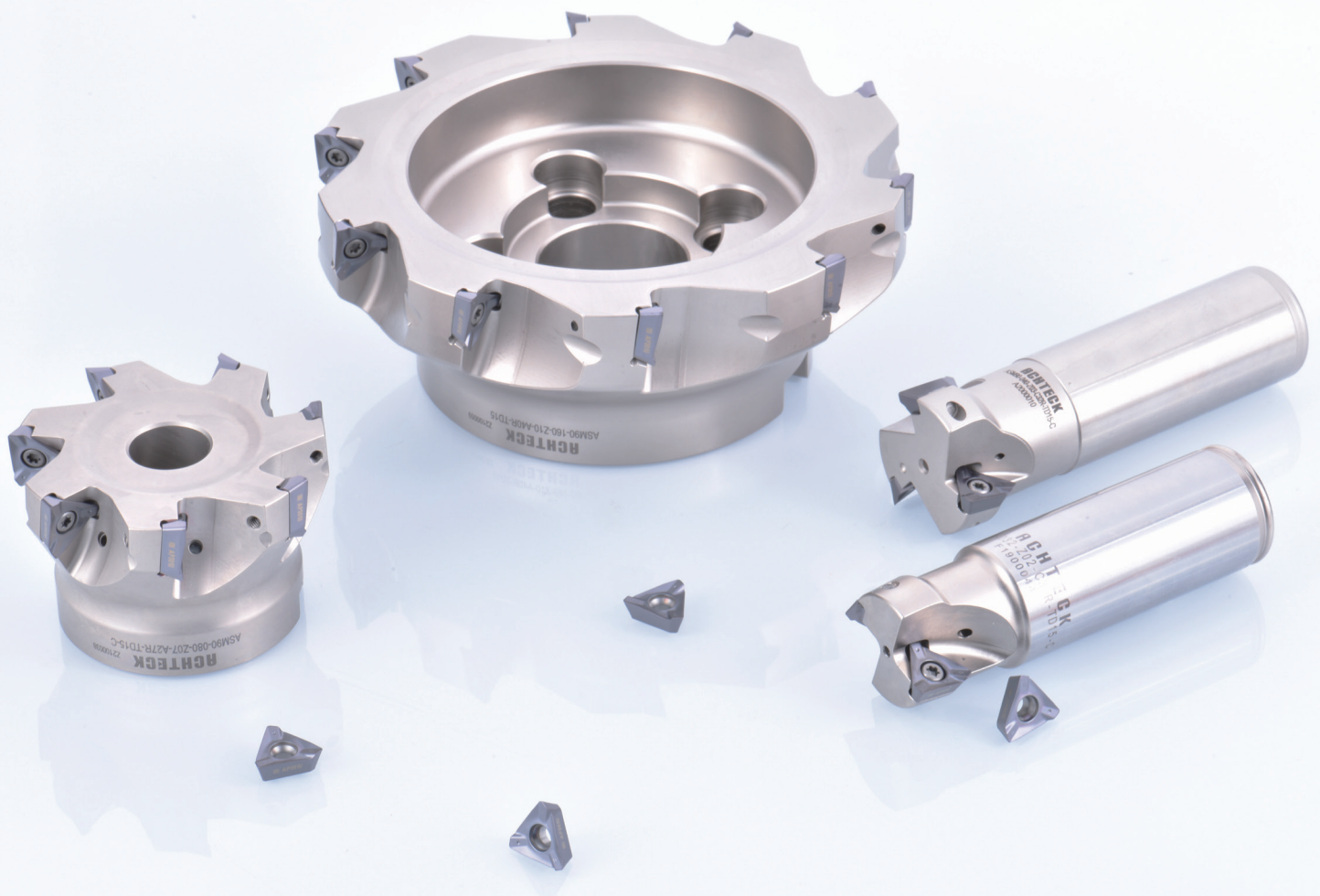


**NEW
PRODUCT!**

NPI (新产品介绍)

