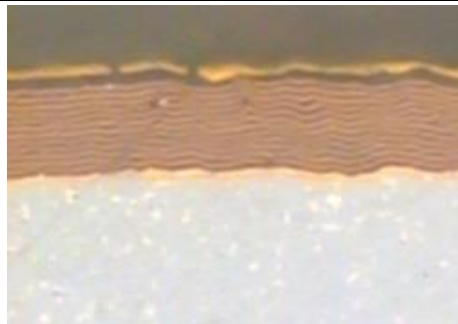


高温合金刀具

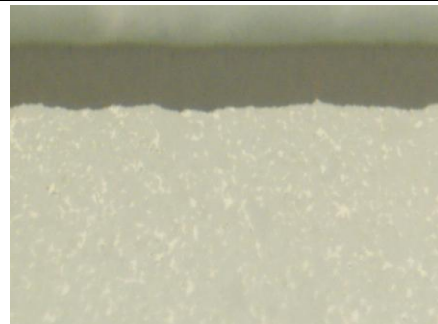
本公司利用添加稀土元素和采用特殊的烧结工艺,研发出专用铣削车削等基体材料牌号 GY83、GY87、GY53 和 GY03、GY08, 特别在搭配优选的 PVD、CVD 复合涂层后, 具有卓越的韧性和耐磨性, 主要用于高温合金、钛合金及不锈钢铣削, 广泛用于汽轮机、飞机发动机叶片、机匣等难加工材料的铣削和车削。该种涂层在干式铣削不锈钢时具有极高的抗月牙洼磨损和抗后刀面磨损性能。

CTRI has developed special grade GY83,GY87,GY03, and GY08 for turning and milling by adding rare earth (RE) and applying special sintering processing. Products demonstrate excellent toughness and wear resistance after PVD and CVD composite coating, mainly applied for high-temperature alloy, titanium alloy and stainless steel milling, widely used in milling and turning of steam turbine, blade of aircraft engine, casing and other hard- to -machine materials. The coating has high anti crater wear resistance and flank wear performance in dry milling of stainless steel.

| 切削参数推荐 | | | | | |
|--------------|---------|--------|---------|---------|---------|
| 切削材质 | 不锈钢 | | | Ni 基合金 | 钛合金 |
| | 粗加工 | | 精加工 | | |
| 加工方式 | 粗加工 | | 精加工 | | |
| 切削速度 (m/min) | 100-200 | | 160-300 | 40-120 | 50-75 |
| 进给 (m/min) | 0.6-1.2 | | 0.6-1.0 | 0.6-0.8 | 0.6-0.8 |
| 切深 (mm) | 0.5-2.5 | | 0.5-2.5 | 0.5-1.5 | 0.5-1.5 |
| 切削材质及涂层 | GY8768 | GY8785 | GY8368 | GY8785 | GY8785 |
| 冷却方式 | 干 | 湿 | 干/湿 | 干/湿 | 干/湿 |



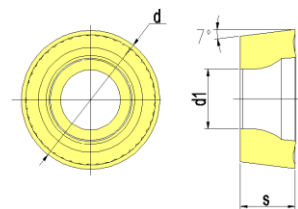
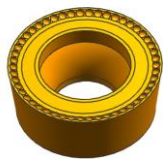
复合 PVD



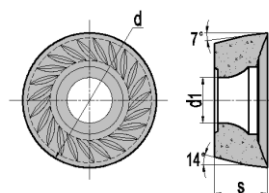
PVD

| Recommended Cutting Parameter | | | | | |
|-------------------------------|-----------------|------------------|---------|----------------|----------------|
| Cutting Material | Stainless Steel | | | Ni-based alloy | titanium alloy |
| Cutting | Rough Machining | Finish Machining | | | |
| Cutting Speed (m/min) | 100-200 | 160-300 | 40-120 | 50-75 | |
| Feed (m/min) | 0.6-1.2 | 0.6-1.0 | 0.6-0.8 | 0.6-0.8 | |
| Cutting Depth (mm) | 0.5-2.5 | 0.5-2.5 | 0.5-1.5 | 0.5-1.5 | |
| Grade | GY8768 | GY8785 | GY8368 | GY8785 | GY8785 |
| Coolant | Dry | wet | dry/wet | dry/wet | dry/wet |

- 代表主推牌号 ○ 代表可选牌号
- Recommended Grade ○ Optional Grade



| Order No. | Dimension (mm) | | | Grade | |
|-----------------|----------------|------|-----|-------|------|
| | d | s | d1 | GY83 | GY87 |
| RCKT10T3MO | 10 | 3.97 | 4.4 | ● | ○ |
| RCKT10T3MOT | 10 | 3.97 | 4.2 | ● | ○ |
| RCKT10T3MOT-3.5 | 10 | 3.97 | 3.9 | ● | ○ |



| Order No. | Dimension (mm) | | | Grade | |
|------------|----------------|------|------|-------|------|
| | d | s | d1 | GY83 | GY87 |
| RCKT1204MO | 12 | 4.76 | 4.05 | ○ | ● |