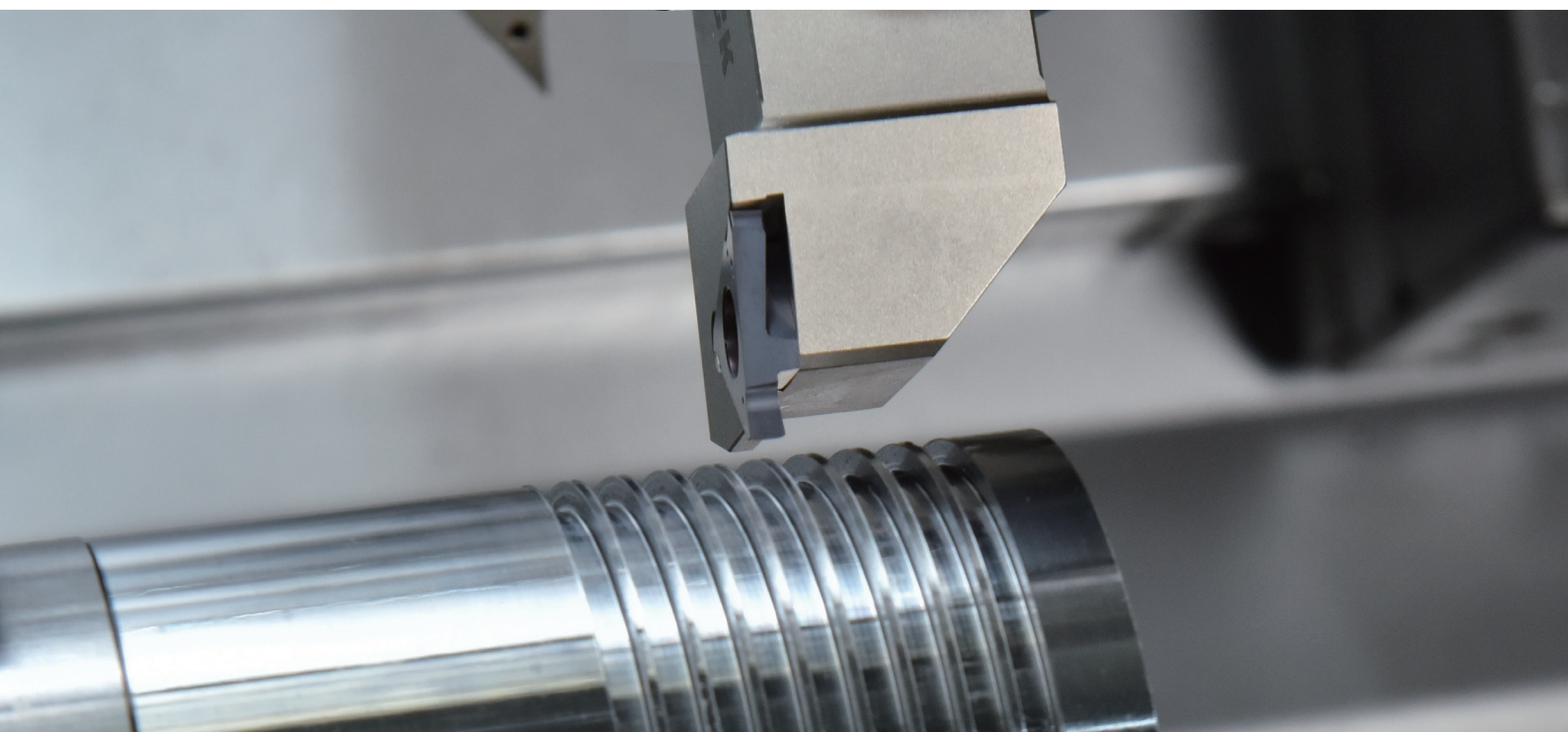


2025.03

三刃浅槽加工刀具 ——ATG



搭配AP301U通用材质

针对钢件、不锈钢加工
拥有良好稳定性

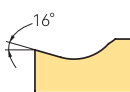


三刃浅槽加工刀具

ATG

高精度公差宽度，±0.025mm，搭配AP301U通用材质，针对钢件、不锈钢加工拥有良好稳定性

刀片槽型介绍

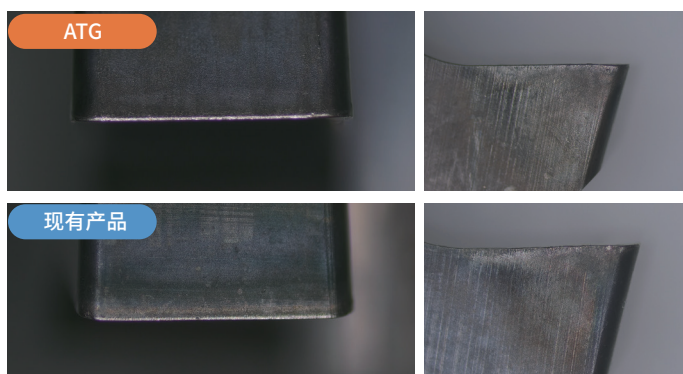
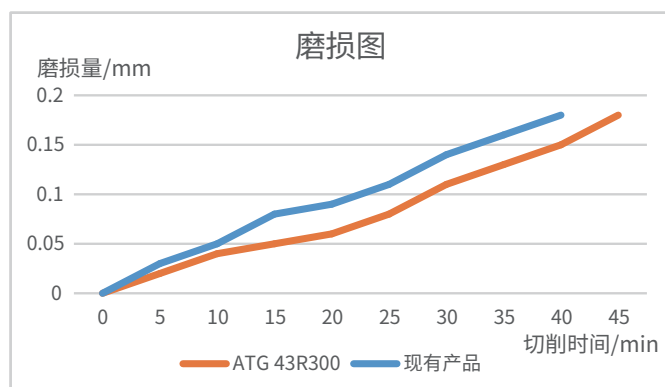
槽型	刀片	刃口图示	特点	各槽型宽度（mm）								
				外径加工					端面加工		内径加工	
				切槽	切断	车削	仿形	越程槽	切槽	车削	切槽	车削
ATG			●采用精密级刀片 ●正前角不易产生震动 ●三刃设计并且扩展性好	0.33	-	-	0.5	-	-	-	0.33	-
