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PCD切削刀片
PCD CUTTING INSERT

山田PCD系列

YAMADA PCD Series

我们的优势：

山田公司率先和国际顶尖材料供应商战略合作，针对性开发了优质的聚晶金刚石切削用材料。根据被加工材料不同的需求开发了细颗粒、中颗粒，粗颗粒以及混合颗粒几大不同的原材料系列，拥有最高的耐磨损性和耐崩损性，以保证在所有铝合金和非铁合金的加工中发挥高性能、高精度和高效率！合理的设计理念、全自动化批量生产模式使产品能够拥有更稳定的品质并最大限度的发挥出 PCD 材质的优异性能！

山田PCD Yamada grades	粒 度 granularity	加工对象 work material	我们的优势 our advantages
DS72	<1um	通用材料 general material	超细颗粒，晶粒间结合能力强，相对普通细颗粒材质在拥有高的刀刃质量的同时兼具更高的韧性、耐磨性和耐崩损性。 For superfine particle,the intergranular combining capacity is strong, compared with the common fine particle texture,it owns high cutting edge quility ,meanwhile high toughness,high wear and crash damage resistance.
DS31	10um	Si<13%的硅铝合金； 铜、铜合金； 石墨以及石墨复合材料； 未烧结陶瓷和硬质合金； Si<13% silumin, copper,copper alloy, graphite and graphite composite material, non-sintering ceramics and cemented carbide	一般切削用材料,刀刃质量高,耐磨性优秀,并具有相当的抗冲击强度 , PCD 层的厚度包括标准、厚和薄三种, 因此可以制作各种普通加工、粗加工以及精加工刀具和耐磨器件 General cutting material with high quility cutting edge, excellent wear resistance and considerable shock resistance strength.The PCD layer thickness includes standard,thick and thin,so it can make all kinds of common machining,rough maching,finish maching and wear resistance components.
DS51	25um	Si>13%的硅铝合金； 金属基复合材料； 烧结陶瓷和硬质合金； 其他高耐磨材料； Si>13% silumin, metal matrix composite, sintering ceramics and cemented carbide, other high wear resistance materials	由25um左右大的粗颗粒金刚石粒子烧结而成，耐磨性和抗冲击强度极高，拥有超长的工具寿命! Sintered by 25um coarse particle diamond granule.The wear and shock strength resistance is strong.So it has a long tool life!
DS71	2um+30um	复合金属（铝+铸铁）； 低速切削铸铁； composite metal(Al+cast iron), low-speed cutting cast iron	由2um和30um的金刚石粒子混合烧结而成，从而使该材料能够拥有细颗粒材料的韧性和粗颗粒材料的耐磨性，并能够刃磨出锋利的切削刃，在苛刻的复合材料加工中发挥最佳的性能! Mixed sintered by 2um and 30um diamond granule,which makes the material possess fine particle toughness and coarse particle wear-resistance,and be able to grind out sharp cutting edge,it plays the best performance in harsh composite material processing.

切削推荐条件

Recommended cutting conditions

被加工材料 Work material	切削速度Vc(m/min) cut speed	进给f(mm/rev) feed rate	切深ap(mm) cut depth	推荐材质 recommended material	
铝合金 (Si<13%)(Aluminum alloy)	100–3000	0.03–0.5	0.1–3	DS31	DS72
铝合金(Si>13%)(Aluminum alloy)	100–2500	0.03–0.4	0.1–2.5	DS51	
铜合金(Copper alloy)	100–1000	0.03–0.3	0.1–3	DS31	
强化塑料(reinforced plastics)	100–1000	0.05–0.3	0.1–2		
钛合金(titanium alloy)	100– 200	0.05–0.2	0.1–2		
硬质合金(cemented carbide)	10–30	0.03–0.1	0.05–0.3		
木材(Wood)	100–4000	0.1–0.4	0.1–3		
石墨(graphite)	100–600	0.1–0.5	0.05–2		

Our advantages:

Shanghai Yamada Tools Co.,Ltd leads to cooperate strategically with outstanding international material supliers, specifically developing superior PCD cutting materials. According to different processing material demands,a few different raw material series (including with fine particle,medium particle,coarse particle and mixed particle)are developed, top wear and crash damage resistance to assure the high-performance, high-precision and high-efficiency in all the Aluminium alloy and non-iron alloy processing! Rational design concept and fully automated mass production mode will make the production stable and the PCD texture excellent to the furthest.

