

汽车行业加工解决方案

Manufacturing Solutions for Automotive Industry



+ 华东大区
Eastern China Region

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+ 西部大区
West Region

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+ 华北大区
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+ 东北大区
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厦门金鹭特种合金有限公司, 成立于 1989 年, 是一家中外合资的国家高新技术企业, 隶属于中国六大稀土集团之一的厦门钨业股份有限公司。公司致力于高品质钨粉末材料、硬质合金、精密切削工具等钨系列产品的研发、生产, 以及行业专业解决方案的提供, 是世界知名的钨粉末、硬质合金及切削工具供应商。

凭借完整钨产业链的产品集成技术研发, 以及务实、创新的管理理念, 厦门金鹭始终保持着强劲的发展势头, 为全球用户提供最高性价比的产品和服务, 为现代工业领域解决高硬度、耐高温、耐磨损问题, 提供了优良的产品和完善的解决方案, 客户遍布全球四十多个工业发达国家和地区, 享誉海内外。

公司拥有国内 4 个生产基地和 1 个国家级企业研发中心, 海外 3 个销售公司和 1 个海外生产基地, 独立承担并完成多项“国家科技支撑计划项目”, “国家科技重大专项”, “国家火炬计划项目”, “国家重点新产品”开发项目及省市重点研究课题, 被评为“战略性新兴产业骨干企业”、“创新型企业”、“先进技术企业”。

Xiamen Golden Egret Special Alloy Co., Ltd. (GESAC), founded in 1989, is a Sino-foreign joint venture with national high-tech, affiliated with XTC, which is one of six major rare earth groups in China. GESAC is committed to research & development, production and professional solutions providing of high-quality tungsten powder materials, cemented carbide, precision cutting tools and other tungsten products. Up to now, GESAC has become world-famous manufacturer and supplier of tungsten powder, cemented carbide and precision cutting tools products.

With the Integrated Product Development of complete tungsten industry chain, as well as a pragmatic and innovative management concept, GESAC has always maintained a strong momentum of development, providing the cost effective tungsten powder products and services for global users, offering the excellent products and perfect solutions for solving high hardness, high temperature resistance and wear resistance topics. Our brand "Golden Egret" has become one of the leading brand in the market, enjoying famous reputation in more than 40 countries and regions.

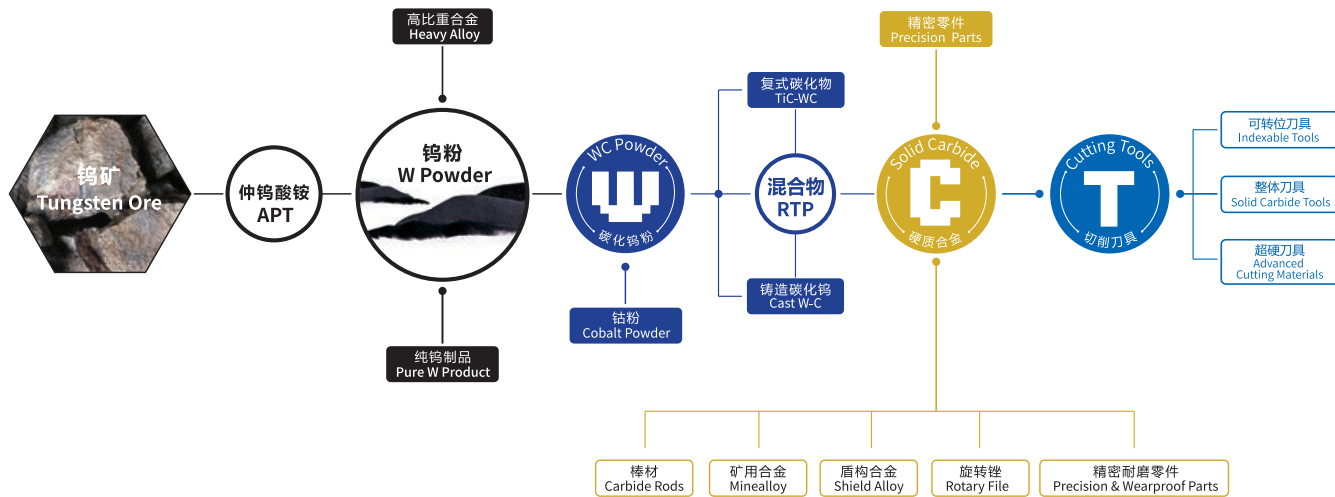
GESAC owns four production headquarters and one national level research center domestically, and three sales branches and one production base overseas. We undertook and completed several development programs independently, including the “National Science and Technology Support Programs”, the “National Torch Program Projects”, and the “National Key Projects” and so on. GESAC was awarded as "Key Enterprise for Strategic Emerging Industry ", “Innovative Enterprise” and "Enterprise with Advanced Technology ".

加工解决方案
Manufacturing Solutions

曲轴 Crankshaft	02
凸轮轴 Camshaft	04
涡轮增压排气歧管 Turbocharger Housing	06
差速器壳体 Differential Housing	08
轴齿 Shaft & Gear	10
车桥前轴 Front Axle	12
后桥桥壳 Rear Axle Housing	14
转向器壳体 Steering Gear Housing	16
门铰链 Door Hinge	18

重点产品介绍
Introduction of Major Products

曲轴内外铣刀具 Crankshaft Internal And External Milling Tool	20
V带槽刀 Non-standard Ring Groove Knife	21
差速器壳体油槽加工刀具 Differential Housing Oil Groove Processing Tool	22
可转位涂层PCBN刀具二代牌号 Indexable Coating Pcbn Tool Second Generation	23
ONEU面铣精加工刀具 Oneu Face Milling Finishing Tool	24
D938深孔内冷麻花钻 D938 Series Deep Hole Internal Coolant Twist Drill	25
GUMD皇冠钻 GUMD Modular Drill	26



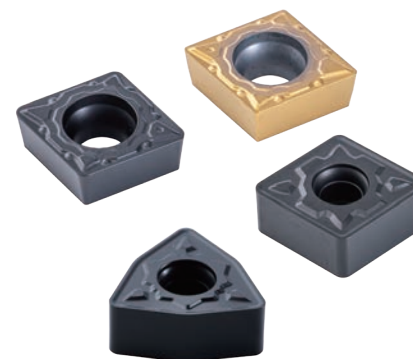
内铣 Internal Milling

- 高刚性、高精度刀体
Cutter With High Rigidity And Precision
- 搭配LNE刀片, 实现高效加工 (详见P20)
Together with LNE inserts to ensure efficiency (Details in P20)



车削加工 Turning

- 通用粗-精车削加工
(详见《车削刀具产品册》)
General Rough-finish Turning
(Details in 《The Catalogs Of Turning Tools》)



车车拉 Turn Turn Broaching

- 高刚性、高精度模块化刀体
Modular Cutter With High Rigidity And Precision
- 刀片灵活布置, 确保高效加工
Flexible Inserts Arrangement Ensures High Productivity



