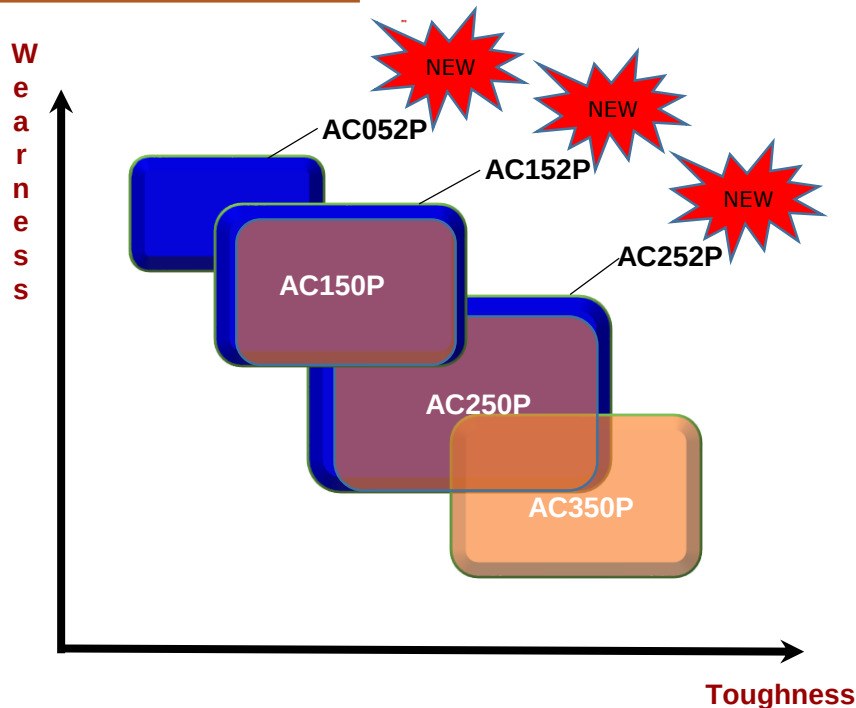


New Grade for Steel

—AC052P/AC152P/AC252P



AC052P, AC152P, AC252P



AC052P: P01-15

It has excellent crater resistance and plastic deformation resistance, Recommended for efficiently medium and rough machining on steel parts under stable machining condition, can bear high temperature and it will not reduce the safety of cutting edge in wet and dry processing applications.

AC152P: P05-25

The new grade of CVD coating carbide used for finishing and roughing on steel parts and steel castings parts, This grade is recommended for continuous cutting and light interrupted cutting, it is upgrade of AC150P.

AC150P: P10-25

Finishing and semi-finishing for steel, high wear resistance grade, Used for high speed cutting and slight interrupted cutting for steel.

AC252P: P15-35

The first choice grade for steel turning, A CVD coated carbide grade for steel parts, casting steel parts and ferritic/martensitic stainless steel parts from finishing to rough turning, this grade is recommended for continuous and interrupted cutting for steel, it is upgrade of AC250P.