PCD断屑槽系列

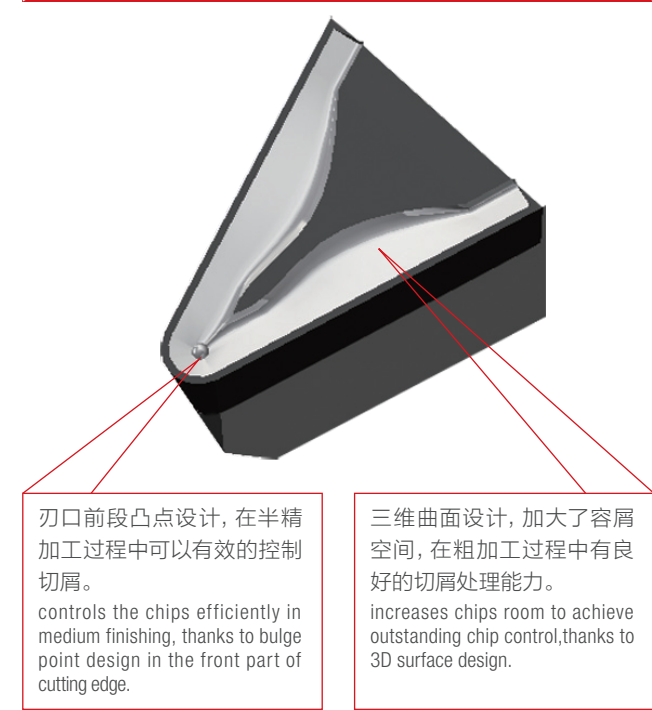
Line up of PCD chipbreaker

◆特点：

山田专利的断屑槽系列，可以轻松的应对加工过程中铝屑缠绕的问题，有效的折断切屑，大幅度提高加工效率，满足精加工表面粗糙度需求。

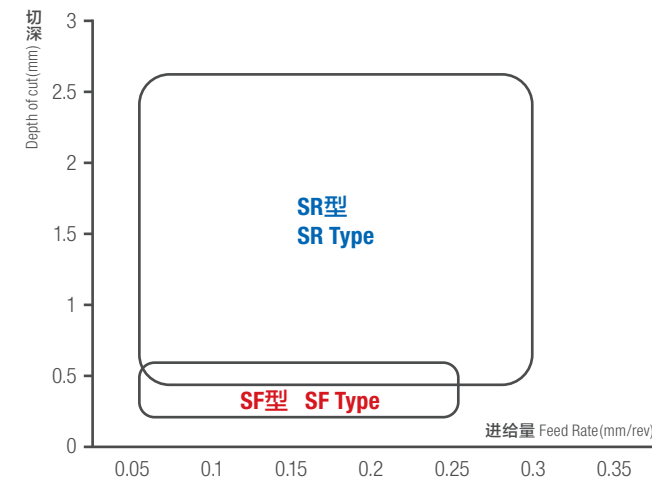
SR型：粗加工—半精加工

SR type: roughing-medium finishing



加工范围

process range

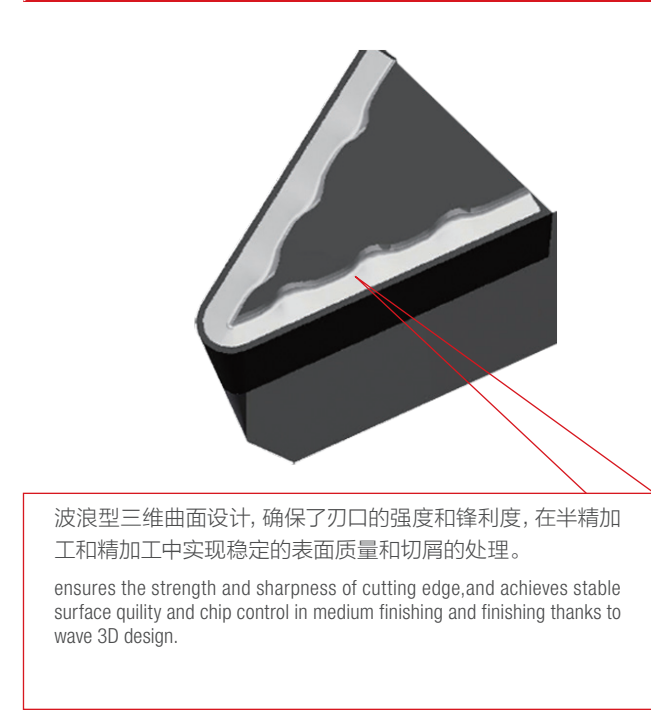


◆ Feature:

Yamada chipbreaker can solve aluminum chip control problems easily break chips effectively,to drastically improve work efficiency,and meet the requirement of surface roughness for finishing.

