航空解决方案
Aerospace Solutions

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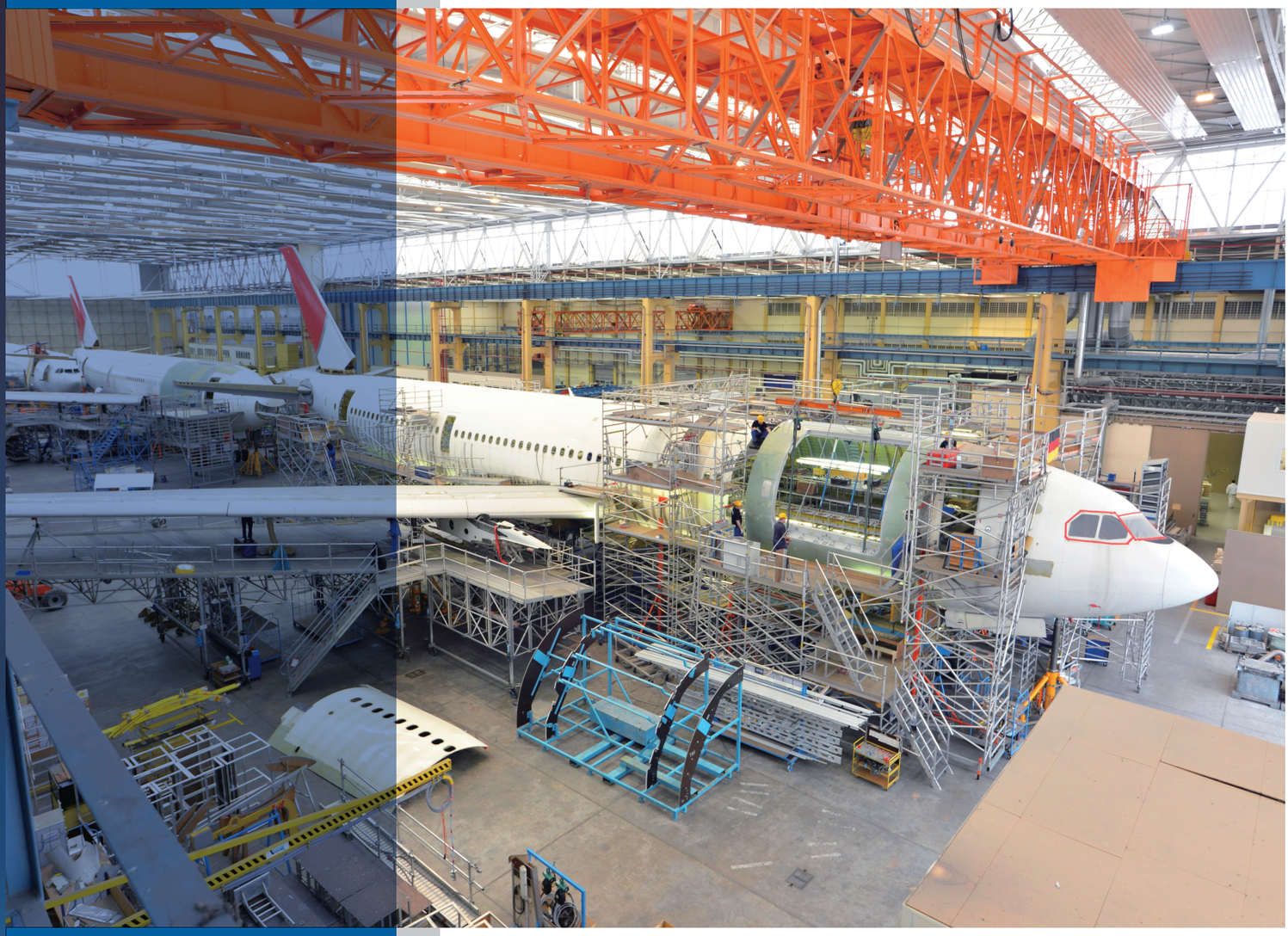
Assembly 装配用

