

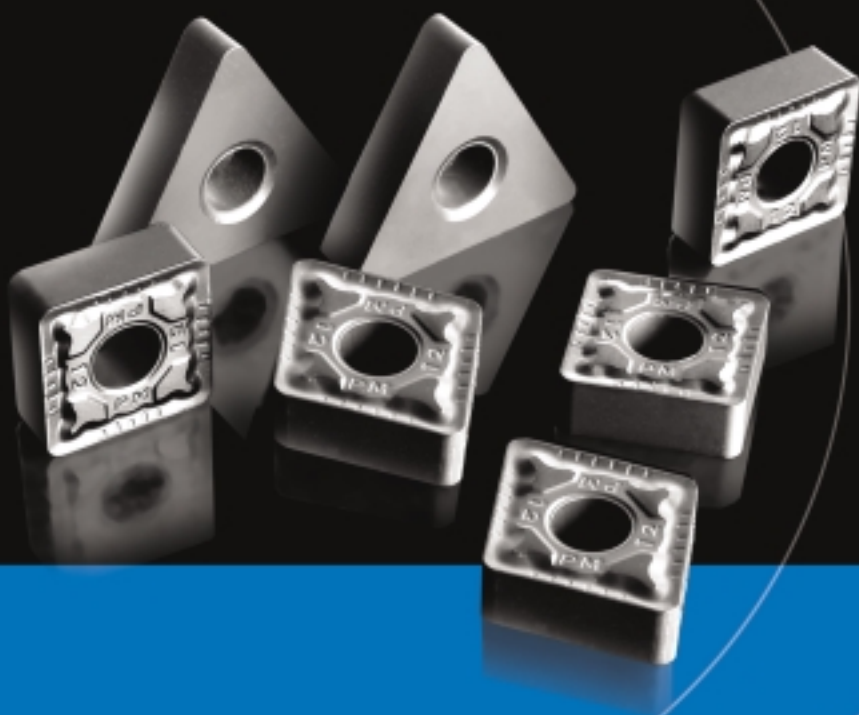
高速 高进给量 长寿命  
Higher speed higher feed longer life

铸铁加工

For cast iron machining

# 黑金刚刀片

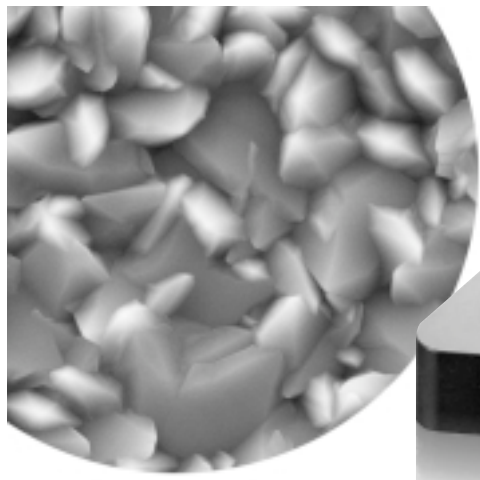
## BLACK-DIAMOND



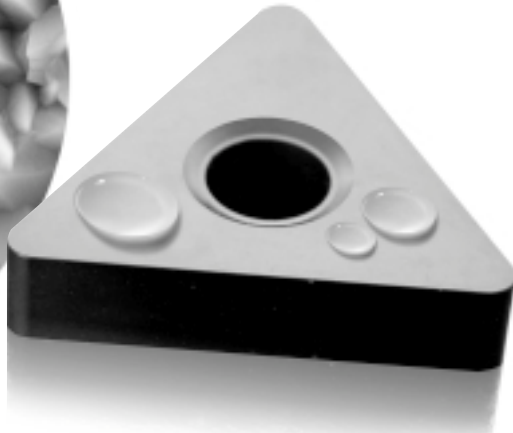
- ▼ YBD052
- ▼ YBD102
- ▼ YBD152
- ▼ YBD252



株洲钻石切削刀具股份有限公司  
ZHUSHOU CEMENTED CARBIDE CUTTING TOOLS CO.,LTD.



表面致密细晶粒层



# 黑金刚刀片

## Black-Diamond

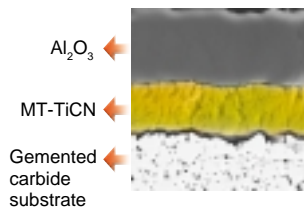
铸铁是汽车、压缩机行业应用最广泛的结构材料之一，应用高速切削技术将会获得极高的生产效率和明显的经济效益。高速切削工艺由于速度高，刀片受到高频率的近乎冲击性质的切削力和热震作用，这就要求刀片具有稳定的高温性能和良好的耐冲击性。“黑金刚”刀片是钻石切削刀具股份有限公司最新推出的满足市场这一性能需求的新产品。

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- 厚的涂层和坚硬耐冲击的基体结合，在满足铸铁高速、高进给量加工要求的同时又提高了刀片的耐磨性。
- 锃亮的全黑色的产品外貌便于识别。

The cast iron is widely used in industries of automobile and compressor. You will make a big leap forward in the productivity and economic benefits if the high speed cutting technology are used. The insert with very high heat-stability and impact-resistance can bear the force under impact, heat-shake and high speed condition. The "Black Diamond" insert made in ZCCCT is the new product for satisfying performance requirement of high cutting speed and/or higher feed.