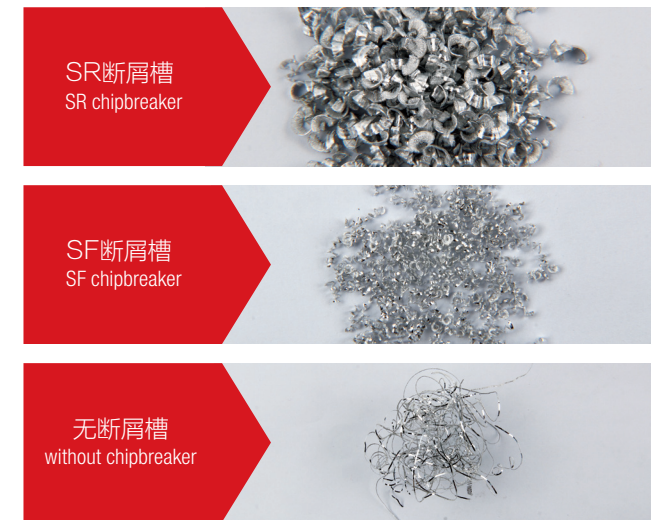
SF型：半精加工 — 精加工

SF type:medium finishing-finishing



断屑效果

chipbreaker effect

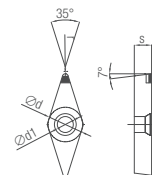
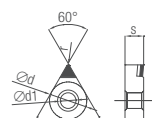
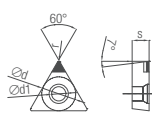
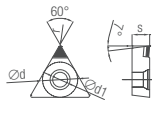
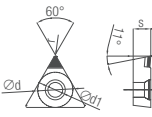
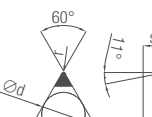


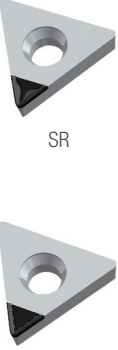
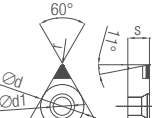
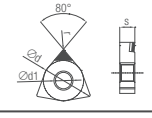
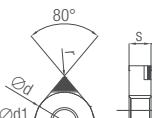
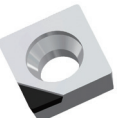
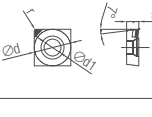
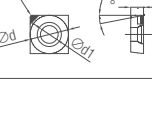
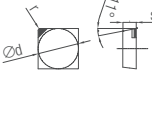
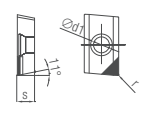
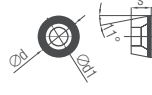
PCD标准刀片规格表

PCD standard insert specification listings

外观 appearance	外形 shape	型号 type	材质 material				内切圆(ϕd) inscribed circle	厚度(s) thickness	刀尖r角 nose radius	孔径(ϕd1) hole diameter
			DS72	DS31	DS51	DS71				
		CNMM	120404				12.7	4.76	0.4	5.16
			120408						0.8	
			120412						1.2	
		CCGW	060201				6.35	2.38	0.1	2.8
			060202						0.2	
			060204						0.4	
		CCGW	09T302				9.525	3.97	0.2	4.4
			09T304						0.4	
			09T308						0.8	
		CCMT	060202				6.35	2.38	0.2	2.8
			060204						0.4	
			060208						0.8	
			09T302						0.2	
		CPMT	080201				7.94	2.38	0.1	2.8
			080202						0.2	
			080204						0.4	
			090304						0.4	
		CPMT	090308				9.525	3.18	0.8	4.4
			090312						1.2	
		CCGT	060202-SR				6.35	2.38	0.2	2.8
			060204-SR						0.4	
		CCGT	060202-SF						0.2	4.4
			060204-SF						0.4	
		CCGT	09T302-SR				9.525	3.97	0.2	
			09T304-SR						0.4	
			09T308-SR						0.8	
		CCGT	09T302-SF						0.2	4.4
			09T304-SF						0.4	
			09T308-SF						0.8	