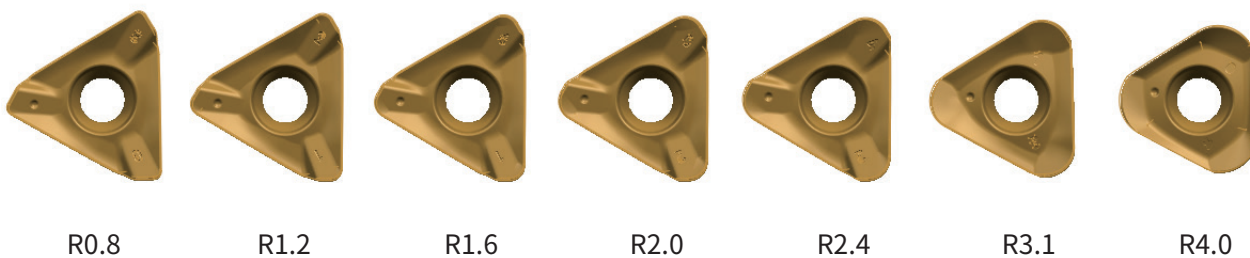
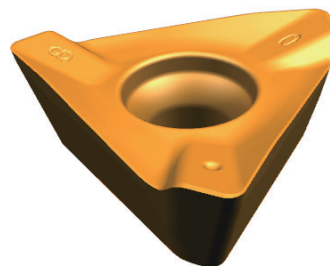
ASM90-TD15系列方肩铣刀



• ASM90-TD15刀片介绍

刀片特点:

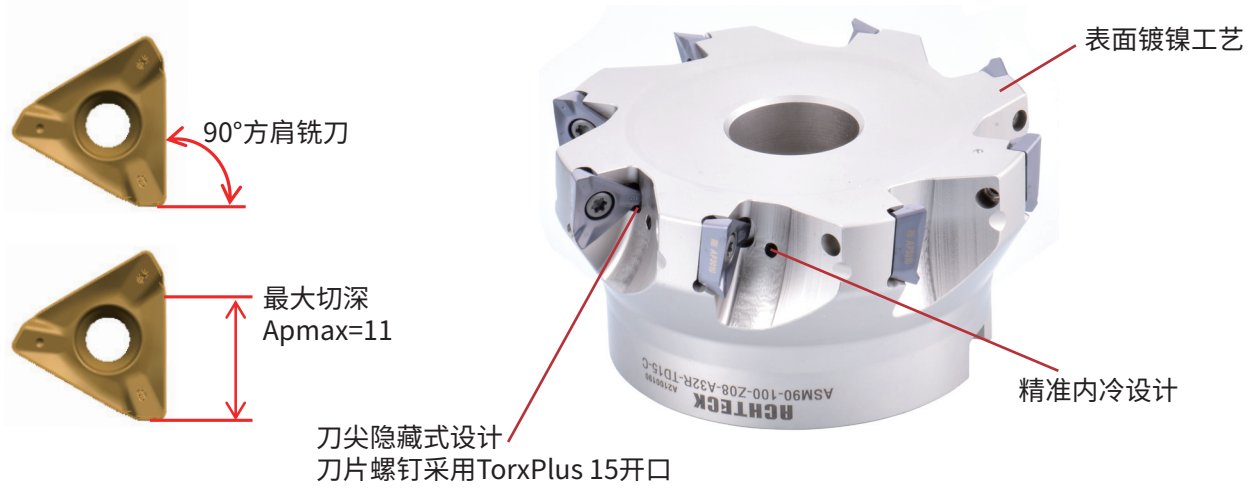
- 正型铣刀片
- 三个切削刃,经济型好
- 正前角及带螺旋角设计,切削轻快
- 刀片带短修光刃设计
- 有M和H级刀片选择



• 刀片类型:

- 圆角范围:R0.8,R1.2,R1.6,R2.0,R2.4,R3.1,R4.0
- 槽型:MM4, MM3, FM2
- 材质:AP301U,AP351M,AP403M,AC301K,AP351K

