

CN

Indexable CN End Mill for Efficient Machining

高效捨棄式 CN 雙面銑刀片

Multi-Purpose, Stable Machining of Steel, Cast Iron, Stainless Steel, and General Purpose by ONE Tool.

實現了單一刀具可穩定加工於一般鋼材、鑄鐵、不銹鋼的通用性。

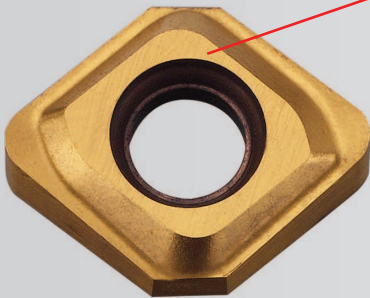
- High accuracy insert which is suitable for middle finishing and finishing.
高精度刀片適用於中、精銑
- 4 times use - The double-sided 2-edge design make it a cost-efficient solution.
大幅降低刀具成本 - 雙面對稱共四角可替換
- Nano composite; the oxidation temperature of nACro coating is up to 1,100°C
奈米級 nACro 高耐氧化溫度塗層
- Nano composite, super high hardness SH coating 奈米級 SH 超硬塗層

■ CN Indexable Insert

● CN 雙面銑刀片

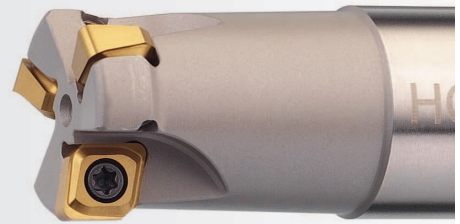
■ Feature 特色

Design 外型設計

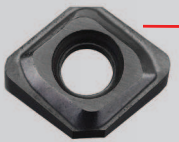


High accuracy insert which is suitable for middle finishing and finishing.
高精度刀片適用於中、精銑。

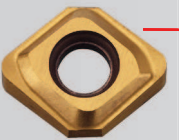
4 times use - The double-sided 2-edge design make it a cost-efficient solution.
雙面對稱四角可替換，減少刀具成本。



Coating 塗層介紹 - nACro and SH coating



The oxidation temperature of nACro coating is up to 1,100°C, which is suitable for milling cast iron, carbon steel, stainless steel, and alloy steel.
nACro 具有高達 1100°C 氧化溫度的特性，適用於切削鑄鐵、一般碳鋼、不鏽鋼以及合金鋼的鍍層。



SH coating is with low friction coefficient and super high hardness which is over HV4000; thus, with cutting tool, it can mill steel very easily.
SH 結構低摩擦係數，超高硬度，表面硬度達 Hv4000 以上，削鐵如泥。

Application 應用 新型超強韌微晶硬質合金 3225/4225 及 3220/4220



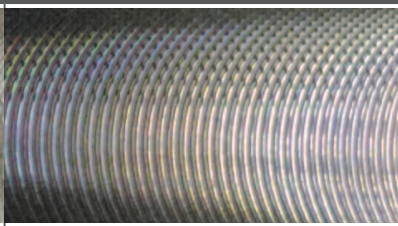
Tool Material 材料型號	ISO Standard Code ISO 標準代號	Cutting Material 材料種類	Applications 應用範圍													P Steel	M Stainless	K Cast Iron	N Non-ferrous	S Heat resistant	H Hard Alloy		
			1	5	10	15	20	25	30	35	40	45	50										
3225	P	Super Hard Alloy 超硬質合金															●					▲	
	M																	▲					
	K																		●				
4225	P	Super Hard Alloy 超硬質合金																●					▲
	M																		▲				
	K																		●				
3220	P	Super Hard Alloy 超硬質合金																●					
	M																	●				▲	
	K																		●				
4220	P	Super Hard Alloy 超硬質合金																●					
	M																		●				▲
	K																			●			

■ Surface Performance


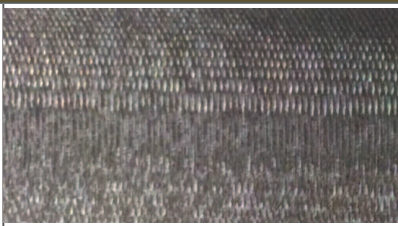
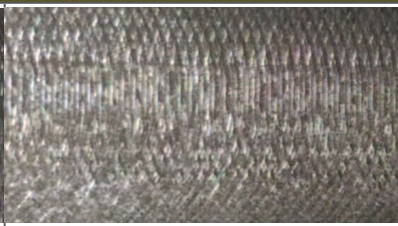
- 表面粗糙度

■ CN face milling CN 平銑

Surface Roughness Tester 表面粗度測量儀 : MitutoyoSurftest_SJ-301

Carbon Steel 中碳鋼 -S45C		
		
Holder 刀具: HCN07-D1602-S16-150		
Insert 刀片: CNGX07-3225		
Vc=180m/min		
N=3580rpm		
Fz=0.05mm/tooth	Fz=0.2mm/tooth	Fz=0.3mm/tooth
Ra=0.45 μm	Ra=1.01 μm	Ra=2.06 μm

