抗崩刃性好, 适合断续加工 适合软钢, 低碳钢以及低碳合金钢的加工 LC025P牌号的辅助牌号

牌号适用范围



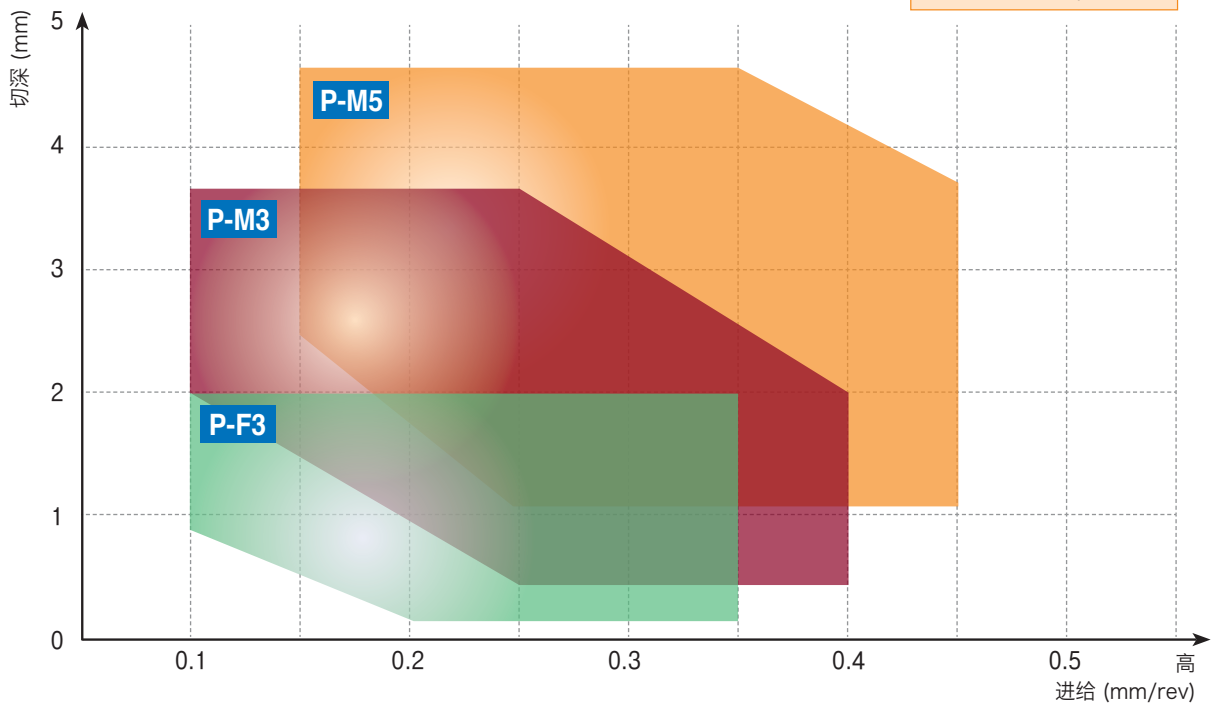


断屑槽

断屑槽型		特点及应用范围
P-F3	  	<ul style="list-style-type: none"> • 3维断屑槽型，适用于精加工到半精加工，适用范围广且断屑性能强
P-M3	  	<ul style="list-style-type: none"> • 适用于工况复杂的情况及断续加工 • 半精及中等加工
P-M5	  	<ul style="list-style-type: none"> • 钢件的中等及粗加工 • 适合连续及断续加工

断屑槽适用范围

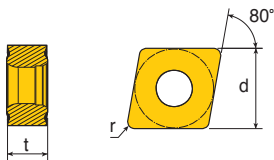
工件材质: SM45C
切削速度: 200m/min





CNMG 负型80° 双面菱形刀片

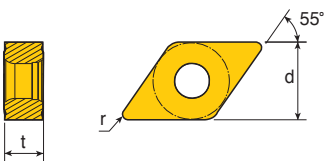
规格	d	t	r
CNMG 090404	9.525	4.76	0.4
090408	9.525	4.76	0.8
090412	9.525	4.76	1.2