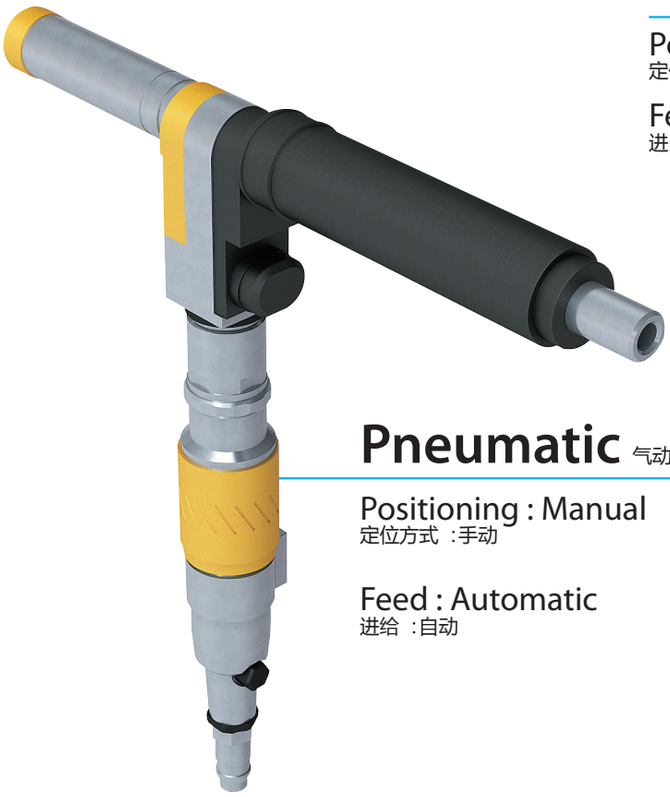


Machine Type 加工设备

Hand 手动

Positioning : Manual
定位方式 :手动

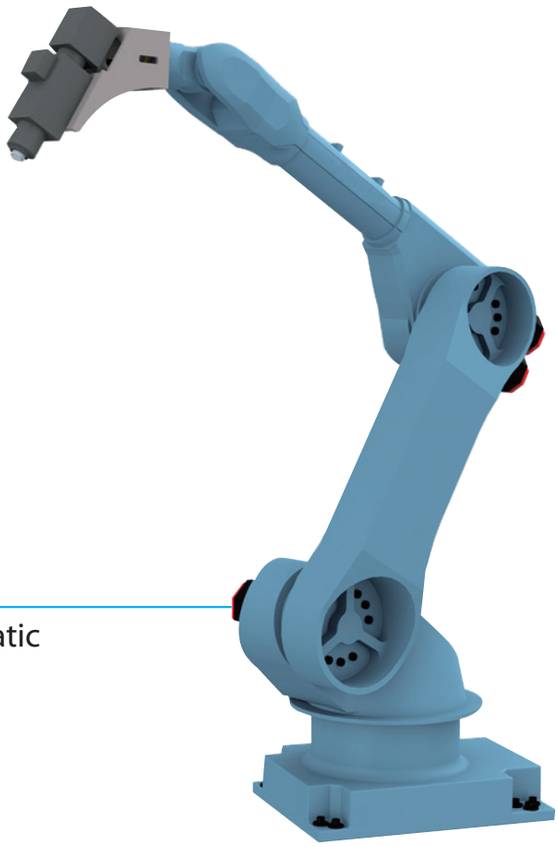
Feed : Manual
进　　给 :手动



Pneumatic 气动

Positioning : Manual
定位方式 :手动

Feed : Automatic
进给 :自动



CNC

Positioning : Automatic
定位方式 :自动

Feed : Automatic
进给 :自动

CFRP 复合材料

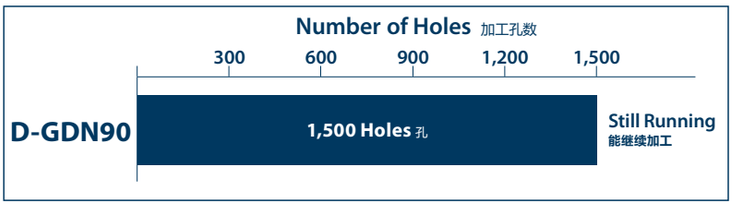
Hand	Pneumatic	CNC
—	○	○

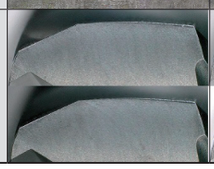
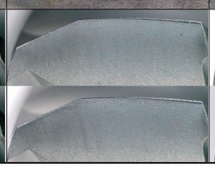
High feed and long tool life
高进给 & 长寿命

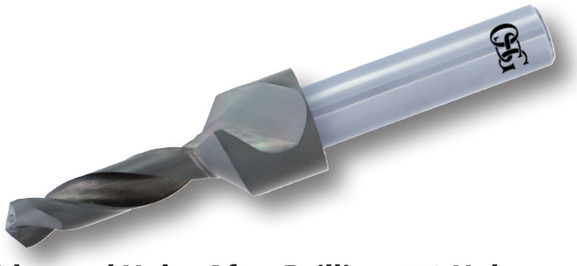
D-GDN90

Diamond Coated 90 Degree Point Angle Drill
金刚石涂层硬质合金钻头 先端角90°

Tool 使用工具	.2510" (ϕ6.375)
Work Material 切削材质	CFRP
Cutting Speed 切削速度	100m/min (5,000min^{-1})
Feed Rate 进给速度	1,000mm/min (0.2mm/rev)
Depth of Hole 加工深度	10mm (Through) 通孔
Coolant 切削油剂	Dry 干式加工
Machine 使用机械	Vertical Machining Center (HSK-63A) 立式加工中心



	500 Holes 孔	1,000 Holes 孔	1,500 Holes 孔
Hole Exit 加工孔出口			
D-GDN90			



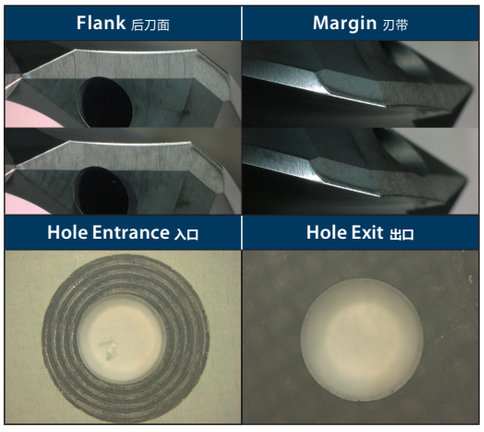
Incredible coolant flow capability
令人难以置信的给油量

DIA-HO-SC-GDS (Special 非标品)

Diamond Coated Countersink Drill with Helical Coolant-Through
金刚石涂层锪钻 带螺旋内冷油孔

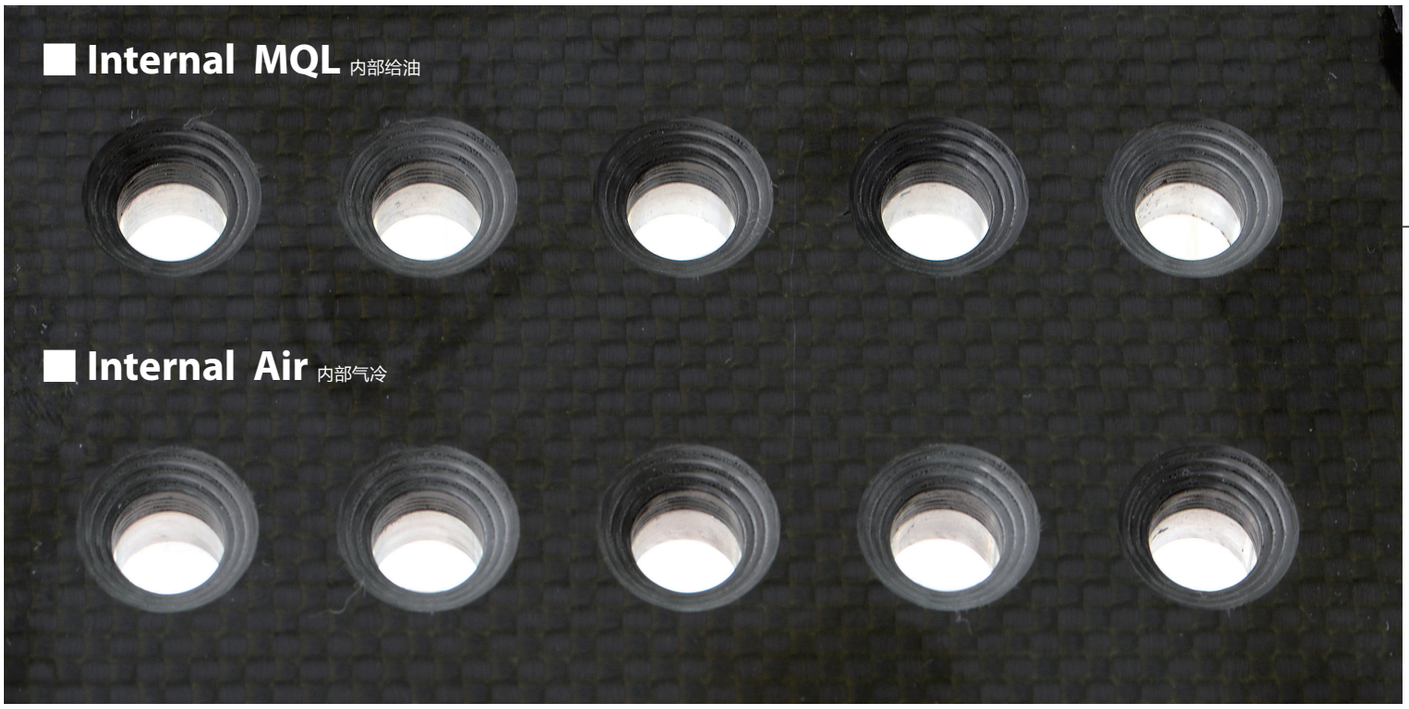
Tool 使用工具	ϕ9.576×100° (Special) 非标品
Work Material 切削材质	CFRP with Copper Mesh Top Layer CFRP+顶层网状金属铜 复合叠材
Cutting Speed 切削速度	150m/min (5,000min^{-1})
Feed Rate 进给速度	670mm/min (0.134mm/rev)
Depth of Hole 加工深度	15mm (Through) 通孔
Coolant 切削油剂	Internal MQL 内部MQL
Machine 使用机械	Vertical Machining Center (HSK-63A) 立式加工中心