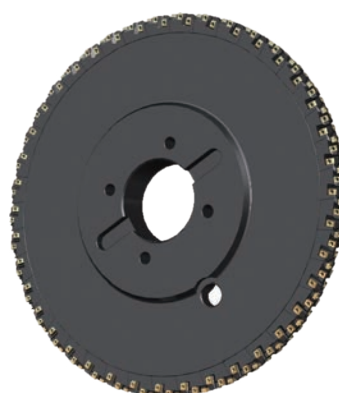
端面铣削 Face Milling

- SNEU+MFB145/245/288
高强度通用铣削
High Intension General Face Milling



孔加工 Hole Making

- D918S
普通钢加工硬质合金麻花钻
Drills for Steel Applications
- QPMG+GHDS
高效可转位钻头
High Efficiency Indexable Drills
- GUMD
GUMD可换式钻头 (详见P26)
Head Changeable Drill (Details in P26)
- 高性能丝锥
High-performance Tap for
Steel & Cast Iron Applications



外铣 External Milling

- 高精度超密齿刀盘, 实现高速、高效加工
High Precision Super Dense Pitch Cutter Enable
High Speed , High Precision Machining
- 减少换刀次数, 降低成本
Reduce Tool Change Frequency
And Production Costs

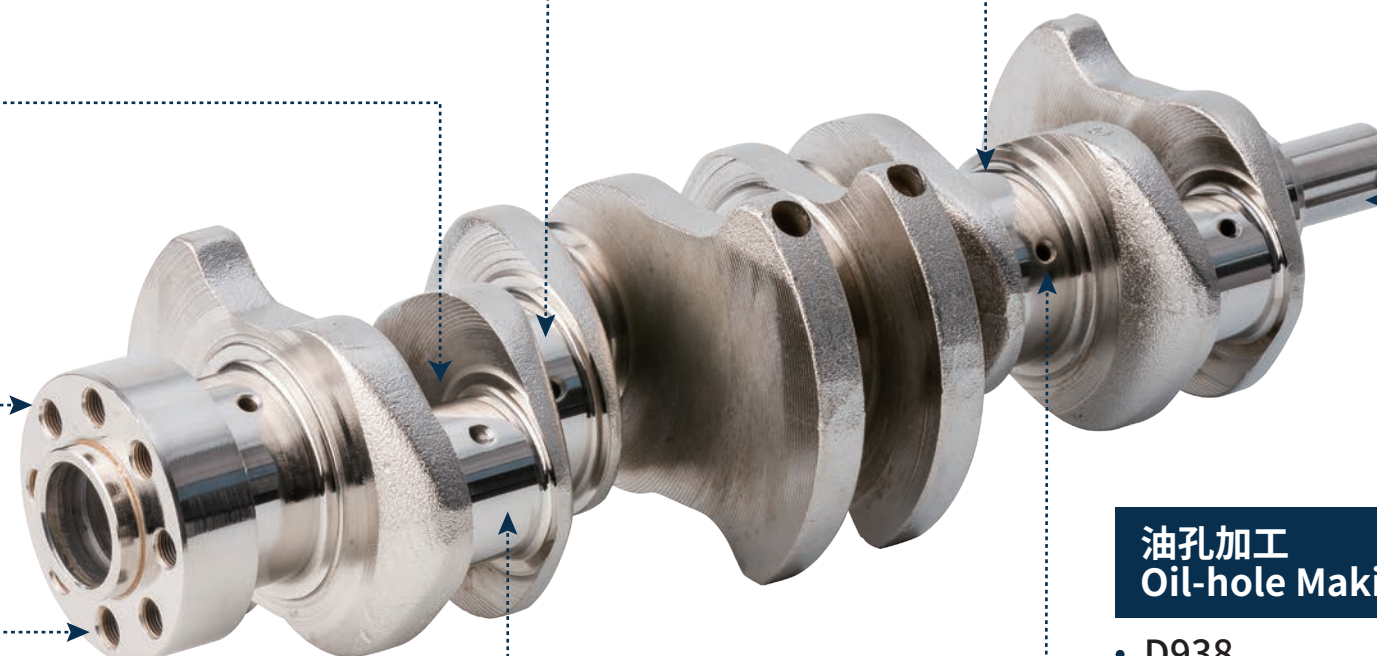
油孔加工 Oil-hole Making

- D938
深孔内冷麻花钻 (详见P25)
Deep-hole Inner Cooling Twist Drill (Details in P25)



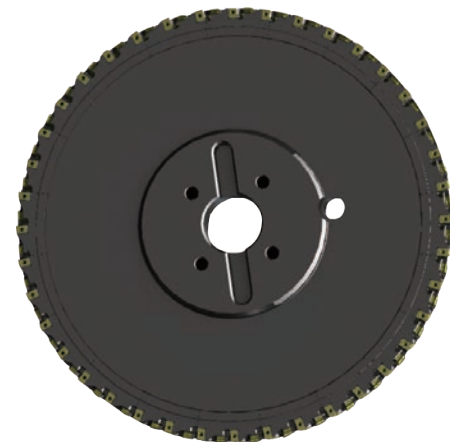
套车 Multistation Turning

- 高效复合加工
High Efficiency Combination Tool



外铣 External Milling

- 高精度超密齿刀盘, 实现高速、高效加工
(详见P20)
High precision super dense pitch cutter enable high speed, high precision machining (Details in P20)



孔加工 Hole Making

- D918S
普通钢加工硬质合金麻花钻
Drills for Steel Applications
- 高性能钢用丝锥
High-performance Tap for Steel Applications



端面铣削 Face Milling

- SNEU+MFB145/245
高强度通用铣削
High Intension General Face Milling

车削加工 Turning

- 通用轴颈车削加工 (详见《车削刀具产品册》)
General Turning for Journal
(Details in 《The Catalogs Of Turning Tools》)



尾槽/VVT槽铣削 Slot Milling

- UP210
通用钢件加工立铣刀
General End Milling for Steel

切槽加工 Grooving

- MT+GK
通用切槽加工
General Grooving
- GB+GB
精密浅槽加工
High Precision Shallow Grooving



外圆/内孔加工 Outer Circle & Internal Hole Machining

- 通用粗-精车削加工
General Rough-finish Turning
- 非标定制镗刀
Customized Combination Tool
- 非标定制套车
Combination Tool Increases Productivity



端面槽加工 Grooving

- MT+GKFR/L
通用切槽加工
General Grooving
- GB+非标定制刀体
GB + Customized Cutter



打标面/U型孔加工 Shoulder Milling

- SN200
高温合金高性能加工立铣刀
High Performance Endmills for Heat Resistant Super Alloy
- SS600
不锈钢高性能加工立铣刀
High Performance Endmills for Stainless Steel
- 非标阶梯立铣刀
Customized Endmills



环槽/V带槽加工 Grooving

- 非标定制槽刀 (详见P21)
Combination Tool Increases Productivity (Details In P21)