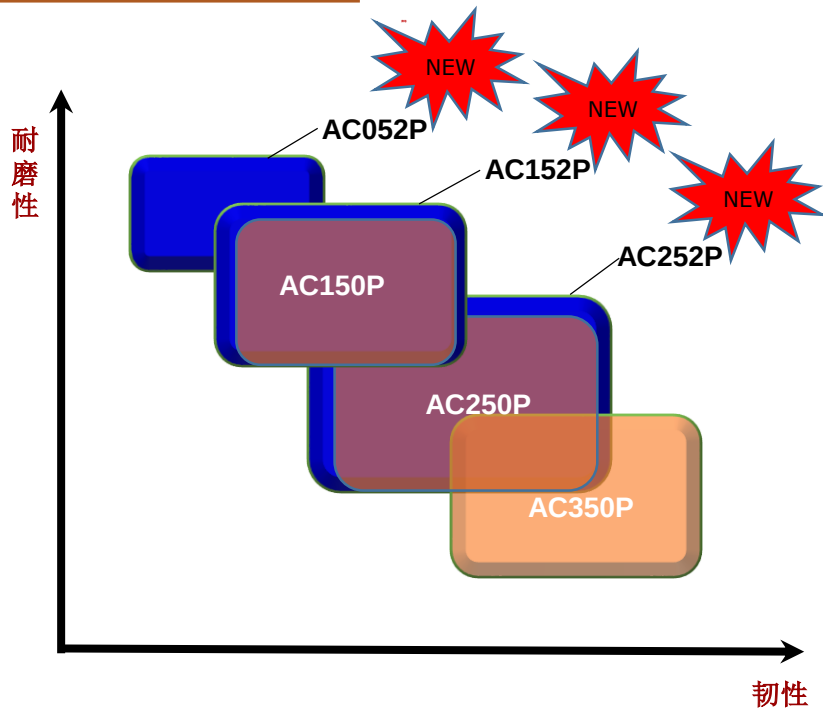
AC250P: P20-35

Steel medium and semi finishing cutting, Good wear resistance and impact resistance, The first choice grade for steel turning.

AC350P: P35-45

Rough machining, low speed cutting, strong interrupted cutting, excellent impact resistance

AC052P, AC152P, AC252P



AC052P: P01-15

具有优异的抗月牙洼和抗塑性变形能力，推荐用于稳定工况下钢件的高效中等加工和粗加工。能承受高温，并且不会降低干湿加工应用中的刃口安全性。

AC152P: P05-25

一种用于对钢件和钢铸件进行精车到粗车的CVD 涂层硬质合金材质。推荐将这种材质用于连续切削以及轻型断续切削。一种能够实现高金属去除率的材质。AC150P的升级

AC150P: P10-25

钢件精加工及半精加工，高耐磨性，用于高速切削及轻微断续切削

AC252P: P15-35

钢件车削的首选材质。用于钢件、铸钢件和铁素体/ 马氏体不锈钢件精车到粗车的CVD 涂层硬质合金材质。推荐将这种材质用于连续切削以及断续切削。AC250P的升级

AC250P: P20-35

钢件中等加工 - 半精加工，良好的耐磨性及抗冲击性。钢件加工第一选择牌号

AC350P: P35-45

粗加工，低速切削，强断续切削，优越的耐冲击性

加工案例Case Study -AC052P

ACHTECK

	普位米特 Pra...t	ACHTECK	ACHTECK
机床Machine	MAZAK		
零件Workpiece	轴套 (40Cr) Shaft sleeve		
刀杆Holder			
刀片Insert	WNMG 080408-RM T9310	WNMG 080408-PD5 AC052P	WNMG 080408-PD3 AC052P
加工类形Machine Type	外圆 External	外圆 External	外圆 External
零件直径 Workpiece Dia	φ 73mm	φ73mm	φ73mm
Vc	195m/min	195m/min	195m/min
f	0.45mm/rev	0.45mm/rev	0.45mm/rev
ap	1.5mm	1.5mm	1.5mm
冷却Coolant	湿切 Wet	湿切 Wet	湿切 Wet
寿命Tool life	20pcs	50pcs	50pcs
备注Note	Improved 150%, AC052P Chip condition normal.		



难加工材料切削专家 THE EXPERT OF DIFFICULT MACHINING

加工案例Case Study -AC052P

ACHTECK

	泰可洛 Tunga...y	ACHTECK	山特维克 Sand. . K
机床Machine	MAZAK		
零件Workpiece	轴套（40Cr） Shaft sleeve		
刀杆Holder			
刀片Insert	WNMG 080408-TM T9215	WNMG 080408-PD3 AC052P	WNMG 080408-PM GC4305
加工类形Machine Type	外圆 External	外圆 External	外圆 External
零件直径 Workpiece Dia	Φ 62mm	Φ 62mm	Φ 62mm
Vc	292m/min	292m/min	292m/min
f	0.2mm/rev	0.2mm/rev	0.2mm/rev
ap	1.25mm	1.25mm	1.25mm
冷却Coolant	湿切 Wet	湿切 Wet	湿切 Wet
寿命Tool life	50~60pcs	60pcs, 60pcs	55pcs, 55pcs
备注Note	Stable and continuous rough turning, AC052P performance best.		