							1.0					
				4.5			1.5				4.5	
							2.0					
							3.0					
							4.0					

适用范围及切削条件

加工材料	钢件					不锈钢				
切削领域	精加工  粗加工					精加工  粗加工				
ISO分类	P01	P10	P20	P30	P40	M01	M10	M20	M30	M40
AP301U										

</

● 针对4140材料切槽耐磨损性比较



<切削条件>

刀片型号: ATG 43R300-R010

切削材料: 4340

切削速度: $V_c=180\text{m/min}$

冷却: 湿式切削

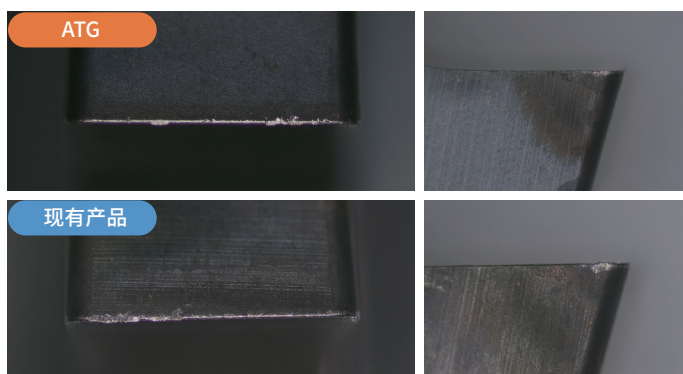
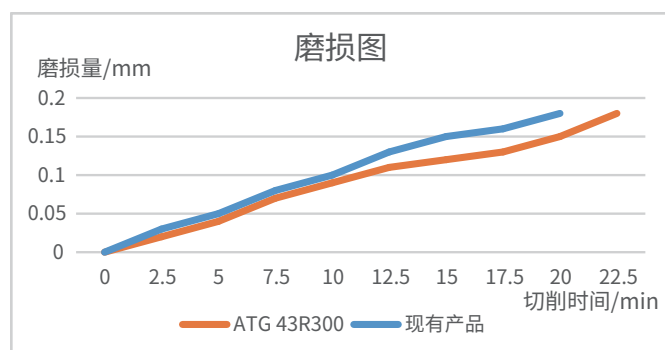
每转进给: $f=0.2\text{mm/rev}$