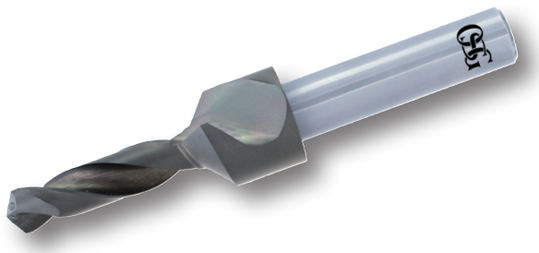
■ Cutting Edge and Holes After Drilling 450 Holes
加工450孔后工具及孔的状态



CFRP/AL CFRP/ 铝叠板材

Hand	Pneumatic	CNC
—	○	○





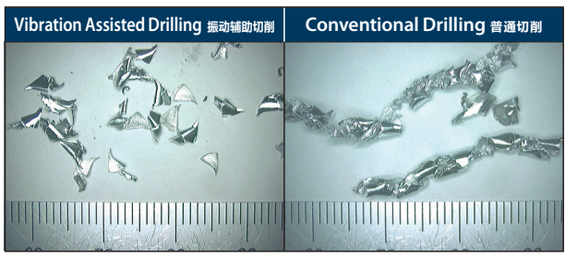
Incredible coolant flow capability
令人难以置信的给油量

DIA-HO-SC-GDS (Special 非标品)

Diamond Coated Countersink Drill with Helical Coolant-Through
金刚石涂层锪钻 带螺旋内冷油孔

Tool 使用工具	ϕ9.576×100° (Special) 非标品	
Work Material 切削材质	CFRP/AL Stack	
Cutting Speed 切削速度	Vibration Assisted Drilling 振动辅助切削	
Coolant 切削油剂	Internal MQL 内部MQL	Internal Air 内部气冷
Cutting Speed 切削速度	150m/min (5,000min^{-1})	80m/min (2,660min^{-1})
Feed Rate 进给速度	500mm/min (0.1mm/rev)	266mm/min (0.1mm/rev)
Machine 使用机械	Vertical Machining Center (HSK-63A) 立式加工中心	

Chip Shape Comparison 切屑形状比较



Coupon 试件

Hole Entrance 入口

CFRP 7mm
A7075 6mm

Hole Exit 出口

CFRP/TI CFRP/ 钛叠板材

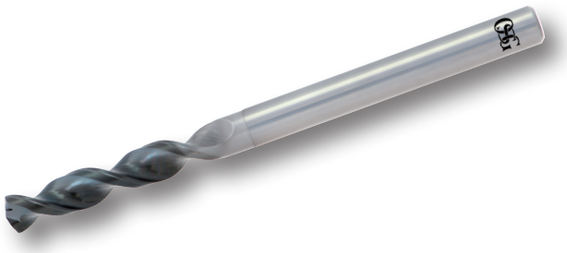
Hand	Pneumatic	CNC
—	○	○

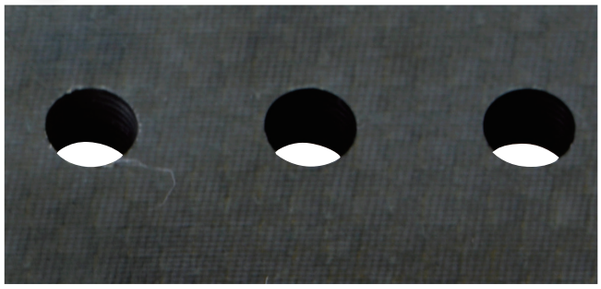
One-shot drilling for stacks
叠板材料一步式加工

STCH-D (Special 非标品)

High Helix Diamond Coated Drill for Stacks
叠板用 大螺旋金刚石涂层钻头

Tool 使用工具	ϕ6.375 (Special) 非标品
Work Material 切削材质	CFRP / TI Stack
Cutting Method 加工方法	Vibration Assisted Drilling 振动辅助切削
Cutting Speed 切削速度	20m/min (1,000min^{-1})
Feed Rate 进给速度	50mm/min (0.05mm/rev)
Coolant 切削油剂	Internal MQL 内部MQL
Machine 使用机械	Vertical Machining Center (HSK-63A) 立式加工中心





Coupon 试件

Hole Entrance 入口

CFRP 7mm
Ti-6Al-4V 5mm

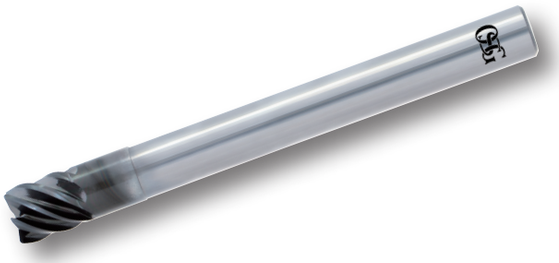
Hole Exit 出口

For improved surface quality
难以想象的加工表面

DIA-O-ENC (Special 非标品)

Diamond-Coated 6-fluted End Mill for Planetary Drilling
行星式加工用 6刃金刚石涂层铣刀

Tool 使用工具	ϕ11× R0.6 6FL (Special) 非标品	
Work Material 切削材质	CFRP / TI Stack	
	CFRP	Ti-6Al-4V
Cutting Speed 切削速度	150m/min (4,340min^{-1})	50m/min (1,447min^{-1})
Feed Rate 进给速度	1,302mm/min (0.05mm/t)	868mm/min (0.1mm/t)
Hole Dia. 孔径	ϕ20	
Ramp Angle 倾斜角	1°	0.5°
Coolant 切削油剂	Internal Air 内部气冷	Internal MQL 内部MQL
Machine 使用机械	Vertical Machining Center (HSK-63A) 立式加工中心	
Machining Time 加工时间	1min 24sec 分 秒	