难加工材料切削专家 THE EXPERT OF DIFFICULT MACHINING

加工案例Case Study -AC152P

ACHTECK

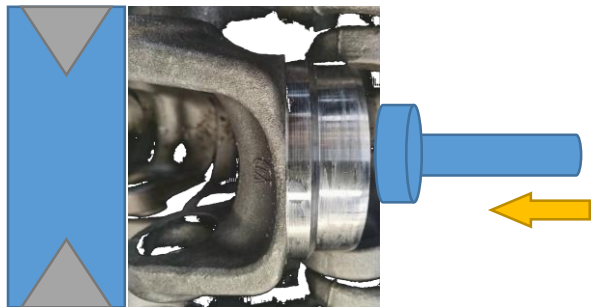
	泰可洛 Tunga...	ACHTECK	山特维克 Sand..K
机床Machine	MAZAK		
零件Workpiece	轴套（40Cr）Shaft sleeve		
刀杆Holder			
刀片Insert	WNMG 080408-TM T9215	WNMG 080408-PD3 AC152P	WNMG 080408-PM GC4315
加工类形 Machine Type	外圆 External	外圆 External	外圆 External
零件直径 Workpiece Dia	Φ 170mm	Φ 170mm	Φ 170mm
Vc	102m/min	102m/min	102m/min
f	0.5mm/rev	0.5mm/rev	0.5mm/rev
ap	2.0mm	2.0mm	2.0mm
冷却Coolant	湿切 Wet	湿切 Wet	湿切 Wet
寿命Tool life	3.5pcs	6pcs	6pcs
备注Note	AC152P better performance than Japanese brand, Equal life with Sand..k		



难加工材料切削专家 THE EXPERT OF DIFFICULT MACHINING

加工案例Case Study -AC252P

	ACHTECK	山特维克 Sand. .K	株钻 ZC...CT	ACHTECK
机床Machine	普通数控车床 Common Lathe			
零件 Workpiece	万向节叉 (Casting 45#) cardan joint			
刀杆Holder				
刀片Insert	CNMG 120408E-PD3 AC252P	CNMG 120408-PM 4325	CNMG 120408-PM YBC251	CNMG 120408E-PD3 AC252P
加工类形 Machine Type	外圆 External	外圆 External	外圆 External	外圆 External
零件直径 Workpiece Dia	Φ 97-110mm	Φ 97-110mm	Φ 97-110mm	Φ 97-110mm
Vc	182-207m/min	182-207m/min	182-207m/min	182-207m/min
f	0.28mm/rev	0.28mm/rev	0.28mm/rev	0.28mm/rev
ap	2.0mm	2.0mm	2.0mm	2.0mm
冷却Coolant	湿切 Wet	湿切 Wet	湿切 Wet	湿切 Wet
寿命Tool life	90	70	43	60
备注Note	Customer using YBC251, Average 300~400pcs workpiece per day one machine, and YBC251 NOT stable in different lot number. AC252P performance best.			



毛坯 Blank



完成品 Finishing

加工案例Case Study -AC252P

ACHTECK

	普拉米特 Tunga...y	ACHTECK	山特维克 Sand..K
机床Machine	普通数控车床 Common Lathe		
零件 Workpiece	齿轮圈 (S48C) Gear ring		
刀杆Holder	-		
刀片Insert	CNMG 120408-PFM2 T9325	CNMG 120408E-PD3 AC252P	CNMG 120408-PM 4325
加工类形 Machine Type	外圆 (断续) External Interrupted	外圆 (断续) External Interrupted	外圆 (断续) External Interrupted
零件直径 Workpiece Dia	φ 530mm	φ 530mm	φ 530mm
Vc	183m/min	183m/min	183m/min
f	0.15mm/rev	0.15mm/rev	0.15mm/rev
ap	2.0mm	2.0mm	2.0mm
冷却Coolant	干切 Dry	干切 Dry	干切 Dry
寿命Tool life	3pcs	4pcs	2pcs
备注Note	Customer used T9125, not good. Pramet cut 3pcs, Can see chipping by eyes, AC252P cut 4pcs still normal.		



难加工材料切削专家 THE EXPERT OF DIFFICULT MACHINING

ACHTECK

谢 谢 观 看

Thank you for attention !



难加工材料切削专家 THE EXPERT OF DIFFICULT MACHINING