刀片	规格	推荐切削参数		牌号						
		进给 (mm/rev)	切深 (mm)	金属陶瓷	CVD涂层					
				LT015P	LC005K	LC015K	LC015P	LC025P	LC030P	LC035P
	CNMA 090408	0.15 - 0.60	1.00 - 4.00		●	●				
	090412	0.15 - 0.70	1.00 - 4.00		●	●				
	CNMG 090404 P-F3	0.07 - 0.30	0.25 - 2.00	●			●	●	●	
	090408 P-F3	0.10 - 0.35	0.30 - 2.00	●			●	●	●	
	090412 P-F3	0.15 - 0.40	0.35 - 2.00	●			●	●	●	
	CNMG 090404 P-M3	0.07 - 0.30	0.40 - 3.50				●	●	●	●
	090408 P-M3	0.10 - 0.40	0.50 - 3.50				●	●	●	●
	090412 P-M3	0.15 - 0.50	0.60 - 3.50				●	●	●	●
	CNMG 090404 P-M5	0.10 - 0.35	0.80 - 4.50				●	●	●	●
	090408 P-M5	0.15 - 0.45	1.00 - 4.50				●	●	●	●
	090412 P-M5	0.20 - 0.55	1.20 - 4.50				●	●	●	●

DNMG 负型55° 双面菱形刀片

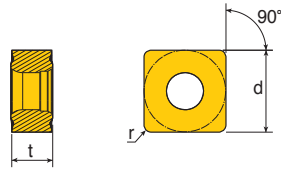
规格	d	t	r
DNMG 130504	11.113	5.56	0.4
130508	11.113	5.56	0.8
130512	11.113	5.56	1.2



刀片	规格	推荐切削参数		牌号						
		进给 (mm/rev)	切深 (mm)	金属陶瓷	CVD涂层					
				LT015P	LC005K	LC015K	LC015P	LC025P	LC030P	LC035P
	DNMG 130504 P-F3	0.07 - 0.30	0.25 - 2.00	●			●	●	●	
	130508 P-F3	0.10 - 0.35	0.30 - 2.00	●			●	●	●	
	130512 P-F3	0.15 - 0.40	0.35 - 2.00	●			●	●	●	
	DNMG 130504 P-M3	0.07 - 0.30	0.25 - 3.50				●	●	●	●
	130508 P-M3	0.10 - 0.40	0.30 - 3.50				●	●	●	●
	130512 P-M3	0.15 - 0.50	0.35 - 3.00				●	●	●	●
	DNMG 130504 P-M5	0.10 - 0.35	0.80 - 4.50				●	●	●	●
	130508 P-M5	0.15 - 0.45	1.00 - 4.50				●	●	●	●
	130512 P-M5	0.18 - 0.55	1.20 - 4.50				●	●	●	●

SNMG 负型90° 双面方形刀片

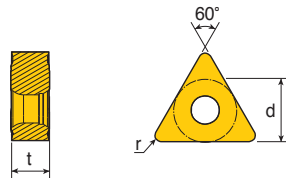
规格	d	t	r
SNMG 090404	9.525	4.76	0.4
090408	9.525	4.76	0.8
090412	9.525	4.76	1.2



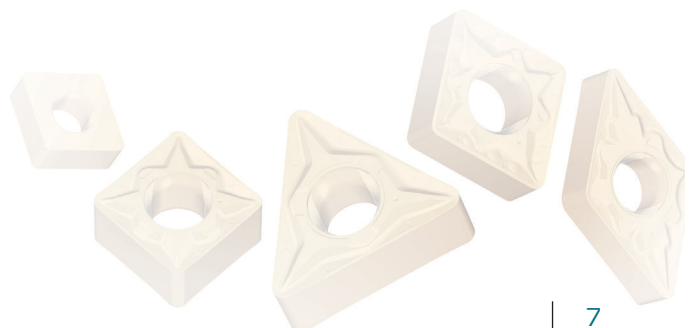
刀片	规格	推荐切削参数		牌号						
				金属陶瓷		CVD涂层				
				LT015P	LC005K	LC015K	LC015P	LC025P	LC030P	LC035P
		进给 (mm/rev)	切深 (mm)							
	SNMG 090404 P-F3	0.07 - 0.30	0.25 - 2.00	●			●	●	●	
	090408 P-F3	0.10 - 0.35	0.30 - 2.00	●			●	●	●	
	090412 P-F3	0.15 - 0.40	0.35 - 2.00	●			●	●	●	
	SNMG 090404 P-M5	0.10 - 0.35	0.80 - 4.00				●	●	●	●
	090408 P-M5	0.15 - 0.45	1.00 - 4.00				●	●	●	●
	090412 P-M5	0.18 - 0.55	1.20 - 4.00				●	●	●	●

