

NEW
PRODUCT!

AC350P

钢件车削CVD涂层新牌号

在低速和强断续加工时有良好的切削性能

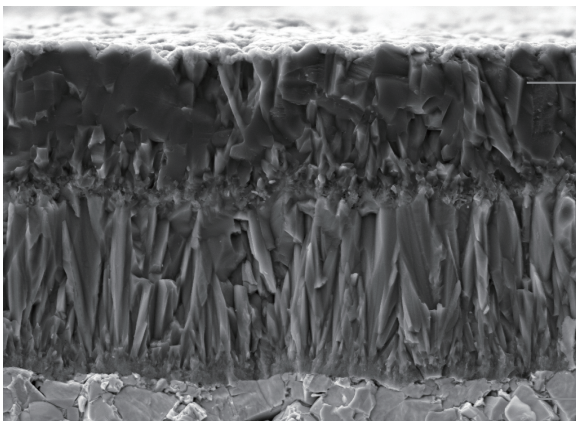


澳克泰工具现推出一款全新的车削CVD牌号产品-AC350P,它能在低速和强断续加工钢件时提供优异的切削性能。该牌号具有高钴、中颗粒基体结构结合澳克泰CVD涂层，增强了刀片的强度和韧性。全新的AC350P牌号的车削刀片，在钢件低切削速度、重型切削和强断续切削加工应用中，保证了加工工序的稳定性，从而获得较好的刀具使用寿命。

● AC350P牌号特征

涂层种类: CVD

ISO 等级: P30-P45



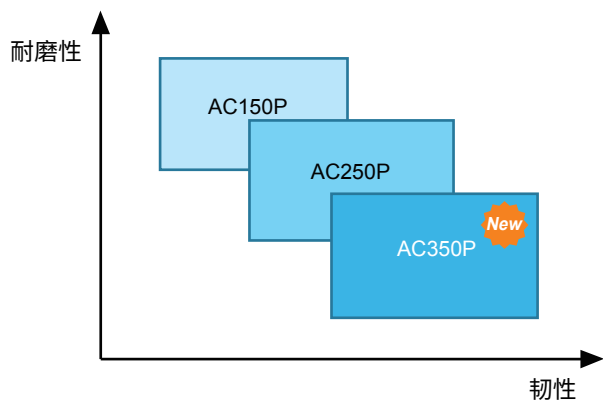
新型CVD涂层

高钴、中颗粒基体，优异的韧性和硬度

<电镜显微结构>

- 全新CVD涂层，具有高的抗氧化性和耐磨性,以及优越的涂层结合力。
- 优异的抗崩刃性能
- 在加工钢件时具有广泛的应用范围从中等到粗加工，适用于低速情况下的钢件中等、粗加工应用
- 良好的加工表面光洁度
- 用于重型切削车削加工

● 应用范围



● 不同材料的推荐切削速度

ISO	分类	材料	强度/硬度		切削速度(m/min)		
					低进给	中等进给	高进给
P (P30-45)	A	非合金钢	<600N/mm ²	<180HBN	250	182	115
	B		<950N/mm ²	<280HBN	160	117	75
	C	合金钢	700-950N/mm ²	200-280HBN	148	109	70
	D		950-1200N/mm ²	280-355HBN	135	100	65
	E		1200-1400N/mm ²	355-415HBN	93	69	45

附注：推荐切削速度指的是在常规条件下的的切削速度。实际的切削速度应当根据实际的加工情况来作调整。如考虑到机床刚性，工件夹紧方式及冷却情况等。

● 加工案例

工件名称：容器外壳

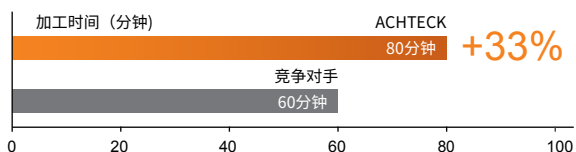
加工材质：合金钢

刀片型号：SNMM 250924S-PD9 AC350P

竞争对手：SNMM 250924-TK CVD涂层牌号

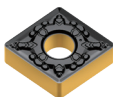
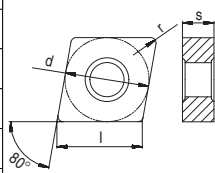
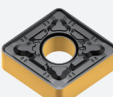
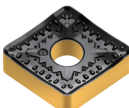
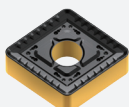
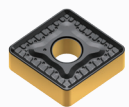
切削参数：Vc=126m/min, f=1.0mm/z

