

DORMER  **PRAMET**

**T8430 新一代PVD通用车削
材质**

ProLaunch 2021

SAFETY FIRST

Dormer Pramet's objective is **zero harm** to our people, the environment we work in, our customers and our suppliers.



ALARM



EMERGENCY
EXIT



ASSEMBLY
POINT



FIRST AID



PROTECTIVE
EQUIPMENT



EMERGENCY
NUMBER

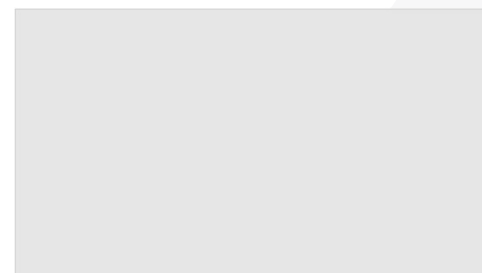


PSYCHOLOGICAL
SAFETY



PROLAUNCH SUMMARY

T8430 新一代PVD通用车削材质



DORMER PRAMET

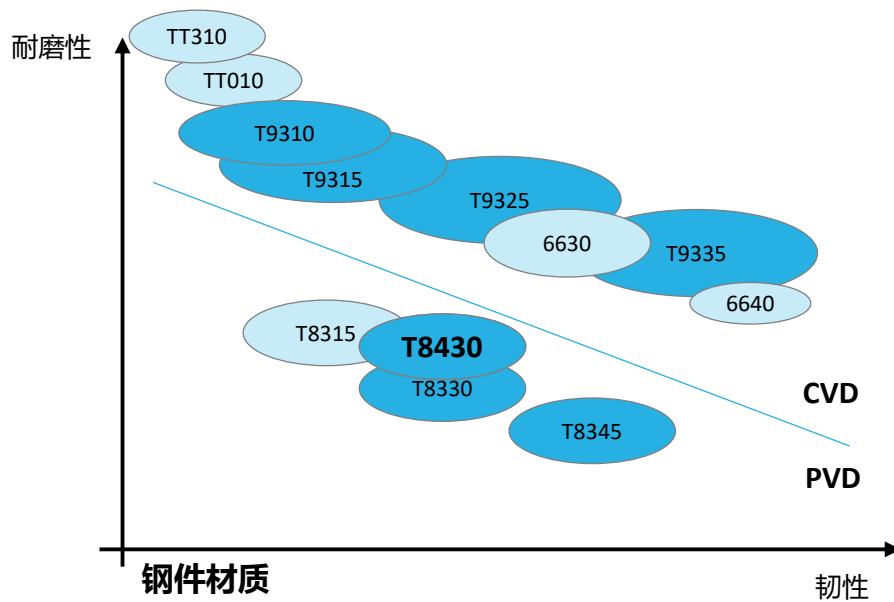
介绍

T8430 新一代PVD通用车削材质



T8430 – 新一代车削材质

产品介绍



为什么要开发T8430材质?

- 需要更有竞争力的材质以提升性能，可以用来替换现有T8330材质的新材质

开发目的

- **效率** – 提升现有性能至少20%
- **可靠性** – 提升抗凹槽磨损和后刀面磨损能力
- **通用性** – 关注主要的ISO材料组;
 - 首选P,M,K材料组
 - 次选S类材料组

可替换性

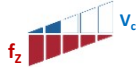
- T8430 $\cong$ T8330

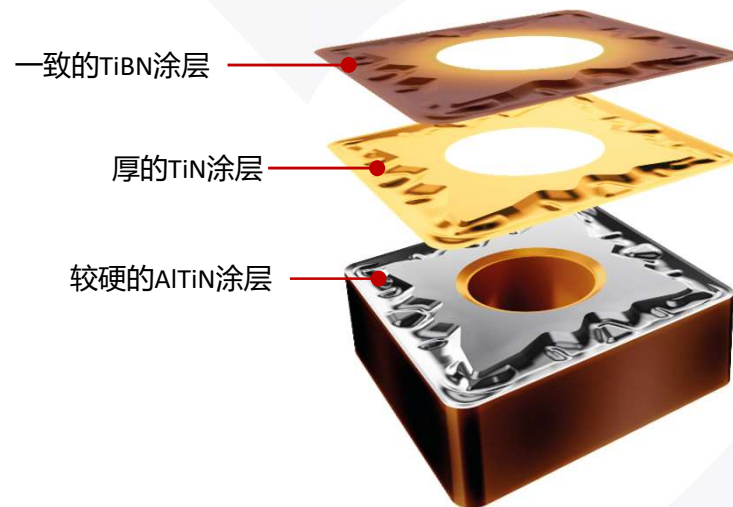
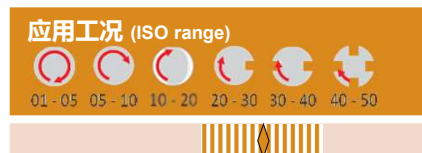
T8430材质

介绍

 **PVD**

T8430		
P	25-40	■
M	20-35	■
K	20-40	■
N		
S	15-25	■
H		





T8430 – 负角刀片预览

介绍



断屑槽			应用工况 	刀片	P	M	K	N	S	H
FF	0.30 – 1.50	0.06 – 0.20		DNMG, TNMG, VNMG	■	■	■			
FM	0.50 – 3.00	0.15 – 0.45		CNMG, DNMG, SNMG, TNMG, VNMG, WNMG	■	■	■			
M	1.00 – 8.00	0.17 – 0.80		CNMG, WNMG	■	■	■			
NF	0.40 – 4.00	0.10 – 0.35		CNMG, DNMG, SNMG, TNMG, VNMG, WNMG	■	■			■	
NM	0.50 – 8.00	0.15 – 0.50		CNMG, DNMG, SNMG, TNMG, VNMG, WNMG	■	■			■	
NMR	0.40 – 8.00	0.18 – 0.70		CNMG, DNMG, SNMG, TNMG, VNMG, WNMG	■	■			■	
NR	1.00 – 9.00	0.25 – 0.80		CNMM, DNMM, SNMM, WNMM	■	■			■	
NR2	1.00 – 16.00	0.25 – 1.20		CNMM, SNMM, TNMM	■	■			■	
OR	2.00 – 16.00	0.25 – 1.70		CNMM, SNMM, WNMM	■	■	■			
RM	1.50 – 7.00	0.30 – 0.80		CNMG, DNMG, SNMG, TNMG, WNMG	■	■	■		■	
SF	0.20 – 3.50	0.08 – 0.35		CNGG, CNMG, DNMG, SNMG, TNMG, VNMG, WNMG	■	■			■	
SI	0.80 – 5.00	0.20 – 0.50		CNMG, DNMG, TNMG, WNMG	■	■			■	
SM	0.40 – 6.00	0.15 – 0.55		CNMG, DNMG, SNMG, TNMG, VNMG, WNMG	■	■	■		■	
923	3.00 – 13.00	0.45 – 1.50		CNMM, SNMM	■	■	■			

应用工况从2017年样本中开始已经做了详细介绍
适用于T8430的工件材料

T8430 – 正角刀片预览

介绍

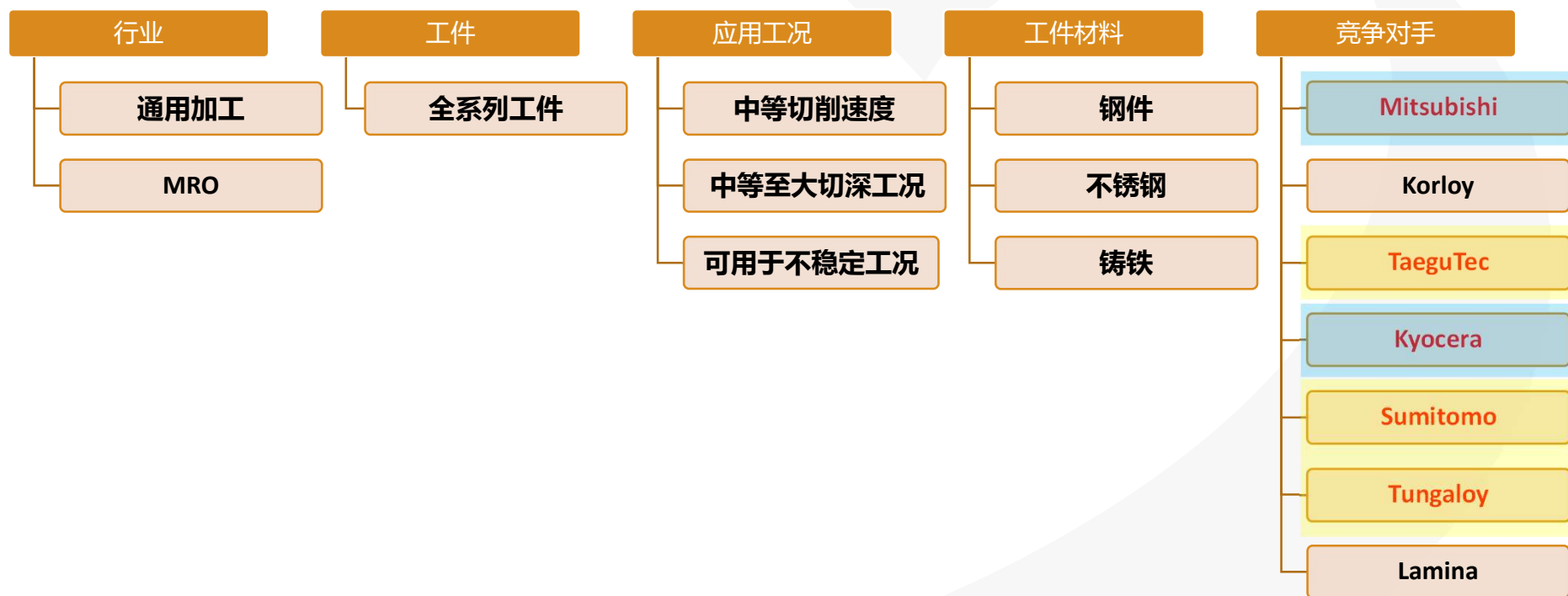


断屑槽			应用工况 01-05 05-10 10-20 20-30 30-40 40-50 	刀片	P	M	K	N	S	H
FF	0.20 – 2.00	0.05 – 0.23		CCMT, DCMT	■	■	■			
FF2	0.15 – 3.00	0.02 – 0.28		CCMT, DCGT, DCMT, SCMT, TCGT, TCMT, VBMT, VCGT, WCGT	■	■	■			
FM	0.20 – 4.00	0.08 – 0.45		CCMT, DCMT, DCMX, SCMT, TCMT, VBMT, VCMT, WCMT	■	■	■			
	0.30 – 4.80	0.10 – 1.00		RCMT	■	■	■			
FM2	0.20 – 4.00	0.04 – 0.40		CCMT, DCMT, ECMT, SCMT, TCMT, VBMT, VCGT	■	■	■			
NF2	0.20 – 4.00	0.05 – 0.45		CCMT	■	■	■		■	
RM	0.80 – 4.50	0.10 – 0.50		CCMT, DCMT, SCMT, TCMT, VBMT	■	■	■		■	
RM3	0.40 – 6.00	0.15 – 0.90		RCMT, SCMT, TCMT	■	■	■			
SI	0.40 – 4.00	0.08 – 0.45		CCGT, DCGT, TCGT	■	■			■	
UR	1.00 – 4.00	0.10 – 0.40		CCMT, DCMT, SCMT, TCMT, VBMT, VCMT	■	■	■			
	0.50 – 5.00	0.15 – 1.00		RCMT	■	■	■			

应用工况从2017年样本中开始已经做了详细介绍
适用于T8430的工件材料

应用市场

介绍



DORMER PRAMET

特点&优势

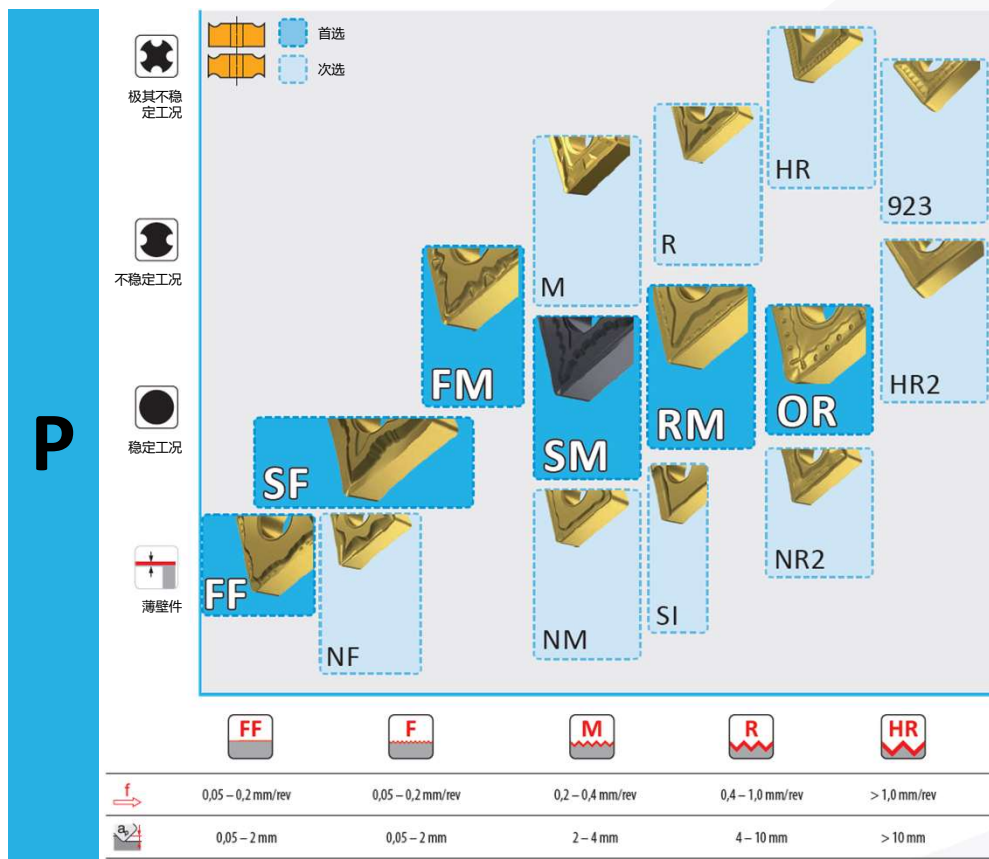
T8430 新一代PVD通用车削材质



钢件(P- 材料组)

