간 저우 그랜드 바다 초경 공동 (주)는 간 저우 그랜드 바다 그룹의 지분을 소유 한 자회사입니다어느〜이다교세라 투자 중외 합자.

이제 카바이드끼워 넣다프로젝트 의 주요 개발 프로젝트멋진바다Cemeneted카바이드그랜드바다 일본에서 수입 (5) 전기 프레스있다생산하다카바이드끼워 넣다2백만...에 대한월.

우리의이점

1. 100 %의 텅스텐 카바이드 원료.

2. R & D 및 생산 능력은 시장 동향과 함께 유지합니다.

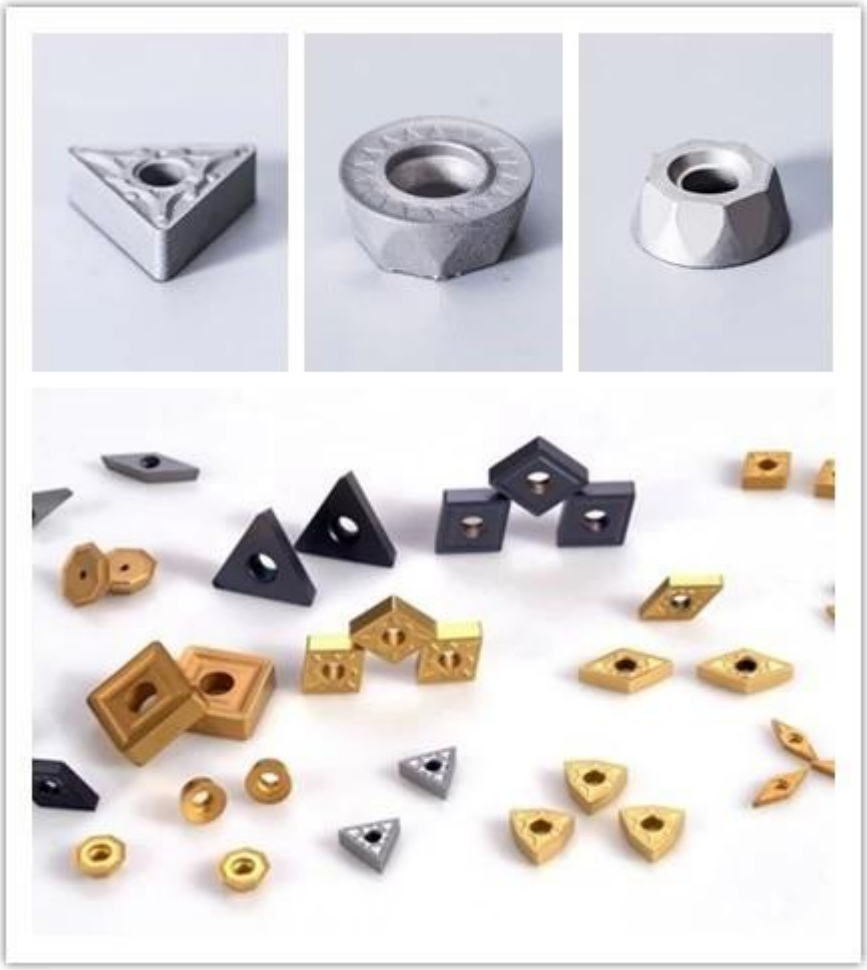
모든 측면에서 고객을위한 프로세싱 솔루션을 해결하기 3. 기술 지원 능력.

4. 적절한 주식은 빠른 배송을 보장합니다.

5. 우리는 도매 및 당신을 위해 카바이드 삽입을 사용자 정의 할 수있는 공급 업체입니다.

적인 **recommandation :**

등급	화장실 %	CO %	입자 크기 (UM)	밀도 (g / ㎤의) 0.1 ±	경도 (HRA) 0.5 ±	TRS (KGF / mm^2 인)
H10F	(90)	10.	0.8	14.40	91.8	> 350
H11F	87.	(12)	0.3.	14.50	91.4	> 350
H12A	88.	22.	1.2	14.20	90.5	> 350



1	2	3	4	5	6	7	8	9	10
C	N	M	G	12	04	08	(E)	(N)-	MP

1. Insert Shape

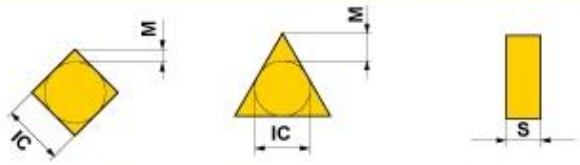
1. Insert Shape	
Symbol	Insert Shape
H	Hexagonal
O	Octagonal
P	Pentagonal
S	Square
T	Triangular
C	Rhombic 80°
D	Rhombic 55°
E	Rhombic 75°
F	Rhombic 50°
M	Rhombic 86°
V	Rhombic 35°
W	Trigon
L	Rectangular
A	Parallelogram 85°
B	Parallelogram 82°
K	Parallelogram 55°
R	Round
X	Special Design

2. Relief Angle

2. Relief Angle	
Symbol	Normal Clearance
A	3°
B	5°
C	7°
D	15°
E	20°
F	25°
G	30°
N	0°
P	11°
O	Other Relief Angle
Major Relief Angle	

3. Tolerance Class

3. Tolerance Class



Triangular insert with a facet (Secondary Cutting Edge)

3. Tolerance Class

Symbol	Tolerance of Nose Height **M** (mm)	Tolerance of Inscribed Circle **IC** (mm)	Tolerance of Thickness **S** (mm)
A	±0.005	±0.025	±0.025
F	±0.005	±0.013	±0.025
C	±0.013	±0.025	±0.025
H	±0.013	±0.013	±0.025
E	±0.025	±0.025	±0.025
G	±0.025	±0.025	±0.13
J	±0.005	±0.05−±0.15	±0.025
K*	±0.013	±0.05−±0.15	±0.025
L*	±0.025	±0.05−±0.15	±0.025
M*	±0.08−±0.18	±0.05−±0.15	±0.13
N*	±0.08−±0.18	±0.05−±0.15	±0.025
U*	±0.13−±0.38	±0.08−±0.25	±0.13

The surface of insert with * mark is sintered.