孔加工 Hole Making

- D968S
不锈钢加工硬质合金麻花钻
Drills for Stainless Steel Applications
- 非标定制铰刀
Customized Reamer
- 高性能钢用丝锥
High-performance Tap for Steel Applications



法兰面铣削 Face Milling

- HNEU+MFC145
高经济型通用铣削
High Economical General Face Milling
- ONEU+MFG140
高精加工平面铣削 (详见P24)
High Precision Face Milling (Details in P24)



衬套孔/凸台面加工 Shoulder Milling

- SDKT+MES190
经济型正型4刃方肩铣削
Economical Positive 4 Edges Shoulder Milling
- 非标定制铰刀
Customized Countersink



车削加工 Turning

- 通用粗-精车削加工
(详见《车削刀具产品册》)
General Rough-finish Turning\
(Details in 《The Catalogs Of Turning Tools》)



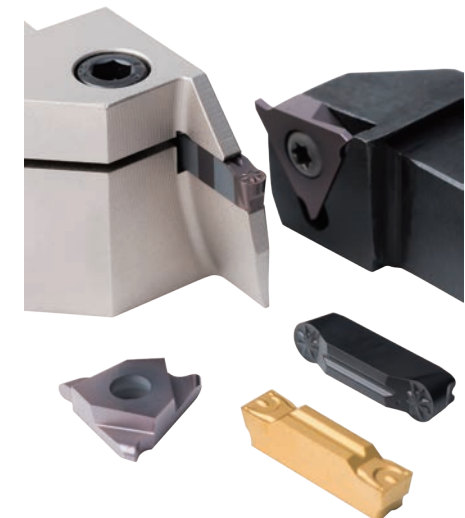
油槽加工 Grooving

- 非标定制刀具CC09T3/TC1603
(详见P22)
Customized TCC09T3/TTC1603
(Details in P22)



切槽加工 Grooving

- MT+GK
通用切槽加工
General Grooving
- GB+GB
精密浅槽加工
High Precision Shallow Grooving



销孔端面铣削 Pin Hole Face Milling

- PP300
高效加工立铣刀
High Efficiency Endmills
- D938
普通钢加工硬质合金麻花钻
Drills for Steel Applications



内球面加工 Inner Sphere Making

- DCGW+非标定制减震刀杆
DCGW + Customized Cutter



轴孔加工 Hole Making

- QPMG+GHDS
高效可转位钻头
High Efficiency Indexable Drills
- 非标定制铰刀
Customized Straight Fluted Drill
- MB系列微小径精镗刀
MB Mini Precision Boring Tool
- 非标定制可转位倒角铣刀
Customized Chamfer Milling
- 非标定制反倒角铣刀
Customized Back Chamfer Milling
- 非标定制环槽铣刀
Customized Inner Ring Groove Milling



法兰孔加工 Hole Making

- D918S
普通钢加工硬质合金麻花钻
Drills for Steel Applications
- 高性能钢及铸铁用丝锥
High-performance Tap for
Steel & Cast Iron Applications



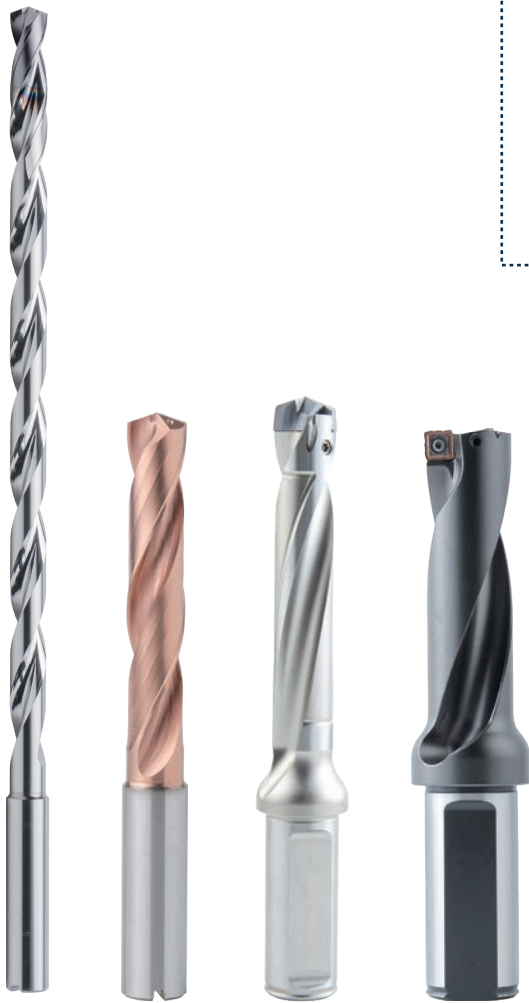
半轴齿轮面车削 Axle Shaft Gear Face Turning

- CCGT+非标定制减震刀杆
CCGT + Customized Cutter



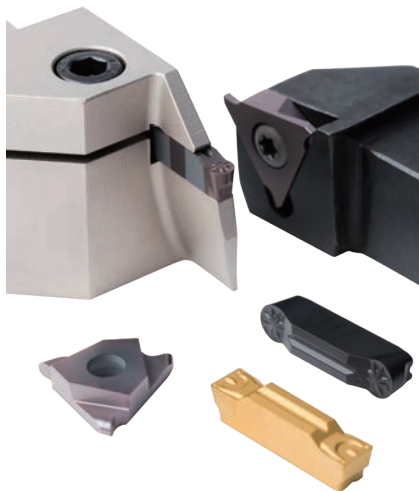
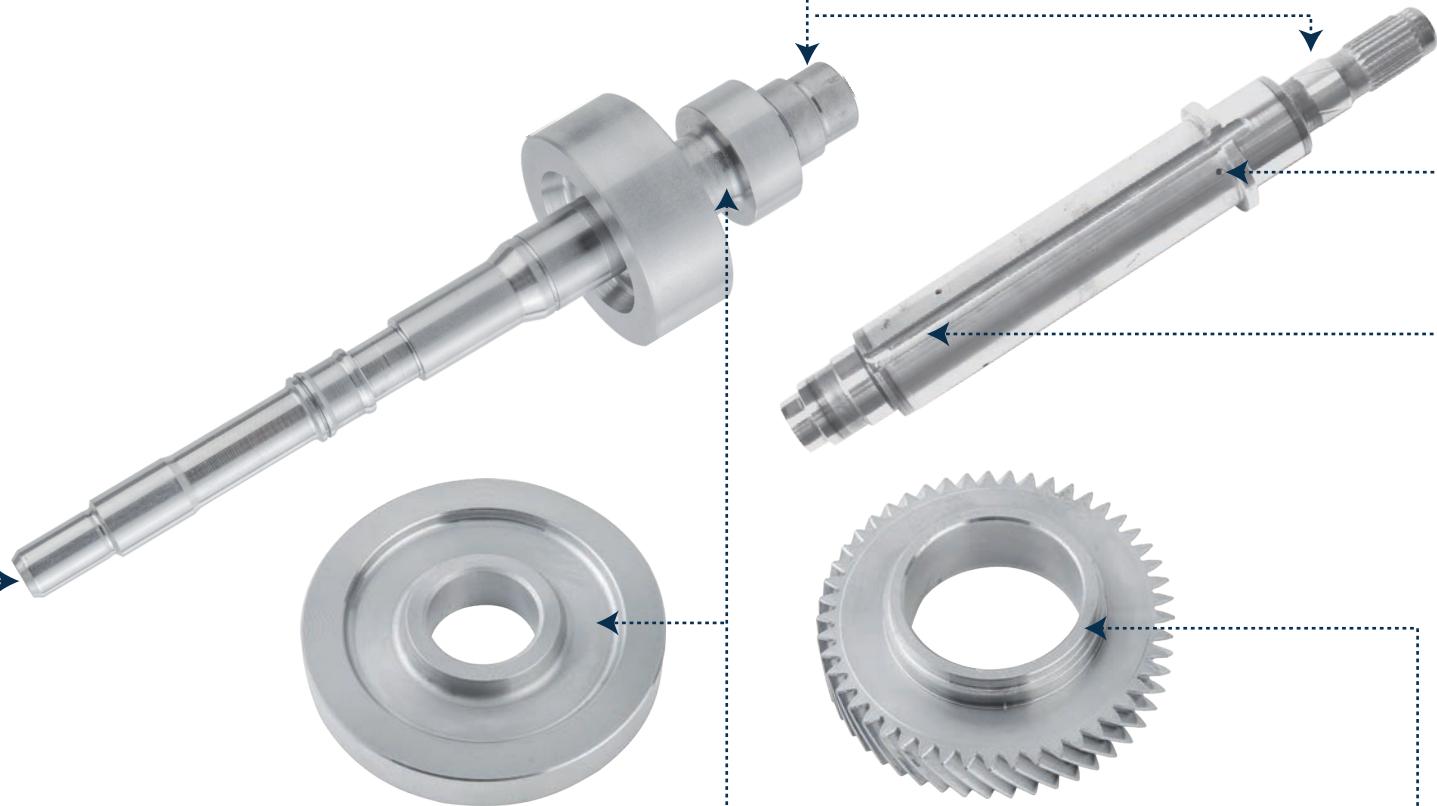
孔加工
Hole Making