ISO group		WMG (Work Material Group)		Hardness (HB or HRC)	Ultimate Tensile Strength (MPa)	Examples of material (AISI, EN, DIN, SS, STN, BS, UNE, GB, AFNOR, GOST, UNI)	
P	P1	P1.1	Free machining steel <i>(carbon steels with increased machinability)</i>	sulfurized	< 240 HB	≤ 830	AISI 1108, EN 15S22, DIN 1.0723, SS 1922, ČSN 11120, BS 210A15, UNE F.210F, GB Y15, AFNOR 10F1, GOST A30, UNI CF10S20
		P1.2		sulfurized and phosphorized	< 180 HB	≤ 620	AISI 1211, EN 11SMn30, DIN 1.0715, SS 1912, ČSN 11109, BS 230M7, UNE F.2111, GB Y15, AFNOR S250, GOST A40G, UNI CF9SMn28
		P1.3		sulfurized/phosphorized and leaded	< 180 HB	≤ 620	AISI 12L13, EN 11SMnPb30, DIN 1.0718, SS 1914, ČSN 12110, BS 210M16, UNE F.2114, GB Y15Pb, AFNOR S250Pb, GOST AS35G2, UNI CF10SPb20
	P2	P2.1	Plain carbon steel <i>(steels comprised of mainly iron and carbon)</i>	containing <0.25%C	< 180 HB	≤ 620	AISI 1015, EN C15, DIN 1.0401, SS 1350, ČSN 11301, BS 080A15, UNE F.111, GB 15, AFNOR C18RR, GOST St2ps, UNI Fe360
		P2.2		containing <0.55%C	< 240 HB	≤ 830	AISI 1030, EN C30, DIN 1.0528, SS 1550, ČSN 12031, BS 080M32, UNE F.1130, GB 30, AFNOR AF50C30, GOST 30G, UNI Fe590
		P2.3		containing >0.55%C	< 300 HB	≤ 1030	AISI 1060, EN C60, DIN 1.0601, SS 1655, ČSN 12061, BS 080A62, UNE F513, GB 60, AFNOR 1C60, GOST 60G, UNI C60
	P3	P3.1	Alloy steel <i>(carbon steels with an alloying content ≤ 10%)</i>	annealed	< 180 HB	≤ 620	AISI 3415, 4140, 4340, 6150, 8620, EN 15NiCr13, 42CrMo4, 41NiCrMo7-3-2, DIN 1.5732, 1.7223, 1.6563, 1.8159, 1.6523, SS 2244, 2541, 2230, 2506, ČSN 15020, BS 1501-240, UNE F.2601, GB 16Mo, AFNOR 15D3, GOST 15M, UNI 16Mo3KW
		P3.2		hardened and tempered	180 - 260 HB	> 620 ≤ 900	
		P3.3			260 - 360 HB	> 900 ≤ 1240	
	P4	P4.1	Tool steel <i>(special alloy steel for tools, dies and molds)</i>	annealed	< 26 HRC	≤ 900	AISI D2, EN X155CrVMo12-1, DIN 1.2370, SS 2736, ČSN 19573, BS BD2, UNE F.520A, GB Cr12Mo1V1, AFNOR Z160CDV12, GOST Ch12MF, UNI X155CrVMo121KU
		P4.2		hardened and tempered	26 - 39 HRC	> 900 ≤ 1240	
		P4.3			39 - 45 HRC	> 1240 ≤ 1450	

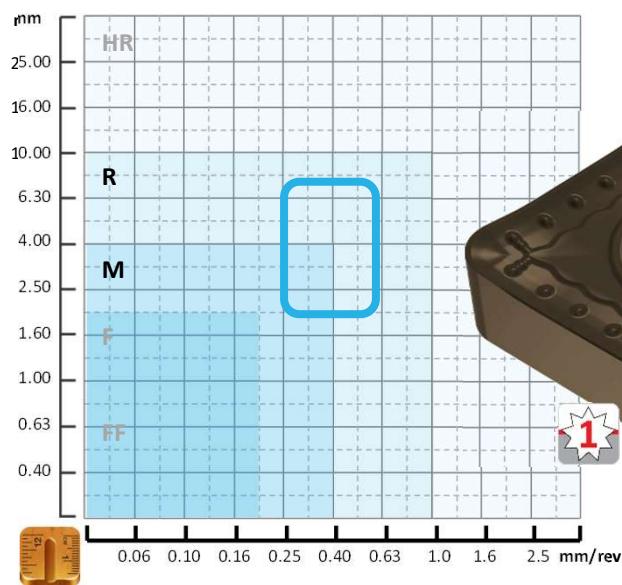
负角刀片断屑槽



FF		大正前角槽型，主要用于钢件，不锈钢，次选可用于铸铁材料，连续加工为主。
SF		精加工通用槽型，可用于钢件，不锈钢，铸铁和耐热合金，以及淬硬钢等材料，也可以用于有色金属材料的加工，适用于连续切削，即便是薄壁件也可以使用
FM		设计用于精加工至半精加工的正前角槽型，用于钢件和铸铁材料的加工，也可用于耐热合金材料，连续或中等断续均可适用
SM		正前角槽型，设计用于加工不锈钢，耐热合金，钢件和铸铁材料，也可以用于有色金属以及淬硬钢的加工，可用于连续和断续切削
RM		设计用于粗加工，以钢件，不锈钢和铸铁材料为主，也可以用于耐热合金，适用于连续和断续切削
OR		设计用于精加工和重载加工，工件材料以钢件和铸铁为主，也可以用于不锈钢以及耐热合金的加工，可用于连续和断续切削

