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Stainless Steel Turning Inserts

不锈钢车削加工

全新
起航

CEMENTED CARBIDE TOOLS

PVD Coating

PVD涂层

KM252P
KM254S
KM402P

New groove type

全新槽型

KMM
KGM

株洲威克多硬质合金有限公司

Zhuzhou Weikeduo Cemented Carbide Co., LTD.

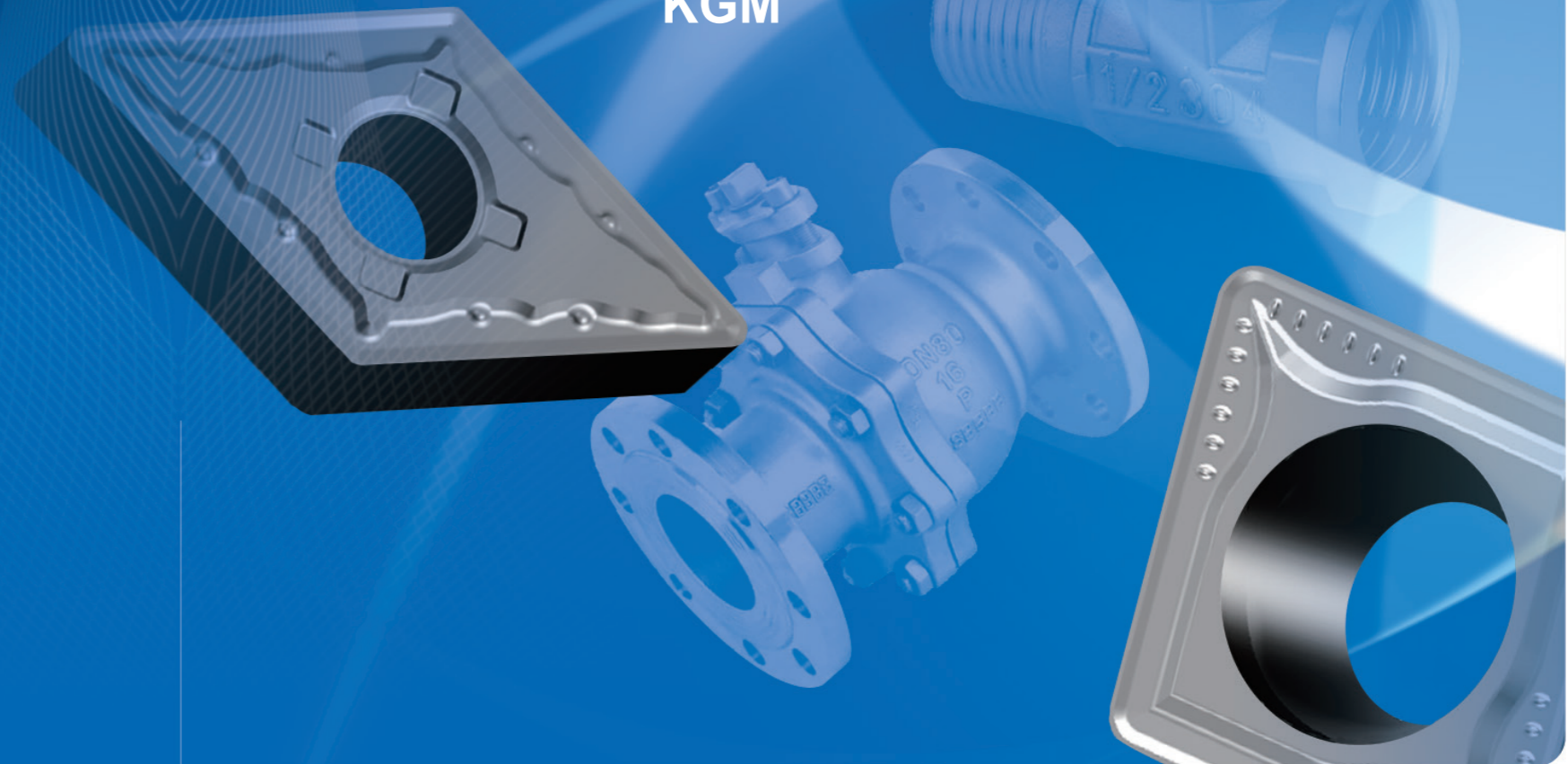
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PVD