Coupon 试件

Hole Entrance 入口

CFRP 7mm
Ti-6Al-4V 5mm

Hole Exit 出口

Special Assembly Tools 非标品

Hand	Pneumatic	CNC
○	○	–

Threaded Hex Shank Adapter Drill

六角螺母螺纹接口式钻头

Double Margin Step Drill

双刃带阶梯钻头

Nutplate Drill / Countersink

螺母孔加工钻头/沉孔加工

Tapered Drill / Reamer

倒锥钻头/铰刀

Threaded Hex Shank Reamer

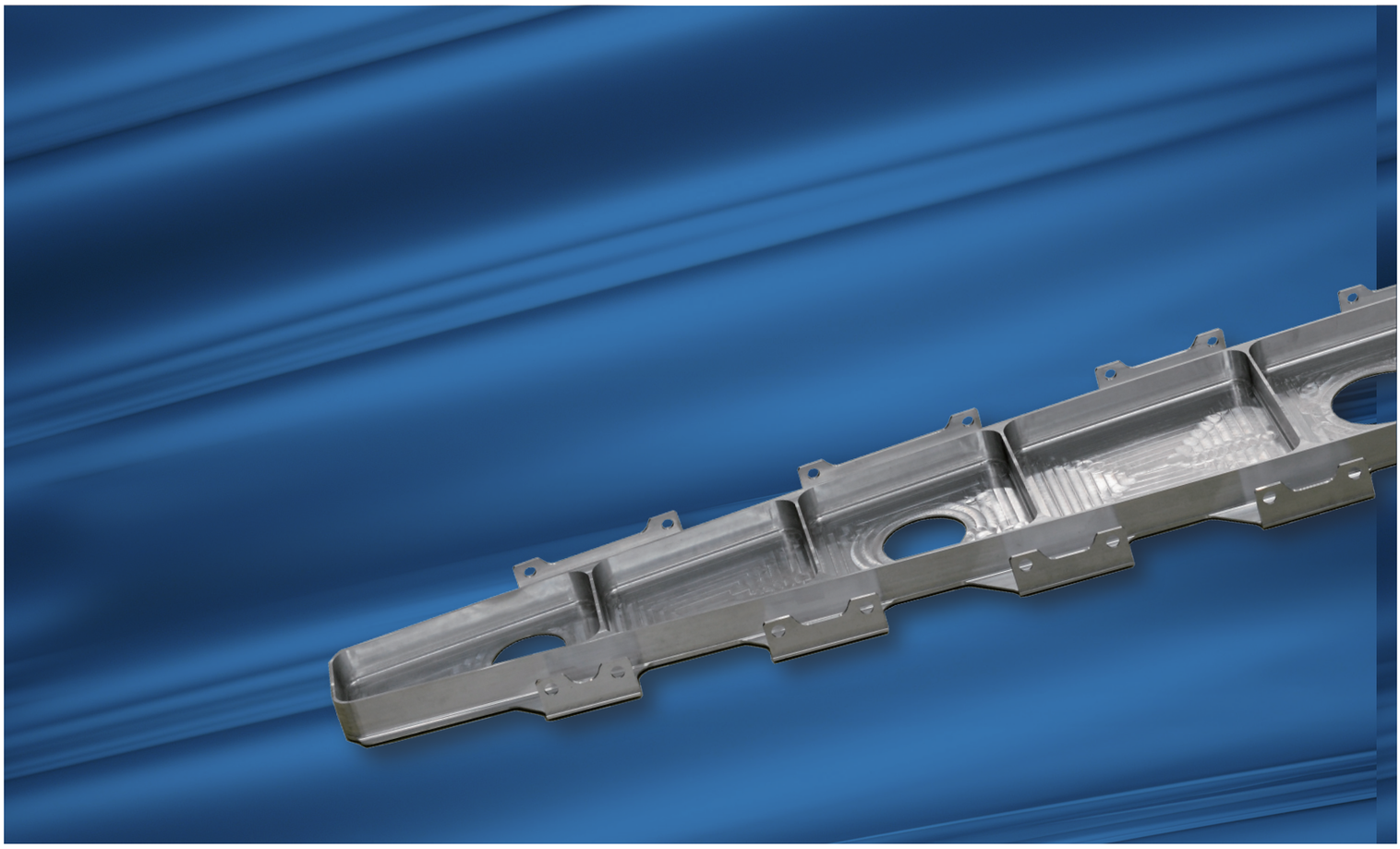
六角螺母螺纹接口式铰刀

PCD Brazed Countersink

PCD焊接刃沉孔加工刀具

Structural Parts 结构件

Aluminum Parts 铝合金部件



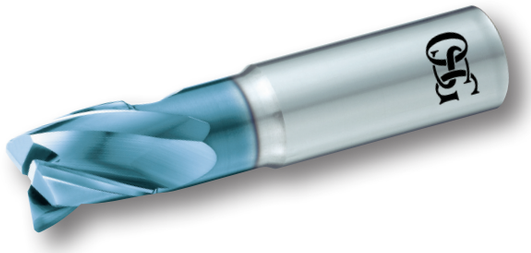
Incredible chip removal rate
难以想象的金属去除率

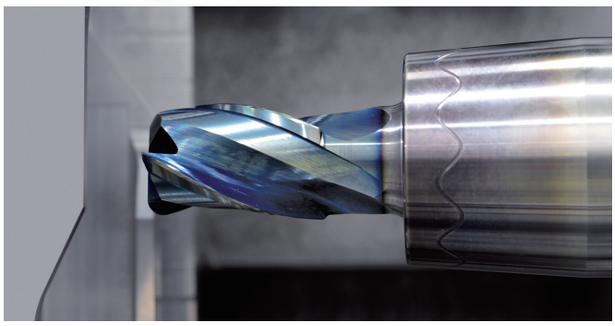
AERO-ETS

Short Flute Rougher

3FL Carbide End Mill with Corner Radius and Short Length of Cut
三刃硬质合金圆弧角立铣刀

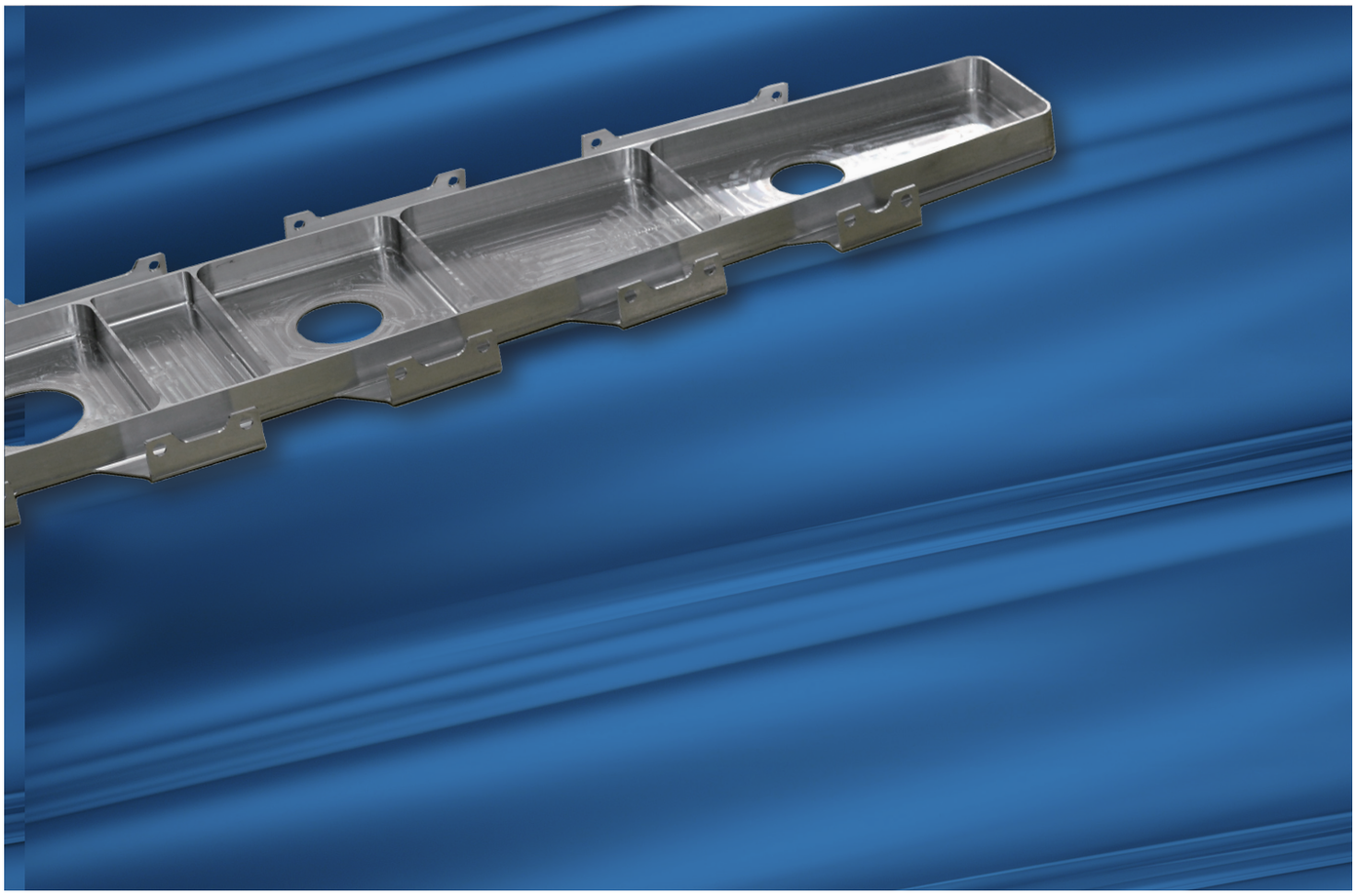
Tool 使用工具	ϕ25 x R4 3FL 3刃
Work Material 切削材质	A7075
Cutting Speed 切削速度	2,591m/min (33,000min^{-1})
Feed Rate 进给速度	29,700mm/min (0.3mm/t)
Depth of Cut 切深量	ap=10mm ae=25mm
Coolant 切削油剂	Water-Soluble 水溶性切削油剂
Holder 刀柄类型	Shrink Holder 热缩刀柄
Spindle Power 主轴输出功率	120kW
M.R.R. 金属材料去除量	7,425cm^3/min