外观 appearance	外形 shape	型号 type	材质 material				内切圆(ϕd) inscribed circle	厚度(s) thickness	刀尖r角 nose radius	孔径(ϕd1) hole diameter		
			DS72	DS31	DS51	DS71						
		DNMM	150402					12.7	4.76	0.2	5.16	
			150404							0.4		
			150408							0.8		
			150412							1.2		
		DCMT	070201					6.35	2.38	0.1	2.8	
			070202							0.2		
			070204							0.4		
		DCMT	11T301					9.525	3.97	0.1	4.4	
			11T302							0.2		
			11T304							0.4		
11T308							0.8					
		DCMT	11T302-SR					9.525	3.97	0.2	4.4	
			11T304-SR							0.4		
			11T308-SR							0.8		
		DCMT	11T302-SF					9.525	3.97	0.2	4.4	
			11T304-SF							0.4		
			11T308-SF							0.8		
			VNMM	160404					9.525	4.76	0.4	3.8
				160408							0.8	
				160412							1.2	
		VBMT	110302					6.35	3.18	0.2	2.8	
			110304							0.4		
			110308							0.8		
		VBMT	160402					9.525	4.76	0.2	4.4	
			160404							0.4		
			160408							0.8		
			160412							1.2		
		VCMT	110302					6.35	3.18	0.2	2.8	
			110304							0.4		
			110308							0.8		
		VCMT	160404					9.525	4.76	0.4	4.4	
			160408							0.8		
160412							1.2					
		VCMT	110302-SR					6.35	3.18	0.2	2.8	
			110304-SR							0.4		
		VCMT	110302-SF					9.525	4.76	0.2	4.4	
			110304-SF							0.4		
		VCMT	160404-SR					9.525	4.76	0.4	4.4	
			160408-SR							0.8		
	160412-SR						1.2					

外观 appearance	外形 shape	型号 type	材质 material				内切圆(φd) inscribed circle	厚度(s) thickness	刀尖r角 nose radius	孔径(φd1) hole diameter
			DS72	DS31	DS51	DS71				
		VCMT	160404-SF				9.525	4.76	0.4	4.4
			160408-SF						0.8	
			160412-SF						1.2	
		TNMM	160404				9.525	4.76	0.4	3.81
			160408						0.8	
			160412						1.2	
		TCGW	110302				6.35	3.18	0.2	3.4
			110304						0.4	
		TCGT	110202				6.35	2.38	0.2	2.8
			110204						0.4	
		TCMT	080202				4.76	2.38	0.2	2.4
			080204						0.4	
		TCMT	090202				5.56	2.38	0.2	2.5
			090204						0.4	
		TCMT	110301				6.35	3.18	0.1	3.4
			110302						0.2	
			110304						0.4	
		TPGW	080202				4.76	2.38	0.2	2.4
			080204						0.4	
		TPGW	090202				5.56	2.38	0.2	2.8
			090204						0.4	
		TPGW	110302				6.35	3.18	0.2	3.4
			110304						0.4	
		TPGW	160404				9.525	4.76	0.4	4.4
			160408						0.8	
			160412						1.2	
		TPGT	110302				6.35	3.18	0.2	3.4
			110304						0.4	
		TPGN	090204				5.56	2.38	0.4	/
			090208						0.8	
		TPGN	110302				6.35	3.18	0.2	/
			110304						0.4	
			110308						0.8	
		TPGN	160302				9.525	3.18	0.2	/
			160304						0.4	
			160308						0.8	

外观 appearance	外形 shape	型号 type	材质 material				内切圆(φd) inscribed circle	厚度(s) thickness	刀尖r角 nose radius	孔径(φd1) hole diameter
			DS72	DS31	DS51	DS71				
		TPGT	090202-SR				5.56	2.38	0.2	2.8
			090204-SR						0.4	
		TPGT	090202-SF				5.56	2.38	0.2	2.8
			090204-SF						0.4	
		TPGT	110302-SR				6.35	3.18	0.2	3.4
			110304-SR						0.4	
		TPGT	110302-SF				6.35	3.18	0.2	3.4
			110304-SF						0.4	
		TPGT	160404-SR				9.525	4.76	0.4	4.4
			160408-SR						0.8	
			160412-SR						1.2	
		TPGT	160404-SF				9.525	4.76	0.4	4.4
			160408-SF						0.8	
			160412-SF						1.2	
		WNMM	080404				12.7	4.76	0.4	5.16
			080408						0.8	
			080412						1.2	
		WNMT	080404-SR				12.7	4.76	0.4	5.16
			080408-SR						0.8	
			080412-SR						1.2	
		WNMT	080404-SF				12.7	4.76	0.4	5.16
			080408-SF						0.8	
			080412-SF						1.2	
		SCMT	09T302				9.525	3.97	0.2	4.4
			09T304						0.4	
			09T308						0.8	
		SPGW	090304				9.525	3.18	0.4	4.4
			090308						0.8	
		SPGN	090304				9.525	3.18	0.4	/
			090308						0.8	
		SPGN	120304				12.7	3.18	0.4	/
			120308						0.8	
		APMT	160404				/	4.76	0.4	4.4
			160408						0.8	
		RPGW	080300				8	3.18	/	3.4
		RPGT	080300						/	