- **D938**
深孔内冷麻花钻
Deep-hole Inner Cooling Twist Drill
- **D918S**
普通钢加工硬质合金麻花钻
Drills for Steel Applications
- **GUMD**
GUMD可换式钻头 (详见P26)
Head Changeable Drill (Details in P26)
- **QPMG+GHDS**
高效可转位钻头
High Efficiency Indexable Drills



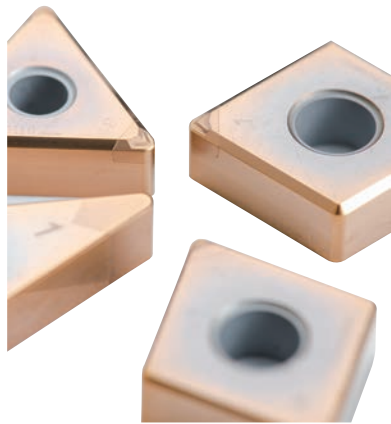
车削加工
Turning

- 通用粗-精车削加工
(详见《车削刀具产品册》)
General Rough-finish Turning
(Details in 《The Catalogs Of Turning Tools》)



切槽加工
Grooving

- **MT+GK**
通用切槽加工
General Grooving
- **GB+GB**
精密浅槽加工
High Precision Shallow Grooving



注油孔加工
Hole Making

- **D918S**
普通钢加工硬质合金麻花钻
Drills for Steel Applications



键槽加工
Grooving

- **SP210**
键槽热前铣削加工
Keyway Hot Front Milling
- **SH360**
键槽热后铣削加工
Keyway Hot Back Milling



热后硬车
Turning after
Heat Treatment

- **PCBN车削加工 (详见P23)**
PCBN Turning (Details in P23)

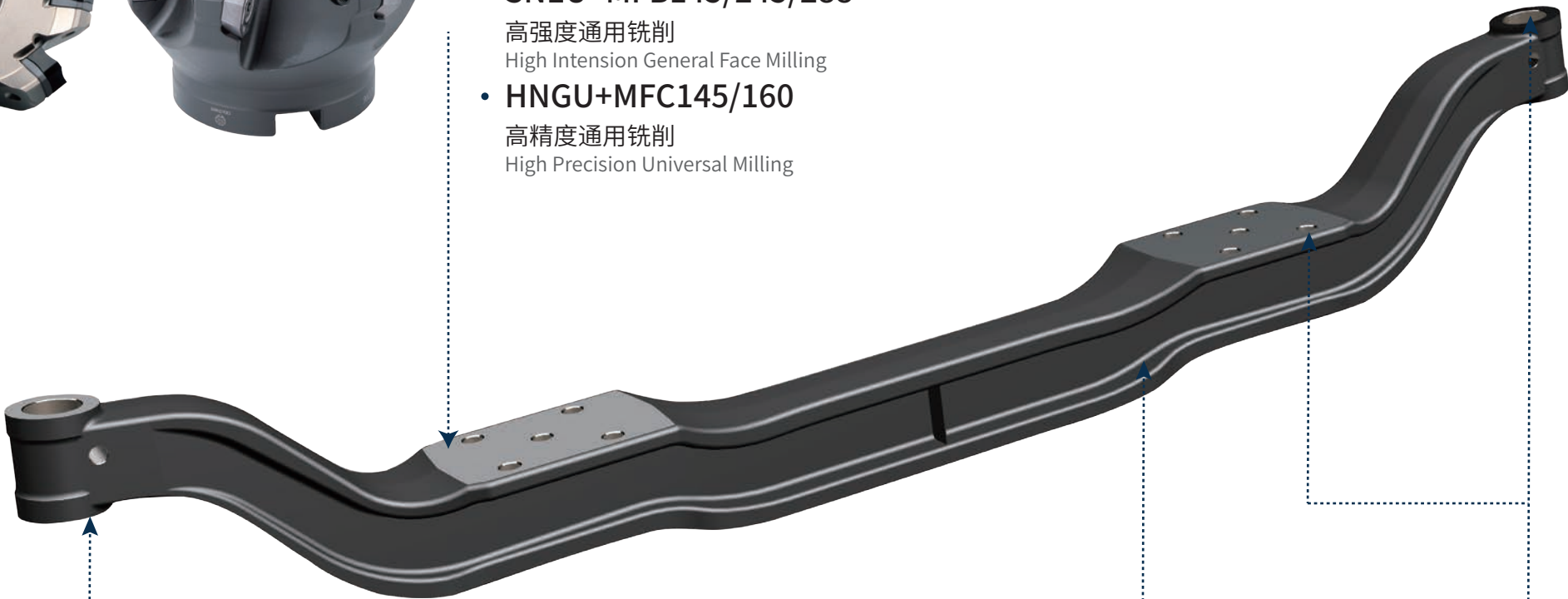


端面铣削
Face Milling

- SNEU+MFB145/245/288
高强度通用铣削
High Intension General Face Milling
- HNGU+MFC145/160
高精度通用铣削
High Precision Universal Milling