Grade Series

■ KM252P

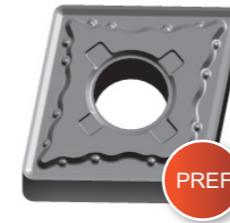
Fine-grained carbide.
nc—TiAlN coating.

■ KM254S

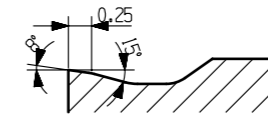
Ultrafine grain cemented carbide.
High temperature resistant coating. **HOT**

■ KM402P

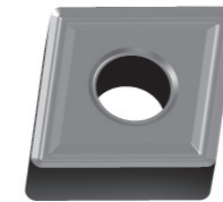
High strength substrate.
nc—TiAlN coating



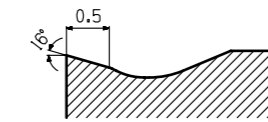
Semi-finishing ~ Roughing



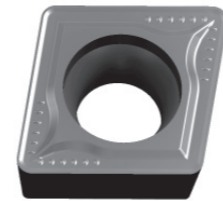
For semi-finishing and rough machining, it has a balance of strength and sharpness, and has extremely high stability regardless of continuous or intermittent working conditions.



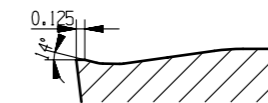
Finishing ~ Semi-finishing



It not only takes into account the strength but also enhances the sharpness of the cutting edge, and has excellent wear resistance under stable working conditions or continuous cutting.



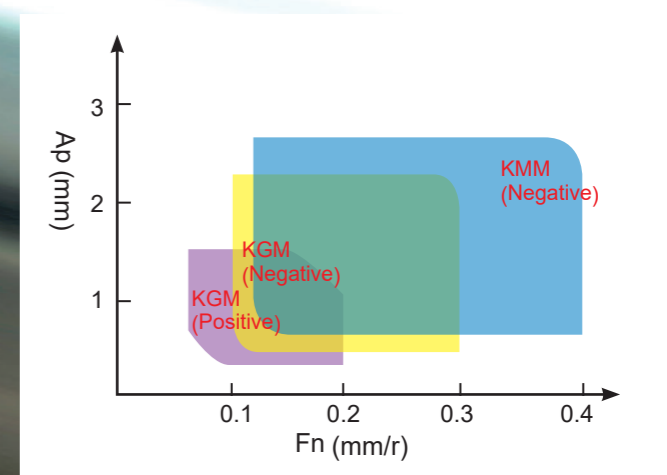
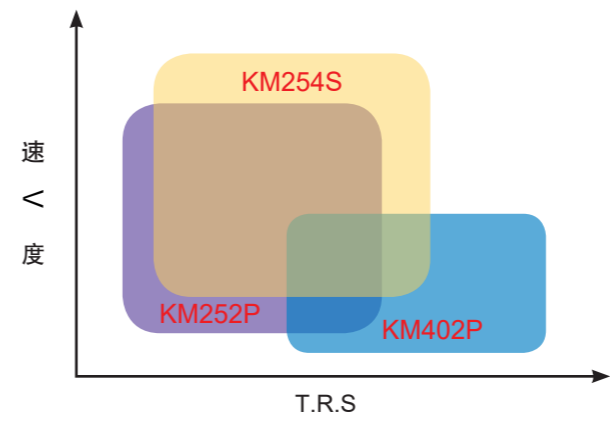
General turning



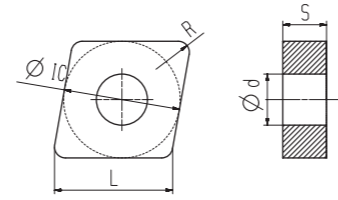
The universal positive-angle geometry of stainless steel, the blade edge and groove width are specially designed to meet the chip breaking requirements of continuous machining and the strength requirements of intermittent machining.