M.R.R. over 7,000cm^3/min is achieved by spindle power of 100kW or more.

高功率主轴设备(100kW以上)在进行粗加工时，可实现7,000cm3/min以上的金属去除率。



Long Length of Cut ≠ Chattering
长刃≠振动

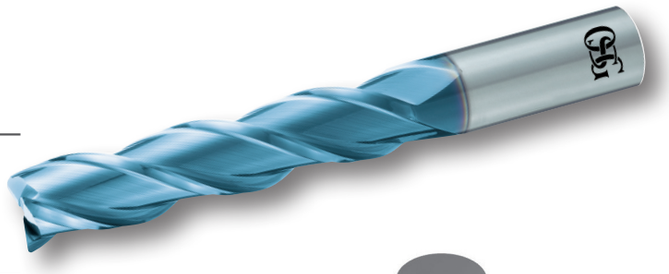
AERO-EXTL

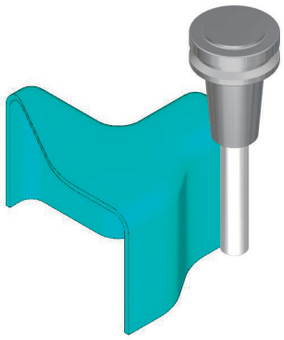
Long Flute Wall Finisher

3FL Carbide End Mill with Corner Radius and Long Length of Cut

三刃硬质合金圆弧角立铣刀（长刃）

Size 尺寸	φ20 x R1 3FL 3刃
Work Material 切削材质	A7075
Cutting Speed 切削速度	817m/min（13,000min^{-1}）
Feed Rate 进给速度	5,850mm/min（0.15mm/t）
Depth of Cut 切深量	ap=87.5mm ae=0.2mm
Coolant 切削油剂	Water-Soluble 水溶性切削油剂
Machine 使用机械	Vertical Machining Center 立式加工中心
Spindle Power 主轴功率	15kW

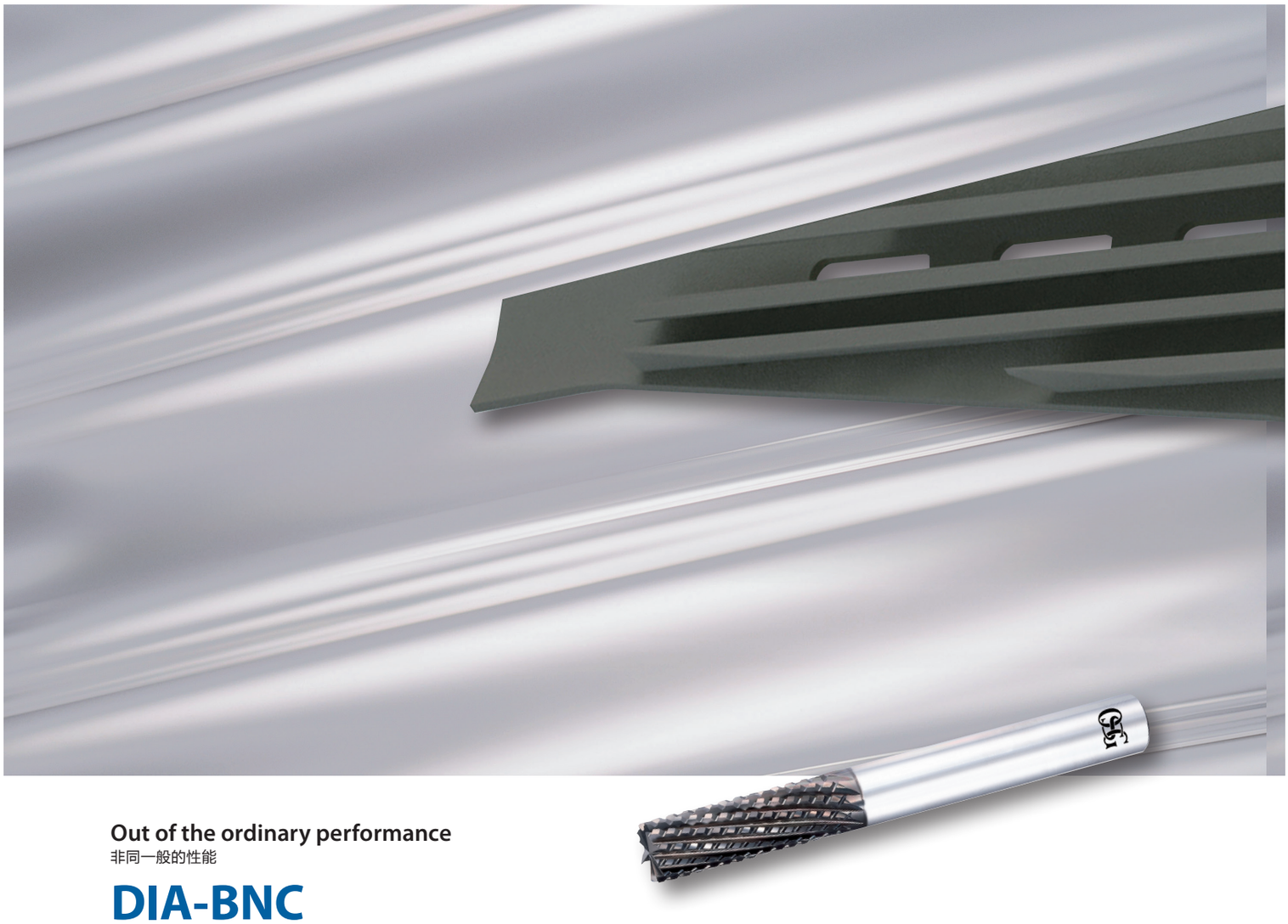




With prevention of chattering, high efficiency side milling is achieved in one-shot milling.