外圆铣削
Shoulder Milling

- APKT+MHB190
曲线刃玉米铣削
Helical Edge Corn Milling



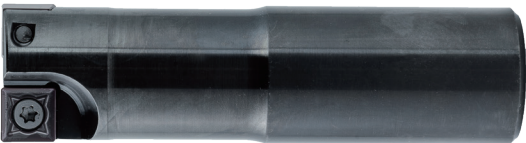
主销孔加工
Hole Making

- QPMG+GHDS
高效可转位钻头
High Efficiency Indexable Drills
- GUMD
GUMD可换式钻头 (详见P26)
Head Changeable Drill (Details in P26)
- RB/FB
粗/精镗系统
Rough/fine Boring System



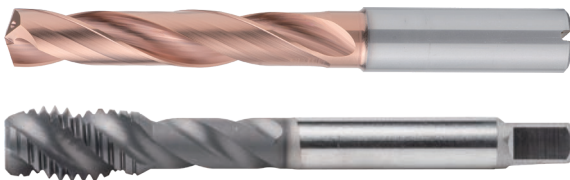
沉台加工
Countersinking

- 非标定制铰刀
Customized Countersink



销孔加工
Pin Hole Making

- D918S
普通钢加工硬质合金麻花钻
Drills for Steel Applications
- 高性能钢用丝锥
High-performance Tap for Steel Applications



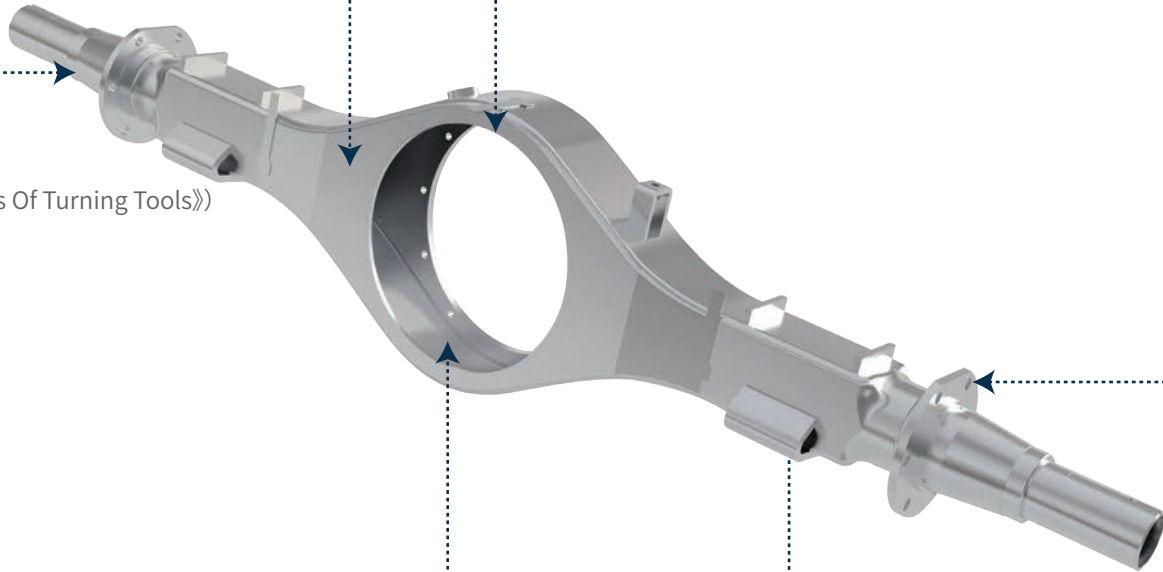
大盘面加工
Face Milling

- HNGU+MFC145
高经济多功能面铣
High Intension General Face Milling
- ONEU+MFG140
高精加工平面铣削 (详见P24)
High Precision Face Milling (Details in P24)



轴头/法兰盘加工
Turning

- 通用粗-精车削加工 (详见《车削刀具产品册》)
General Rough-finish Turning (Details in 《The Catalogs Of Turning Tools》)



大盘面缺口加工
Side Milling

- ANKX+MHC190
高强度玉米铣削
High Strength Corn Milling
- PP300
高效加工立铣刀
High Efficiency Endmills for Steel



孔加工
Hole Making

- D918S
普通钢加工硬质合金麻花钻
Drills for Steel Applications
- QPMG+GHDS
高效可转位钻头
High Efficiency Indexable Drills
- GUMD
GUMD可换式钻头 (详见P26)
Head Changeable Drill (Details in P26)
- 高性能丝锥
High-performance Tap for
Steel & Cast Iron Applications



大盘面内孔加工
Hole Making

- GBR-RB
粗镗刀
Rough Boring System
- GBR-FB
精镗刀
Finish Boring System



板簧座面加工
Face Milling

- SNEU+MFB288
高强度通用铣削
High Intension General Face Milling



油孔加工 Oil-hole Making

- D938
深孔内冷麻花钻 (详见P25)
Deep-hole Inner Cooling Twist Drill (Details in P25)

缸孔加工 Hole Making

- GBR-RB系列
粗镗刀
Rough Boring System
- GBR-FB系列
精镗刀
Finish Boring System

缸孔内槽加工 Grooving

- GKD系列
GKD Series
- NOTCH系列
NOTCH Series

销孔加工 Hole Making

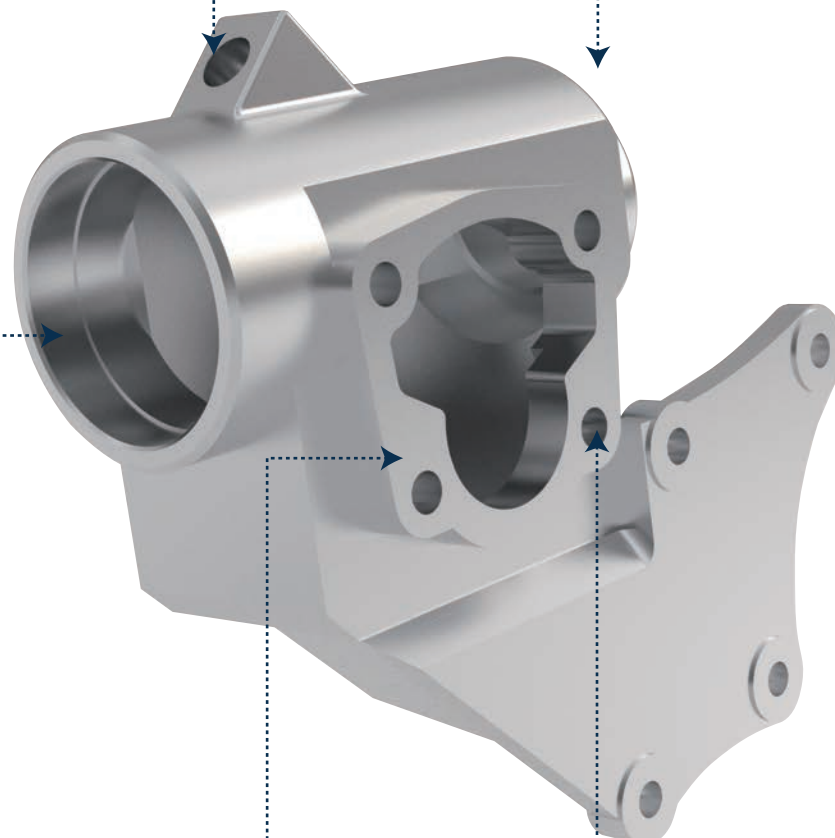
- QPMG+GHDS
高效可转位钻头
High Efficiency Indexable Bit
- GUMD系列
GUMD可换式钻头 (详见P26)
Head Changeable Drill (Details in P26)