涂层表面经过特殊的后处理，大幅降低了摩擦系数

The coating surface has been specially post-treated to significantly reduce the friction coefficient



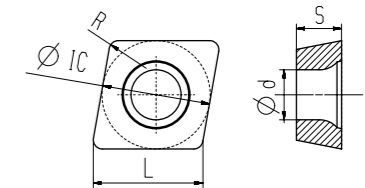
Negative



Insert Shape	Model	尺寸 (Dimension)mm					Grade					
		L	IC	d	S	R	KM152P	KM252P	KM254S	KM402P	KM251U	KM401U
	CNMG120404-KMM	12.9	12.7	5.16	4.76	0.4		●	★			○
	CNMG120408-KMM	12.9	12.7	5.16	4.76	0.8		●	★			○
	CNMG120412-KMM	12.9	12.7	5.16	4.76	1.2		●	★			○
	CNMG120404-KGM	12.9	12.7	5.16	4.76	0.4		●				○
	CNMG120408-KGM	12.9	12.7	5.16	4.76	0.8		●				○
	CNMG120412-KGM	12.9	12.7	5.16	4.76	1.2		●				○
	WNMG080404-KMM	8.7	12.7	5.16	4.76	0.4		●	★			○
	WNMG080408-KMM	8.7	12.7	5.16	4.76	0.8		●	★			○
	WNMG080412-KMM	8.7	12.7	5.16	4.76	1.2		●	★			○
	WNMG080404-KGM	8.7	12.7	5.16	4.76	0.4		●				○
	WNMG080408-KGM	8.7	12.7	5.16	4.76	0.8		●				○
	WNMG080412-KGM	8.7	12.7	5.16	4.76	1.2		●				○
	DNMG150604-KMM	15.5	12.7	5.16	4.76	0.4		●	★			○
	DNMG150608-KMM	15.5	12.7	5.16	4.76	0.8		●	★			○
	DNMG150612-KMM	15.5	12.7	5.16	4.76	1.2		●	★			○
	DNMG150604-KGM	15.5	12.7	5.16	4.76	0.4		●				○
	DNMG150608-KGM	15.5	12.7	5.16	4.76	0.8		●				○
	DNMG150612-KGM	15.5	12.7	5.16	4.76	1.2		●				○
	TNMG160404-KMM	16.5	9.525	3.81	4.76	0.4		●	★			○
	TNMG160408-KMM	16.5	9.525	3.81	4.76	0.8		●	★			○
	TNMG160412-KMM	16.5	9.525	3.81	4.76	1.2		●	★			○
	TNMG160404-KGM	16.5	9.525	3.81	4.76	0.4		●				○
	TNMG160408-KGM	16.5	9.525	3.81	4.76	0.8		●				○
	TNMG160412-KGM	16.5	9.525	3.81	4.76	1.2		●				○

Insert Shape	Model	尺寸 (Dimension)mm					Grade					
		L	IC	d	S	R	KM152P	KM252P	KM254S	KM402P	KM251U	KM401U
	SNMG120408-KMM	12.7	12.7	5.16	4.76	0.8		●				○
	SNMG120412-KMM	12.7	12.7	5.16	4.76	1.2		●				○
	SNMG120408-KGM	12.7	12.7	5.16	4.76	0.8			★			○
	SNMG120412-KGM	12.7	12.7	5.16	4.76	1.2			★			○
	VNMG160404-KMM	16.6	9.525	3.81	4.76	0.4		●				○
	VNMG160408-KMM	16.6	9.525	3.81	4.76	0.8		●				○
	VNMG160412-KMM	16.6	9.525	3.81	4.76	1.2		●				○
	VNMG160404-KGM	16.6	9.525	3.81	4.76	0.4			★			○
	VNMG160408-KGM	16.6	9.525	3.81	4.76	0.8			★			○
	VNMG160412-KGM	16.6	9.525	3.81	4.76	1.2			★			○