Detail of M Class Insert Tolerance

●Tolerance of Nose Height **M** (mm)

D.I.C.	Triangular	Square	Rhombic 80°	Rhombic 55°	Rhombic 35°	Round
6.35	±0.08	±0.08	±0.08	±0.11	±0.16	–
9.525	±0.08	±0.08	±0.08	±0.11	±0.16	–
12.70	±0.13	±0.13	±0.13	±0.15	–	–
15.875	±0.15	±0.15	±0.15	±0.18	–	–
19.05	±0.15	±0.15	±0.15	±0.18	–	–
25.40	–	±0.18	–	–	–	–
31.75	–	±0.20	–	–	–	–

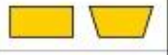
●Tolerance of Inscribed Circle **IC** (mm)

D.I.C.	Triangular	Square	Rhombic 80°	Rhombic 55°	Rhombic 35°	Round
6.35	±0.05	±0.05	±0.05	±0.05	±0.05	–
9.525	±0.05	±0.05	±0.05	±0.05	±0.05	±0.05
12.70	±0.08	±0.08	±0.08	±0.08	–	±0.08
15.875	±0.10	±0.10	±0.10	±0.10	–	±0.10
19.05	±0.10	±0.10	±0.10	±0.10	–	±0.10
25.40	–	±0.13	–	–	–	±0.13
31.75	–	±0.15	–	–	–	±0.15

4. Chipbreaker and Clamping System

4. Chipbreaker and Clamping System

Metric

Symbol	Hole	Hole Configuration	Chip Breaker	Figure	Symbol	Hole	Hole Configuration	Chip Breaker	Figure
W	With Hole	Cylindrical Hole + One Countersink (40−60°)	No		**A**	With Hole	Cylindrical Hole	No	
T	With Hole		One Sided		**M**	With Hole	Cylindrical Hole	Single Sided	
Q	With Hole	Cylindrical Hole + Double Countersink (40−60°)	No		**G**	With Hole	Cylindrical Hole	Double Sided	
U	With Hole		Double Sided		**N**	Without Hole	–	No	
B	With Hole	Cylindrical Hole + One Countersink (70−90°)	No		**R**	Without Hole	–	Single Sided	
H	With Hole		One Sided		**F**	Without Hole	–	Double Sided	
C	With Hole	Cylindrical Hole + Double Countersink (70−90°)	No		**X**	–	–	–	Special Design
J	With Hole		Double Sided						

5. Insert Size

5. Insert Size							
Symbol							Diameter of Inscribed Circle (mm)
R	W	V	D	C	S	T	
	02		04	03	03	06	3.97
	L3	08	05	04	04	08	4.76
	03	09	06	05	05	09	5.56
06							6.00
	04	11	07	06	06	11	6.35
	05	13	09	08	07	13	7.94
08							8.00
09	06	16	11	09	09	16	9.525
10							10.00
12							12.00
12	08	22	15	12	12	22	12.70
15	10		19	16	15	27	15.875
16							16.00
19	13		23	19	19	33	19.05
20							20.00
			27	22	22	38	22.225
25							25.00
25			31	25	25	44	25.40
31			38	32	31	54	31.75
32							32.00

6. Insert Thickness

6. Insert Thickness

*Thickness is from the bottom of the insert to the top of the cutting edge.

Symbol	Thickness (mm)
S1	1.39
01	1.59
T0	1.79
02	2.38
T2	2.78
03	3.18
T3	3.97
04	4.76
06	6.35
07	7.94
09	9.52

7. Insert Corner Configuration

7. Insert Corner Configuration	
Symbol	Corner Radius (mm)
00	Sharp Nose
V3	0.03
V5	0.05
01	0.1
02	0.2
04	0.4
08	0.8
12	1.2
16	1.6
20	2.0
24	2.4
28	2.8
32	3.2
00 : Inch M0 : Metric	Round Insert

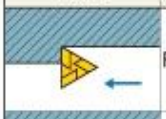
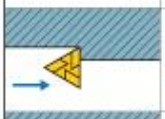
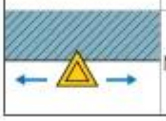
8. Cutting Edge Condition

8. Cutting Edge Condition

Figure	Cutting Edge	Symbol
	Sharp Cutting Edges	F
	Round Cutting Edges	E
	Chamfered Cutting Edges	T
	Chamfered and Rounded Cutting Edges	S

Mitsubishi Materials omit the honing symbol.

9. Cutting Direction

9. Cutting Direction		
Figure	Hand	Symbol
	Right	R
	Left	L
	Neutral	N

10. Chip Breaker

10. Chip Breaker		
LP	MP	RP
		
LM	MM	RM
		
LK	MK	RK
		
LS	MS	RS
		
FP	LP	MP
		
MA	SW	MW
		
HZ	HX	HV