CNMM 120408E-OR

产品特点



钢件参数范围

f_z 0.25 – 0.60 mm/rev
 a_p 2.0 – 8.0 mm
 V_c 190 – 135 m/min

正前角槽型

小负角T-倒棱

3D 断屑槽

深而宽的断屑槽

断屑槽加强筋

一致的PVD涂层
AlTiN-TiN-TiBN

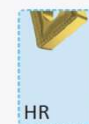
具有高韧性的亚微米基体



T8430



需要更高性能可以选择T9325



极其不稳定
工况



不稳定工
况



稳定工况



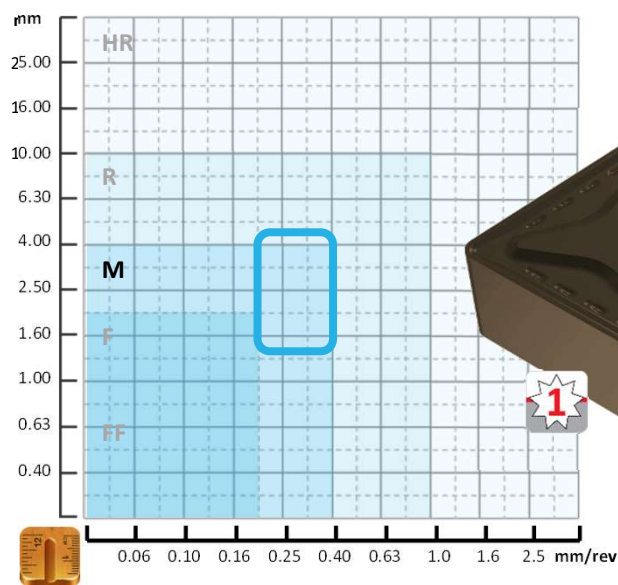
薄壁件

可替换断屑槽



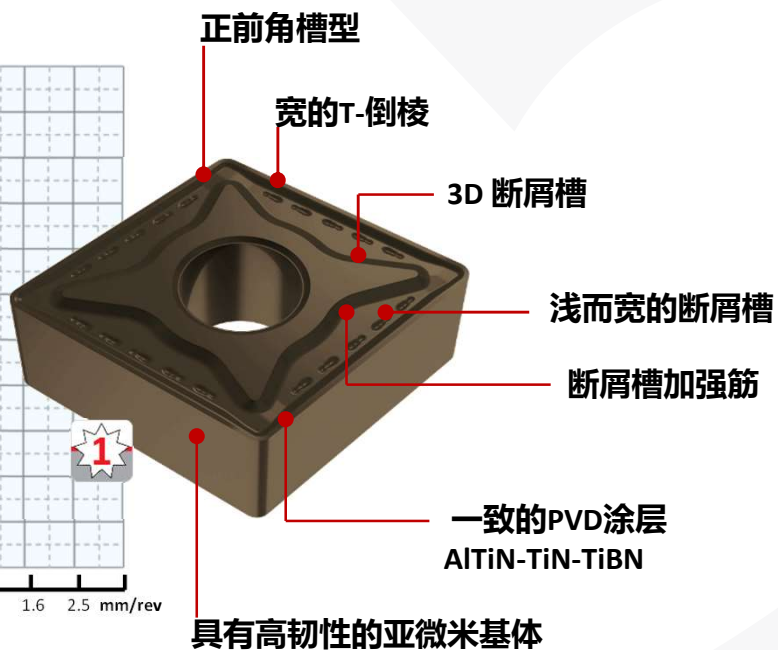
CNMG 120408E-RM

产品特点



钢件参数范围

f_z 0.20 – 0.40 mm/rev
 a_p 1.5 – 4.5 mm
 V_c 200 – 145 m/min



T8430

P	M	K	N	S	H
■	■	■	■	■	■

需要更高性能可以选择T9325

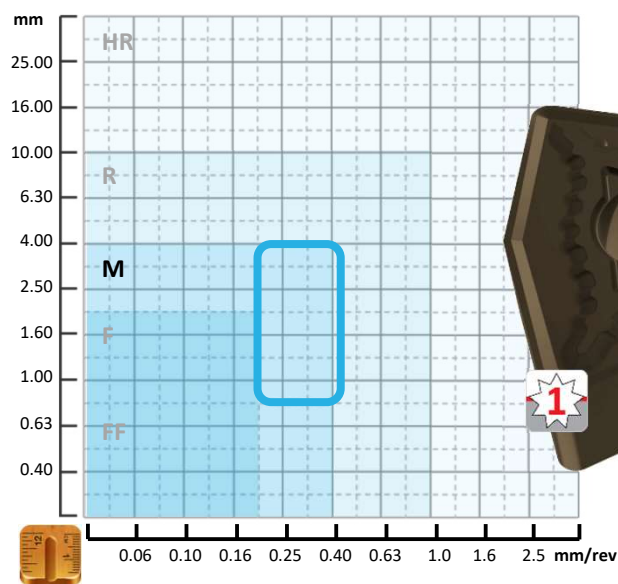


可替换断屑槽



WNMG 080408E-SM

产品特点



钢件参数范围

f_z 0.20 – 0.45 mm/rev
 a_p 0.8 – 4.0 mm
 V_c 195 – 105 m/min

正前角槽型

中等宽度的正前角T-倒棱

3D 断屑槽

浅而宽的断屑槽

断屑槽加强筋

一致的PVD涂层
AlTiN-TiN-TiBN

具有高韧性的亚微米基体



T8430

P	M	K	N	S	H
■	■	■	■	■	■

需要更高性能可以选择T9325

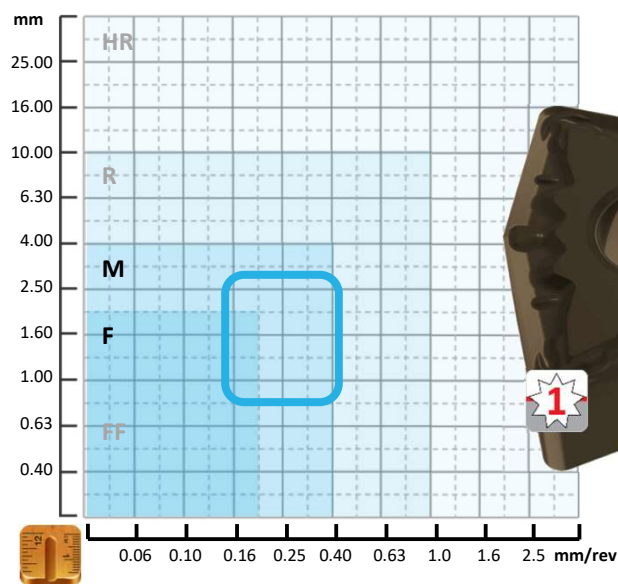


可替换断屑槽



WNMG 080408E-FM

产品特点



钢件参数范围

f_z 0.15 – 0.45 mm/rev
 a_p 0.8 – 3.0 mm
 V_c 235 – 150 m/min

正前角槽型

中等宽度的正前角T-倒棱

3D断屑槽

浅而窄的断屑槽

断屑槽加强筋

一致的PVD涂层
AlTiN-TiN-TiBN

具有高韧性的亚微米基体



T8430



需要更高性能可以选择T9325

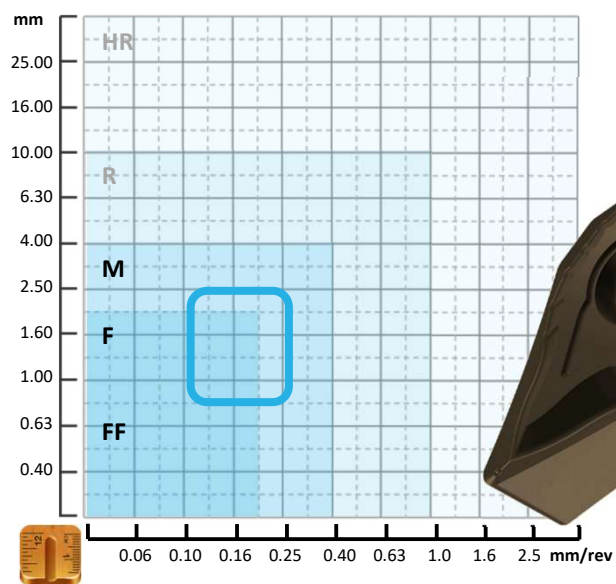


可替换断屑槽



DNMG 110408E-SF

产品特点



钢件参数范围

f_z 0.12 – 0.27 mm/rev
 a_p 0.8 – 2.5 mm
 V_c 190 – 95 m/min

正前角槽型

刃口圆弧倒钝的T-倒棱

3D 断屑槽

深而宽的断屑槽

断屑槽加强筋

一致的PVD涂层
AlTiN-TiN-TiBN

具有高韧性的亚微米基体



T8430



需要更高性能可以选择T9325

极其不稳定
工况

不稳定工
况

稳定工况

薄壁件

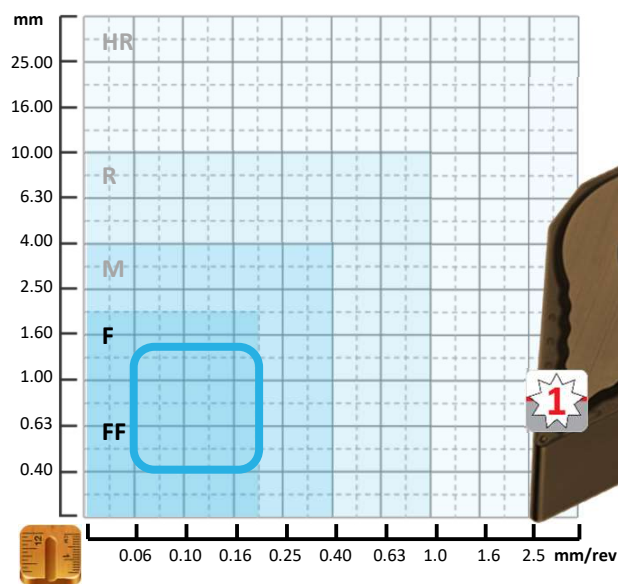


可替换断屑槽



DNMG 110404E-FF

产品特点



钢件参数范围

f_z 0.06 – 0.20 mm/rev

a_p 0.4 – 1.5 mm

V_c 215 – 140 m/min

大正前角槽型

正前角窄T-倒棱

3D断屑槽

浅而窄的断屑槽

断屑槽加强筋

一致的PVD涂层
AlTiN-TiN-TiBN

具有高韧性的亚微米基体



T8430

P	M	K	N	S	H
■	■	■	■	■	■

极其不稳定
工况

不稳定工
况

稳定工况



薄壁件

可替换断屑槽



正前角刀片槽型


极其不稳定工况


不稳定工况

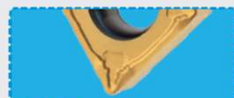

稳定工况


薄壁件


首选


次选


SF3


UR

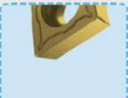

FF

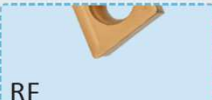

FF2


RM


FM


RM3


FM2


RF


SR


OR


DR4


FF


F


M


R


HR


0,05 – 0,2 mm/rev


0,05 – 0,2 mm/rev


0,2 – 0,4 mm/rev


0,4 – 1,0 mm/rev


> 1,0 mm/rev

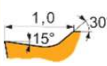
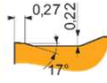
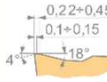

0,05 – 2 mm


0,05 – 2 mm


2 – 4 mm

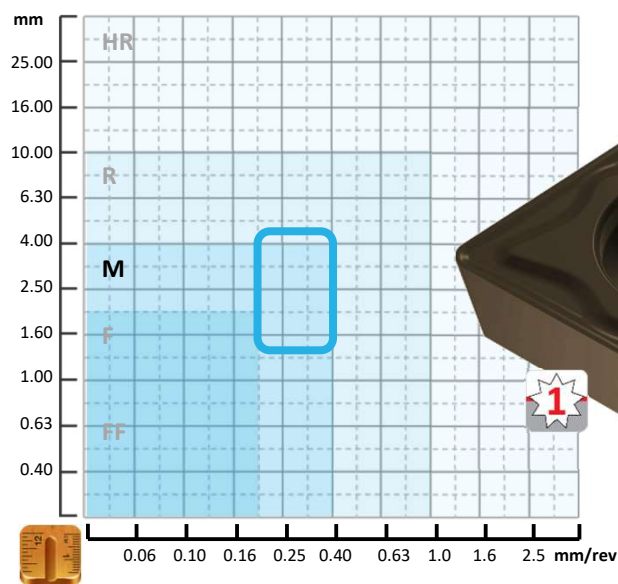

4 – 10 mm


> 10 mm

UR		超精至精加工，以钢件，铸铁为主，也可以加工不锈钢，连续和断续切削可适用
FM		设计用于精至半精加工，钢件，不锈钢为主，也可以用于加工铸铁和有色金属材料，适用于连续和中等断续切削
RM		设计用于半精至粗加工，以钢件，不锈钢和铸铁加工为主，也可以用于加工耐热合金和淬硬钢，适用于连续和断续切削
OR		设计用于粗加工至重载加工，以钢件，不锈钢和铸铁加工为主，也可以用于加工耐热合金材料，适用于连续和断续切削 目前没有搭配T8430材质

CCMT 120408E-RM

产品特点



钢件参数范围

f_z 0.20 – 0.40 mm/rev
 a_p 1.5 – 4.5 mm
 V_c 200 – 145 m/min

正前角槽型

宽的T-倒棱

3D 断屑槽

浅而宽的断屑槽

断屑槽加强筋

一致的PVD涂层
AlTiN-TiN-TiBN

具有高韧性的亚微米基体



T8430

P	M	K	N	S	H
■	■	■	■	■	■

需要更高性能可以选择T9325



RF



RM3



RM

极其不稳定工况

不稳定工况

稳定工况

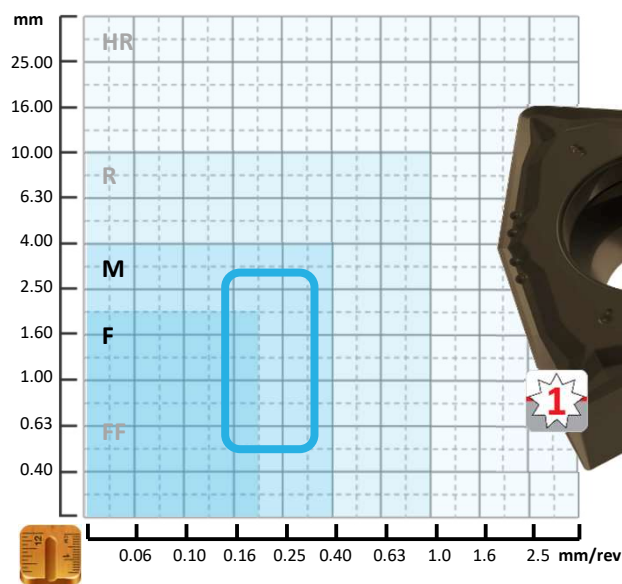
薄壁件

可替换断屑槽



WCMT 080408E-FM

产品特点



钢件参数范围

f_z 0.15 – 0.35 mm/rev
 a_p 0.5 – 3.0 mm
 V_c 210 – 145 m/min

正前角槽型

刃口圆弧倒钝的T-倒棱

3D断屑槽

浅和中等宽度槽型

断屑槽加强筋

一致的PVD涂层
AlTiN-TiN-TiBN

具有高韧性的亚微米基体



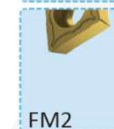
T8430



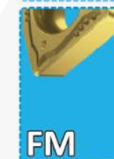
需要更高性能可以选择T9325



RF



FM2



FM

极其不稳定
工况

不稳定工
况

稳定工况

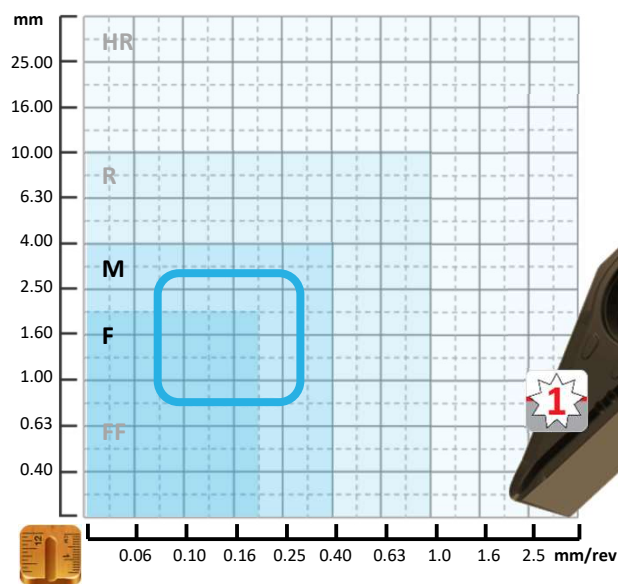
薄壁件

可替换断屑槽



VCMT 160408E-UR

产品特点



钢件参数范围

f_z 0.08 – 0.30 mm/rev
 a_p 0.8 – 3.0 mm
 V_c 150 – 95 m/min

正前角槽型

刃口圆弧倒钝的T-倒棱

3D 断屑槽

浅和中等宽度槽型

断屑槽加强筋

一致的PVD涂层
AlTiN-TiN-TiBN

具有高韧性的亚微米基体



T8430

P	M	K	N	S	H
■	■	■	■	■	■

需要更高性能可以选择T9325

极其不稳定工况

不稳定工况

稳定工况

薄壁件



UR

SF3

可替换断屑槽

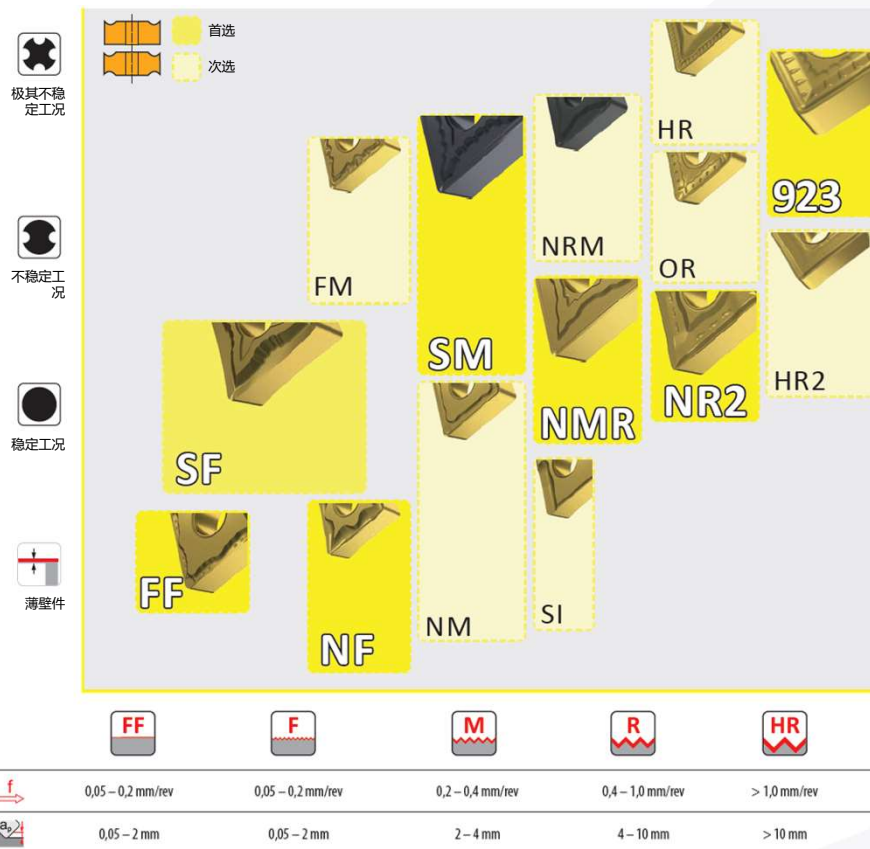


不锈钢(M- 材料组)

ISO group		WMG (Work Material Group)		Hardness (HB or HRC)	Ultimate Tensile Strength (MPa)	Examples of material (AISI, EN, DIN, SS, STN, B.S, UNE, CN, AFNOR, GOST, UNI)	
M	M1	M1.1	Ferritic stainless steel <i>(straight chromium non-hardenable alloys)</i>	< 160 HB	≤ 520	AISI S429, EN X7Cr14, DIN 1.4001, SS 2326, BS 434S17, UNE F.3401, AFNOR Z8C12, GOST 08Ch13, UNI X6CrTi12	
		M1.2		160 - 220 HB	> 520 ≤ 700	AISI 446, EN X10CrAl24, DIN 1.4762, SS 2322, ČSN 17113, BS 430S17, UNE F.3154, GB 10Cr17, AFNOR Z10CAS24, GOST 12Ch17, UNI X16Cr26	
	M2	M2.1	Martensitic stainless steel <i>(straight chromium hardenable alloys)</i>	annealed	< 200 HB	≤ 670	AISI 430F, EN X14CrMoS17, DIN 1.4104, SS 2383, ČSN 17140, BS 410S21, UNE F.3117, AFNOR Z10CF17, UNI X10CrS17
		M2.2		quenched and tempered	200 - 280 HB	> 670 ≤ 950	AISI 440C, EN X105CrMo17, DIN 1.4125, SS 2385, ČSN 17023, BS 425C11, UNE F.3402; GB 102Cr17Mo, AFNOR Z100CD17, GOST 95Ch18, UNI GX6CrNi 13 04
		M2.3		precipitation-hardened	280 - 380 HB	> 950 ≤ 1300	AISI 420, EN X45Cr13, DIN 1.4034, ČSN 17029, BS 425C11, UNE F.3405, AFNOR Z44C14, GOST 20X17H12, UNI X30Cr13
	M3	M3.1	Austenitic stainless steel <i>(chromium-nickel and chromium-nickel-manganese alloys)</i>	< 200 HB	≤ 750	AISI 304, 309, 5848 EN X5CrNi18-12, X15CrNiSi20-12, X45CrNiW18-9, DIN 1.4303, 1.4828, 1.4873, SS 2352, ČSN 17249, BS 305S17, UNE F.3513, GB 10Cr18Ni12, AFNOR Z8CN18.12, UNI X7CrNi18 10	
		M3.2		200 - 260 HB	> 750 ≤ 870		
		M3.3		260 - 300 HB	> 870 ≤ 1040		
	M4	M4.1	Austenitic-ferritic (DUPLEX) or super-austenitic stainless steel <i>(alloys with austenitic-ferritic microstructure, austenitic alloys with > 20%Ni)</i>	< 300 HB	≤ 990	AISI 329, EN X1-NiCrMoCU25-20-5, DIN 1.4539, SS 2562, ČSN 17265, BS 318S13, UNE F.3552, GB 022Cr25NiMo2N, AFNOR Z1NCDU25.20	
		M4.2	Precipitation hardening austenitic stainless steel	300 - 380 HB	≤ 1320	AISI 631 (17-7PH), EN X7CrNiAl17-7, DIN 1.4568, SS 2388, ČSN 17465, BS 301S13, UNE F.3217, GB 07Cr17Ni7Al, AFNOR 29CNA17-07	