出色的防振性能，实现高效一次式走刀的侧面铣削。

CFRP Parts 复合材料加工部件



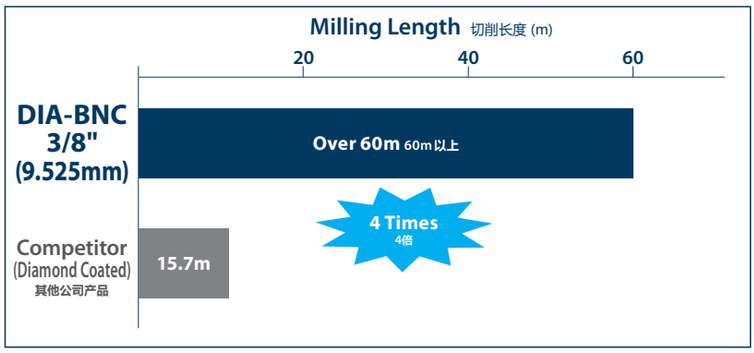
Out of the ordinary performance
非同一般的性能

DIA-BNC

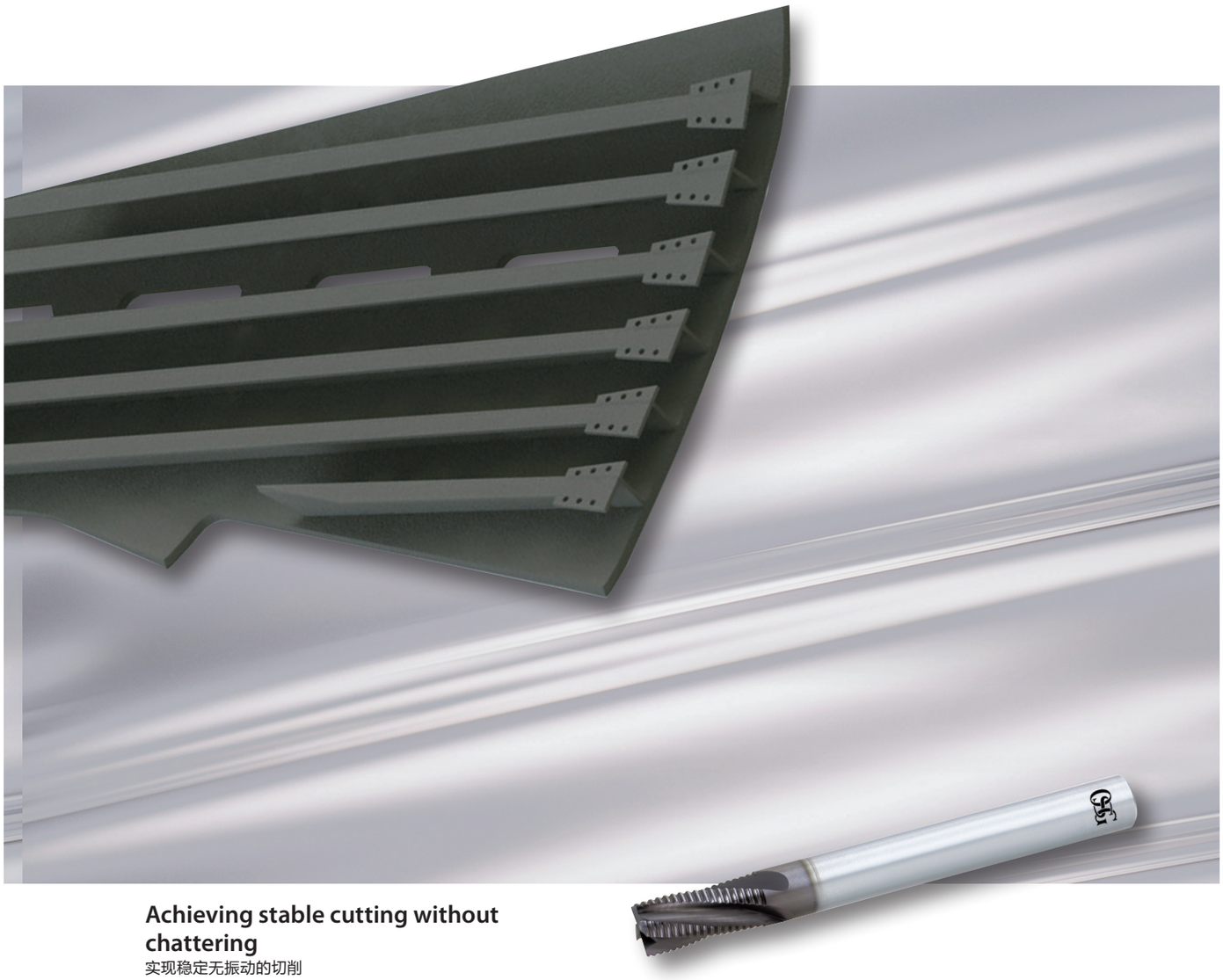
Nick Rougher

Diamond Coated Fine Nick Router
金刚石涂层细菱齿铣刀

■ Comparison of Durability 耐久比较



DIA-BNC was able to achieve 4 times the durability versus the competitor.
DIA-BNC 可以实现其他公司产品约4倍的耐久性。

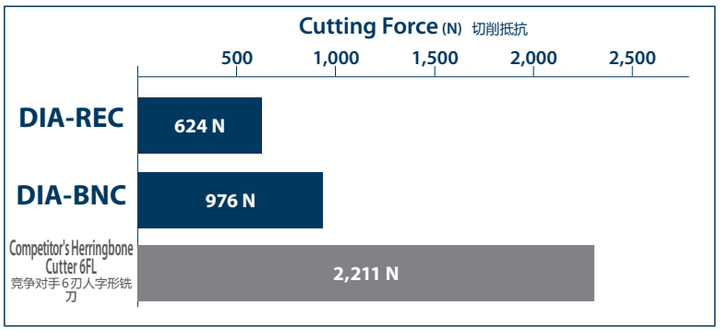


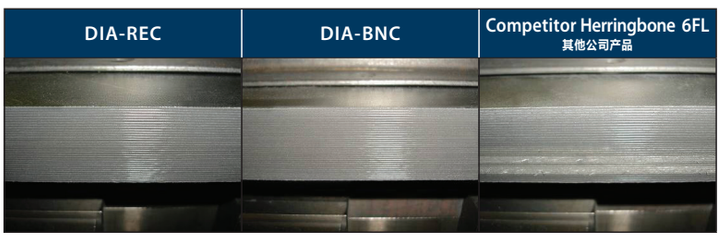
Achieving stable cutting without chattering
实现稳定无振动的切削

DIA-REC

Roughing Rougher
Diamond Coated Roughing Router
金刚石涂层粗加工铣刀

Tool 使用工具	DIA-REC	DIA-BNC	Competitor 其他公司
Tool Dia 工具径	ϕ10		
Work Material 切削材质	CFRP		
Cutting Speed 切削速度	200m/min (6,400min^{-1})		
Feed Rate 进给速度	400mm/min (0.063mm/rev)		
Depth of Cut 切深量	ap=25.4mm ae=10mm		
Coolant 切削油剂	Dry 干式加工		
Machine 使用机械	Vertical Machining Center 立式加工中心		





By reducing the cutting force, stable milling even under low rigidity is achieved.
由于切削抵抗较低，在低刚性加工环境下也实现稳定加工