缸孔法兰面孔加工 Hole Making

- 非标定制阶梯钻
Customized Step Drill
- 高性能钢用丝锥
High Performance Steel Tap

端面铣削 Hole Making

- UP210/SP210
通用/高效加工立铣刀
General/Efficient End Milling Cutter
- SNMU+MFB145
通用面铣加工
General Face Milling



安装面加工 Mounting Surface Machining

- **D968S**
不锈钢加工硬质合金麻花钻
Drills for Stainless Steel Applications
- **SP210**
高效加工立铣刀
High Efficiency End Mill
- **APMT+MEA190**
正型两刃方肩铣
Positive 2 Edges Shoulder Milling
- **UP210**
通用加工倒角铣刀
Universal Machining Chamfered Milling Cutter



底座面加工 Base Surface Machining

- **RDET+MPA100**
Positive Profile Milling



方形孔加工 Hole Making

- **SP210/SS600**
高效加工立铣刀
High Efficiency End Mill
- **UP210**
通用加工倒角铣刀
Universal Machining Chamfered Milling Cutter



孔加工 Hole Making

- **D968S**
不锈钢加工硬质合金麻花钻
Drills for Stainless Steel Applications
- 非标定制铰刀
Customized Countsink
- 非标定制铰刀
Customized Reamer
- **FB 精镗系统**
Finish Boring System



铣开档及台面 Milling

- **SP210/SS600**
高效加工立铣刀
High Efficiency End Mill



曲轴内外铣刀具

Crankshaft internal and external milling tool

厦门金鹭对于直径150-750mm的内外铣刀盘，轴向及径向跳动精度控制在0.02-0.03mm以内，接受普通及可调式精铣刀夹定制，曲轴刀片尺寸关键尺寸精度可达±0.01mm，一致性控制标准0.008mm。

For 150-750mm diameter of the inner and outer milling cutter head, the axial and radial runout accuracy is controlled within 0.02-0.03mm, accept ordinary and adjustable finishing milling cutter clamp customization, crankshaft blade size key dimension accuracy up to ±0.01mm, consistency control standard 0.008mm.

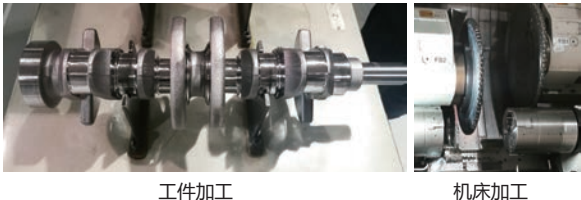
目前已推出CS1及CS2系列刀片，其中CS1系列刀片刀尖强度高，适用于大余量柴油机曲轴加工，CS2系列刀片刀口锋利，适用于汽油机及小型柴油机曲轴加工。

At present, CS1 and CS2 series blades have been launched. CS1 series blades have high blade tip strength and are suitable for crankshaft processing of large surplus diesel engines. CS2 series blades have sharp edge and are suitable for crankshaft processing of gasoline engines and small diesel engines.

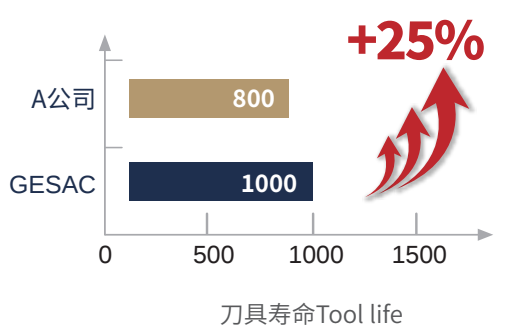
	刀片规格 Specification	CS1-N	CS1-D	CS1-Q	CS1-T
CS1系列刀片 CS1 series blades	刀片外形 Shape				
	加工部位 Processing site	 轴颈	 内档	 外档	 沉割槽

	刀片规格 Specification	CS2-N	CS2-D	CS2-Q	CS2-T
CS2系列刀片 CS2series blades	刀片外形 Shape	 N1	 D1	 Q1	 T1
	刀片外形 Shape	 N2	 D2	 Q2	 T2
	加工部位 Processing site	 轴颈	 内档	 外档	 沉割槽

曲轴外铣加工 Crankshaft external milling machining	
刀具规格 Specification	LNE141109M、LNE221107M
加工材料 Material	SAE1538MV， 硬度27-33HRC
切削速度 Cutting speed	f=0.37mm/r
每转给量 Feed	F=280mm/min Fz=0.25mm/z
切削量 Cutting amount	ap=1.5-2.5mm
切削方式 Cutting method	外铣加工 External milling
冷却方式 Cooling method	干切 Dry cut



工件加工 机床加工



A公司 800
GESAC 1000
+25%
刀具寿命Tool life

V带槽刀

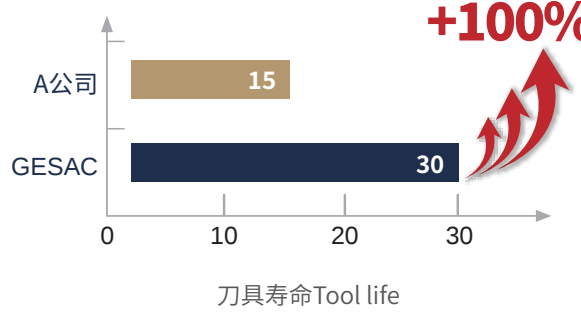
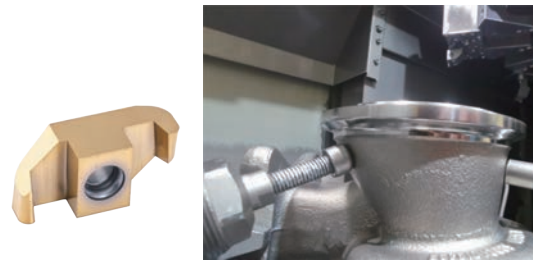
Non-standard ring groove knife



产品特点
Product features:

- 多次修磨，极大限度提升经济性
Repairable and grindable, greatly improving economy
- 常备通用毛坯，满足不同机型成型尺寸快速定制需求
General-purpose blanks are always in stock to meet the needs of rapid customization of molding sizes for different models
- 多种刀片形式，满足不同加工深度、避让选择需求
Various blade forms to meet the needs of different processing depths and collision avoidance options
- 可根据工况进行针对性的牌号搭配。
Targeted brand matching can be carried out according to working conditions

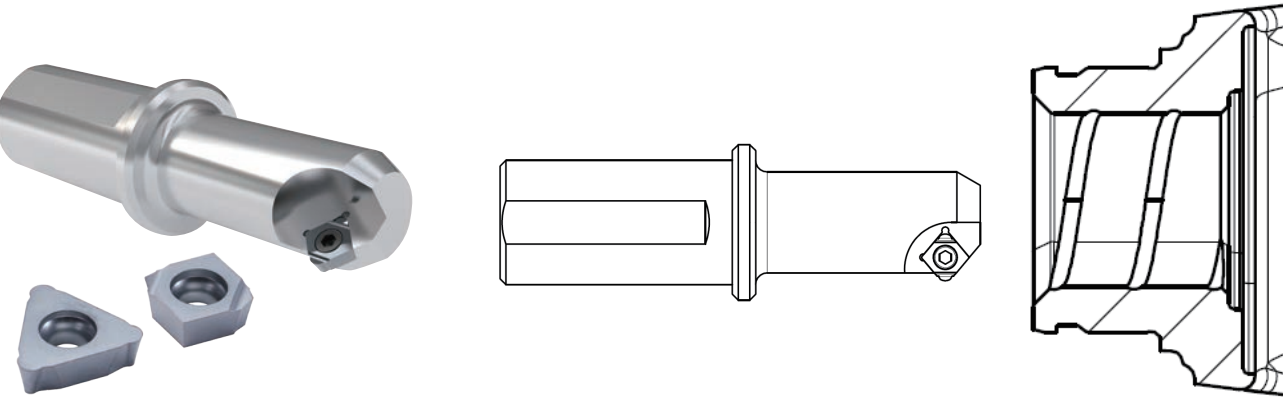
涡轮增压壳外环槽加工 Turbocharged shell outer ring groove machining	
刀具规格 Specification	KNEU31440820R-GST7115
加工材料 Material	1.488
切削速度 Cutting speed	N=380RPM Vc=110~130m/min
进给量 Feed rate	F=55mm/min fr=0.13~0.15mm/r
切削量 Cutting amount	ap=3mm
切削方式 Cutting method	外环槽粗加工 Rough machining of outer ring groove
冷却方式 Cooling method	水基乳化液/外冷 Water-based emulsion/external



A公司 15
GESAC 30
+100%
刀具寿命Tool life

差速器壳体油槽加工刀具

Differential housing oil groove processing tool



- 产品特点**
Product features:
- 刀尖根据油槽尺寸进行非标定制
The tool tip is customized according to the size of the oil groove
 - 搭配韧性优异的牌号GM3225
With excellent toughness brand GM3225
 - 多刃口设计, 提升加工产品经济性
Multi-edge design, improve the economy of processed products
 - 常备基体库存, 交货周期短
the matrix stock is always available. The delivery time is short

差速器油槽加工 Differential housing oil groove machining	
刀具规格 Specification	PTCCET09T320-GM3225
加工材料 Material	45# (HRC20)
切削速度 Cutting speed	N=680r/min (Vc=108m/min)
进给量 Feed rate	F=55mm/min (Fn=0.08mm/rpm)
切削量 Cutting amount	ap=1.2mm (分三刀)
切削方式 Cutting method	内圆车削 Inner hole turning
冷却方式 Cooling method	水基乳化液/外冷 Water based emulsion/external cooling

刀具寿命Tool life

可转位涂层PCBN刀具二代牌号

Indexable coating PCBN tool second generation

BHC210P/BHC225P **H**

- ↑ **稳定性**
Stable

焊片升级 Weld Sheet

采用全CBN焊片, 去除硬质合金衬底, 提升焊接稳定性, 进一步强化产品切削加工稳定性。
The use of all cbn material, no hard alloy substrate, improve the welding stability, further strengthen the product machining stability
- ↑ **耐磨性**
Wear

涂层升级 Coating Upgrade

第二代PCBN涂层, TiAlSiN涂层, 抗化学磨损性能好, 提升高线速度下的使用寿命。
The second generation of PCNB coating, TiAlSiN coating, good chemical wear resistance, improve the service life of high line speed.
- ↑ **经济**
Economy

新增系列 New Series

第二代PCBN涂层, TiAlSiN涂层, 抗化学磨损性能好, 提升高线速度下的使用寿命。
The second generation of PCNB coating, TiAlSiN coating, good chemical wear resistance, improve the service life of high line speed.

齿轮轴加工 Gear shaft machining	
刀具规格 Specification	PCNGA120408LS-2-BHC210P
加工材料 Material	TL438 (HRC55-60)
切削速度 Cutting speed	V:238-417 (m/min) N:1200 rpm
进给量 Feed rate	F:240 mm/min 0.2 mm/rpm
切削量 Cutting amount	0.2-0.25mm
切削方式 Cutting method	外圆 (D63-110) 连续精加工 Continuous finishing of outer circle (D63-110)
冷却方式 Cooling method	水基乳化液/外冷 Water-based emulsion/external

刀具寿命tool life

ONEU面铣精加工刀具

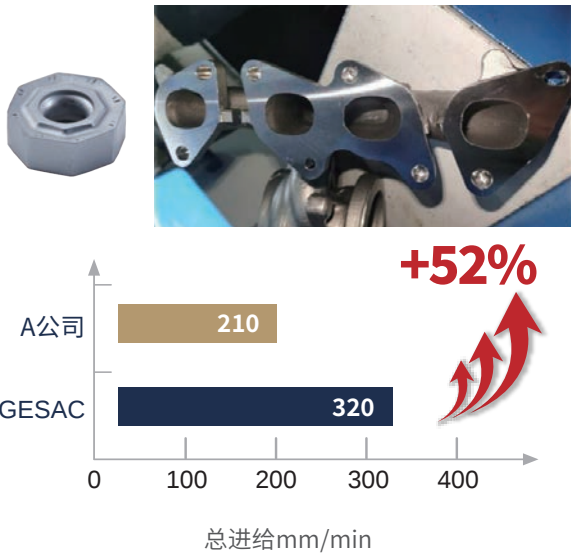
ONEU face milling finishing tool



产品特点 Product features:

- 双面十六刃刀片极大限度提升经济性
Double-sided sixteen-edged blades greatly improve the economy
- 不等齿距刀盘减轻加工震刀
Unequal tooth pitch cutter head reduces machining vibration
- 40度面铣加工黄金主偏角
40 ° face milling processing gold main deflection angle
- 刀片自带修光刃保证加工表面Ra<1.0
The blade comes with a wiper edge to ensure the processed surface Ra<1.0
- 高精度刀盘+精磨刀片轻松实现精加工
High-precision cutter head + fine-grinding blade to easily achieve finishing