切削深度: $a_p=2.5\text{mm}$

失效时间: 43.2min

↑ 同等工况下，
刀具寿命提升28%

● 针对304材料切槽耐磨损性比较



<切削条件>

刀片型号: ATG 43R300-R010

切削材料: 304

切削速度: $V_c=120\text{m/min}$

冷却: 湿式切削

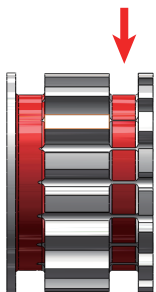
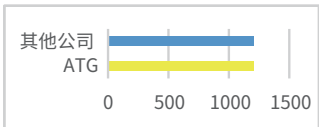
每转进给: $f=0.15\text{mm/rev}$

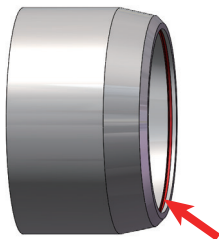
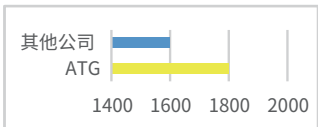
切削深度: $a_p=2.0\text{mm}$

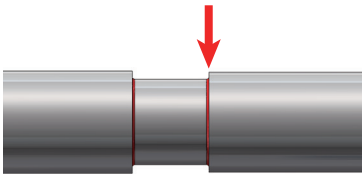
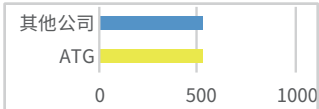
失效时间: 21.4min

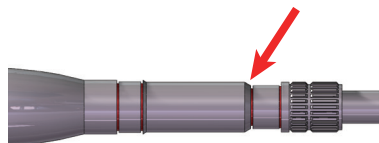
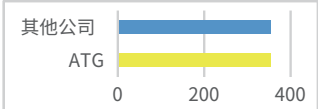
↑ 同等工况下，
刀具寿命提升15%

加工案例

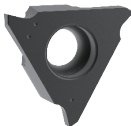
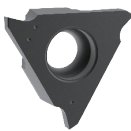
刀具型号	ATG 43R200T35-R020 AP301U
加工零件	轴类零件 
加工材料	20CrMn
切削速度	200m/min
进 给	0.13mm/rev
切 深	2.5mm
冷 却	油性
结 果	 ATG加工稳定, 同等寿命实现单件成本下降20%

刀具型号	ATG 43R145T35-R020 AP301U
加工零件	汽车零部件 
加工材料	42CrMn
切削速度	118m/min
进 给	0.08mm/rev
切 深	2.0mm
冷 却	油性
结 果	 ATG加工稳定, 实现刀具寿命增长12.5%

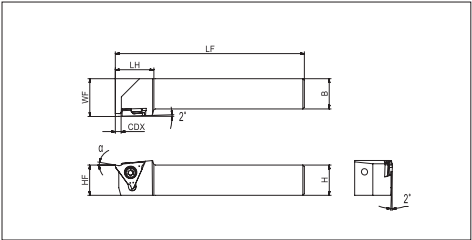
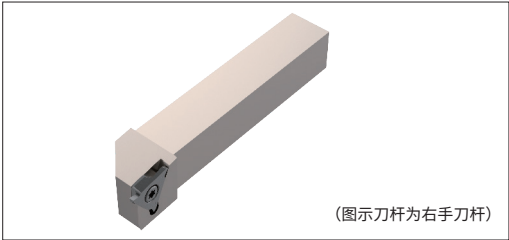
刀具型号	ATG 43R100T20-R050 AP301U
加工零件	制动主轴 
加工材料	20MnCr5
切削速度	150m/min
进 给	0.05mm/rev
切 深	1.6mm
冷 却	油性
结 果	 ATG加工稳定, 同等寿命实现单件成本下降25%

刀具型号	ATG 32R150T25-R020 AP301U
加工零件	齿轴 
加工材料	20CrMnTi
切削速度	164m/min
进 给	0.08mm/rev
切 深	2.0mm
冷 却	油性
结 果	 ATG加工稳定, 同等寿命实现单件成本下降15%