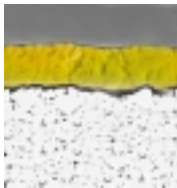
- Thick coating and hard substrate can improve the wear resistance of insert, and satisfy the requirement of higher speed or higher feed cutting for cast iron.
- The black appearance is easy to identify.



### YBD052

CVD 涂层牌号，(超厚  $Al_2O_3$  + 厚 TiCN) 涂层与坚硬基体结合，表面光滑，晶粒超细。在灰口铸铁的干式高速切削时体现了极好的耐磨性。

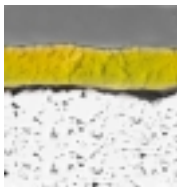
CVD coated grade, (Super thick  $Al_2O_3$  + thick TiCN) coated carbide grade consisting of a thick, smooth and super micro grain coating on top of a hard substrate. This grade is optimised for best wear resistance when machining grey cast iron at high speeds under dry conditions.



### YBD102

CVD 涂层牌号，是(厚  $Al_2O_3$  + 厚 TiCN) 涂层与坚硬基体结合，在球墨铸铁的高速加工时体现了良好的耐磨性和抗冲击能力。

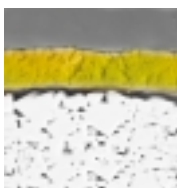
CVD coated grade, (Thick  $Al_2O_3$  + thick TiCN) on top of very hard substrate is optimised for best balance between wear resistance and flaking resistance when machining nodular cast iron at high speeds.



### YBD152

CVD 涂层牌号，(中厚  $Al_2O_3$  + 中厚 TiCN) 涂层与坚硬基体结合，良好的抗剥落性，适合于铸铁中高速车削加工，在中速时还能承受轻微断续切削。此牌号应用于铸铁的铣削时也有较强的通用性。

CVD coated grade, (medium thick  $Al_2O_3$  + medium thick TiCN) consisting of a medium thick coating with excellent flaking resistance on top of a hard substrate. YBD152 is a general choice for turning in most of cast iron from moderate to high cutting speeds. YBD152 is capable of demanding interrupted cutting conditions at moderate cutting speeds. YBD152 can also be used for milling of cast iron.



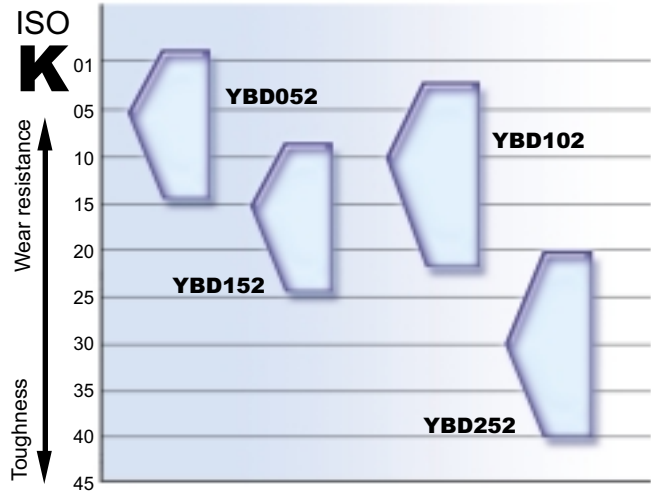
### YBD252

CVD 涂层牌号，(中厚  $Al_2O_3$  + 中厚 TiCN) 涂层与韧性基体结合，耐磨性和韧性能良好结合，适用于有韧性要求的铸铁(例如球墨铸铁)的中低速湿式铣削，也适合断续条件下的车削加工。

CVD coated grade, (medium thick  $Al_2O_3$  + medium thick TiCN) consisting of a medium thick coating on top of a toughness substrate. YBD252 have both good wear resistance and good edge toughness for toughness demanding milling of cast iron (e.g. nodular cast iron) under wet conditions. YBD252 can also be used for turning of cast iron under interrupted conditions.