ap=8.0mm, 干切

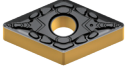

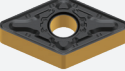

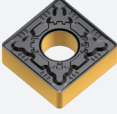
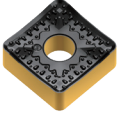
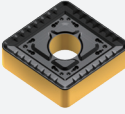
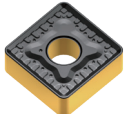


◆ 产品库存表

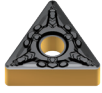
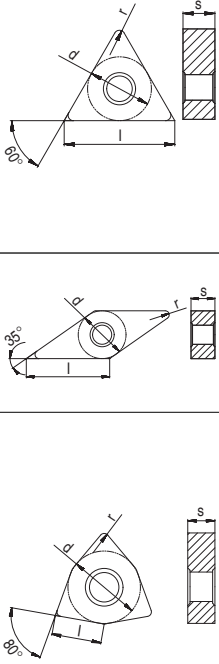

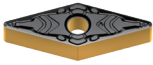
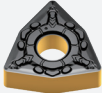
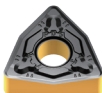
负型刀片

刀片	型号	推荐参数		尺寸(mm)				牌号 (CVD)	几何形状
		进给 (mm/rev)	切深 (mm)	d	l	s	r	AC350P	
	CNMG 120404E-PD3	0.08-0.22	0.40-4.30	12.70	12.9	4.76	0.4	○	
	120408E-PD3	0.15-0.44	0.80-4.30	12.70	12.9	4.76	0.8	●	
	120412E-PD3	0.23-0.66	1.20-4.30	12.70	12.9	4.76	1.2	●	
	160608E-PD3	0.15-0.44	0.80-5.30	15.87	16.1	6.35	0.8	○	
	190608E-PD3	0.15-0.44	0.80-6.40	19.05	19.3	6.35	0.8	○	
	CNMG 120408E-PD5	0.20-0.60	1.20-6.40	12.70	12.9	4.76	0.8	●	
	120412E-PD5	0.30-0.90	1.80-6.40	12.70	12.9	4.76	1.2	●	
	160612E-PD5	0.30-0.90	1.80-8.10	15.87	16.1	6.35	1.2	○	
	160616E-PD5	0.40-1.20	2.40-8.10	15.87	16.1	6.35	1.6	●	
	190612E-PD5	0.30-0.90	1.80-9.70	19.05	19.3	6.35	1.2	○	
	190616E-PD5	0.40-1.20	2.40-9.70	19.05	19.3	6.35	1.6	●	
	CNMM 120408E-PD8	0.16-0.32	1.44-5.20	12.70	12.9	4.76	0.8	●	
	120412E-PD8	0.24-0.48	2.16-5.20	12.70	12.9	4.76	1.2	●	
	160612E-PD8	0.24-0.48	2.16-6.40	15.87	16.1	6.35	1.2	○	
	160616E-PD8	0.32-0.64	2.88-6.40	15.87	16.1	6.35	1.6	○	
	160624E-PD8	0.48-0.96	4.32-6.40	15.87	16.1	6.35	2.4	○	
	190612E-PD8	0.24-0.48	2.16-7.70	19.05	19.3	6.35	1.2	○	
	190616E-PD8	0.32-0.64	2.88-7.70	19.05	19.3	6.35	1.6	●	
	190624E-PD8	0.48-0.96	4.32-7.70	19.05	19.3	6.35	2.4	●	
	250724E-PD8	0.48-0.96	4.32-10.3	25.40	25.8	7.94	2.4	○	
	250924E-PD8	0.48-0.96	4.32-10.3	25.40	25.8	9.52	2.4	●	
	CNMM 190612S-PC9	0.26-0.60	2.40-9.70	19.05	19.3	6.35	1.2	○	
	190616S-PC9	0.35-0.80	3.20-9.70	19.05	19.3	6.35	1.6	○	
	190624S-PC9	0.53-1.20	4.80-9.70	19.05	19.3	6.35	2.4	●	
	250724S-PC9	0.53-1.20	4.80-12.9	25.40	25.8	7.94	2.4	●	
	250924S-PC9	0.53-1.20	4.80-12.9	25.40	25.8	9.52	2.4	○	
	CNMM 190612S-PD9	0.30-0.72	2.64-11.6	19.05	19.3	6.35	1.2	○	
	190616S-PD9	0.40-0.96	3.52-11.6	19.05	19.3	6.35	1.6	○	
	190624S-PD9	0.60-1.44	5.28-11.6	19.05	19.3	6.35	2.4	●	
	250724S-PD9	0.60-1.44	5.28-15.5	25.40	25.8	7.94	2.4	○	
	250924S-PD9	0.60-1.44	5.28-15.5	25.40	25.8	9.52	2.4	●	