刀杆信息

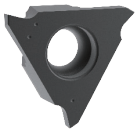
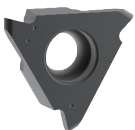
刀杆型号		刀方 (mm)	切深 (mm)	配合刀片 (ATG)	刀片宽度 (mm)	切深 (mm)
ATGHR/L		20x20	2.50		0.33	0.80
		25x25	5.00		4.50	5.00
ATGIR/L		25	2.80		0.33	0.05
		32	3.00		4.50	2.00

ATGHR/L 外径浅槽刀杆

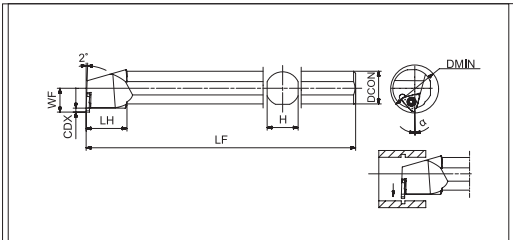
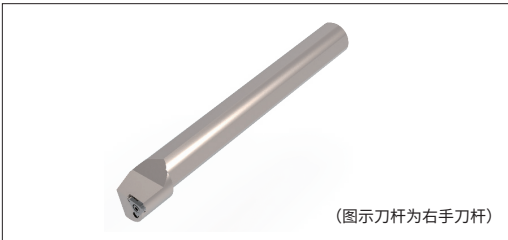


型号		尺寸 (mm)						配件	
		H	B	LF	LH	WF	CDX	螺钉型号	扳手型号
									
ATGHR/L	2020K32-T25	20	20	125	24	25	2.5	SP040085	FT-TP15
	2525M32-T25	25	25	150	24	30	2.5		
	2020K43-10T40	20	20	125	25.5	25	4.0	SP05008550	FT-TP20
	2525M43-10T40	25	25	150	25.5	30	4.0		
	2020K43-20T45	20	20	125	25.5	25	4.5		
	2525M43-20T45	25	25	150	25.5	30	4.5		
	2020K43-20T55	20	20	125	25.5	25	5.5		
	2525M43-20T55	25	25	150	25.5	30	5.5		
	2020K43-30T55	20	20	125	25.5	25	5.5		
	2525M43-30T55	25	25	150	25.5	30	5.5		

适用刀片

用途	切槽	仿形
刀片形状		
刀杆型号		
ATGHR** 32	ATG 32R	ATG 32R
ATGHR** 43	ATG 43R	ATG 43R
ATGHL** 32	ATG 32L	ATG 32L
ATGHL** 43	ATG 43L	ATG 43L

ATGIR/L 内径浅槽刀杆



型号		尺寸 (mm)						配件	
		DMIN	DCON	LF	LH	WF	CDX	螺钉型号	扳手型号
ATGIR/L	25R32-35T28	35	25	220	30	17.5	2.8	SP040085	FT-TP15
	32S43-40T30	40	32	250	30	23.0	3.0	SP05008550	FT-TP20

适用刀片

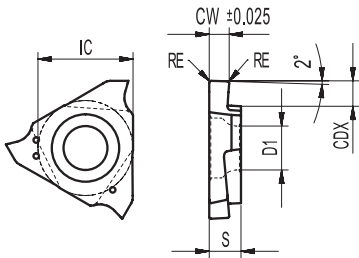
用途	切槽	仿形
刀片形状 刀杆型号		
ATGIR** 32	ATG 32L	ATG 32L
ATGIR** 43	ATG 43L	ATG 43L
ATGIL** 32	ATG 32R	ATG 32R
ATGIL** 43	ATG 43R	ATG 43R

刀片型号

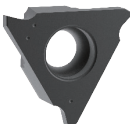
浅槽系列

ATG:三刃刀片，应用于外圆、内孔、端面的切槽

型号	IC	S	D1
ATG 32-	9.525	3.18	4.4
ATG 43-	12.7	4.76	5.5
ATG 43R/L450	12.7	5.0	5.5



(图示刀为右手刀)