# Grades for cast iron machining

## 牌号适用范围

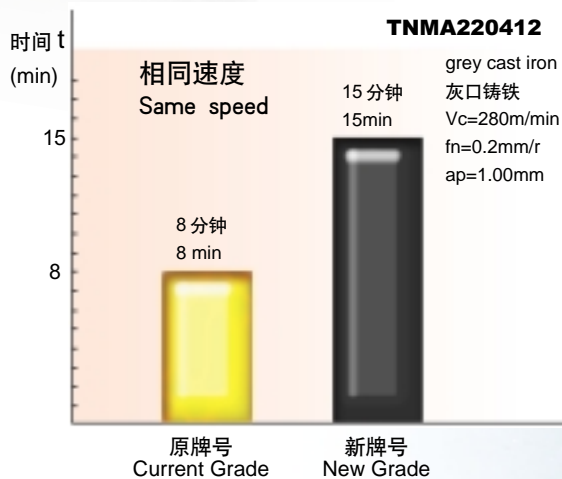
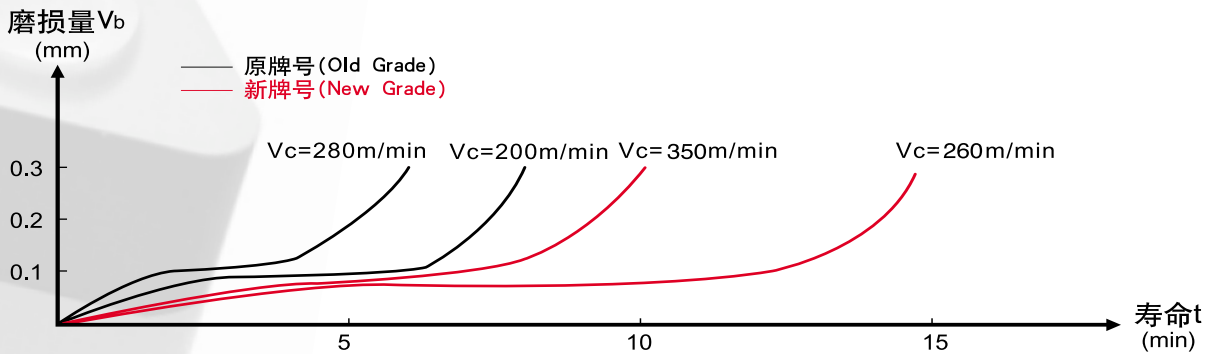


### 显著效果:

- 提高了生产效率，涂层和基体都适应铸铁的高速、高进给切削。 **切削速度可提高 30%-40%。**
- 降低经济成本， **使用寿命却提高将近 40%-50%。**
- 加工稳定性高。


### The excellent effect of "Black Diamond" insert is the following:

- Improving the productivity. Substrate and coating are suitable for machining cast iron at high speed and/or high feed. **The speed can be improved by 30-40%.**
- Reducing the economic cost. **The life will be improved by 40-50% .**
- Higher machining stability.




# Inserts for cast iron machining


## 产品型号




	YBD052	YBD102	YBD152	YBD252
CNMG120408-PM	●	●	○	○
CNMG120412-PM	●	●	○	○
CNMG120416-PM	●	●	○	○
CNMG160608-PM	●	●	○	○
CNMG160612-PM	●	●	○	○
CNMG160616-PM	●	●	○	○
CNMG190612-PM	●	●	○	○
CNMG190616-PM	●	●	○	○




	YBD052	YBD102	YBD152	YBD252
CNMA120404	●	●	○	○
CNMA120408	●	●	○	○
CNMA120412	●	●	○	○
CNMA120416	●	●	○	○
CNMA160612	●	●	○	○
CNMA190612	●	●	○	○
CNMA190616	●	●	○	○




	YBD052	YBD102	YBD152	YBD252
DNMG110408-PM	●	●	○	○
DNMG110412-PM	●	●	○	○
DNMG150408-PM	●	●	○	○
DNMG150412-PM	●	●	○	○
DNMG150608-PM	●	●	○	○
DNMG150612-PM	●	●	○	○




	YBD052	YBD102	YBD152	YBD252
DNMA150408	●	●	○	○
DNMA150412	●	●	○	○
DNMA150608	●	●	○	○
DNMA150612	●	●	○	○




	YBD052	YBD102	YBD152	YBD252
SNMG090308-PM	●	●	○	○
SNMG120408-PM	●	●	○	○
SNMG120412-PM	●	●	○	○
SNMG120416-PM	●	●	○	○
SNMG150612-PM	●	●	○	○
SNMG190612-PM	●	●	○	○




	YBD052	YBD102	YBD152	YBD252
SNMA090308	●	●	○	○
SNMA120408	●	●	○	○
SNMA120416	●	●	○	○
SNMA190612	●	●	○	○
SNMA190616	●	●	○	○




	YBD052	YBD102	YBD152	YBD252
TNMG160408-PM	●	●	○	○
TNMG160412-PM	●	●	○	○
TNMG220408-PM	●	●	○	○
TNMG220412-PM	●	●	○	○
TNMG220416-PM	●	●	○	○



	YBD052	YBD102	YBD152	YBD252
TNMA160404	●	●	○	○
TNMA160408	●	●	○	○
TNMA160412	●	●	○	○
TNMA160416	●	●	○	○
TNMA220404	●	●	○	○
TNMA220408	●	●	○	○
TNMA220412	●	●	○	○
TNMA220416	●	●	○	○



	YBD052	YBD102	YBD152	YBD252
WNMG060408-PM	●	●	○	○
WNMG060412-PM	●	●	○	○
WNMG080408-PM	●	●	○	○
WNMG080412-PM	●	●	○	○



	YBD052	YBD102	YBD152	YBD252
WNMA060408	●	●	○	○
WNMA080408	●	●	○	○
WNMA080416	●	●	○	○

● 产品型号系列有扩展，如有需求请垂询本公司各地营销网点或经销商



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