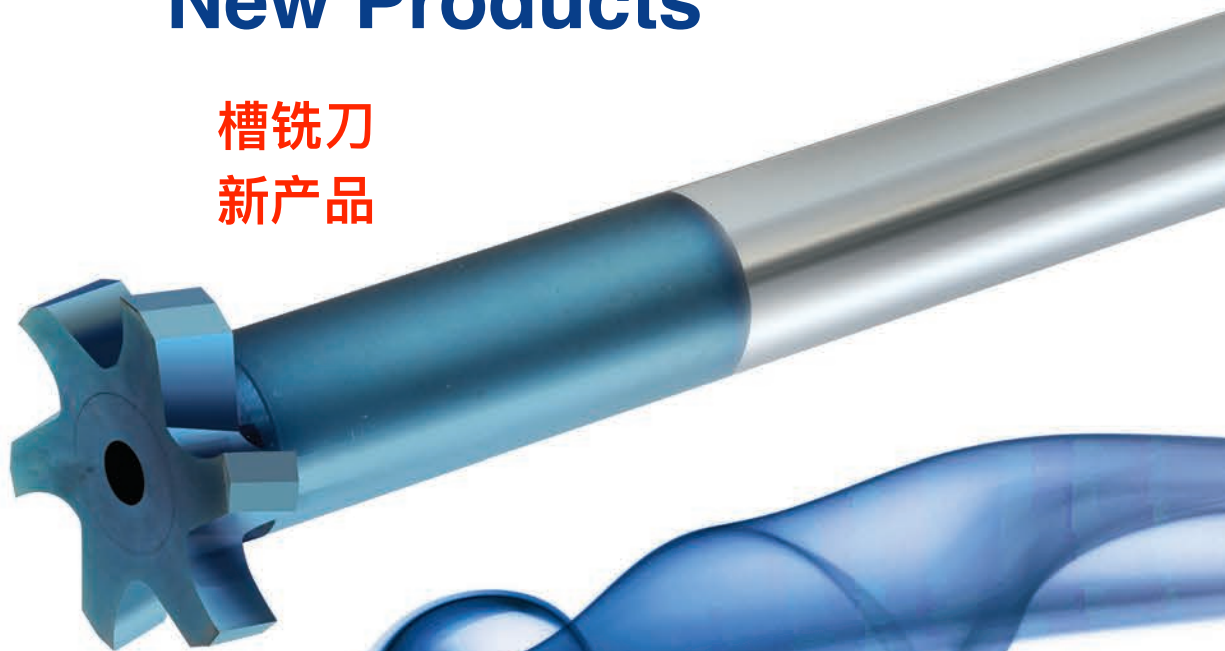




Carmex
Precision Tools Ltd.
x-treme thread cutting™

Groove Milling New Products

槽铣刀
新产品



Metric 2014

Carmex expands the MG Groove Milling line with new full carbide cutters.

Carmex新推出MG槽铣刀，新的硬质合金完整的切削刀具

Precision Ground Profile 外形精密磨制

- 6 flutes minimize cycle time and increase productivity 6槽减少切削时间和提高效率
- Spiral flutes reduce cutting forces and provide smooth cutting actions 降低切削力，稳定
- Large flute space for effective chip evacuation 大槽有效的增加排屑空间
- High stability to prevent vibration 稳定性高，减少振动
- Internal coolant bore 带有内冷孔

Applications 操作

- Machining deep holes 加工深孔
- Allows high overhang 允许长的悬深
- Can fit on small or large machining centers and Swiss type lathe machines
能在小型或大型加工中心和瑞士机床上使用
- Same tool for internal and external grooving 相同的刀具可用于内和外槽加工

Carbide grade: MT8 MT8级硬质合金

Sub-Micron grade with advance PVD triple coating (ISO K10-K20). 亚微粒级先进的PVD三层涂层(K10-K20)

Extremely high heat and wear resistance for high performance, and normal machining conditions.

General purpose for all materials. 特别高的耐热和耐磨，高效能和常规的机加条件，通用全部材料

Groove Milling 槽铣刀

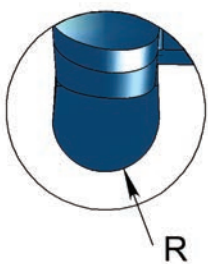


Ordering Code	W ±0.02	R	T (max.)	Groove Dia. (min.)	d	D	No. of Flutes	L
MGD 10195 F W15	1.5	0.1	4.5	Ø > 19.5	10	19.4	6	133
MGD 10195 F W20	2.0							
MGD 10195 F W30	3.0							
MGD 10195 F W35	3.5							
MGD 10195 F W40	4.0							
MGD 10195 F W50	5.0							

Special Tools 特殊刀具

We offer a large variety of special tools in compliance with customer requirements
 我们为客户提供各种特殊要求的刀具

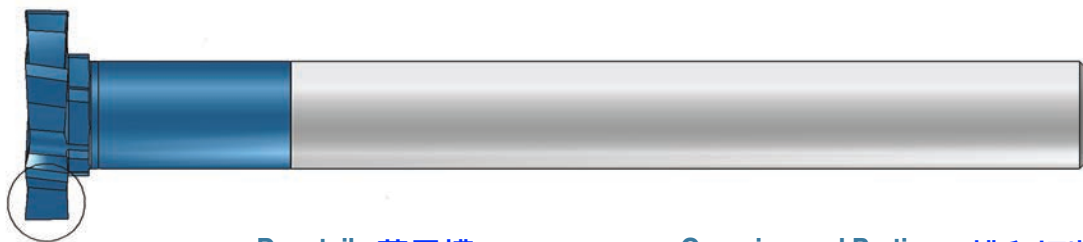
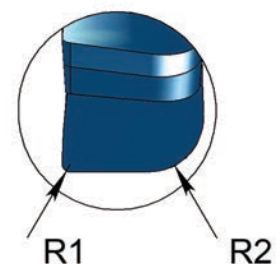
Round Groove R槽



Chamfering 倒角



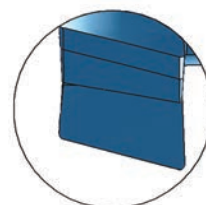
Grooving and Profiling 槽和仿形



Dovetail 燕尾槽



Grooving and Parting 槽和切断



Cutting Data 切削参数

ISO Standard	Material	Cutting Speed m/min	Feed mm/tooth
P	Low & Medium Carbon Steels <0.55%C	60-120	0.15-0.20
	High Carbon Steels ≥0.55%C	60-90	0.15-0.20
	Alloy Steels, Treated Steels	50-80	0.11-0.16
M	Stainless Steel-Free Cutting	70-100	0.10-0.15
	Stainless Steel-Austenitic	60-90	0.10-0.15
	Cast Steels	70-90	0.11-0.16
K	Cast Iron	40-80	0.15-0.20
N	Aluminium ≤12%Si, Copper	100-200	0.15-0.20
	Aluminium >12%Si	60-140	0.11-0.16
	Synthetics, Duroplastics, Thermoplastics	50-200	0.17-0.22
S	Nickel alloys, Titanium alloys.	20-40	0.05-0.10
H	Hardened Steel, 45-50HRc	60-70	0.08-0.13



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