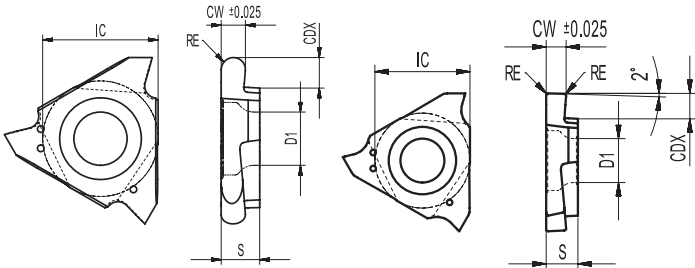
		符号说明				●良好工况		⦿一般工况		✱恶劣工况			
		推荐使用工况				●	✱	⦿	✱	●	⦿	●	●
刀片	型号	切削参数		尺寸		P			M		K		N
		切槽	CDX	CW	RE	AP301U	AP330M	AC230P	AP330M	AP301U	AC230P	AP301U	AW100K
		进给 (mm/rev)											
	ATG 32R/L033T08-R005	0.03-0.08	0.8	0.33	0.05	●				●		●	
	ATG 32R/L050T12-R005	0.03-0.08	1.2	0.50	0.05	●				●		●	
	ATG 32R/L075T20-R005	0.03-0.08	2.0	0.75	0.05	●				●		●	
	ATG 32R/L095T20-R005	0.03-0.08	2.0	0.95	0.05	●				●		●	
	ATG 32R/L100T20-R005	0.03-0.08	2.0	1.00	0.05	●				●		●	
	ATG 32R/L110T20-R005	0.03-0.08	2.0	1.10	0.05	●				●		●	
	ATG 32R/L120T20-R005	0.03-0.08	2.0	1.20	0.05	●				●		●	
	ATG 32R/L125T20-R020	0.04-0.09	2.0	1.25	0.20	●				●		●	
	ATG 32R/L130T20-R020	0.04-0.09	2.0	1.30	0.20	●				●		●	
	ATG 32R/L140T25-R020	0.04-0.09	2.5	1.40	0.20	●				●		●	
	ATG 32R/L145T25-R020	0.04-0.09	2.5	1.45	0.20	●				●		●	
	ATG 32R/L150T25-R020	0.04-0.09	2.5	1.50	0.20	●				●		●	
	ATG 32R/L160T25-R020	0.04-0.09	2.5	1.60	0.20	●				●		●	
	ATG 32R/L170T25-R020	0.04-0.09	2.5	1.70	0.20	●				●		●	
	ATG 32R/L175T25-R020	0.04-0.09	2.5	1.75	0.20	●				●		●	
	ATG 32R/L200T25-R020	0.04-0.09	2.5	2.00	0.20	●				●		●	
	ATG 32R/L225T25-R020	0.04-0.09	2.5	2.25	0.20	●				●		●	
	ATG 32R/L250T25-R020	0.05-0.10	2.5	2.50	0.20	●				●		●	
	ATG 32R/L300T25-R020	0.05-0.10	2.5	3.00	0.20	●				●		●	
	ATG 43R/L100T20-R010	0.03-0.08	2.0	1.00	0.10	●				●		●	
	ATG 43R/L125T20-R010	0.04-0.09	2.0	1.25	0.10	●				●		●	
	ATG 43R/L125T20-R020	0.04-0.09	2.0	1.25	0.20	●				●		●	
	ATG 43R/L130T30-R010	0.04-0.09	3.0	1.30	0.10	●				●		●	
	ATG 43R/L130T30-R020	0.04-0.09	3.0	1.30	0.20	●				●		●	
	ATG 43R/L140T35-R020	0.04-0.09	3.5	1.40	0.20	●				●		●	
	ATG 43R/L145T35-R020	0.04-0.09	3.5	1.45	0.20	●				●		●	
	ATG 43R/L150T35-R010	0.04-0.09	3.5	1.50	0.10	●				●		●	
	ATG 43R/L150T35-R020	0.04-0.09	3.5	1.50	0.20	●				●		●	
	ATG 43R/L170T35-R020	0.04-0.09	3.5	1.70	0.20	●				●		●	
	ATG 43R/L175T35-R020	0.04-0.09	3.5	1.75	0.20	●				●		●	
	ATG 43R/L185T35-R020	0.04-0.09	3.5	1.85	0.20	●				●		●	
	ATG 43R/L195T35-R020	0.04-0.09	3.5	1.95	0.20	●				●		●	