★ Mainly grade brands are in stock ● Optional grades ○ Made to Order



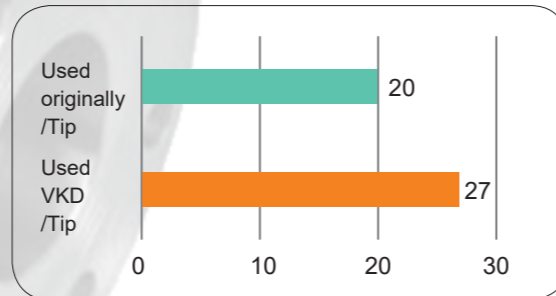
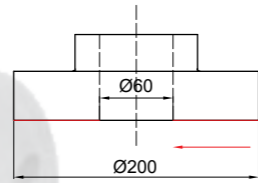
Positive

Insert Shape	Model	尺寸 (Dimension)mm					Grade					
		L	IC	d	S	R	KM152P	KM252P	KM254S	KM402P	KM251U	KM401U
	CCMT060202-KGM	6.4	6.35	2.8	2.38	0.2		●			●	○
	CCMT060204-KGM	6.4	6.35	2.8	2.38	0.4		●			●	○
	CCMT060208-KGM	6.4	6.35	2.8	2.38	0.8		●			●	○
	CCMT09T304-KGM	9.7	9.525	4.4	3.97	0.4		●			●	○
	CCMT09T308-KGM	9.7	9.525	4.4	3.97	0.8		●			●	○
	TCMT110202-KGM	11	6.35	2.8	2.38	0.2		●			●	○
	TCMT110204-KGM	11	6.35	2.8	2.38	0.4		●			●	○
	TCMT110208-KGM	11	6.35	2.8	2.38	0.8		●			●	○

★ Mainly grade brands are in stock ● Optional grades ○ Made to Order

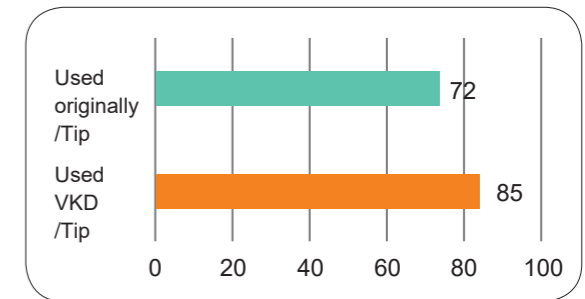
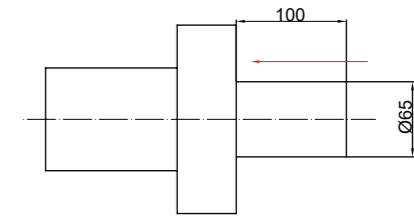
工件名称 (Work piece): Flange

- 被加工材料 (Work piece material): 316L
- 加工设备 (Lathe type): CNC Lathe
- 使用刀片 (insert): KM254S WNMG080408-KGM
- 加工内容 (Processing content): 车端面
- 换刀标准 (Insert change criteria): Surface processing quality, excessive wear of inserts.
- 切削液 (Cooling type): wet cut
- 加工参数 (Cutting parameters):
Vc=120-200m/min Fn=0.25mm/r Ap=1~2mm



