



重力车削加工刀片  
Inserts for Heavy-Duty Turning



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**株洲大有新材料有限公司**  
ZHUSHOU OTOMO ADVANCED MATERIAL CO.,LTD.



**OT08415** High hardness substrate, thickened TiCN and thick Al<sub>2</sub>O<sub>3</sub> coating  
Excellent wear resistance, suitable for heavy turning under continuous working conditions

**Preferred** **OT08425** Both hardness and strength substrate, thick TiCN and Al<sub>2</sub>O<sub>3</sub> coating  
Excellent wear resistance, taking into account both continuous and weak intermittent processing, good general performance

**OT08435** Both hardness and strength substrate, thick TiCN and Al<sub>2</sub>O<sub>3</sub> coating  
Excellent wear resistance, taking into account both continuous and weak intermittent processing, good general performance

Different working conditions  
Different solutions



### HLR - Light cutting

The chip breaking range is wide, the cutting is light and fast, and it is suitable for continuous cutting or heavy turning with small allowance.



### HIR - Continue cutting

The cutting edge is strengthened and has a high level of safety, and is suitable for heavy turning under unstable conditions such as intermittent work.

**Preferred**



### HGR - General Purpose Cutting

The trough structure takes into account the needs of chip control and strength, and is suitable for continuous and weak intermittent heavy turning machining.



### HMR - light cutting

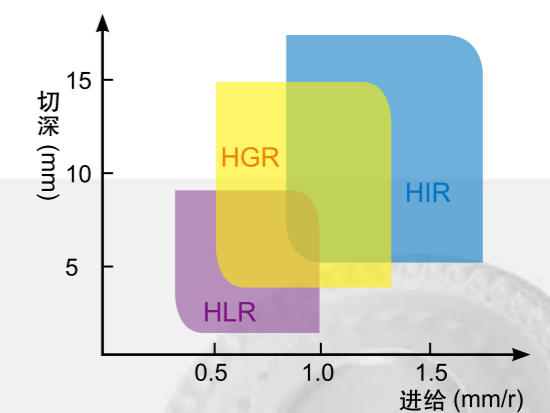
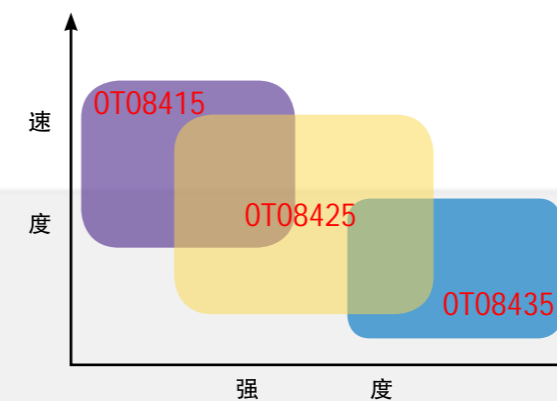
Double-sided heavy-turning stainless steel machining geometry, the chip flow direction is well controlled, and it is suitable for stable working conditions or small margin machining.

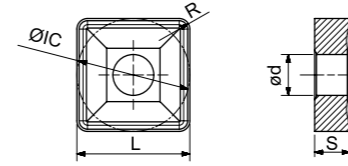
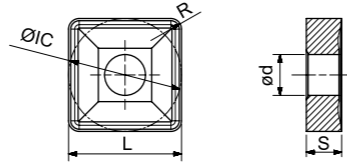
**Preferred**



### HGR - General Purpose Cutting

Double-sided universal machining geometry, the structure takes into account the needs of chip control and strength, and has extremely high economy under stable working conditions.



