

New nano-Carbide Technology for **Hardened steel**
with **HRC45-55**

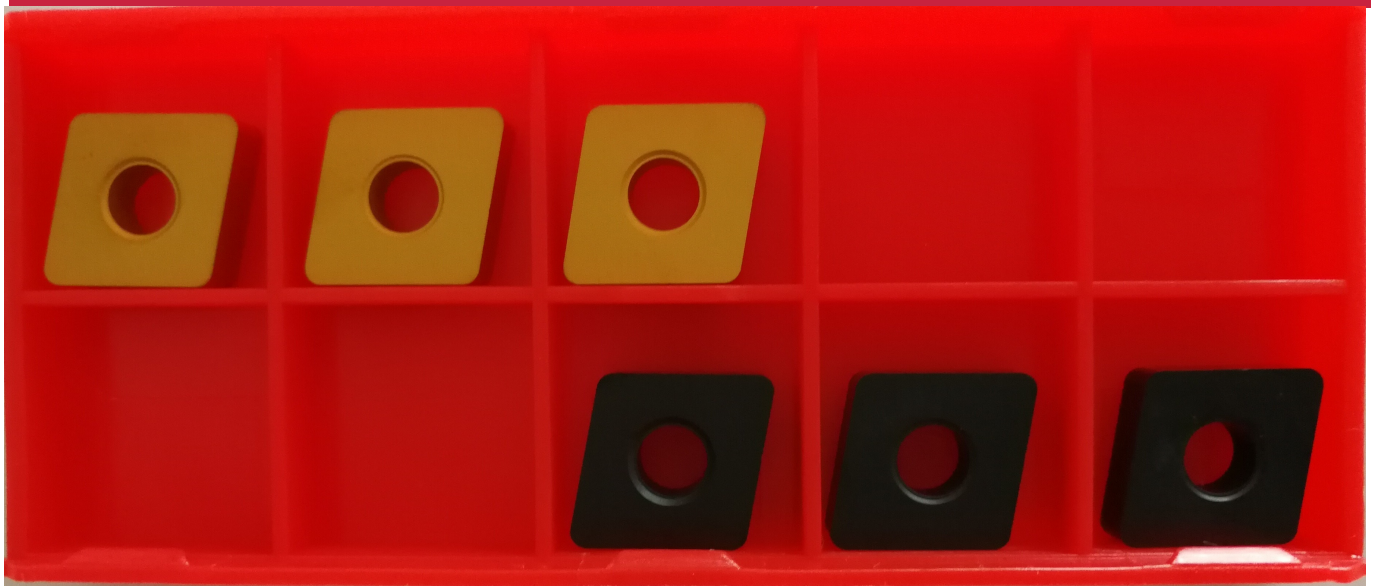
最新纳米硬质合金技术加工**HRC45-55**中硬度钢用刀片

TBC15 **SERIES**

Nano-Carbide & Coating Technology

TOOLINGBOX

Good anti-chipping performance ensures stable tool life
良好的抗崩刃性能确保稳定的刀具寿命



CNMG120412-FMX TBC15
CNMG232

P M K N S **H**

Vc 100-250m/min
f 0.07-0.4mm/rev
ap 0.2-3.0mm

ToolingBox®



Made in China

<http://www.toolingbox.com>

Stable tool life

非常稳定的刀具寿命

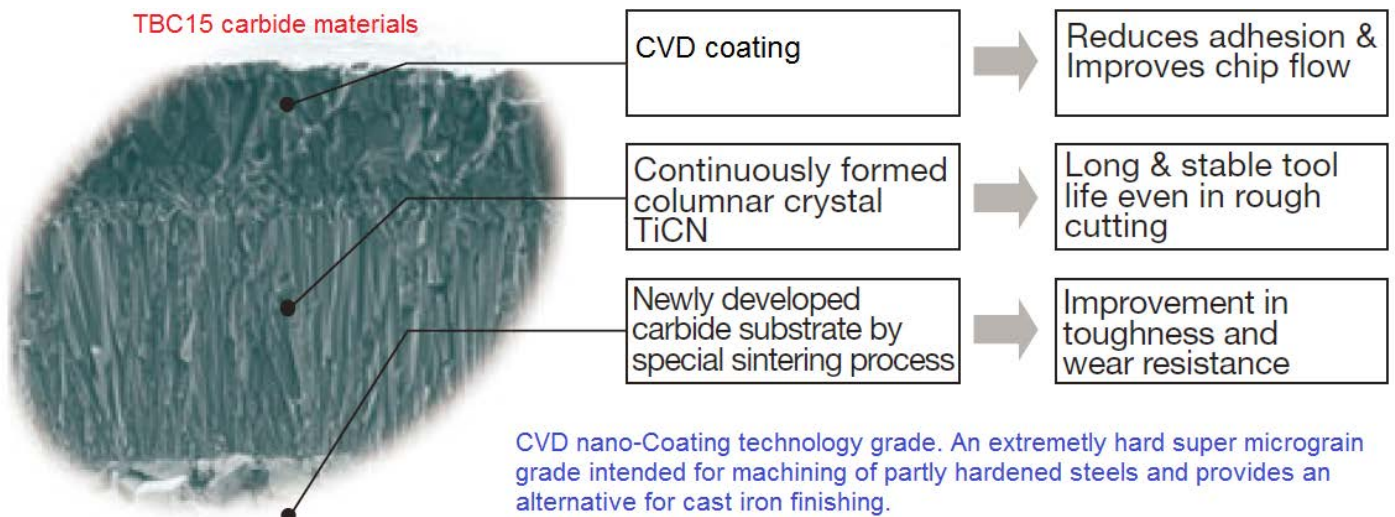
Using a new nano-carbide technology to provide excellent stability of the anti-chipping performance. It's the expert for interrupted cutting , and make up for the lack of CBN!

采用全新的硬质合金纳米技术，提供稳定极佳的抗崩刃性。强断续加工的能手，弥补CBN的不足！



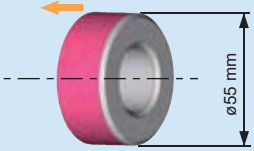
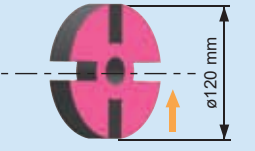