• **ASM90-TD15刀盘介绍**

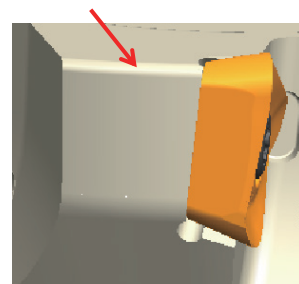
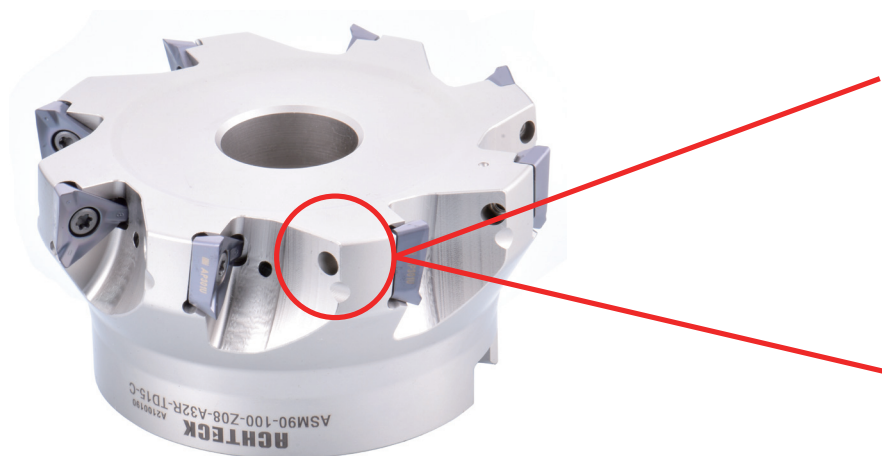


- 应用范围:适用于方肩铣、面铣、槽铣、斜坡铣、螺纹插补铣
- 通用性好:适用钢件、铸铁、不锈钢的粗,半精和精加工场合
- 刀体两种齿距:密齿和疏齿
- 两种接口
刀杆式直径:Φ32-40mm
芯轴式直径:Φ40-200mm

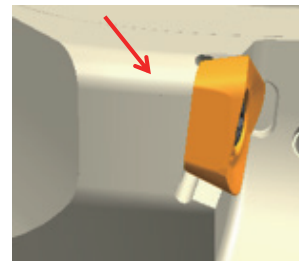


• **ASM90-TD15刀盘介绍**

当使用大圆角刀片时,刀体需要改制



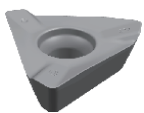

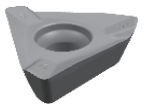

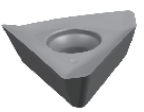

改制前



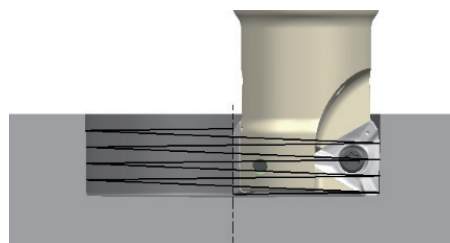
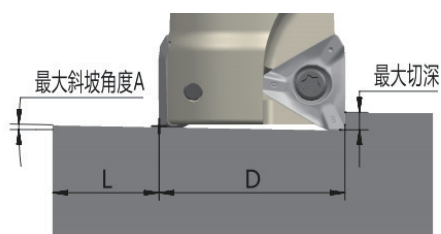
改制后

TDMT 150531R-MM4	刀盘端面周边R角车削至R2.0
TDMT 150540R-MM4	刀盘端面周边R角车削至R4.0

• **TD15系列刀片槽型和牌号描述**

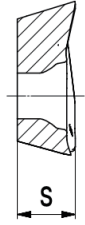
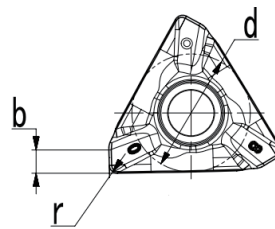
刀片	断屑槽	刃口形状	应用场合
	MM4		<ul style="list-style-type: none"> · 用于中等加工工况 · 通用加工首选槽型
	MM3		<ul style="list-style-type: none"> · 用于较好的工况及精加工 · 切削力低,可用于小功率机床
	FM2		<ul style="list-style-type: none"> · 锋利槽型 · 低切削力槽型,用于弱工况 · 用于铝合金材料加工