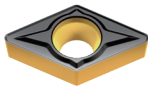
●: 常规库存
○: 按订单生产

刀片	型号	推荐参数		尺寸(mm)				牌号 (CVD)	几何形状
		进给 (mm/rev)	切深 (mm)	d	l	s	r	AC350P	
	DNMG 150408E-PD3	0.15-0.44	0.8-3.9	12.7	15.5	4.76	0.8	●	
	150412E-PD3	0.23-0.66	1.2-3.9	12.7	15.5	4.76	1.2	●	
	150608E-PD3	0.15-0.44	0.8-3.9	12.7	15.5	6.35	0.8	○	
	150612E-PD3	0.23-0.66	1.2-3.9	12.7	15.5	6.35	1.2	○	
	DNMG 150408E-PD5	0.20-0.60	1.2-5.4	12.7	15.5	4.76	0.8	●	
	150412E-PD5	0.30-0.90	1.8-5.4	12.7	15.5	4.76	1.2	●	
	150416E-PD5	0.40-1.20	2.4-5.4	12.7	15.5	4.76	1.6	●	
	150608E-PD5	0.20-0.60	1.2-5.4	12.7	15.5	6.35	0.8	●	
	150612E-PD5	0.30-0.90	1.8-5.4	12.7	15.5	6.35	1.2	○	
	150616E-PD5	0.40-1.20	2.4-5.4	12.7	15.5	6.35	1.6	○	
	SNMG 120404E-PD3	0.08-0.22	0.4-4.2	12.7	12.7	4.76	0.4	○	
	120408E-PD3	0.15-0.44	0.8-4.2	12.7	12.7	4.76	0.8	●	
	120412E-PD3	0.23-0.66	1.2-4.2	12.7	12.7	4.76	1.2	●	
	190608E-PD3	0.15-0.44	0.8-6.3	19.05	19.05	6.35	0.8	○	
	SNMG 150608E-PD5	0.20-0.60	1.2-7.9	15.87	15.87	6.35	0.8	●	
	150612E-PD5	0.30-0.90	1.8-7.9	15.87	15.87	6.35	1.2	●	
	150616E-PD5	0.40-1.20	2.4-7.9	15.87	15.87	6.35	1.6	○	
	190612E-PD5	0.30-0.90	1.8-9.5	19.05	19.05	6.35	1.2	○	
	190616E-PD5	0.40-1.20	2.4-9.5	19.05	19.05	6.35	1.6	○	
	SNMM 120408E-PD8	0.16-0.32	1.44-5.1	12.7	12.7	4.76	0.8	●	
	120412E-PD8	0.24-0.48	2.16-5.1	12.7	12.7	4.76	1.2	○	
	150612E-PD8	0.24-0.48	2.16-6.40	15.87	15.87	6.35	1.2	○	
	190616E-PD8	0.32-0.64	2.88-7.60	19.05	19.05	6.35	1.6	●	
	190624E-PD8	0.48-0.96	4.32-7.60	19.05	19.05	6.35	2.4	●	
	250724E-PD8	0.48-0.96	4.32-10.2	25.4	25.4	7.94	2.4	○	
	250924E-PD8	0.48-0.96	4.32-10.2	25.4	25.4	9.525	2.4	○	
	SNMM 190612S-PC9	0.26-0.60	2.4-9.5	19.05	19.05	6.35	1.2	○	
	190616S-PC9	0.35-0.80	3.20-9.50	19.05	19.05	6.35	1.6	○	
	190624S-PC9	0.53-1.20	4.80-9.50	19.05	19.05	6.35	2.4	●	
	250724S-PC9	0.53-1.20	4.80-12.7	25.4	25.4	7.94	2.4	○	
	250924S-PC9	0.53-1.20	4.80-12.7	25.4	25.4	9.525	2.4	○	
	SNMM 190612S-PD9	0.30-0.72	2.64-11.4	19.05	19.05	6.35	1.2	○	
	190616S-PD9	0.40-0.96	3.52-11.4	19.05	19.05	6.35	1.6	○	
	190624S-PD9	0.60-1.44	5.28-11.4	19.05	19.05	6.35	2.4	●	
	250724S-PD9	0.60-1.44	5.28-15.2	25.4	25.4	7.94	2.4	○	
	250924S-PD9	0.60-1.44	5.28-15.2	25.4	25.4	9.525	2.4	●	

