

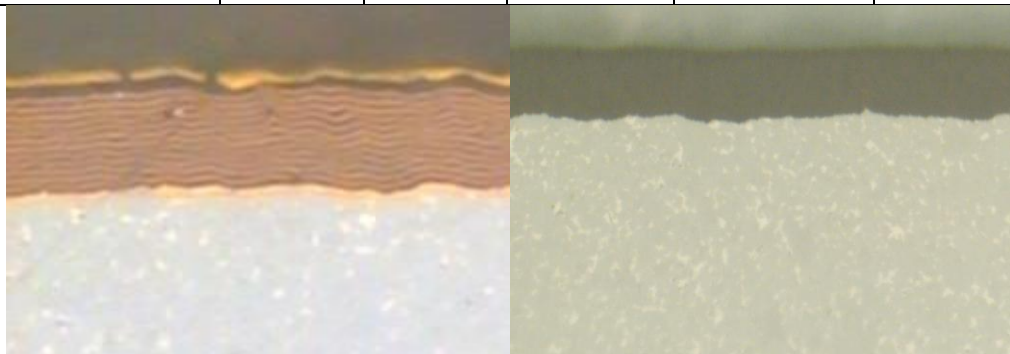
# 高温合金刀具

## High Temperature Alloy Tool

本公司利用添加稀土元素和采用特殊的烧结工艺,研发出专用铣削车削等基体材料牌号 GY83、GY87、GY53 和 GY03、GY08, 特别在搭配优选的 PVD、CVD 复合涂层后, 具有卓越的韧性和耐磨性, 主要用于高温合金、钛合金及不锈钢铣削, 广泛用于汽轮机、飞机发动机叶片、机匣等难加工材料的铣削和车削。该种涂层在干式铣削不锈钢时具有极高的抗月牙洼磨损和抗后刀面磨损性能。

CTRI has developed special grade GY83,GY87,GY03, and GY08 for turning and milling by adding rare earth (RE) and applying special sintering processing. Products demonstrate excellent toughness and wear resistance after PVD and CVD composite coating, mainly applied for high-temperature alloy, titanium alloy and stainless steel milling, widely used in milling and turning of steam turbine, blade of aircraft engine, casing and other hard- to -machine materials. The coating has high anti crater wear resistance and flank wear performance in dry milling of stainless steel.

切削参数推荐					
切削材质	不锈钢			Ni 基合金	钛合金
	加工方式				
切削速度 (m/min)	粗加工		精加工	40-120	50-75
进给 (m/min)	0.6-1.2		0.6-1.0	0.6-0.8	0.6-0.8
切深 (mm)	0.5-2.5		0.5-2.5	0.5-1.5	0.5-1.5
切削材质及涂层	GY8768	GY8785	GY8368	GY8785	GY8785
冷却方式	干	湿	干/湿	干/湿	干/湿



复合 PVD

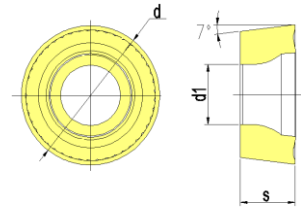
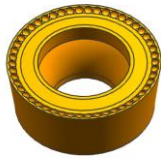
PVD

## Composite PVD

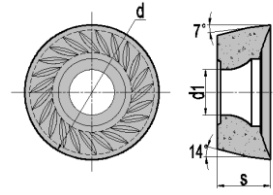
Recommended Cutting Parameter					
Cutting Material	Stainless Steel			Ni-based alloy	titanium alloy
	Rough Machining	Finish Machining			
Cutting Speed (m/min)	100-200		160-300	40-120	50-75
Feed (m/min)	0.6-1.2		0.6-1.0	0.6-0.8	0.6-0.8
Cutting Depth (mm)	0.5-2.5		0.5-2.5	0.5-1.5	0.5-1.5
Grade	GY8768	GY8785	GY8368	GY8785	GY8785
Coolant	Dry	wet	dry/wet	dry/wet	dry/wet

● 代表主推牌号    ○ 代表可选牌号

● Recommended Grade    ○ Optional Grade



Order No.	Dimension (mm)			Grade	
	d	s	d1	GY83	GY87
RCKT10T3MO	10	3.97	4.4	●	○
RCKT10T3MOT	10	3.97	4.2	●	○
RCKT10T3MOT-3.5	10	3.97	3.9	●	○



Order No.	Dimension (mm)			Grade	
	d	s	d1	GY83	GY87
RCKT1204MO	12	4.76	4.05	○	●