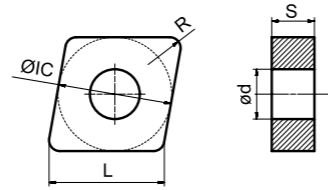


刀片外形	型号	尺寸 (Dimension)mm					牌号		
		L	IC	d	S	R	OT08415	OT08425	OT08435
	CNMM160608-HLR	16.1	15.875	6.35	6.35	0.8	★		●
	CNMM160612-HLR	16.1	15.875	6.35	6.35	1.2	★		●
	CNMM160616-HLR	16.1	15.875	6.35	6.35	1.6	★		●
	CNMM190612-HLR	19.3	19.05	6.35	7.94	1.2	★		●
	CNMM190616-HLR	19.3	19.05	6.35	7.94	1.6	★		●
	CNMM190624-HLR	19.3	19.05	6.35	7.94	2.4	★		●
	CNMM250924-HLR	25.8	25.4	9.525	9.12	2.4	★		●
	SNMM150608-HLR	15.875	15.875	6.35	6.35	0.8	★		●
	SNMM150612-HLR	15.875	15.875	6.35	6.35	1.2	★		●
	SNMM150616-HLR	15.875	15.875	6.35	6.35	1.6	★		●
	SNMM190612-HLR	19.05	19.05	6.35	7.94	1.2	★		●
	SNMM190616-HLR	19.05	19.05	6.35	7.94	1.6	★		●
	SNMM190624-HLR	19.05	19.05	6.35	7.94	2.4	★		●
	SNMM250724-HLR	25.4	25.4	9.12	7.94	2.4	★		●
	SNMM250924-HLR	25.4	25.4	9.12	9.525	2.4	★		●
	CNMM190612-HGR	19.3	19.05	6.35	6.35	1.2		★	
	CNMM190616-HGR	19.3	19.05	6.35	6.35	1.6		★	
	CNMM190624-HGR	19.3	19.05	6.35	6.35	2.4		★	
	CNMM250724-HGR	25.8	25.4	9.12	7.94	2.4		★	
	CNMM250924-HGR	25.8	25.4	9.12	9.525	2.4		★	
	SNMM190612-HGR	19.05	19.05	6.35	6.35	1.2		★	
	SNMM190616-HGR	19.05	19.05	6.35	6.35	1.6		★	
	SNMM190624-HGR	19.05	19.05	6.35	6.35	2.4		★	
	SNMM250724-HGR	25.4	25.4	9.12	7.94	2.4		★	
	SNMM250924-HGR	25.4	25.4	9.12	9.525	2.4		★	
	CNMM190624-HIR	19.3	19.05	6.35	6.35	2.4			●
	CNMM250724-HIR	25.8	25.4	9.12	7.94	2.4			●
	CNMM250924-HIR	25.8	25.4	9.12	9.525	2.4			●

刀片外形	型号	尺寸 (Dimension)mm					牌号		
		L	IC	d	S	R	OT08415	OT08425	OT08435
	SNMM190624-HIR	19.05	19.05	6.35	6.35	2.4		●	
	SNMM250724-HIR	25.4	25.4	9.12	7.94	2.4		●	
	SNMM250924-HIR	25.4	25.4	9.12	9.525	2.4		●	
	SNMM250932-HIR	25.4	25.4	9.12	9.525	3.2		●	
	CNMM190616-HPR	19.3	19.05	6.35	7.94	1.6	★		●
	CNMM190624-HPR	19.3	19.05	6.35	7.94	2.4	★		●
	CNMM250724-HPR	25.8	25.4	7.94	9.12	2.4	★		●
	CNMM250924-HPR	25.8	25.4	9.525	9.12	2.4	★		●
	SNMM190616-HPR	19.05	19.05	6.35	7.94	1.6	★		●
	SNMM190624-HPR	19.05	19.05	6.35	7.94	2.4	★		●
	SNMM250724-HPR	25.4	25.4	7.94	9.12	2.4	★		●
	SNMM250924-HPR	25.4	25.4	9.525	9.12	2.4	★		●
	CNMM190624-HZ	19.3	19.05	6.35	7.94	2.4	★		●
	CNMM250924-HZ	25.8	25.4	9.525	9.12	2.4	★		●
	SNMM190624-HZ	19.05	19.05	6.35	7.94	2.4	★		●
	SNMM250924-HZ	25.4	25.4	9.525	9.12	2.4	★		●
	SNMM250932-HZ	25.4	25.4	9.525	9.12	3.2	★		●