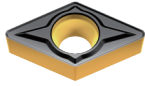

●: 常规库存
○: 按订单生产

刀片	型号	推荐参数		尺寸(mm)				牌号 (CVD)	几何形状
		进给 (mm/rev)	切深 (mm)	d	l	s	r	AC350P	
	TNGM 160404E-PD3	0.08-0.22	0.4-4.1	9.52	16.5	4.76	0.4	○	
	160408E-PD3	0.15-0.44	0.8-4.1	9.52	16.5	4.76	0.8	●	
	160412E-PD3	0.23-0.66	1.2-4.1	9.52	16.5	4.76	1.2	○	
	TNGM 160408E-PD5	0.20-0.60	1.2-5.8	9.52	16.5	4.76	0.8	●	
	160412E-PD5	0.30-0.90	1.8-5.8	9.52	16.5	4.76	1.2	●	
	220408E-PD5	0.20-0.60	1.2-7.7	12.7	22	4.76	0.8	●	
	220412E-PD5	0.30-0.90	1.8-7.7	12.7	22	4.76	1.2	●	
	220416E-PD5	0.40-1.20	2.4-7.7	12.7	22	4.76	1.6	●	
	VNMG 160404E-PD3	0.08-0.22	0.4-3.3	9.52	16.5	4.76	0.4	○	
	160408E-PD3	0.15-0.44	0.8-3.3	9.52	16.5	4.76	0.8	○	
	160412E-PD3	0.23-0.66	1.2-3.3	9.52	16.5	4.76	1.2	○	
	WNMG 080404E-PD3	0.08-0.22	0.4-2.9	12.7	8.7	4.76	0.4	○	
	080408E-PD3	0.15-0.44	0.8-2.9	12.7	8.7	4.76	0.8	●	
	080412E-PD3	0.23-0.66	1.2-2.9	12.7	8.7	4.76	1.2	●	
	WNMG 080408E-PD5	0.20-0.60	1.2-4.3	12.7	8.7	4.76	0.8	●	
	080412E-PD5	0.30-0.90	1.8-4.3	12.7	8.7	4.76	1.2	●	