TNMG 负型60° 双面三角形刀片

规格	d	t	r
TNMG 130404	7.94	4.76	0.4
130408	7.94	4.76	0.8
130412	7.94	4.76	1.2

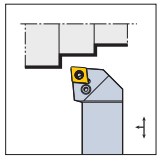


刀片	规格	推荐切削参数		牌号						
				金属陶瓷		CVD涂层				
				LT015P	LC005K	LC015K	LC015P	LC025P	LC030P	LC035P
		进给 (mm/rev)	切深 (mm)							
	TNMG 130404 P-F3	0.07 - 0.30	0.25 - 1.50	●			●	●	●	
	130408 P-F3	0.07 - 0.30	0.30 - 1.50	●			●	●	●	
	130412 P-F3	0.07 - 0.30	0.35 - 1.50	●			●	●	●	
	TNMG 130404 P-M3	0.07 - 0.30	0.25 - 2.50				●	●	●	●
	130408 P-M3	0.10 - 0.40	0.30 - 2.50				●	●	●	●
	130412 P-M3	0.15 - 0.50	0.35 - 2.50				●	●	●	●
	TNMG 130404 P-M5	0.10 - 0.35	0.80 - 3.50				●	●	●	●
	130408 P-M5	0.15 - 0.45	1.00 - 3.50				●	●	●	●
	130412 P-M5	0.18 - 0.55	1.20 - 3.50				●	●	●	●

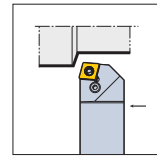
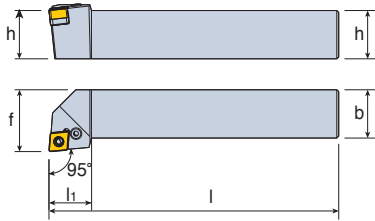




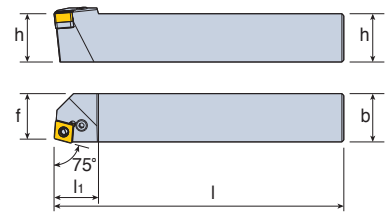
PCLNR/L PCBNR/L



PCLNR/L

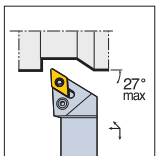


PCBNR/L

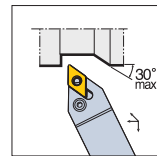
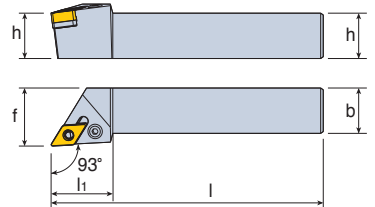


主偏角	规格	尺寸(mm)					刀片	配件				
		h	b	l	l ₁	f		杠杆	螺钉	刀垫	刀垫卡簧	扳手
95°	PCLNR/L 1616 H0904	16	16	100	22	20	CNMA 0904 □□ CNMG 0904 □□	LCL 09-NX	LCS 3	LSC 32A	LSP 3A	L-W 2.5
	2020 K0904	20	20	125	22	25						
	2525 M0904	25	25	150	22	32						
75°	PCBNR/L 2020 K0904	20	20	125	23	18.56						
	2525 M0904	25	25	150	23	23.56						

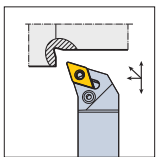
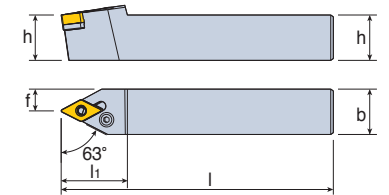
PDJNR/L PDNNR/L PDQNR/L