★主推牌号常备库存 ●可选牌号备库存

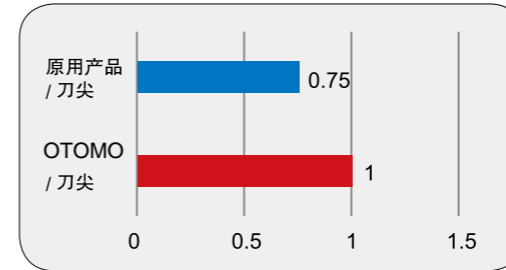
# 双面重车



刀片外形	型号	尺寸 (Dimension)mm					牌号		
		L	IC	d	S	R	OT08415	OT08425	OT08435
	CNMG160608-HGR	16.1	15.875	6.35	6.35	0.8	★		●
	CNMG160612-HGR	16.1	15.875	6.35	6.35	1.2	★		●
	CNMG160616-HGR	16.1	15.875	6.35	6.35	1.6	★		●
	CNMG190612-HGR	19.3	19.05	6.35	6.35	1.2	★		●
	CNMG190616-HGR	19.3	19.05	6.35	6.35	1.6	★		●
	CNMG190624-HGR	19.3	19.05	6.35	6.35	2.4	★		●
	CNMG250924-HGR	25.8	25.4	9.12	9.525	2.4	★		●
	SNMG160612-HGR	15.875	15.875	6.35	6.35	1.2	★		●
	SNMG160616-HGR	15.875	15.875	6.35	6.35	1.6	★		●
	SNMG190612-HGR	19.05	19.05	6.35	6.35	1.2	★		●
	SNMG190616-HGR	19.05	19.05	6.35	6.35	1.6	★		●
	SNMG190624-HGR	19.05	19.05	6.35	6.35	2.4	★		●
	SNMG250724-HGR	25.4	25.4	9.12	7.94	2.4	★		●
	SNMG250924-HGR	25.4	25.4	9.12	9.525	2.4	★		●
	CNMG160608-HMR	16.1	15.875	6.35	6.35	0.8		★	
	CNMG160612-HMR	16.1	15.875	6.35	6.35	1.2		★	
	CNMG160616-HMR	16.1	15.875	6.35	6.35	1.6		★	
	CNMG190612-HMR	19.3	19.05	6.35	6.35	1.2		★	
	CNMG190616-HMR	19.3	19.05	6.35	6.35	1.6		★	
	CNMG190624-HMR	19.3	19.05	6.35	6.35	2.4		★	
	CNMG250924-HMR	25.8	25.4	9.12	9.525	2.4		★	
	SNMG160612-HMR	15.875	15.875	6.35	6.35	1.2		★	
	SNMG160616-HMR	15.875	15.875	6.35	6.35	1.6		★	
	SNMG190612-HMR	19.05	19.05	6.35	6.35	1.2		★	
	SNMG190616-HMR	19.05	19.05	6.35	6.35	1.6		★	
	SNMG190624-HMR	19.05	19.05	6.35	6.35	2.4		★	
	SNMG250724-HMR	25.4	25.4	9.12	7.94	2.4		★	
	SNMG250924-HMR	25.4	25.4	9.12	9.525	2.4		★	