◆ **ASM90-TD15刀盘应用参数推荐**



刀具直径 (mm)	直线斜坡铣削			螺旋插补铣孔		
	最大斜坡角 (°)	最小长度 (mm)	最大切深 (mm)	最小加工孔径 (mm)	最大加工孔径 (mm)	最大螺距 (mm)
32	1.4°	479	11.5	53.5		1.4
	1.4°	479	11.5		64.0	2.1
40	1.0°	633	11.5	70.1		1.5
	0.7°	957	11.5		80.0	1.3
50	0.8°	824	11.5	90.1		1.5
	0.8°	824	11.5		100.0	1.9
63	0.6°	1073	11.5	116.1		1.5
	0.6°	1073	11.5		126.0	1.8
80	0.5°	1399	11.5	150.3		1.5
	0.5°	1399	11.5		160.0	1.8
100	0.3°	2144	11.5	190.5		1.3
	0.3°	2144	11.5		200.0	1.4
125	0.3°	2262	11.5	240.3		1.6
	0.3°	2262	11.5		250.0	1.7
160	0.2°	2933	11.5	310.3		1.6
	0.2°	2933	11.5		320.0	1.7
200	0.2°	3692	11.5	390.3		1.6
	0.2°	3692	11.5		400.0	1.7

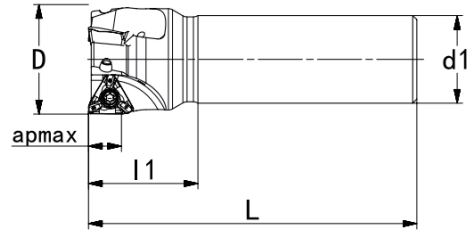
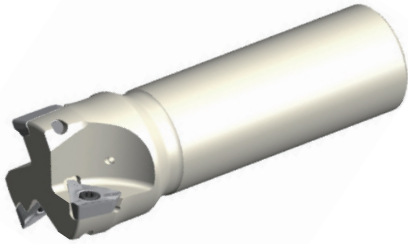
◆ TD15刀片型号



型号	尺寸				牌号								
	d	b	s	r	AP301U	AC301P	AP351U	AP403M	AP351M	AC301K	AP351K	AP403S	AW100K
TDMT 150508R-MM4	11.40	1.49	5.6	0.8	●			●	●	●	●		
TDMT 150512R-MM4	11.40	1.0	5.6	1.2	●			●	●	●	●		
TDMT 150516R-MM4	11.40	0.93	5.6	1.6	●			●	●	●	●		
TDMT 150520R-MM4	11.40	0.71	5.6	2.0	●			●					
TDMT 150524R-MM4	11.40	0.59	5.6	2.4				●					
TDMT 150531R-MM4	11.40	0.4	5.56	3.1				●					
TDMT 150540R-MM4	11.40	0.4	5.56	4.0				●					
TDMT 150508R-MM3	11.40	1.49	5.56	0.8	●			●	●				
TDHT 150508R-MM4	11.40	1.5	5.6	0.8	●			●	●				
TDHT 150508R-MM3	11.40	1.53	5.6	0.8	◎			◎	◎				
TDHT 150508R-FM2	11.40	1.62	5.6	0.8									◎

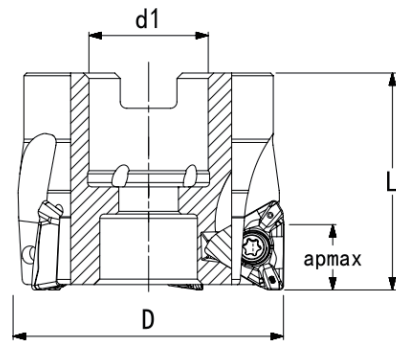
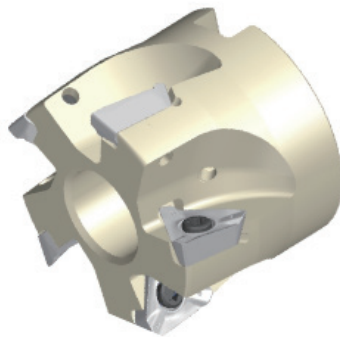
◆ **ASM90-TD15 刀体**