正型刀片

刀片	型号	推荐参数		尺寸(mm)				牌号 (CVD)	几何形状
		进给 (mm/rev)	切深 (mm)	d	l	s	r	AC350P	
	CCMT 060204E-KC2	0.06-0.18	0.4-2.1	6.35	6.45	2.38	0.4	○	
	060208E-KC2	0.12-0.36	0.8-2.1	6.35	6.45	2.38	0.8	●	
	09T304E-KC2	0.06-0.18	0.4-3.2	9.52	9.67	3.97	0.4	○	
	09T308E-KC2	0.12-0.36	0.8-3.2	9.52	9.67	3.97	0.8	●	
	120404E-KC2	0.06-0.18	0.4-4.3	12.7	12.9	4.76	0.4	○	
	120408E-KC2	0.12-0.36	0.8-4.3	12.7	12.9	4.76	0.8	●	
	120412E-KC2	0.18-0.54	1.2-4.3	12.7	12.9	4.76	1.2	○	
	DCMT 070204E-KC2	0.06-0.18	0.4-2.3	6.35	7.75	2.38	0.4	○	
	070208E-KC2	0.12-0.36	0.8-2.3	6.35	7.75	2.38	0.8	●	
	11T304E-KC2	0.06-0.18	0.4-3.5	9.52	11.63	3.97	0.4	○	
	11T308E-KC2	0.12-0.36	0.8-3.5	9.52	11.63	3.97	0.8	●	
	11T312E-KC2	0.18-0.54	1.2-3.5	9.52	11.63	3.97	1.2	○	

●: 常规库存
○: 按订单生产

刀片	型号	推荐参数		尺寸(mm)				牌号 (CVD)	几何形状
		进给 (mm/rev)	切深 (mm)	d	l	s	r	AC350P	
	DCMT 070204E-KC2	0.06-0.18	0.4-2.3	6.35	7.75	2.38	0.4	○	
	070208E-KC2	0.12-0.36	0.8-2.3	6.35	7.75	2.38	0.8	○	
	11T304E-KC2	0.06-0.18	0.4-3.5	9.52	11.63	3.97	0.4	○	
	11T308E-KC2	0.12-0.36	0.8-3.5	9.52	11.63	3.97	0.8	●	
	11T312E-KC2	0.18-0.54	1.2-3.5	9.52	11.63	3.97	1.2	○	
	SCMT 09T304E-KC2	0.06-0.18	0.4-3.1	9.52	9.52	3.97	0.4	●	
	09T308E-KC2	0.12-0.36	0.8-3.1	9.52	9.52	3.97	0.8	●	
	120404E-KC2	0.06-0.18	0.4-4.2	12.7	12.7	4.76	0.4	○	
	120408E-KC2	0.12-0.36	0.8-4.2	12.7	12.7	4.76	0.8	●	
	120412E-KC2	0.18-0.54	1.2-4.2	12.7	12.7	4.76	1.2	○	
	TCMT 090204E-KC2	0.06-0.18	0.4-2.9	5.56	9	2.38	0.4	○	
	090208E-KC2	0.12-0.36	0.8-2.9	5.56	9	2.38	0.8	○	
	110204E-KC2	0.06-0.18	0.4-3.3	6.35	11	2.38	0.4	○	
	110208E-KC2	0.12-0.36	0.8-3.3	6.35	11	2.38	0.8	○	
	16T304E-KC2	0.06-0.18	0.4-4.9	9.52	16.5	3.97	0.4	○	
	16T308E-KC2	0.12-0.36	0.8-4.9	9.52	16.5	3.97	0.8	●	
	16T312E-KC2	0.18-0.54	1.2-4.9	9.52	16.5	3.97	1.2	○	
	VBMT 160404E-KC2	0.06-0.18	0.4-3.3	9.52	16.61	4.76	0.4	○	
	160408E-KC2	0.12-0.36	0.8-3.3	9.52	16.61	4.76	0.8	●	
	160412E-KC2	0.18-0.54	1.2-3.3	9.52	16.61	4.76	1.2	○	
	RCMX 100300S	0.25-0.50	1.5-4.0	10	-	3.18	5	○	
	120400S	0.30-0.60	2.5-5.0	12	-	4.76	6	●	
	160600S	0.40-0.75	3.0-7.0	16	-	6.35	8	○	
	200600S	0.48-0.90	3.5-9.0	20	-	6.35	10	○	
	250700S	0.55-1.20	4.0-12.0	25	-	7.94	12.5	●	
	320900S	0.65-1.50	5.0-15.0	32	-	9.52	16	○	

●: 常规库存
○: 按订单生产