★主推牌号常备库存 ●可选牌号备库存

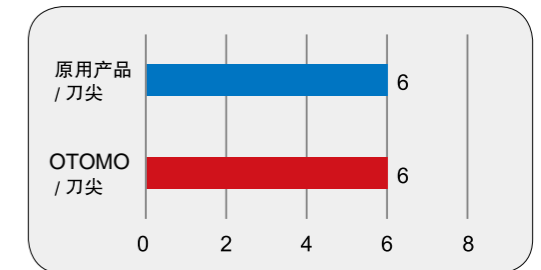
- 被加工材料 (Work piece material): 合金钢
- 加工设备 (Lathe type): 卧车
- 使用刀片 (insert): OT08425 SNMM250924-HGR
- 对比刀片 (Compare insert): 某知名厂家



- 加工内容 (Processing content): 外圆粗车
- 换刀标准 (Insert change criteria): 表面加工质量, 刀片过度磨损
- 切削液 (Cooling type): 无
- 加工参数 (Cutting parameters): Vc=80-120m/min Fn=0.9mm/r Ap=5~10mm

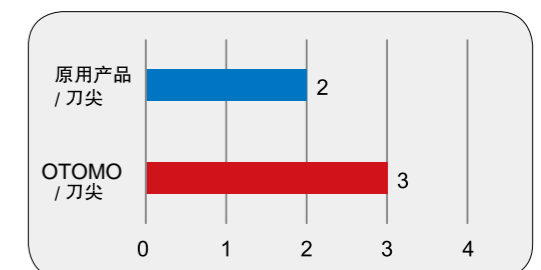
## 回转支承

- 被加工材料 (Work piece material): 40CrNiMo
- 加工设备 (Lathe type): 数车
- 使用刀片 (insert): OT08425 CNMM190624-HLR
- 对比刀片 (Compare insert): 某知名厂家
- 加工内容 (Processing content): 外圆
- 换刀标准 (Insert change criteria): 表面加工质量或者刀尖磨损严重
- 切削液 (Cooling type): 干切
- 加工参数 (Cutting parameters): Vc=80-120m/min Fn=0.63mm/r Ap=2~8mm



## 石油接头

- 被加工材料 (Work piece material): 40CrNiMo
- 加工设备 (Lathe type): 数车
- 使用刀片 (insert): OT08435 CNMM250924-HI
- 对比刀片 (Compare insert): 某知名厂家
- 加工内容 (Processing content): 外圆及端面
- 换刀标准 (Insert change criteria): 表面加工质量或者刀尖磨损严重
- 切削液 (Cooling type): 干切
- 加工参数 (Cutting parameters): Vc=80-120m/min Fn=1.3mm/r Ap=8~15mm





■ 推荐切削速度 (Vc: m/min)

	连续-断续 Continuous-Intermittent		强断续 Strong discontinuity
	OT08415	OT08425	OT08435
	160(100-220)	140(80-200)	120(70-150)

■ 推荐切深、进给 (Ap: mm Fn: mm/r)

	连续加工 Continuous processing ○	轻断续加工 Light intermittent machining ◐	断续加工 Intermittent processing ⊕	强断续加工 Strong intermittent machining ⊕
HLR (单面/Single)	Ap: 2~8 Fn: 0.3~1.0	Ap: 2~8 Fn: 0.3~0.6	----	----
HGR (单面/Single)	----	Ap: 4~15 Fn: 0.5~1.3	Ap: 4~10 Fn: 0.5~0.9	----
HIR (单面/Single)	----	----	Ap: 5~20 Fn: 0.7~1.5	Ap: 5~15 Fn: 0.7~1.0
HPR (单面/Single)	AP:4-12 Fn: 0.35-1.3	AP:4-12 Fn: 0.35-1.0		
HY (单面/Single)	AP:4-15 Fn: 0.5-1.	AP:4-15 Fn: 0.5-1.1		
HGR (双面) (Double-sided)	Ap: 4~12 Fn: 0.5~1.0	Ap: 4~8 Fn: 0.5~1.0	----	----
HMR (双面) (Double-sided)	Ap: 2~8 Fn: 0.3~1.0	Ap: 2~8 Fn: 0.3~0.6	----	----