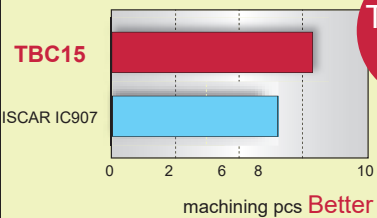
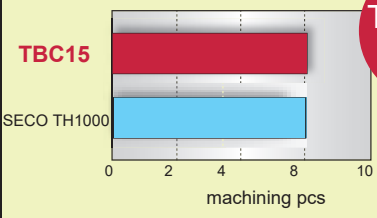
Materials Performance 材料性能

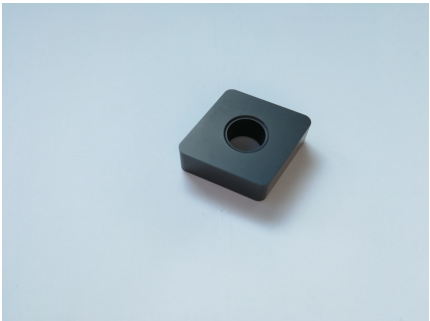
- 纳米硬质合金晶体技术 Nano Carbide Crystal Technology
- 涂层增强技术 Coating Enhancement Technology
- 特殊的刃口处理技术 Special edge processing technology



TBC15 SERIES

Case Story应用实例

workpiece工件种类		Auto parts	Shaft parts
Inserts刀片		CNMG120412-S	CNMG120412-FMX
Materials Grade 材质		TBC15	TBC15
workpiece materials工件材料		1.2365 ESU HRC50	1.2365 ESU HRC50
			
Cutting data	切削速度 : Vc (m/min)	180	150
	进给量 : f (mm/rev)	0.2	0.3
	切深 : ap (mm)	0.5	0.5
	加工方式 Machining Mode	continuous cutting	interrupted cutting
	冷却液cooling	wet	wet
结论		 Tool life machining pcs Better tool life than ISCAR IC907	 Tool life machining pcs Same proformance as SECO TH1000





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