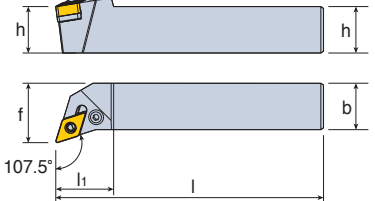
PDJNR/L



PDNNR/L

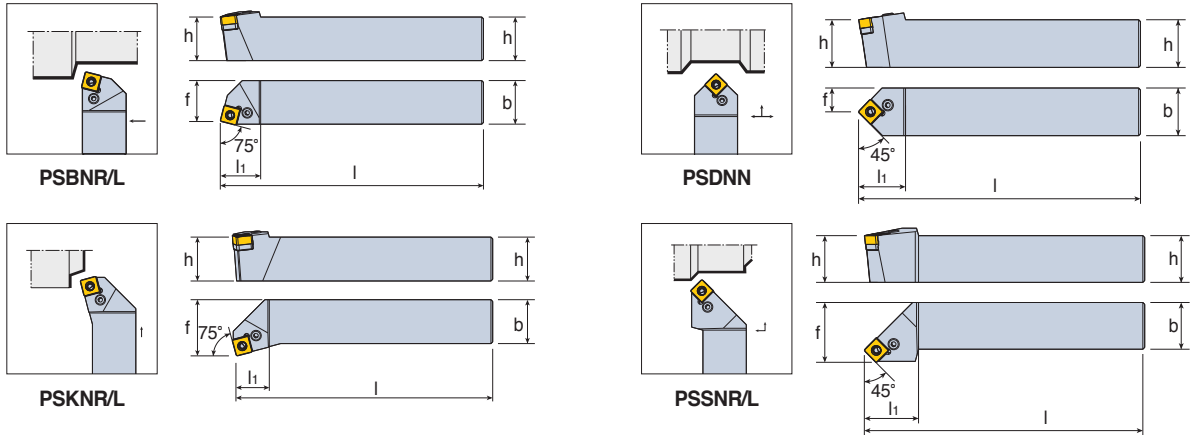


PDQNR/L



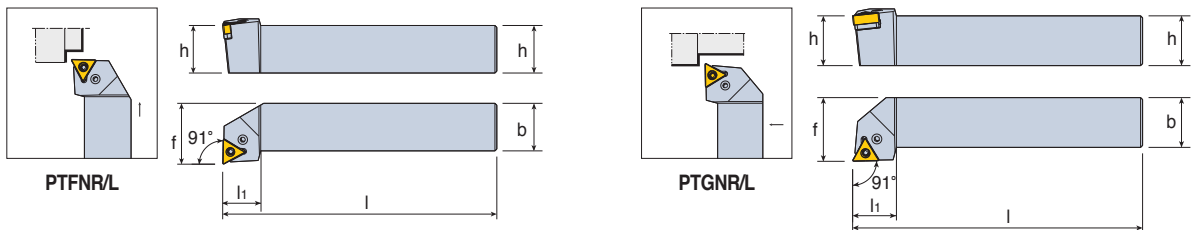
主偏角	规格	尺寸(mm)					刀片	配件				
		h	b	l	l ₁	f		杠杆	螺钉	刀垫	刀垫卡簧	扳手
93°	PDJNR/L 2020 K1305	20	20	125	34	25	DNMG 1305 □□	LCL 11-NX	LCS 4	LSD 3.52	LSP 4	L-W 3
	2525 M1305	25	25	150	34	32						
63°	PDNNR/L 2020 K1305	20	20	125	36.5	10						
	2525 M1305	25	25	150	36.5	12						
107.5°	PDQNR/L 2020 K1305	20	20	125	31	25						
	2525 M1305	25	25	150	31	32						

PSBNR/L PSDNN PSKNR/L PSSNR/L



主偏角	规格	尺寸(mm)					刀片	配件				
		h	b	l	l ₁	f		杠杆	螺钉	刀垫	刀垫卡簧	扳手
75°	PSBNR/L 2020 K0904	20	20	125	23	18.5	SNMG 0904 □□	LCL 09-NX	LCS 3	LSS 32A	LSP 3A	L-W 2.5
	2525 M0904	25	25	150	23	23.5						
45°	PSDNN 2020 K0904	20	20	125	25	10						
	2525 K0904	25	25	150	25	12.5						
75°	PSKNR/L 2020 K0904	20	20	125	19	25						
	2525 M0904	25	25	150	19	32						
45°	PSSNR/L 2020 K0904	20	20	125	21.5	25						
	2525 M0904	25	25	150	29	32						

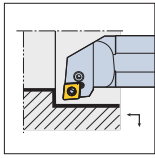
PTFNR/L PTGNR/L



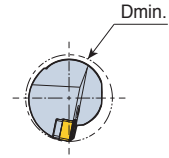
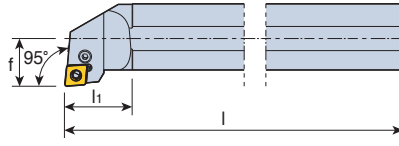
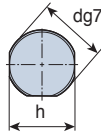
主偏角	规格	尺寸(mm)					刀片	配件				
		h	b	l	l ₁	f		杠杆	螺钉	刀垫	刀垫卡簧	扳手
91°	PTFNR/L 2020 K1304	20	20	125	20	25	TNMG 1304 □□	LCL 08-NX	LCS 3-NX	LST 2.51.8	LSP 3B	L-W 2.5
	2525 M1304	25	25	150	20	32						
91°	PTGNR/L 1616 H1304	16	16	100	22	20						
	2020 K1304	20	20	125	22	25						
	2525 M1304	25	25	150	22	32						