负角刀片断屑槽

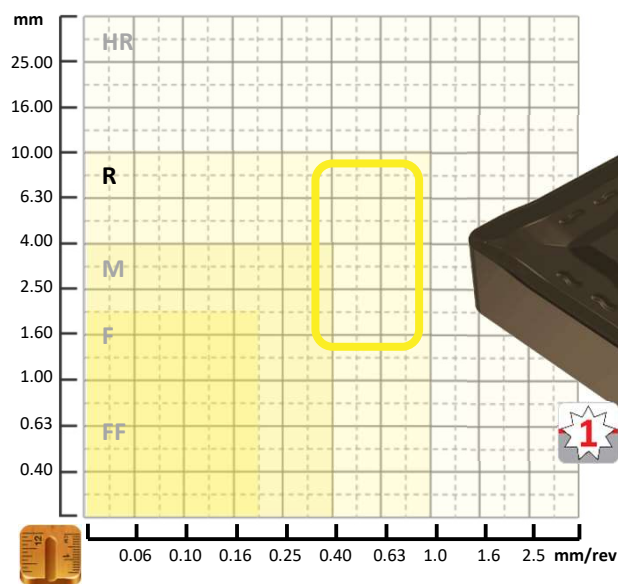
M



FF		大正前角槽型，主要用于钢件，不锈钢，次选可用于铸铁材料，连续加工为主。
SF		精加工通用槽型，可用于钢件，不锈钢，铸铁和耐热合金，以及淬硬钢等材料，也可以用于有色金属材料的加工，适用于连续切削，即便是薄壁件也可以使用
NF		大正前角槽型，设计用于精加工至中等加工，用于不锈钢，钢件，也可以适用于铸铁和有色金属以及耐热合金材料，以连续切削为主
SM		正前角槽型，设计用于加工不锈钢，耐热合金，钢件和铸铁材料，也可以用于有色金属以及淬硬钢的加工，可用于连续和断续切削
NMR		正前角槽型，适用于中等至粗加工，以不锈钢为主，也可用于软钢和耐热合金材料，连续切削为主
NR2		设计用于精加工至粗加工，以不锈钢和钢件为主，也可以用于铸铁和耐热合金材料，用于连续切削和断续切削