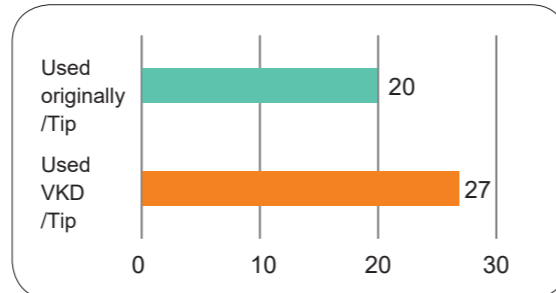
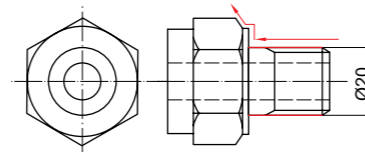
工件名称 (Work piece): Bearings

- 被加工材料 (Work piece material): 316L
- 加工设备 (Lathe type): CNC Lathe
- 使用刀片 (insert): KM254S CNMG120408-KGM
- 加工内容 (Processing content): Outer circle
- 换刀标准 (Insert change criteria): Surface processing quality, excessive wear of inserts.
- 切削液 (Cooling type): wet cut
- 加工参数 (Cutting parameters):
Vc=100-140m/min Fn=0.25mm/r Ap=1~1.54mm



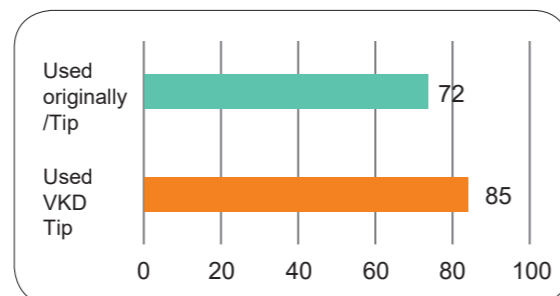
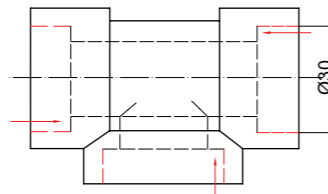
工件名称 (Work piece): Connectors

- 被加工材料 (Work piece material): 316L
- 加工设备 (Lathe type): CNC Lathe
- 使用刀片 (insert): KM252P WNMG080408-KMM
- 加工内容 (Processing content):
Outer circle and shoulder
- 换刀标准 (Insert change criteria): Surface processing quality, excessive wear of inserts.
- 切削液 (Cooling type): wet cut
- 加工参数 (Cutting parameters):
Vc=80-120m/min Fn=0.3mm/r Ap=0.7~1.5mm



工件名称 (Work piece): Connectors

- 被加工材料 (Work piece material): 304
- 加工设备 (Lathe type): CNC Lathe
- 使用刀片 (insert): KM252P CCMT09T308-KGM
- 加工内容 (Processing content): Inner hole
- 换刀标准 (Insert change criteria): Surface processing quality, excessive wear of inserts.
- 切削液 (Cooling type): wet cut
- 加工参数 (Cutting parameters):
Vc=80-120m/min Fn=0.15mm/r Ap=0.3~1mm



Recommended turning speed (Vc: m/min)

	Continuous	Light Intermittent	Intermittent
Austenitic type	180(120-240)	150(80-220)	120(70-160)
ferrite type	190(130-250)	160(90-230)	130(80-170)
martensite type	190(130-250)	160(90-230)	---

Recommended turning depth and feed (Ap: mm Fn: mm/r)

	Continuous ~ Light Intermittent		Intermittent
	KM254S	KM252P	KM402P
KMM	Ap: 0.5~3.5 Fn: 0.12~0.35	---	---
KGM(Negative)	Ap: 0.5~3.5 Fn: 0.15~0.4	Ap: 0.5~3.5 Fn: 0.15~0.35	Ap: 0.5~2.5 Fn: 0.15~0.3
KGM(Positive)	Ap: 0.2~2 Fn: 0.08~0.25	Ap: 0.2~2 Fn: 0.08~0.2	Ap: 0.2~2 Fn: 0.08~0.2