S-PCLNR/L

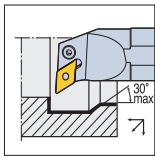


S-PCLNR/L

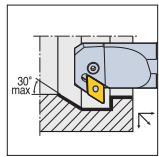
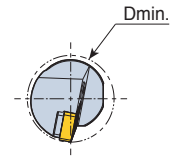
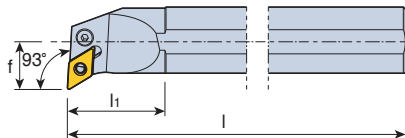
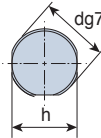


规格	尺寸(mm)							刀片	配件					
	d	h	l	l ₁	f	D	杠杆		螺钉	刀垫	刀垫卡簧	卡环	扳手	
S16Q PCLNR/L 0904	16	15	180	25	11	20	CNMA 0904 □□ CNMG 0904 □□	LCL 09B- NX	LCS 3B	-	-	LSR 3B	L-W 2	
S20Q PCLNR/L 0904	20	18	180	28	13	25								
S25R PCLNR/L 0904	25	23	200	31	17	32		LCL 09-NX	LCS 3	LSC 32	LSP 3A	-	L-W 2.5	
S32S PCLNR/L 0904	32	30	250	31	22	40								

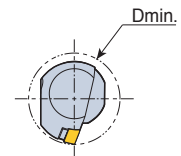
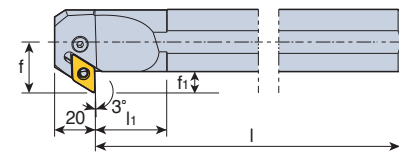
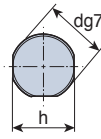
S-PDUNR/L



S-PDUNR/L

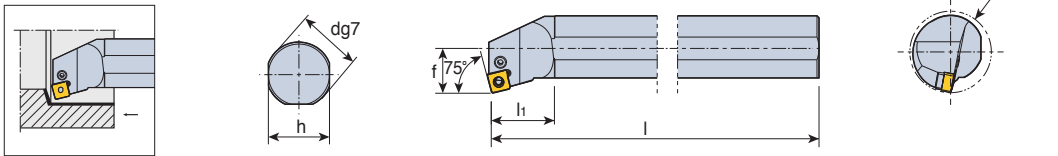


S-PDZNR/L



规格	尺寸(mm)							刀片	配件					
	d	h	l	l ₁	f	f ₁	D		杠杆	螺钉	刀垫	刀垫卡簧	卡环	扳手
S32S PDUNR/L 1305	32	30	250	45	22	-	40	DNMG 1305 □□	LCL 11-NX	LCS 4S	LSD 3.52B	LSP 4	-	L-W 3
S40T PDUNR/L 1305	40	37	300	55	27	-	50							
S32S PDZNR/L 1305	32	30	250	35	25	10.5	45							
S40T PDZNR/L 1305	40	37	300	40	29	10.5	50							

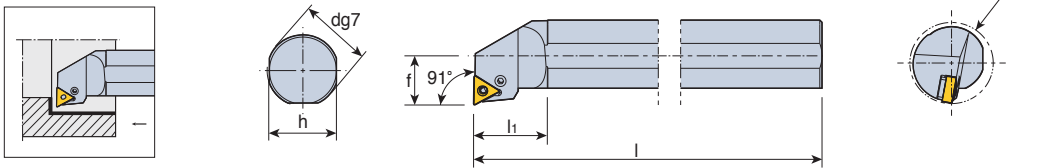
S-PSKNR/L



S-PSKNR/L

规格	尺寸(mm)						刀片	配件					
	d	h	l	l ₁	f	D		杠杆	螺钉	刀垫	刀垫卡簧	卡环	扳手
S25R PSKNR/L 0904	25	23	200	31	17	32	SNMG			-	-	LSR 3B	L-W 2
S32S PSKNR/L 0904	32	30	250	31	22	40	0904 □□			LSS 32	LSP 3A	-	L-W 2.5

S-PTFNR/L



S-PTFNR/L

规格	尺寸(mm)						刀片	配件					
	d	h	l	l ₁	f	D		杠杆	螺钉	刀垫	刀垫卡簧	卡环	扳手
S16Q PTFNR/L 1304	16	15	180	25	11	20	TNMG 1304 □□			-	-	LSR 3B	L-W 2
S20Q PTFNR/L 1304	20	18	180	28	13	25				-	-	LSR 3B	
S25R PTFNR/L 1304	25	23	200	33	17	32				LST 2.51.8B	LSP 3B	-	L-W 2.5
S32S PTFNR/L 1304	32	30	250	33	22	40				LST 2.51.8B	LSP 3B	-	L-W 2.5