CNMM 190612E-NR2

产品特点



不锈钢加工参数推荐

f_z 0.35 – 0.90 mm/rev
 a_p 1.5 – 9.0 mm
 V_c 110 – 70 m/min

正前角槽型

较宽的负前角T-倒棱

3D断屑槽

深而宽的断屑槽

断屑槽加强筋

一致的PVD涂层
AlTiN-TiN-TiBN

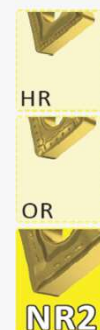
具有高韧性的亚微米基体



T8430

P	M	K	N	S	H
■	■	■	■	■	■

需要更高性能可选用T7325



极其不稳定工况

不稳定工况

稳定工况

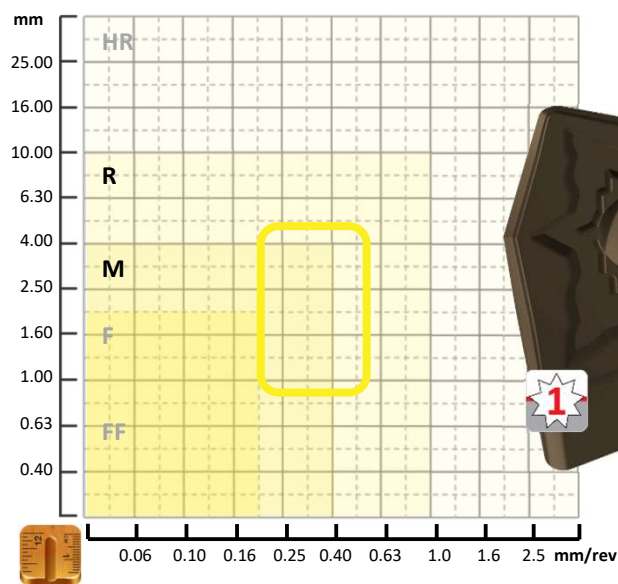
薄壁件

可替换断屑槽



WNMG 080408E-NMR

产品特点



不锈钢加工参数推荐

f_z 0.20 – 0.55 mm/rev
 a_p 0.8 – 5.0 mm
 V_c 110 – 75 m/min

正前角槽型

中等宽度的正前角T-倒棱

3D 断屑槽

浅而宽的断屑槽

断屑槽加强筋

一致的PVD涂层
AlTiN-TiN-TiBN

具有高韧性的亚微米基体



T8430

P	M	K	N	S	H
■	■	■	■	■	■

需要更高性能可选用T7325



极其不稳定工况

NRM



不稳定工况

NMR



稳定工况

SI

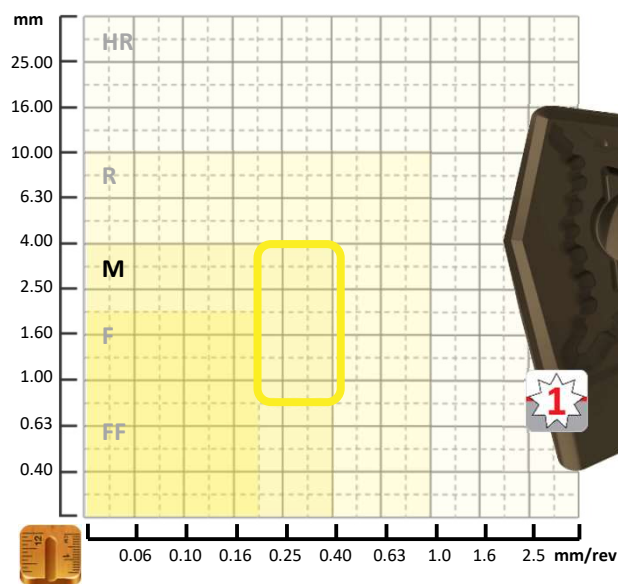
薄壁件

可替换断屑槽



WNMG 080408E-SM

产品特点



不锈钢加工参数推荐

f_z 0.20 – 0.45 mm/rev
 a_p 0.8 – 4.0 mm
 V_c 115 – 60 m/min

正前角槽型

中等宽度的正前角T-倒棱

3D 断屑槽

浅而宽的断屑槽

断屑槽加强筋

一致的PVD涂层
AlTiN-TiN-TiBN

具有高韧性的亚微米基体



T8430

P	M	K	N	S	H
■	■	■	■	■	■

需要更高性能可选用T7325



极其不稳定
工况



不稳定工
况



稳定工
况



薄壁件

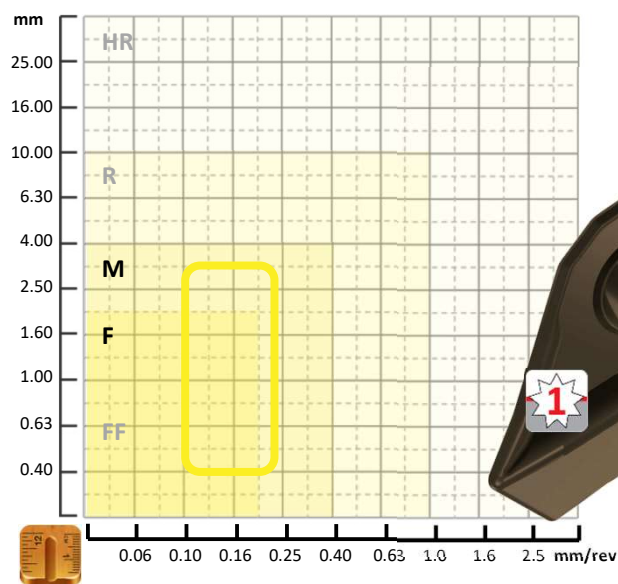


可替换断屑槽



DNMG 110404E-NF

产品特点



不锈钢加工参数推荐

f_z 0.10 – 0.24 mm/rev

a_p 0.4 – 3.0 mm

V_c 105 – 60 m/min

大正前角槽型

中等宽度的正前角T-倒棱

3D 断屑槽

宽而深的断屑槽

断屑槽加强筋

一致的PVD涂层
AlTiN-TiN-TiBN

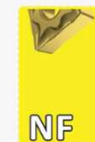
具有高韧性的亚微米基体



T8430

P	M	K	N	S	H
■	■	■	■	■	■

需要更高性能可選用T7325



可替换断屑槽



极其不稳定
工况

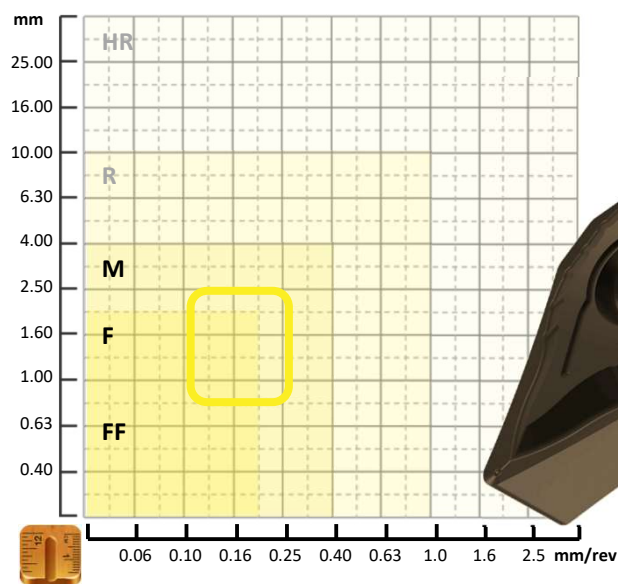
不稳定工
况

稳定工况

薄壁件

DNMG 110408E-SF

产品特点



不锈钢加工参数推荐

f_z 0.12 – 0.27 mm/rev

a_p 0.8 – 2.5 mm

V_c 110 – 55 m/min

正前角槽型

刃口圆弧倒钝的T-倒棱

3D 断屑槽

深而宽的断屑槽

断屑槽加强筋

一致的PVD涂层
AlTiN-TiN-TiBN

具有高韧性的亚微米基体



T8430

P	M	K	N	S	H
■	■	■	■	■	■

需要更高性能可选用T7325



极其不稳定
工况



不稳定工
况



稳定工况



薄壁件



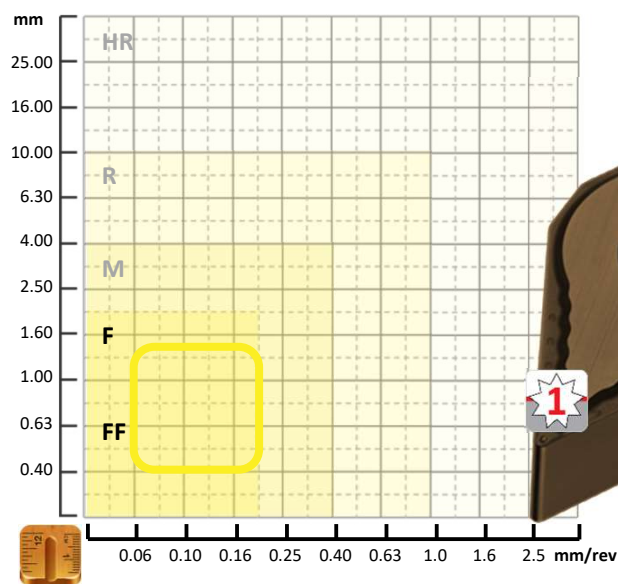
SF

可替换断屑槽



DNMG 110404E-FF

产品特点



不锈钢加工参数推荐

f_z 0.06 – 0.20 mm/rev

a_p 0.4 – 1.5 mm

V_c 125 – 80 m/min

大正前角槽型

正前角窄T-倒棱

3D断屑槽

浅而窄的断屑槽

断屑槽加强筋

一致的PVD涂层
AlTiN-TiN-TiBN

具有高韧性的亚微米基体



T8430

P	M	K	N	S	H
■	■	■	■	■	■

极其不稳定
工况

不稳定工
况

稳定工况



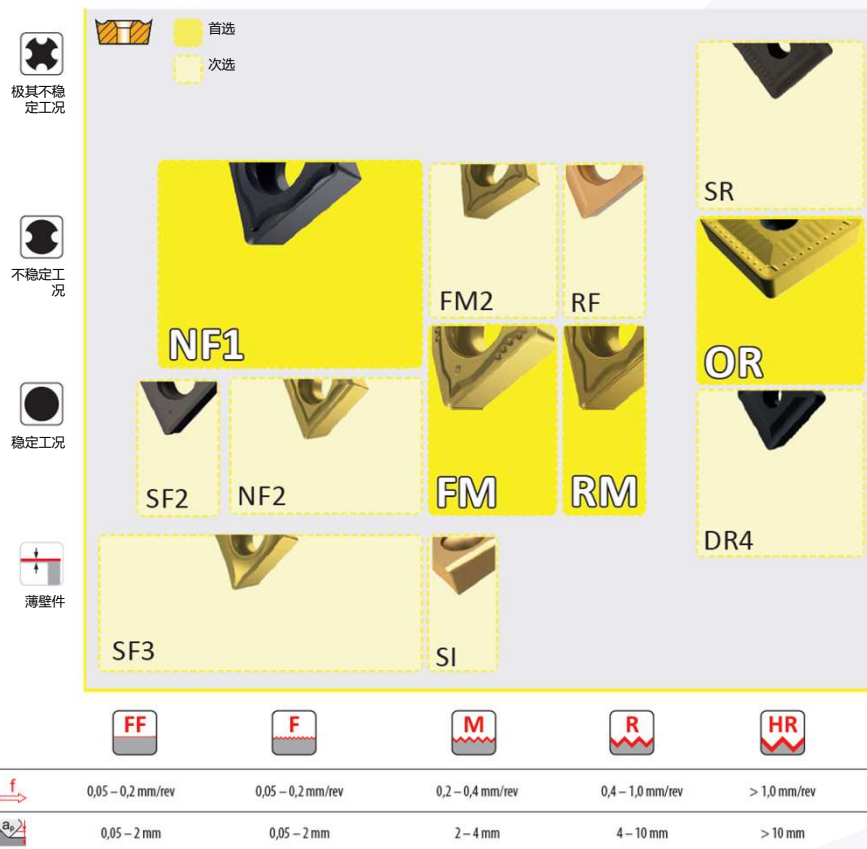
薄壁件

可替换断屑槽



正前角刀片槽型

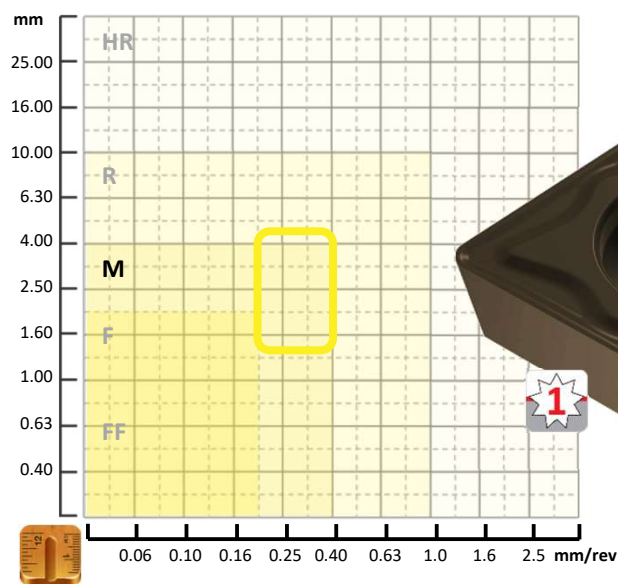
M



NF1		正前角槽型，适用于精加工至中等加工，以不锈钢和耐热合金材料为主，也可以用于钢件，有色金属以及淬硬钢等材料，推荐连续加工d materials, continuous cuts. 目前没有搭配T8430材质
FM		设计用于精至半精加工，钢件，不锈钢为主，也可以用于加工铸铁和有色金属材料，适用于连续和中等断续切削
RM		设计用于半精至粗加工，以钢件，不锈钢和铸铁加工为主，也可以用于加工耐热合金和淬硬钢，适用于连续和断续切削
OR		设计用于粗加工至重载加工，以钢件，不锈钢和铸铁加工为主，也可以用于加工耐热合金材料，适用于连续和断续切削 目前没有搭配T8430材质

CCMT 120408E-RM

产品特点



不锈钢加工参数推荐

f_z 0.20 – 0.40 mm/rev

a_p 1.5 – 4.5 mm

V_c 120 – 85 m/min

正前角槽型

宽的T-倒棱

3D 断屑槽

浅而宽的断屑槽

断屑槽加强筋

一致的PVD涂层
AlTiN-TiN-TiBN

具有高韧性的亚微米基体



T8430

P	M	K	N	S	H
■	■	■	■	■	■

需要更高性能可选用T7325

极其不稳定工况

不稳定工况

稳定工况

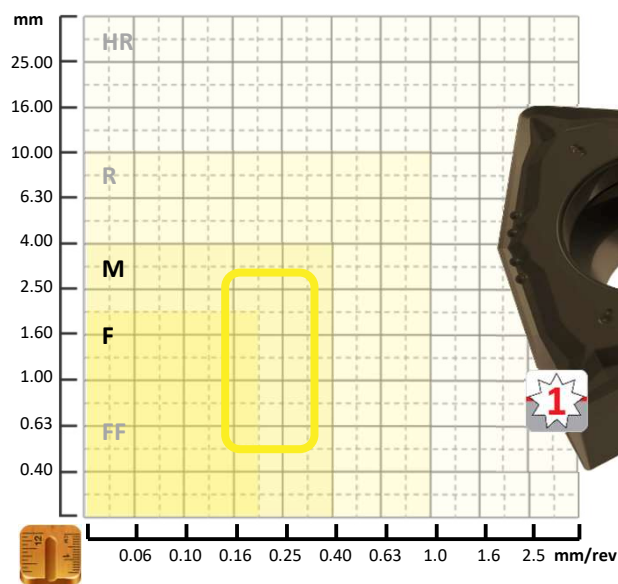
薄壁件

可替换断屑槽



WCMT 080408E-FM

产品特点



不锈钢加工参数推荐

f_z 0.15 – 0.35 mm/rev
 a_p 0.5 – 4.0 mm
 V_c 120 – 80 m/min

正前角槽型

刃口圆弧倒钝的T-倒棱

3D断屑槽

浅和中等宽度槽型

断屑槽加强筋

一致的PVD涂层
AlTiN-TiN-TiBN

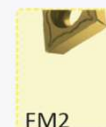
具有高韧性的亚微米基体



T8430

P	M	K	N	S	H
■	■	■	■	■	■

需要更高性能可选用T7325

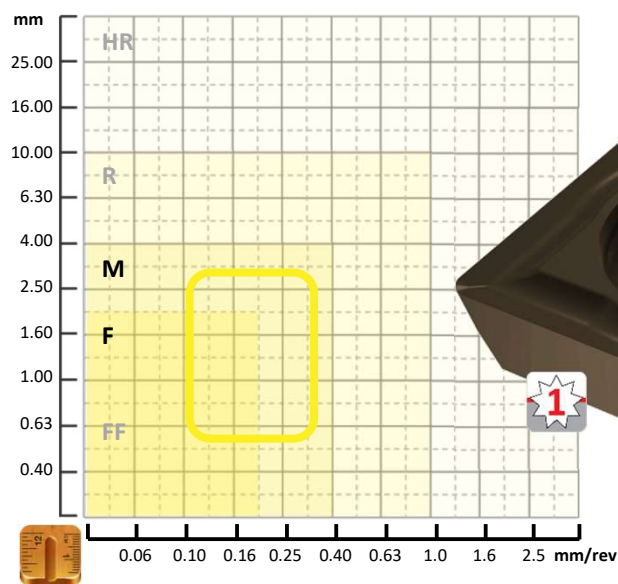


可替换断屑槽



CCMT 09T308E-NF2

产品特点



不锈钢加工参数推荐

f_z 0.12 – 0.35 mm/rev
 a_p 0.6 – 4.0 mm
 V_c 105 – 65 m/min

正前角槽型

刃口圆弧倒钝的T-倒棱

2D 断屑槽

浅和中等宽度槽型

断屑槽加强筋

一致的PVD涂层
AlTiN-TiN-TiBN

具有高韧性的亚微米基体



T8430

P	M	K	N	S	H
■	■	■	■	■	■

需要更高性能可选用T7325



极其不稳定工况

不稳定工况

稳定工况

薄壁件

可替换断屑槽

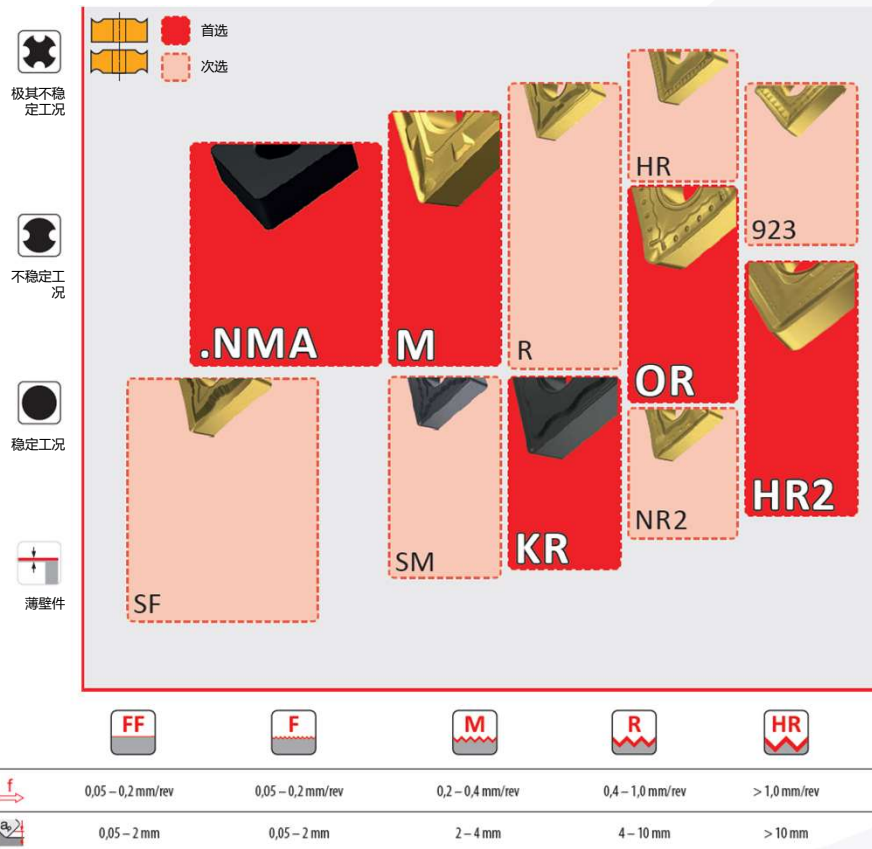


铸铁(K- 材料组)

ISO group		WMG (Work Material Group)			Hardness (HB or HRC)	Ultimate Tensile Strength (MPa)	Examples of material (ASTM, EN, DIN, SS, STN, B.S, UNE, CN, AFNOR, GOST, UNI)
K	K1	K1.1	Gray iron or Automotive Gray iron <i>(iron-carbon castings with a lamellar graphite microstructure)</i>	ferritic or ferritic-pearlitic	< 180 HB	≤ 190	ASTM A48 Grade 20, EN-JL-100, DIN GG-10 (0.6010), STN 422410
		K1.2		ferritic-pearlitic or pearlitic	180 - 240 HB	> 190 ≤ 310	ASTM A48 Grade 30, EN-JL-1030, DIN GG-20 (0.6020), SS 0120, STN 422420
		K1.3		pearlitic	240 - 280 HB	> 310 ≤ 390	ASTM A48 Grade 50, EN-JL-1060, DIN GG-35 (0.6035), SS 0135, STN 422435
	K2	K2.1	Malleable iron <i>(iron-carbon castings with a graphite-free microstructure)</i>	ferritic	< 160 HB	≤ 400	ASTM A602 Grade M3210, EN-JM-1130, DIN GTS-35 (0.8135), SS 0815
		K2.2		ferritic or pearlitic	160 - 200 HB	> 400 ≤ 550	ASTM A602 Grade M4504 (F20001), EN-JM-1040, DIN GTS-50-05 (0.8045)
		K2.3		pearlitic	200 - 240 HB	> 550 ≤ 660	ASTM A602 Grade M7002, EN-JM-1140, DIN GTS-45 (0.8145), STN 422540
	K3	K3.1	Ductile iron <i>(iron-carbon castings with a nodular graphite microstructure)</i>	ferritic	< 180 HB	≤ 560	ASTM A536 Grade 60-40-18, EN-JS-1030, DIN GGG-40 (0.7040), STN 422304
		K3.2		ferritic or pearlitic	180 - 220 HB	> 560 ≤ 680	ASTM A536 Grade 80-55-06, EN-JS-1050, DIN GGG-50 (0.7050), STN 422305
		K3.3		pearlitic	220 - 260 HB	> 680 ≤ 800	ASTM A536 Grade 100-70-03, EN-JS-1060, DIN GGG-60 (0.7060), STN 422306
	K4	K4.1	Austenitic gray iron <i>(iron-carbon alloy castings with an austenitic lamellar graphite microstructure)</i>		< 180 HB	≤ 190	ASTM A436 Type 1 (L-NiCuCr 15 6 2), DIN GGL-NiMn 13 7 (0.6652)
		K4.2	Austenitic ductile iron <i>(iron-carbon alloy castings with an austenitic nodular graphite microstructure)</i>		< 240 HB	≤ 740	ASTM A439 Type D-2B (S-NiCr 20 3), DIN GGG-NiMn 23 4, GOST ЧН19Х3Ш
		K4.3	Austempered ductile iron <i>(iron-carbon alloy castings with an ausferrite microstructure)</i>		< 280 HB	> 840 ≤ 980	ASTM A897 Grade 110-70-11
		K4.4			280 - 320 HB	> 980 ≤ 1130	ASTM A897 Grade 125-80-10, EN-JS-1100, DIN GGG-90 (5.3400)
		K4.5			320 - 360 HB	> 1130 ≤ 1280	ASTM A897 Grade 2 (150-110-07), EN-JS-1110, DIN GGG-100 (5.3403)
	K5	K5.1	Compacted graphite iron <i>(iron-carbon castings with a vermicular graphite structure)</i>	ferritic	< 180 HB	≤ 400	ASTM A842 Grade 300, EN-GJV-300, DIN GGV 30, GOST ЧВГ30,
		K5.2		ferritic-pearlitic	180 - 220 HB	> 400 ≤ 450	ASTM A842 Grade 350, EN-GJV-350, DIN GGV 35 (5.2200), GOST ЧВГ30,
		K5.3		pearlitic	220 - 260 HB	> 450 ≤ 500	ASTM A842 Grade 450, EN-GJV-450, DIN GGV 45, GOST ЧВГ45,

负角刀片断屑槽

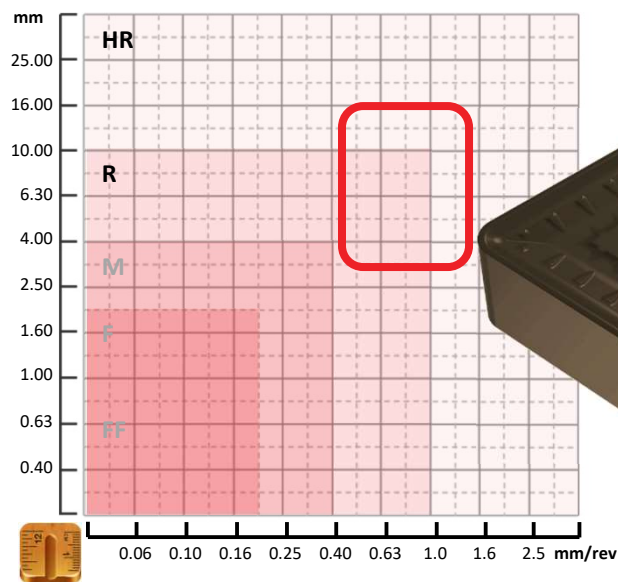
K



.NMA		设计用于精加工至粗加工，以铸铁材料为主，也可以加工淬硬钢材料，连续和断续切削均可 目前没有搭配T8430材质
M		设计用于精和中等加工，以铸铁材料为主，也可以用于钢件和淬硬钢，适用于连续和断续切削
KR		设计用于粗加铸铁材料，也可以加工钢件和淬硬钢，可用于连续和断续切削 目前没有搭配T8430材质
OR		设计用于精加工和重载加工，工件材料以钢件和铸铁为主，也可以用于不锈钢以及耐热合金的加工，可用于连续和断续切削
HR2		设计用于粗加工和重载粗加工，可大幅度提升效率，适用于钢件和铸铁，也可以用于不锈钢材料，适用于连续和断续切削 目前没有搭配T8430材质