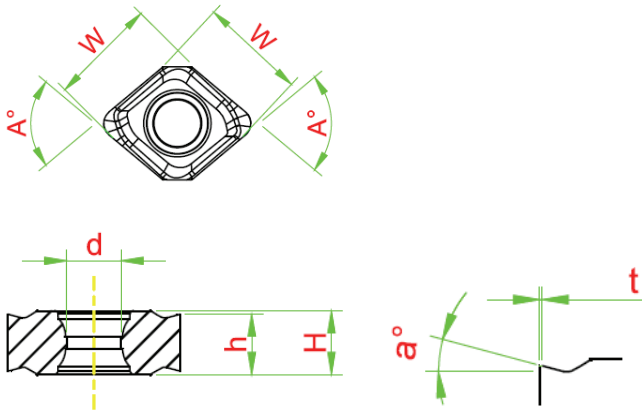
Stainless Steel 不鏽鋼 - SUS304		
		
Holder 刀具: HCN07-D1602-S16-150		
Insert 刀片: CNGX07-3225		
Vc=100m/min		
N=1990rpm		
Fz=0.05mm/tooth	Fz=0.2mm/tooth	Fz=0.3mm/tooth
Ra=0.38 μm	Ra=0.52 μm	Ra=1.38 μm

Nodular Cast Iron/Ductile Iron 球墨鑄鐵		
		
Holder 刀具: HCN07-D1602-S16-150		
Insert 刀片: CNGX07-3225		
Vc=200m/min		
N=3980rpm		
Fz=0.05mm/tooth	Fz=0.2mm/tooth	Fz=0.3mm/tooth
Ra=0.81 μm	Ra=1.09 μm	Ra=1.30 μm

■ CN Indexable Insert

● CN 雙面菱形銑刀

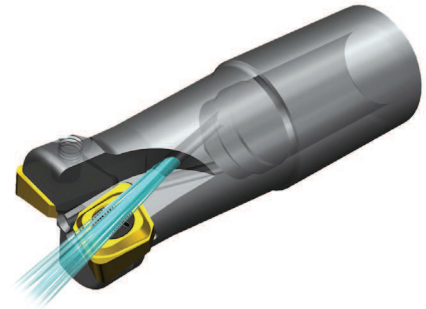
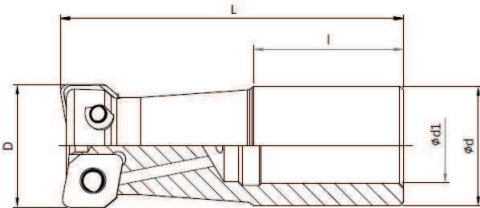
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Item Code 規格碼	Dimensions (mm) 規格							Material 材質		Coating 塗層		Milling 銑削	P	M	K
	W	d	h	H	A	a	t	3225 4225	3220 4220	nACro	SH				
CNGX07-3225	7	3.1	3.41	3.6	80	15	0.02 ~0.03	✓			✓	Roughing 粗銑	●	▲	●
												Medium 中	●	▲	●
												Finishing 精銑	●	▲	●
CNGX07-4225	7	3.1	3.41	3.6	80	15	0.02 ~0.03	✓		✓		Roughing 粗銑	●	●	●
												Medium 中	●	●	●
												Finishing 精銑	●	●	●
CNGX07-3220	7	3.1	3.41	3.6	80	15	0.02 ~0.03		✓		✓	Roughing 粗銑	●	▲	▲
												Medium 中	●	▲	●
												Finishing 精銑	●	▲	●
CNGX07-4220	7	3.1	3.41	3.6	80	15	0.02 ~0.03		✓	✓		Roughing 粗銑	●	●	▲
												Medium 中	●	●	●
												Finishing 精銑	●	●	●

■ CNGX07 Indexable Shrink Fit Head & Holder

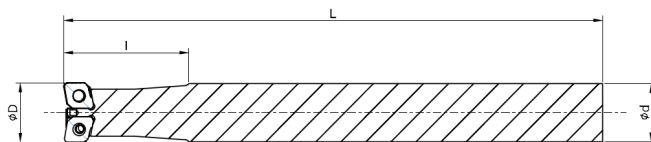
● CNGX07 捨棄式燒結刀頭 & 整體刀柄



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CN Indexable Shrink Fit Head CN 捨棄式燒結刀頭

Item Code 規格碼	Dimensions (mm) 規格						Available Tools 適用工具		
	D	d	d1	L	l	齒數T*	Insert 刀片	Screw 星形螺絲	Screwdriver 旗形板手
SCN07-D1602	16	16	10	45	35.0	2	CN__07	M3x6.3x4xT10 (D07160100113)	T10
SCN07-D1603	16	16	10	45	35.0	3			
SCN07-D1702	17	16	10	45	35.0	2			
SCN07-D1703	17	16	10	45	35.0	3			
SCN07-D2003	20	20	12	45	40.0	3			
SCN07-D2004	20	20	12	45	40.0	4			
SCN07-D2103	21	20	12	45	40.0	3			
SCN07-D2104	21	20	12	45	40.0	4			



Holder 菱形整體刀柄

Item Code 規格碼	Dimensions (mm) 規格					Available Tools 適用工具		
	D	d	L	l	齒數T*	Insert 刀片	Screw 星形螺絲	Screwdriver 旗形板手
HCN07-D1602-S16-150	16	16	150	35	2	CN__07	M3x6.3x4xT10 (D07160100113)	T10
HCN07-D1702-S16-150	17	16	150	35	2			
HCN07-D2003-S20-150	20	20	150	40	3			
HCN07-D2103-S20-150	21	20	150	40	3			