Titanium Parts 钛合金部品

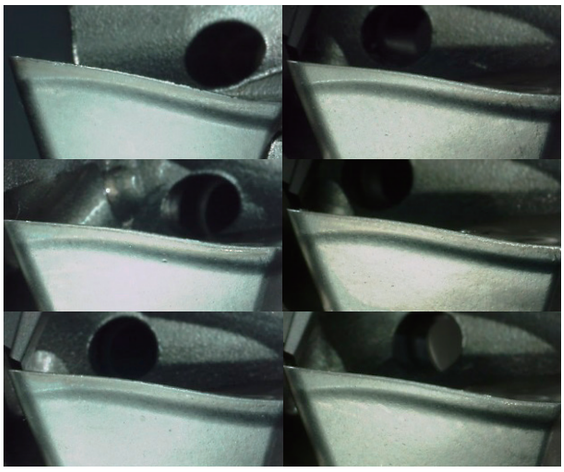
Strong cutter body and insert
强力刀柄及刀片

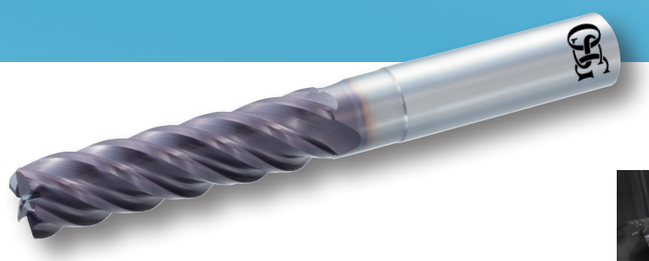
PSEL + XC5040

OSG Phoenix Roughing End Mill
OSG Phoenix 粗加工铣刀

Tool 使用工具	ϕ50 5FL (Special) 非标品
Insert (grade) 刀片型号(材质)	ZDKT11T308ER-SM (XC5040)
Work Material 切削材质	Ti-6Al-4V AMS4911
Cutting Speed 切削速度	40m/min (255min^{-1})
Feed Rate 进给率	128mm/min (0.1mm/t)
Depth of Cut 切深量	ap=20mm ae=46mm
M.R.R. 金属去除率	118cm^3/min
Coolant 切削油剂	Water-Soluble 水溶性切削油剂
Machine 使用机械	5-axis Machining Center (HSK-A100) 五轴加工中心

■After Milling 1.5 hours 1.5小时加工后

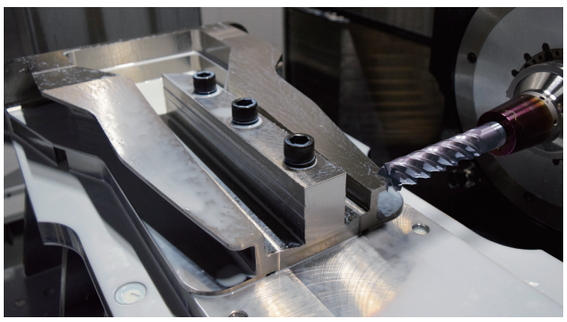




High efficiency roughing and finishing with one tool
一把刀具实现高效率粗加工及精加工

UVXL-TI-5FL

Variable Lead End Mill Long Type for Titanium Alloy (5FL)
五刃钛合金加工用不等导程长柄型



■ Roughing → Finishing 粗—精加工

Tool 使用工具	ϕ20× R3	
Process 加工	Roughing 粗	Finishing 精
Work Material 切削材质	Ti-6Al-4V AMS4911	
Cutting Speed 切削速度	100m/min (1,592min^{-1})	80m/min (1,274min^{-1})
Feed Rate 进给率	796mm/min (0.1mm/t)	510mm/min (0.08mm/t)
Depth of Cut 切深量	ap=78mm ae=2mm	ap=78mm ae=0.1mm
M.R.R. 金属去除率	124cm^3/min	4cm^3/min
Coolant 切削油剂	Water-Soluble 水溶性切削油剂	
Machine 使用机械	5-axis Machining Center (HSK-A100) 五轴加工中心	

■ Finishing 精加工

Tool 使用工具	ϕ25× R3
Process 加工	Finishing 精加工
Work Material 切削材质	Ti-6Al-4V AMS4911
Cutting Speed 切削速度	80m/min (1,019min^{-1})
Feed Rate 进给率	408mm/min (0.08mm/t)
Depth of Cut 切深量	ap=98mm ae=0.1mm
M.R.R. 金属去除率	4cm^3/min
Coolant 切削油剂	Water-Soluble 水溶性切削油剂
Machine 使用机械	5-axis Machining Center (HSK-A100) 五轴加工中心

OSG - HAIMER

New Tool & Holder Combo

UVX-TI + Safe-Lock™ 新的提案

■ Features of Safe-Lock™ system
系统的特点

- High runout accuracy (less than 3 μm)
- Adjustable overhang length
- Easy removal of broken tools
- Internal coolant supply capability from the holder
- Also suitable for high speed steel tools

· 高跳动精度(小于3μm)
· 可以调整工具的悬长
· 方便取出折损的刀具
· 可实现刀柄内部给油
· 适用于高速钢刀具

The key to stability in high performance machining
确保高效率加工下的加工安全

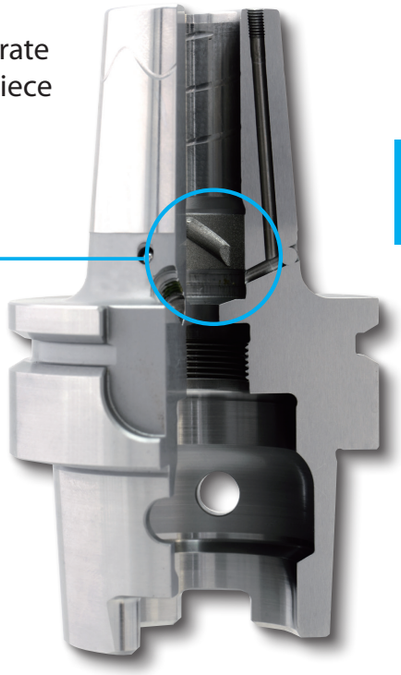
Special grooves in the tool shank
工具柄部的特殊沟槽

UVXL-TI-5FL

■ On the safe side with Safe-Lock™
这样的时候 Safe-Lock ™可以满足您的需求

- No pull-out of the tool
- Achieves maximum chip removal rate
- No damages on expensive work piece
- Ideal for large diameter milling

· 加工中工具脱落的时候
· 想提高加工效率的时候
· 不想让昂贵的工件出现加工不良的时候
· 大直径加工的场合



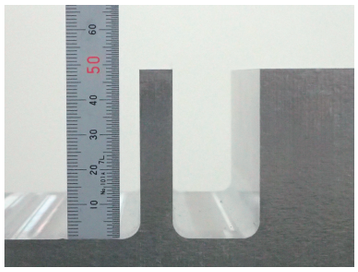
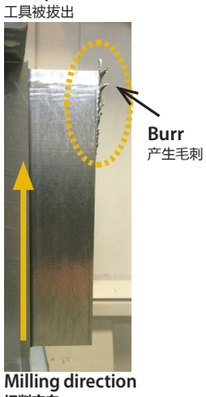
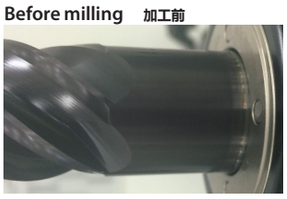
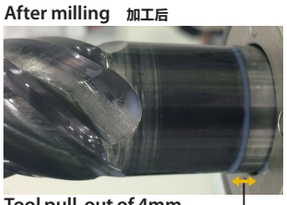
Form closed drive keys in the holder
刀柄上的轴向卡销