CNMM 250924S-923

产品特点



铸铁材料加工参数推荐

f_z 0.45 – 1.50 mm/rev
 a_p 3.0 – 16.0 mm
 V_c 120 – 75 m/min

正前角槽型

Very 较宽的负前角T-倒棱

3D 断屑槽

深而宽的断屑槽

断屑槽加强筋

一致的PVD涂层
AlTiN-TiN-TiBN

具有高韧性的亚微米基体



T8430

P	M	K	N	S	H
■	■	■	■	■	■

如果需要更高性能可选用T9335



极其不稳定工况

不稳定工况

稳定工况

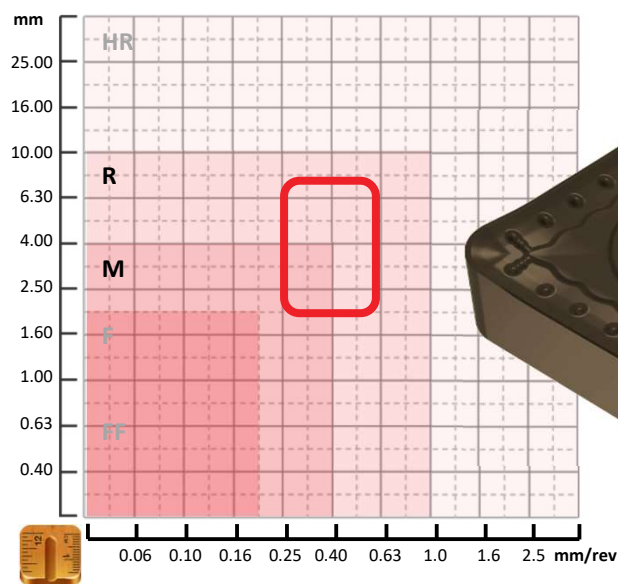
薄壁件

可替换断屑槽



CNMM 120408E-OR

产品特点



铸铁材料加工参数推荐

f_z 0.25 – 0.60 mm/rev
 a_p 2.0 – 8.0 mm
 V_c 180 – 125 m/min

正前角槽型

小负角T-倒棱

3D 断屑槽

深而宽的断屑槽

断屑槽加强筋

一致的PVD涂层
AlTiN-TiN-TiBN

具有高韧性的亚微米基体



T8430

P	M	K	N	S	H
■	■	■	■	■	■

需要更高性能可以选择T9325



极其不稳定工况



不稳定工况



稳定工况



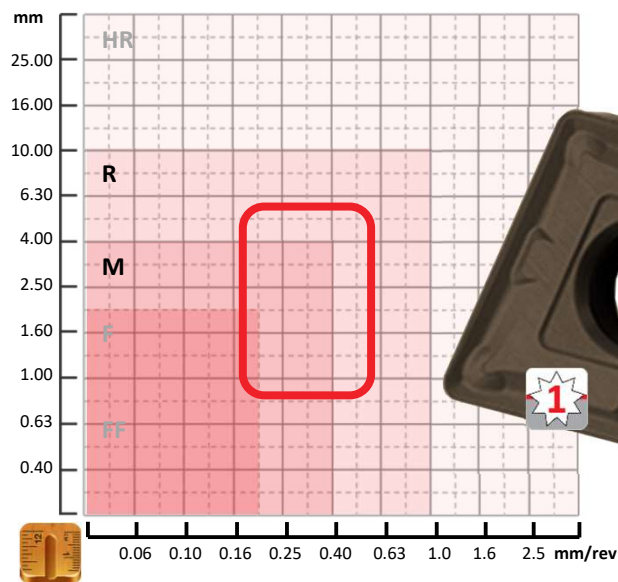
薄壁件

可替换断屑槽



CNMG 120408E-M

产品特点



铸铁材料加工参数推荐

f_z 0.17 – 0.60 mm/rev
 a_p 0.8 – 6.0 mm
 V_c 195 – 110 m/min

正前角槽型

Medium 较宽的负前角T-倒棱

3D断屑槽

Deep, medium wide chip-groove

断屑槽加强筋

一致的PVD涂层
AlTiN-TiN-TiBN

具有高韧性的亚微米基体



T8430

P	M	K	N	S	H
■	■	■	■	■	■

如果需要更高性能可选用T5315材质



可替换断屑槽



极其不稳定工况

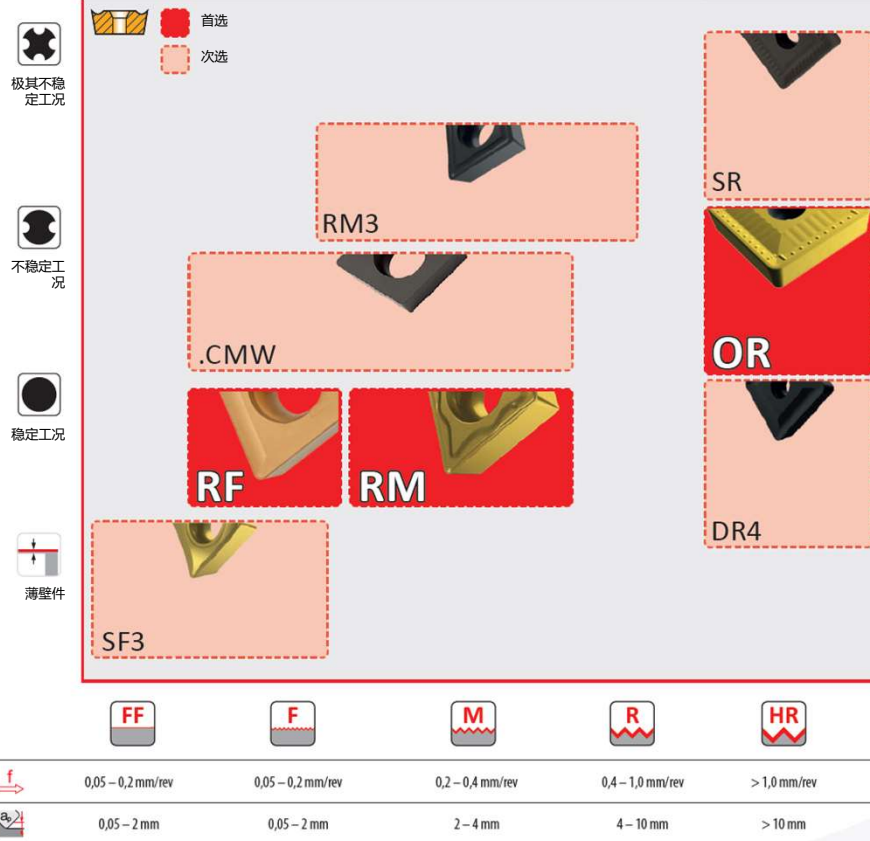
不稳定工况

稳定工况

薄壁件

正前角刀片槽型

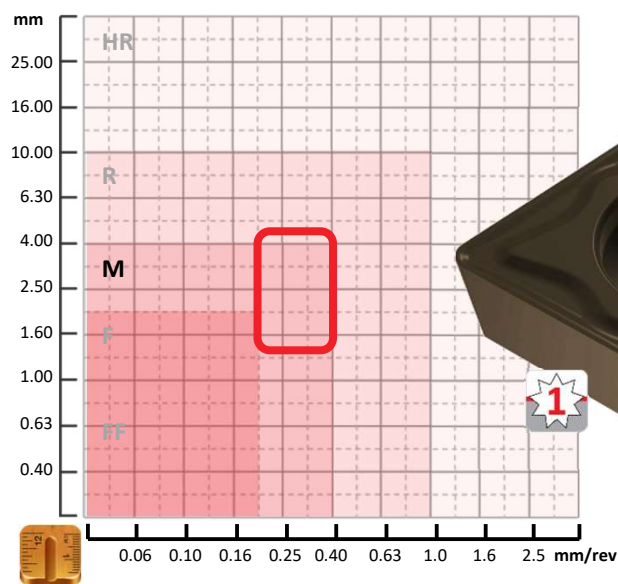
K



RF		设计用于粗加工铸铁，也可以加工钢件，不锈钢以及淬硬钢，可用于连续和断续切削 目前没有搭配T8430材质
RM		设计用于半精至粗加工，以钢件，不锈钢和铸铁加工为主，也可以用于加工耐热合金和淬硬钢，适用于连续和断续切削
OR		设计用于粗加工至重载加工，以钢件，不锈钢和铸铁加工为主，也可以用于加工耐热合金材料，适用于连续和断续切削 目前没有搭配T8430材质

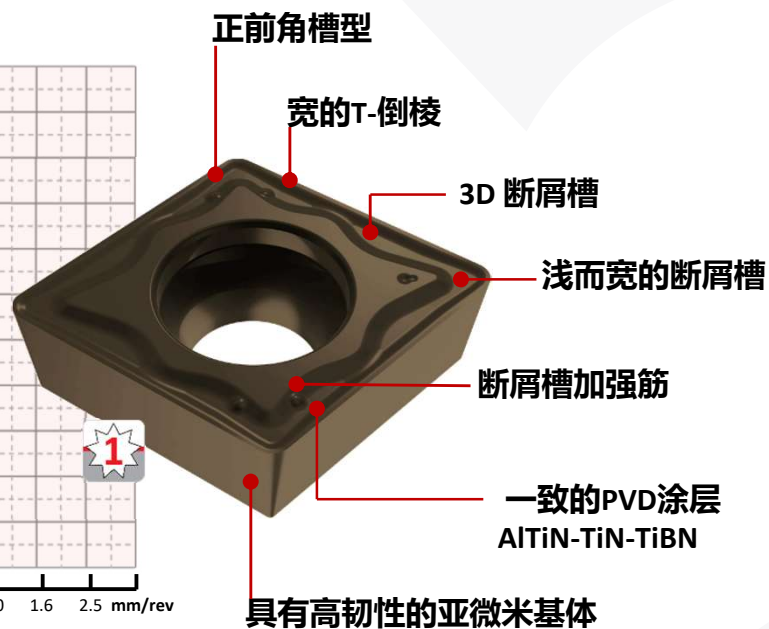
CCMT 120408E-RM

产品特点



铸铁材料加工参数推荐

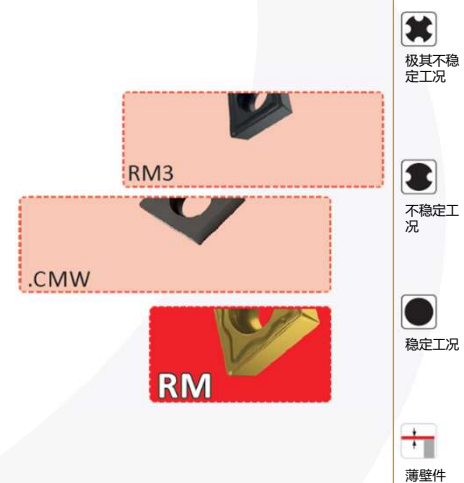
f_z 0.20 – 0.40 mm/rev
 a_p 1.5 – 4.5 mm
 V_c 190 – 135 m/min



T8430



如果需要更高性能可选用T5315 材质



可替换断屑槽



DORMER PRAMET

测试情况

T8430 新一代PVD通用车削材质



区域测试

Reported by		M. Nunes (Brazil)		A. Nikonorov (Russia)		A. Nikonorov (Russia)		A. Nikonorov (Russia)		A. Nikonorov (Russia)	
Work-material		AISI 316 (WMG M3.2)		C40(WMG P2.2)		41Cr4 (WMG P3.2)		31Cr19N9MoWNBtI (WMG M3.2)		AISI 420 (WMG M2.2)	
Hardness		215HB		190-210HB		190-210HB		200-240HB		200-220HB	
Coolant		Yes		Yes		Yes		Yes		Yes	
Brand		PRAMET		PRAMET		PRAMET		PRAMET	日韩	PRAMET	
Insert		TNMG 160404ER-SI		CNMG 120404E-NF		CNMG 120408E-SM		CNMG 120408E-NM	CNMG 120408-	CNMG 120404E-NF	
Grade		T8430	T8330	T8430	T8330	T8430	T8330	T8430	M20	T8430	TT9080
Depth of cut	a_p [mm]	1.5		1.0		0.5~2.8		0.6~1.0		1.5	
Feed per revolution	f_n [mm/rev]	0.25		0.20		0.22		0.20		0.19	
Cutting speed	V_c [m/min]	120		160		235		87		160	
Tool life comparison	T_m [%]	53%	100%	100%	100%	>100%	100%	100%	100%	130%	100%

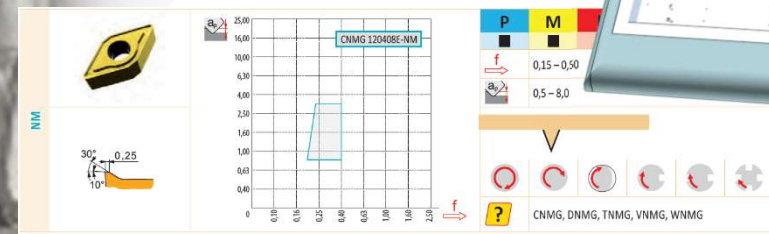
Reported by		B. He (China)		B. He (China)		B. He (China)		B. He (China)		B. He (China)	
Work-material		1.4474 (WMG M4.1)		1.4474 (WMG M4.1)		AISI 304 (WMG M3.1)		AISI 316 (WMG M3.1)		1.4308 (WMG M3.1)	
Hardness		160-180HB		160-180HB		200-230HB		160-180HB		160-180HB	
Coolant		Yes		Yes		Yes		Yes		Yes	
Brand		PRAMET	日韩	PRAMET	日韩	PRAMET	日韩	PRAMET	日韩	PRAMET	日韩
Insert		WNMG 080408E-NM	WNMG 080408-	CNMG 120408E-NMR	CNMG 120408-	CCMT 09T308E-FM	CCMT 09T308-	CCMT 09T308E-FM	CCMT 09T308-	CCMT 060204E-FM	CCMT 060204-
Grade		T8430	M15	T8430	M15	T8430	M15	T8430	M15	T8430	M15
Depth of cut	a_p [mm]	1.5~2.5		2.5		0.9~0.1		1.0		1.0~0.5	
Feed per revolution	f_n [mm/rev]	0.15		0.15		0.08		0.18		0.08	
Cutting speed	V_c [m/min]	50		45		70		60		63	
Tool life comparison	T_m [%]	133%	100%	200%	100%	117%	100%	100%	100%	104%	100%