圆柱柄



型号	D	d1	L	L1	apmax	内冷	Z	刀片
ASM90-032-Z02-C32R-TD15-C	32	32	110	40	11	2		TD..1505..
ASM90-032-Z02-C32R-TD15-L200-C	32	32	200	40	11	2		
ASM90-040-Z03-C32R-TD15-C	40	32	120	40	11	3		
ASM90-040-Z03-C32R-TD15-L200-C	40	32	200	40	11	3		

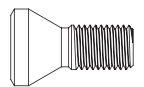
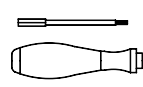

芯轴式



型号	D	d1	L	apmax	内冷	Z	刀片
ASM90-040-Z04-A16R-TD15-C	40	16	4	11		4	TD..1505..
ASM90-050-Z04-A22R-TD15-C	50	22	40	11		4	
ASM90-050-Z05-A22R-TD15-C	50	22	40	11		5	
ASM90-063-Z04-A22R-TD15-C	63	22	40	11		4	
ASM90-063-Z05-A22R-TD15-C	63	22	40	11		5	
ASM90-063-Z06-A22R-TD15-C	63	22	40	11		6	
ASM90-080-Z05-A27R-TD15-C	80	27	50	11		5	
ASM90-080-Z06-A27R-TD15-C	80	27	50	11		6	

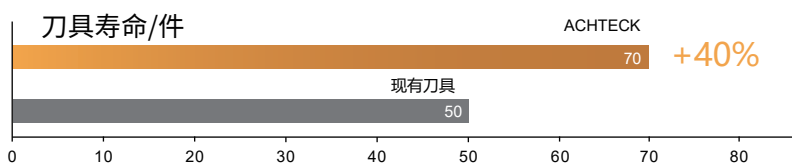
◆ **ASM90-TD15 刀体**

型号	D	d1	L	apmax	内冷	Z	刀片
ASM90-080-Z07-A27R-TD15-C	80	27	50	11		7	TD..1505..
ASM90-100-Z06-A32R-TD15-C	100	32	50	11		6	
ASM90-100-Z08-A32R-TD15-C	100	32	50	11		8	
ASM90-125-Z07-A40R-TD15-C	125	40	63	11		7	
ASM90-125-Z09-A40R-TD15-C	125	40	63	11		9	
ASM90-160-Z08-A40R-TD15	160	40	63	11		8	
ASM90-160-Z10-A40R-TD15	160	40	63	11		10	
ASM90-200-Z09-A60R-TD15	200	60	63	11		9	
ASM90-200-Z11-A60R-TD15	200	60	63	11		11	

尺寸		刀盘配件			
刀盘直径	螺钉型号	扳手型号	扭力值		
φ32-200			3.5Nm		
	SP040100H	DT-TP15			
ASM90-040-Z04-A16R-TD15-C	安装螺栓		螺栓型号	WD080300	

加工案例-01

工件名称:泵体
加工材料:HT250
刀片型号:TDMT 150508R-MM4 AC301K
刀盘型号:ASM90-050-Z05-A22R-TD15-C
加工内容:铣四周平面
切削参数: $V_c=280\text{m/min}$, $a_p=0.5\text{mm}$, $f_z=0.3$
切削方式:湿切

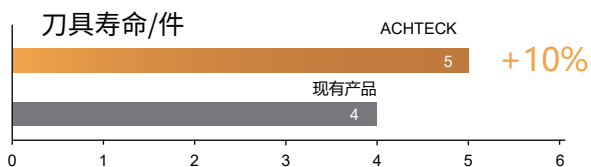


对比结果: ACHTECK刀具寿命比现有刀具提高40%



加工案例-02

工件名称:导轨
加工材料:Q235
刀片型号:TDMT 150508R-MM4 AP301U
刀盘型号:ASM90-100-Z08-A32R-TD15-C
加工内容:铣导轨面
切削参数: $V_c=200\text{m/min}$, $a_p=0.5\text{mm}$, $f_z=0.12$
切削方式:湿切



对比结果: ACHTECK刀具寿命比现有刀具提高10%