●:标准库存产品 ○:按订单生产

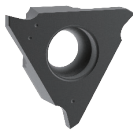
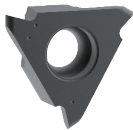
浅槽系列

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型号	IC	S	D1
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ATG 43-	12.7	4.76	5.5
ATG 43R/L450	12.7	5.0	5.5



(图示刀为右手刀)

		符号说明				●良好工况				⦿一般工况		✱恶劣工况	
		推荐使用工况				●	✱	⦿	✱	●	⦿	●	●
刀片	型号	切削参数		尺寸		P			M		K		N
		切槽	CDX	CW	RE	AP301U	AP330M	AC230P	AP330M	AP301U	AC230P	AP301U	AW100K
		进给 (mm/rev)											
	ATG 43R/L200T35-R010	0.04-0.09	3.5	2.00	0.10	●				●		●	
	ATG 43R/L200T35-R020	0.04-0.09	3.5	2.00	0.20	●				●		●	
	ATG 43R/L225T35-R020	0.04-0.09	3.5	2.25	0.20	●				●		●	
	ATG 43R/L230T35-R020	0.05-0.10	3.5	2.30	0.20	●				●		●	
	ATG 43R/L250T50-R010	0.05-0.10	5.0	2.50	0.10	●				●		●	
	ATG 43R/L250T50-R030	0.05-0.10	5.0	2.50	0.30	●				●		●	
	ATG 43R/L265T50-R030	0.05-0.10	5.0	2.65	0.30	●				●		●	
	ATG 43R/L280T50-R030	0.05-0.10	5.0	2.80	0.30	●				●		●	
	ATG 43R/L300T50-R010	0.05-0.10	5.0	3.00	0.10	●				●		●	
	ATG 43R/L300T50-R030	0.05-0.10	5.0	3.00	0.30	●				●		●	
	ATG 43R/L325T50-R030	0.05-0.10	5.0	3.25	0.30	●				●		●	
	ATG 43R/L330T50-R030	0.05-0.12	5.0	3.30	0.30	●				●		●	
	ATG 43R/L350T50-R010	0.05-0.12	5.0	3.50	0.10	●				●		●	
	ATG 43R/L350T50-R030	0.05-0.12	5.0	3.50	0.30	●				●		●	
	ATG 43R/L400T50-R010	0.05-0.12	5.0	4.00	0.10	●				●		●	
	ATG 43R/L400T50-R040	0.05-0.12	5.0	4.00	0.40	●				●		●	
	ATG 43R/L430T50-R040	0.05-0.12	5.0	4.30	0.40	●				●		●	
	ATG 43R/L450T50-R040	0.05-0.12	5.0	4.50	0.40	●				●		●	
	ATG 32R/L050T12-R025	0.03-0.08	1.2	0.50	0.25	●				●		●	
	ATG 32R/L100T12-R050	0.03-0.08	1.2	1.00	0.50	●				●		●	
	ATG 32R/L150T25-R075	0.04-0.09	2.5	1.50	0.75	●				●		●	
	ATG 32R/L200T25-R100	0.04-0.09	2.5	2.00	1.00	●				●		●	
	ATG 32R/L300T25-R150	0.05-0.10	2.5	3.00	1.50	●				●		●	
	ATG 43R/L100T20-R050	0.03-0.08	2.0	1.00	0.50	●				●		●	
	ATG 43R/L150T35-R075	0.04-0.09	3.5	1.50	0.75	●				●		●	
	ATG 43R/L200T35-R100	0.04-0.09	3.5	2.00	1.00	●				●		●	
	ATG 43R/L250T40-R125	0.05-0.10	5.0	2.50	1.25	●				●		●	
	ATG 43R/L300T40-R150	0.05-0.10	5.0	3.00	1.50	●				●		●	
	ATG 43R/L400T50-R200	0.05-0.12	5.0	4.00	2.00	●				●		●	

●:标准库存产品 ○:按订单生产