车削不锈钢

Field test

Company		NN (China)		
Work-material		1.4474 (WMG M4.1)		
Hardness		160-180HB		
Coolant		Yes		
Brand		PRAMET		日韩品牌
Tool				
Insert		WNMG 080408E-NM		WNMG 080408-
Grade		T8430	T8330	M15
Depth of cut	a_p [mm]	1.5~2.5		
Feed per revolution	f_n [mm/rev]	0.15		
Cutting speed	V_c [m/min]	50		
Tool life	T_m [h:mm:ss]	0:46:00	0:46:00	0:34:30

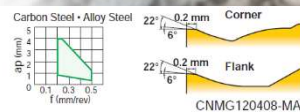
Tool life
133%



Work Material	Hardness	Cutting Mode	Priority	Breaker	Grade	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)
Two-phase Stainless Steel (AISI 329)	≤280HB	R	1	RM	MC7025	95-125	0.25-0.55	1.50-6.00
		R	2	GH	US735	65-105	0.25-0.60	1.50-6.00
		H	1	HL	US735	50-95	0.40-1.00	1.50-8.00
		H	2	HM	US735	50-95	0.50-1.10	2.00-10.00
		L	1	LM	MP7035	65-105	0.10-0.30	0.30-2.00
		L	2	SH	US735	65-125	0.10-0.40	0.30-2.00
		M	1	MM	MP7035	60-95	0.15-0.45	0.70-5.00
		M	2	GM	MP7035	60-95	0.16-0.50	0.50-4.00
		M	3	MA	MP7035	60-95	0.20-0.50	0.30-4.00
		M	4	MS	US735	60-115	0.16-0.50	0.50-4.00
		M	5	MS	VP15TF	50-90	0.16-0.50	0.50-4.00
		M	6	MS	UP20M	65-100	0.16-0.50	0.50-4.00
		M	7	MS	UTi20T	50-75	0.16-0.50	0.50-4.00
		M	8	MA	VP15TF	50-90	0.20-0.50	0.30-4.00
		M	9	Std	VP15TF	50-90	0.25-0.60	1.50-5.00
		R	1	RM	MP7035	55-90	0.25-0.55	1.50-6.00
		R	2	GH	US735	55-105	0.25-0.60	1.50-6.00
		H	1	HL	US735	50-95	0.40-1.00	1.50-8.00
		H	2	HM	US735	50-95	0.50-1.10	2.00-10.00

MA

First recommendation for medium cutting of carbon steel and alloy steel
Ideal for general cutting applications.
Positive land provides sharp cutting action.



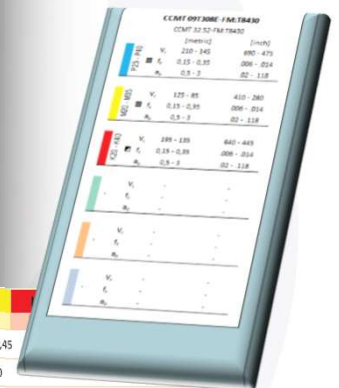
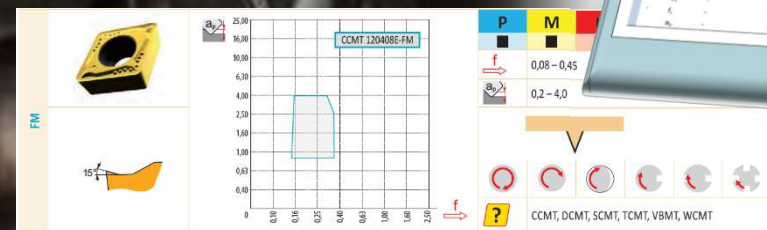
车削不锈钢

Field test

Company		NN (China)	
Work-material		AISI 304 (WGM M3.2)	
Hardness		200-230HB	
Coolant		Yes	
Brand		PRAMET	日韩品牌
Tool			
Insert		CCMT 09T308E-FM	CCMT 09T308-
Grade		T8430	M15
Depth of cut	a_p [mm]	0.9~0.1	
Feed per revolution	f_n [mm/rev]	0.08	
Cutting speed	V_c [m/min]	70	
Tool life	T_m [h:mm:ss]	3:23:20	2:53:20
Number of pieces		610	520



Tool life
117%



DORMER PRAMET

加工推荐

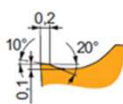
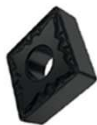
T8430 新一代PVD通用车削材质



样本的参数推荐

Vf,fn,ap 的初始值可使用参数计算器

Product		RE	P																								M						K						N						S						H																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																	
			vc						f						ap						vc						f						ap						vc						f						ap						vc						f						ap																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																															
			[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]		[m/min]		[mm/rev]		[mm]	



设计用于精加工至半精加工的正前角槽型，用于钢件和铸铁材料的加工，也可用于耐热合金材料，连续或中等断续均可适用

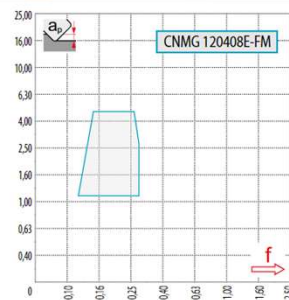
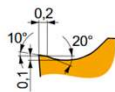
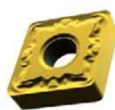
Part Number	Material	Dimensions (mm)	Weight (kg)	Notes
CNMG 090304E-FM	T7325	0.4	195 0.2 1.4	150 0.18 1.4
	T8330	0.4	175 0.2 1.4	105 0.18 1.4
	T8430	0.4	180 0.2 1.4	100 0.18 1.4
	T9315	0.4	265 0.2 1.4	- - -
	T9325	0.4	240 0.2 1.4	140 0.18 1.4
CNMG 090308E-FM	T7325	0.8	235 0.2 1.4	180 0.18 1.4
	T8330	0.8	205 0.2 1.4	120 0.18 1.4

ISO材料组对应的初始参数推荐

刀尖圆角

材质

刀片型号



P	M	K	N	S	H
					0,15 – 0,4
					0,5 – 3

?

CNMG, DNMG, SNMG, TNMG, VNMG, WNMG

工序窗
每齿进给，切深以及工况

刀片选择

标签上的参数推荐

CNMG 090304E-FM	T7325	0.4	195	0.2	1.4	150	0.18	1.4	-	-	-	60	0.16	1.1	-	-	-
	T8430	0.4	175	0.2	1.4	105	0.18	1.4	165	0.2	1.4	-	-	-	40	0.14	1.1

CNMG 321-FM:T8430

P25 - P40	V _c	205 - 130	675 - 425
	f _z	0,1 - 0,3	.004 - .012
	a _p	0,5 - 6,3	.02 - .248

M20 - M35	V _c	120 - 75	395 - 245
	f _z	0,1 - 0,3	.004 - .012
	a _p	0,5 - 6,3	.02 - .248

K20 - K40	V _c	190 - 120	625 - 395
	f _z	0,1 - 0,3	.004 - .012
	a _p	0,5 - 6,3	.02 - .248

	V _c	-	-
	f _z	-	-
	a _p	-	-

S15 - S25	V _c	55 - 25	180 - 80
	f _z	0,1 - 0,21	.004 - .008
	a _p	0,5 - 5,04	.02 - .198

	V _c	-	-
	f _z	-	-
	a _p	-	-

参数初始值打印在标签上

推荐替换
T8430 = T8330

WNMG 080408E-NM:T8430				刀片型号
WNMG 432-NM:T8430				工序窗
P25 - P40	V _c	230 - 160	755 - 525	切削速度
	f _z	0,2 - 0,5	.008 - .020	每齿进给
	a _p	0,8 - 3	.031 - .118	切深
M20 - M35	V _c	135 - 95	445 - 310	
	f _z	0,2 - 0,5	.008 - .020	
	a _p	0,8 - 2,25	.031 - .089	
	V _c	-	-	
	f _z	-	-	
	a _p	-	-	
S15 - S25	V _c	65 - 30	215 - 100	
	f _z	0,2 - 0,43	.008 - .017	
	a _p	0,8 - 2,7	.031 - .106	
	V _c	-	-	
	f _z	-	-	
	a _p	-	-	
Edit				

WMG材料组的校正因子

加工推荐

ISO P	WMG (Work Material Group)	C _{VcWMG}
P1.1	Free machining sulfurized carbon steel with a hardness of < 220HB	1,17
P1.2	Free machining sulfurized and phosphorized carbon steel with a hardness of < 180HB	1,31
P1.3	Free machining sulfurized/phosphorized and leaded carbon steel with a hardness of < 160HB	1,35
P2.1	Plain low carbon steel containing < 0.25%C with a hardness of < 180HB	1,00
P2.2	Plain medium carbon steel containing < 0.55%C with a hardness of < 240HB	0,88
P2.3	Plain high carbon steel containing > 0.55%C, with a hardness of < 300HB	0,78
P3.1	Alloy steel with a hardness of < 180HB	0,81
P3.2	Alloy steel with a hardness of 180 - 260HB	0,65
P3.3	Alloy steel with a hardness of 260 - 360HB	0,55
P4.1	Tool steel with a hardness of < 26HRC	0,48
P4.2	Tool steel with a hardness of 26 - 39HRC	0,41
P4.3	Tool steel with a hardness of 39 - 45HRC	0,33

ISO N	WMG (Work Material Group)	C _{VcWMG}
N1.1	Pure aluminium and wrought aluminium alloys with a hardness of < 80HB	1,33
N1.2	Wrought aluminium alloys with a hardness of 60 - 100HB	1,00
N1.3	Wrought aluminium alloys with a hardness of 100 - 150HB	0,67
N2.1	Cast aluminium alloys with ≤7%Si and a hardness of < 75HB	0,67
N2.2	Cast aluminium alloys with 7 ≤12%Si and a hardness of 75 - 90HB	0,60
N2.3	Cast aluminium alloys with >12%Si and a hardness of 90 < 140HB	0,43
N3.1	Free-cutting copper-alloys materials with excellent machining properties	0,70
N3.2	Short-chip copper-alloys with good to moderate machining properties	0,41
N3.3	Electrolytic copper and long-chip copper-alloys with moderate to poor machining properties	0,21
N4.1	Thermoplastic polymers	0,70
N4.2	Thermosetting polymers	0,27
N4.3	Reinforced polymers or composites	0,29
N5.1	Graphite	(1,00)

ISO M	WMG (Work Material Group)	C _{VcWMG}
M1.1	Stainless steel, ferritic with a hardness of < 160HB	1,22
M1.2	Stainless steel, ferritic with a hardness of 160 - 220HB	1,03
M2.1	Stainless steel, martensitic with a hardness of < 200HB	1,08
M2.2	Stainless steel, martensitic with a hardness of 200 - 280HB	0,89
M2.3	Stainless steel, martensitic with a hardness of 280 - 380HB	0,75
M3.1	Stainless steel, austenitic with a hardness of < 200HB	1,00
M3.2	Stainless steel, austenitic with a hardness of 200 - 260HB	0,86
M3.3	Stainless steel, austenitic with a hardness of 260 - 300HB	0,77
M4.1	Stainless steel, austenitic-ferritic or super-austenitic with a hardness of < 300HB	0,75
M4.2	Stainless steel, precipitation hardening austenitic with a hardness of 300 - 380HB	0,64

ISO S	WMG (Work Material Group)	C _{VcWMG}
S1.1	Titanium or titanium alloys, with a hardness of <200HB	1,94
S1.2	Titanium alloys, with a hardness of 200 - 280HB	1,72
S1.3	Titanium alloys, a hardness of 280 - 360HB	1,44
S2.1	High-temperature Fe-based alloys with a hardness of <200HB	1,33
S2.2	High-temperature Fe-based alloys with a hardness of 200-280HB	1,17
S3.1	High-temperature Ni-based alloys with a hardness of <280HB	1,00
S3.2	High-temperature Ni-based alloys with a hardness of 280 - 360HB	0,83
S4.1	High-temperature Co-based alloys with a hardness of <240HB	0,78
S4.2	High-temperature Co-based alloys with a hardness of 240 - 320HB	0,67

ISO K	WMG (Work Material Group)	C _{VcWMG}
K1.1	Gray iron, ferritic or ferritic-pearlitic with a hardness of < 180HB	1,35
K1.2	Gray iron, ferritic-pearlitic or pearlitic with a hardness of 180 - 240HB	1,00
K1.3	Gray iron, pearlitic with a hardness of 240 - 280HB	0,75
K2.1	Malleable iron, ferritic with a hardness of < 160HB	1,39
K2.2	Malleable iron, ferritic or pearlitic with a hardness of 160 - 200HB	1,13
K2.3	Malleable iron, pearlitic with a hardness of 200 - 240HB	0,90
K3.1	Ductile (nodular/spheroidal) iron, ferritic with a hardness of < 180HB	1,23
K3.2	Ductile (nodular/spheroidal) iron, ferritic or pearlitic with a hardness of 180 - 220HB	0,94
K3.3	Ductile (nodular/spheroidal) iron, pearlitic with a hardness of 220 - 260HB	0,76
K4.1	Austenitic cast iron with a hardness of < 180HB	1,14
K4.2	Austenitic cast iron with a hardness of 180 - 240HB	0,86
K4.3	Austempered ductile iron with a hardness of 240 - 280HB	0,63
K4.4	Austempered ductile iron with a hardness of 280 - 320HB	0,54
K4.5	Austempered ductile iron with a hardness of 320 - 360HB	0,45
K5.1	Vermicular, compacted graphite iron with a hardness of < 180HB	1,29
K5.2	Vermicular, compacted graphite iron with a hardness of 180 - 220HB	0,97
K5.3	Vermicular, compacted graphite iron with a hardness of 220 - 260HB	0,75

ISO H	WMG (Work Material Group)	C _{VcWMG}
H1.1	Chilled cast iron with a hardness of <440HB	1,52
H2.1	Hardened cast iron with a hardness <55HRC	0,90
H2.2	Hardened cast iron with a hardness >55HRC	0,77
H3.1	Hardened steel with a hardness of <51HRC	1,00
H3.2	Hardened steel with a hardness of 51 - 55HRC	0,82
H4.1	Hardened steel with a hardness of 55 - 59HRC	0,64
H4.2	Hardened steel with a hardness of >59HRC	0,54

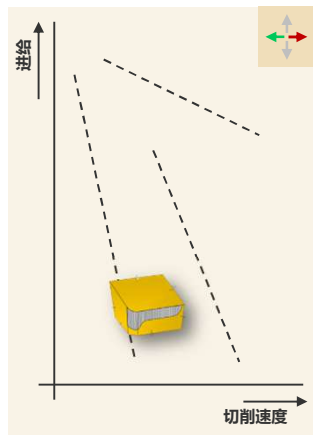
Important note:

Look into the technical section of the catalogue for the correction factors for the different work material harnesses!