排气歧管面铣加工 Exhaust manifold surface milling	
刀具规格 Specification	ONEU050410E-SF-GM2140 MFG140-125R08 (装4片)
加工材料 Material	1.4837
切削速度 Cutting speed	N=800RPM Vc=315m/min
进给量 Feed rate	F=320mm/min fz=0.1mm/z
切削量 Cutting amount	ap=0.3mm
切削方式 Cutting method	面铣精铣 Finish face milling
冷却方式 Cooling method	水基乳化液/外冷 Water-based emulsion/external



D938深孔内冷麻花钻

D938 Series Deep Hole Internal Coolant Twist Drill

全新的基材材质 New substrate material

- 韧性和耐磨损性的完美平衡
Perfect balance between toughness and wear resistance

双刃带 Double cutting relief

- 具有优良的导向性
With excellent directivity

柄部标准 Standard

- 基于DIN6535HA标准设计
The shank is designed in accordance with DIN6535HA Standard

刃径精度 Cutting Diameter accuracy

- 采用h7公差精度等级
h7 tolerance accuracy class

超光滑排屑槽 Super smooth chip flute

- 超低表面摩擦系数
Ultra low surface friction coefficient

短涂层 Short Coating

- 超低表面摩擦系数
Ultra low surface friction coefficient

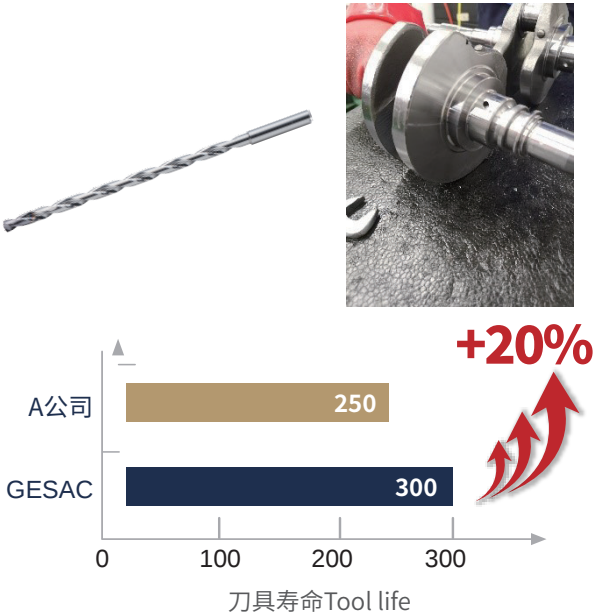
D938系列钻尖 D938 Series Drill Tip

- 超强的自定心性能和断屑性能
Superior self-centering and chipbreaking performance

AlTiN-nano涂层 AlTiN-nano Coating

- 优异的红硬性和抗氧化性
High heat resistance and high resistance to oxidation

曲轴深孔加工 Crankshaft deep hole machining	
刀具规格 Specification	D938-A20C-0400
加工材料 Material	42CrMo
切削速度 Cutting speed	N=3100RPM Vc=39m/min
进给量 Feed	F=341mm/min Fz=0.11mm/z
孔深 hole depth	70mm
切削方式 Cutting method	引导钻预钻孔+一钻到底 Guided drilling pre-drill + one drill to the bottom
冷却方式 Cooling method	水基乳化液/内冷 Water based emulsion/external cooling

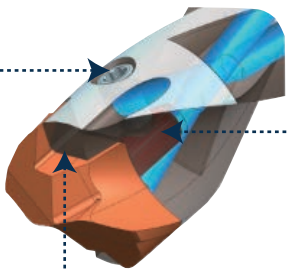


GUMD皇冠钻

GUMD Modular drill

锁紧可靠 Reliable locking

- 卡槽及防松设计
Special locking design
- 避免刀头脱落
Avoid drill tip falling off



精度可靠 Reliable accuracy

- 销与孔紧密配合
The pin fits closely with the hole

受力可靠 Reliable stress

- 扭矩传递面特殊设计
Special design of torque transmission surface
- 确保扭矩稳固传输
Ensure stable torque transmission

高强度钻尖设计 High strength drill tip design

- 定心性能好
Prefect centering capacity

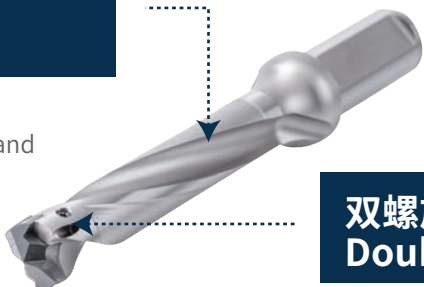


通用刀型设计 Universal edge design

- 兼顾P/K/M断屑与强度
Considering P/K/M chip breaking and strength

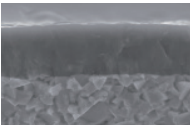
变螺旋排屑槽 Variable flutes

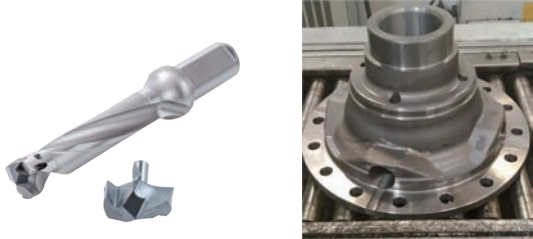
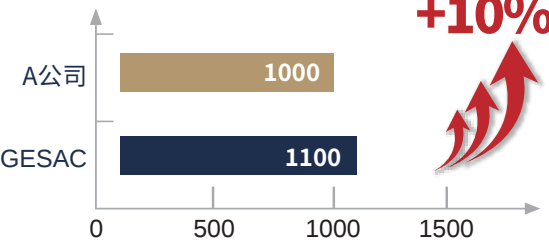
- 兼顾切削效果及钻体刚性
Take into account the cutting effect and drill body rigidity



双螺旋内冷孔 Double helix internal cold

- 提高冷却液流量
Increase cooling flow

材质 Material	加工材料 Work material		
	P	M	K
GM3225(较硬Harder)	● 耐磨 Wear resistant	○	○
GPD7115(韧性Toughness)	● 韧性 Toughness		
① 材质GM3225 适用通用材料, 在耐磨性要求较高工况性能优异 It is suitable for general purpose material, and has excellent performance in high abrasion resistance condition ② 新材质GPD7115 NEW 在钢材韧性要求较高工况性能卓越 Excellent performance in the steel toughness requirements of higher conditions			

差速器壳体轴孔加工 Differential housing shaft hole machining		  刀具寿命Tool life
刀具规格 Specification	刀头: GUMD185-PKM-GM3225 钻杆: GUMD-180-5D-F25S	
加工材料 Material	QT600	
切削速度 Cutting speed	N=1100RPM Vc=63m/min	
进给量 Feed rate	F=280mm/min Fz=0.25mm/z	
孔深 hole depth	15mm	
切削方式 Cutting method	一钻到底 one drill to the bottom	
冷却方式 Cooling method	水基乳化液/内冷 Water-based emulsion/external	

MEMO

MEMO