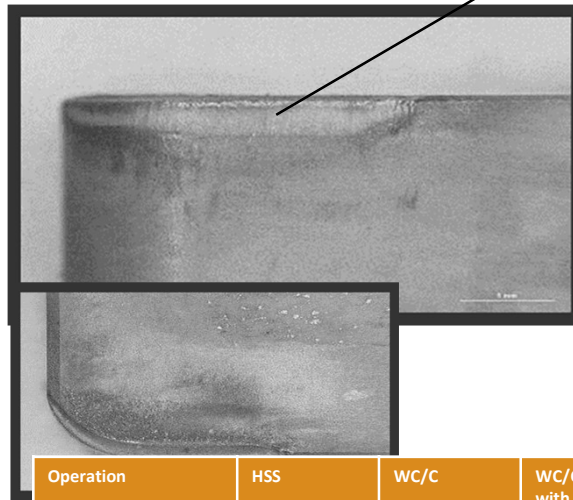
后刀面磨损

加工推荐

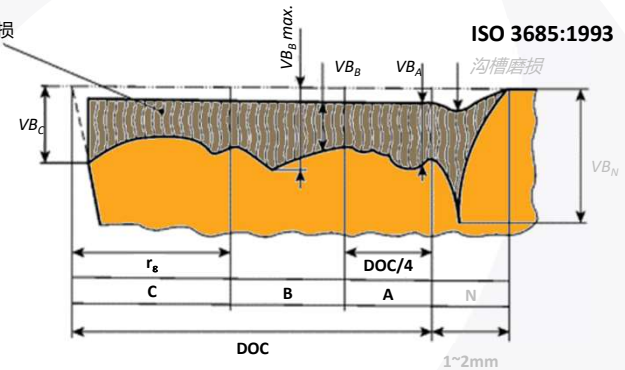
后刀面磨损



磨损与工况的关系

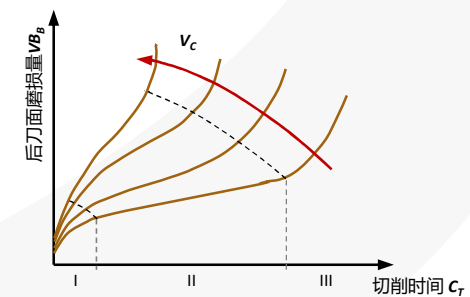


后刀面磨损



Operation	HSS	WC/C	WC/C coated with Al_2O_3 top	Ceramics Si_3N_4
Roughing (.014 – .039)	.0118 – .0197	.0118 – .0197	.0098 – .0118	.0098 – .0197
Finishing (.008 – .012)	.0039 – .0098	.0039 – .0098	.0039 – .0079	.0039 – .0079

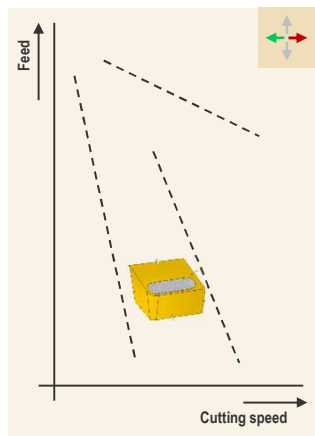
Recommended criteria for flank wear VB_B (mm)



沟槽磨损

加工推荐

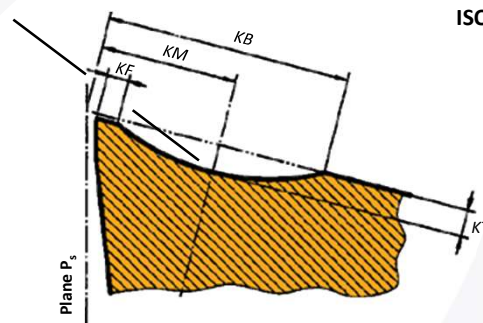
沟槽



磨损类型和工况的关系



沟槽磨损



ISO 3685:1993

Feed IPT (inch/rev)	.0039	.0098	.0157	.0248
Crater depth KT (inch)	.0035	.0053	.0071	.0098

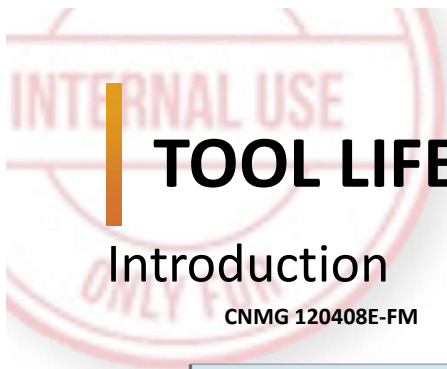
Recommended cutting conditions for VICT (inch)



销售信息

T8430 新一代PVD通用车削材质





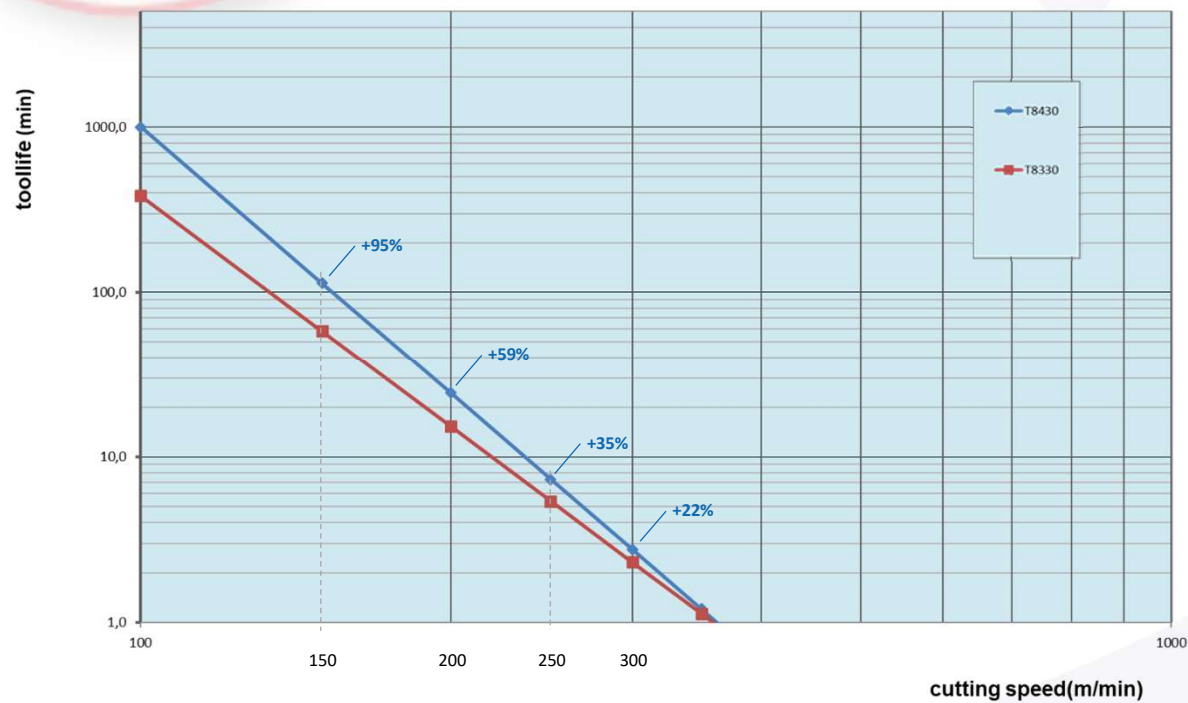
TOOL LIFE PERFORMANCE

Introduction

CNMG 120408E-FM

$f_n = 0.250$ mm/rev

C45 WMG 2.2



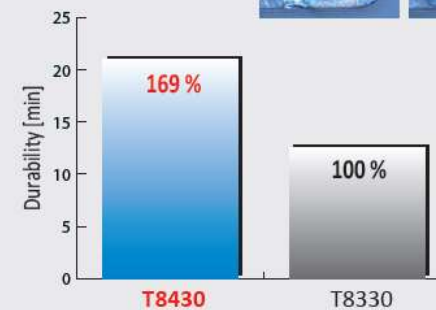
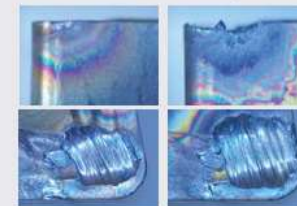
MACHINING EXAMPLE

Material: C45
Material group: P2.2
Insert: CNMG120408E-FM
Coolant: No

Grade			T8430	T8330
Cutting speed	v_c	m/min	170	170
Feed tooth	f_z	mm/tooth	0,35	0,35
Axial length of cut	a_p	mm	2,0	2,0
Durability	T	min	21,0	12,5

T8430
after 21 min

T8330
after 12,5 min



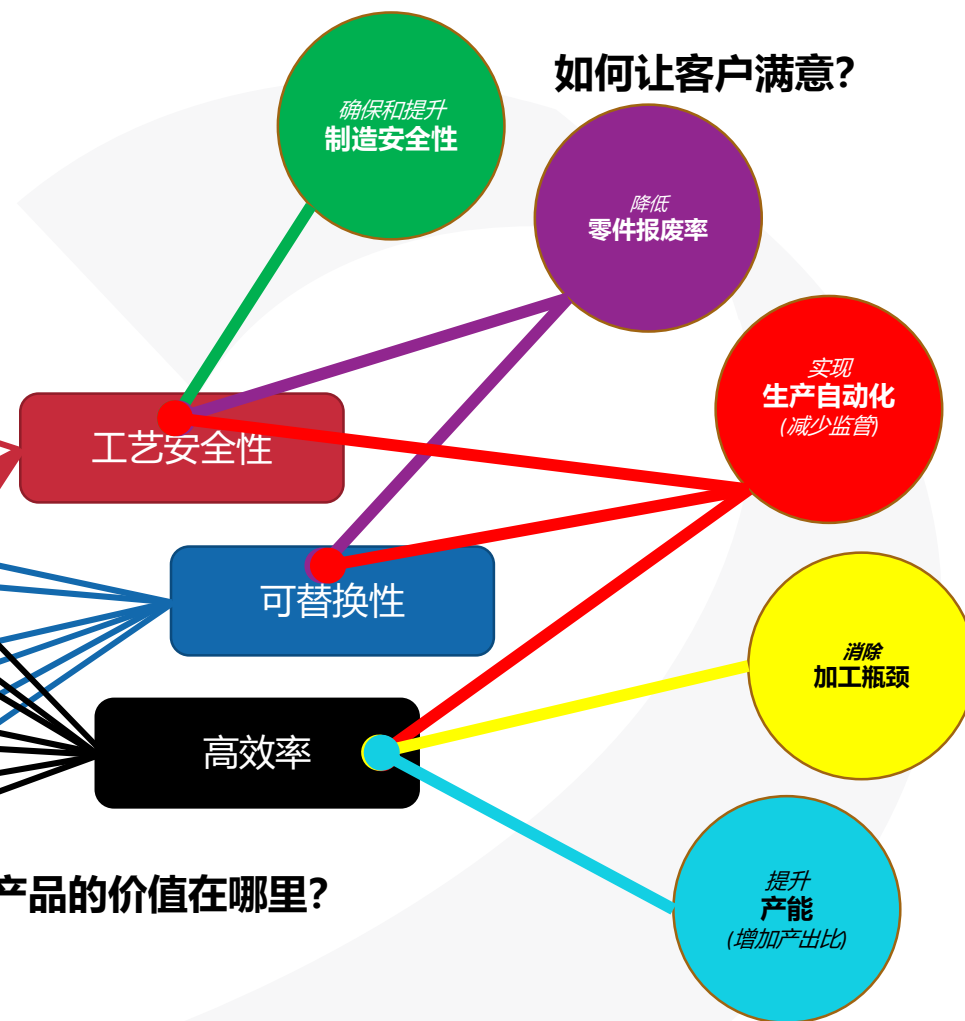
销售信息

产品的卖点在哪里？

产品特点	产品优势
亚微米基体 (高钴含量)	不稳定工况中提高韧性 可用于更大切深 通用加工至重载加工中增加材质的稳定性
PVD涂层	更低的切削应力 增强热应力保护
提升离子抛光性能	确保基体和涂层的有力附着
硬的AlTiN涂层 (新一代结构)	增加后刀面的耐磨性，减少热应力和热氧化性
厚TiN涂层 (较低的残余压应力)	提升抗沟槽磨损性能 提升磨损保护
TiBN 顶部涂层	降低机械瘤
表面后处理	降低表面粗糙度，提升耐磨损性能

产品的价值在哪里？

如何让客户满意？



DORMER PRAMET



SIMPLY
RELIABLE



/DormerPrametSocial



Dormer Pramet



@DormerPramet



Dormer Pramet



dormerpramet.com

COVID-19 PRECAUTIONS



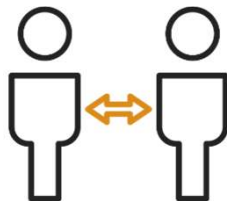
FOLLOW LOCAL
GUIDELINES



STAY HOME WHEN
FEELING SICK



WASH YOUR HANDS
CAREFULLY



OBSERVE PHYSICAL
DISTANCING GUIDELINES



COUGH AND SNEEZE
CORRECTLY



AVOID TOUCHING
YOUR FACE