SAFE-λOCK®
by HAIMER

Safe-Lock is a registered trademark of the Haimer GmbH.
SAFE-λOCK 是 Haimer 公司的注册商标

High efficiency milling of Ti-6Al-4V with Safe-Lock™ power shrink chuck

Safe-Lock™ 强力热缩夹头 钛合金加工高效率加工

Holder 使用刀柄	**Safe-Lock™ Power Shrink Chuck** Safe-Lock™强力热缩夹头	**Milling Chuck** 铣夹头
Tool 使用工具	UVX-TI-5FL　ϕ25×R3×75-SL	UVX-TI-5FL　ϕ25×R3×75
Work Material 切削材质	Ti-6Al-4V AMS4911	
Milling Method 加工方法	**Slotting** 槽加工	**Side Milling** 侧面加工
Cutting Speed 切削速度	50m/min (637min^{-1})	
Feed Rate 进给率	255mm/min (0.08mm/t)	
Depth of Cut 切深量	ap=48mm　ae=25mm	ap=48mm　ae=12.5mm
Coolant 切削油剂	**Water-Soluble** 水溶性切削油剂	
Machine 使用机械	**Horizontal Machining Center (BT50)** 卧式加工中心	
M.R.R. 金属去除率	306cm^3/min	153cm^3/min
Result 结果	**No tool pull-out** 工具不会被拉拔出 	**Tool pull-out** 工具被拔出  **Burr** 产生毛刺 **Milling direction** 切削方向 **Before milling**　加工前  **After milling**　加工后  **Tool pull-out of 4mm** 工具被拔出4mm

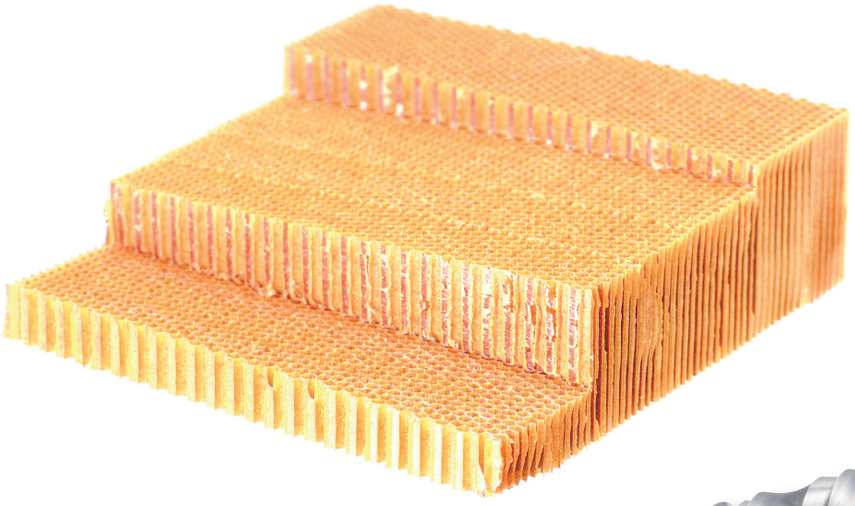
Safe-Lock ™ Power Shrink Chuck

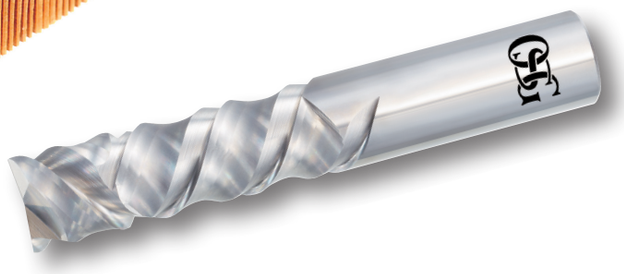
Safe-Lock ™ 系统强力热缩夹头

Tool pull-out occurred with the milling chuck holder under the above cutting condition. The tool paired with the Safe-Lock™ system, on the other hand, encountered no such issue and could be use for deep slotting of ap=48mm.

在以上的切削条件下，铣夹头的工具被拉拔出，而刀具装夹在Safe-Lock™系统上的并没有发生这样的问题，即使ap=48mm的深槽加工也能对应。

Honeycomb Parts 蜂窝零件

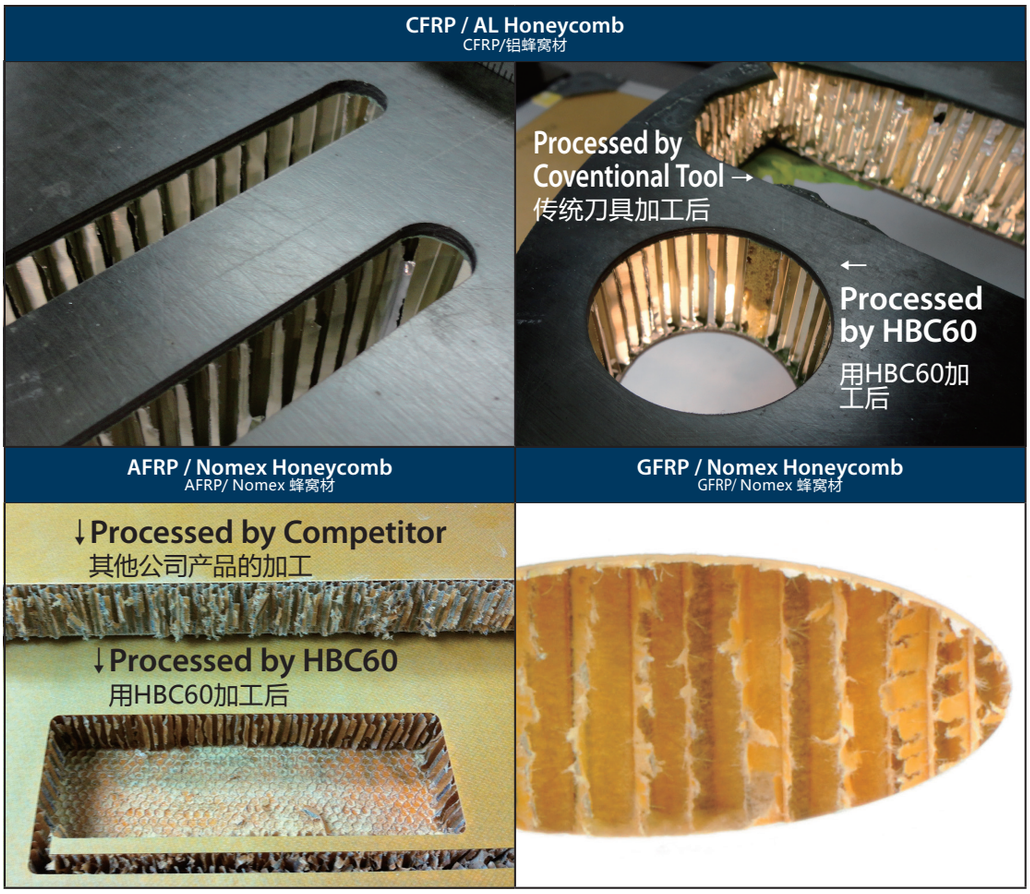




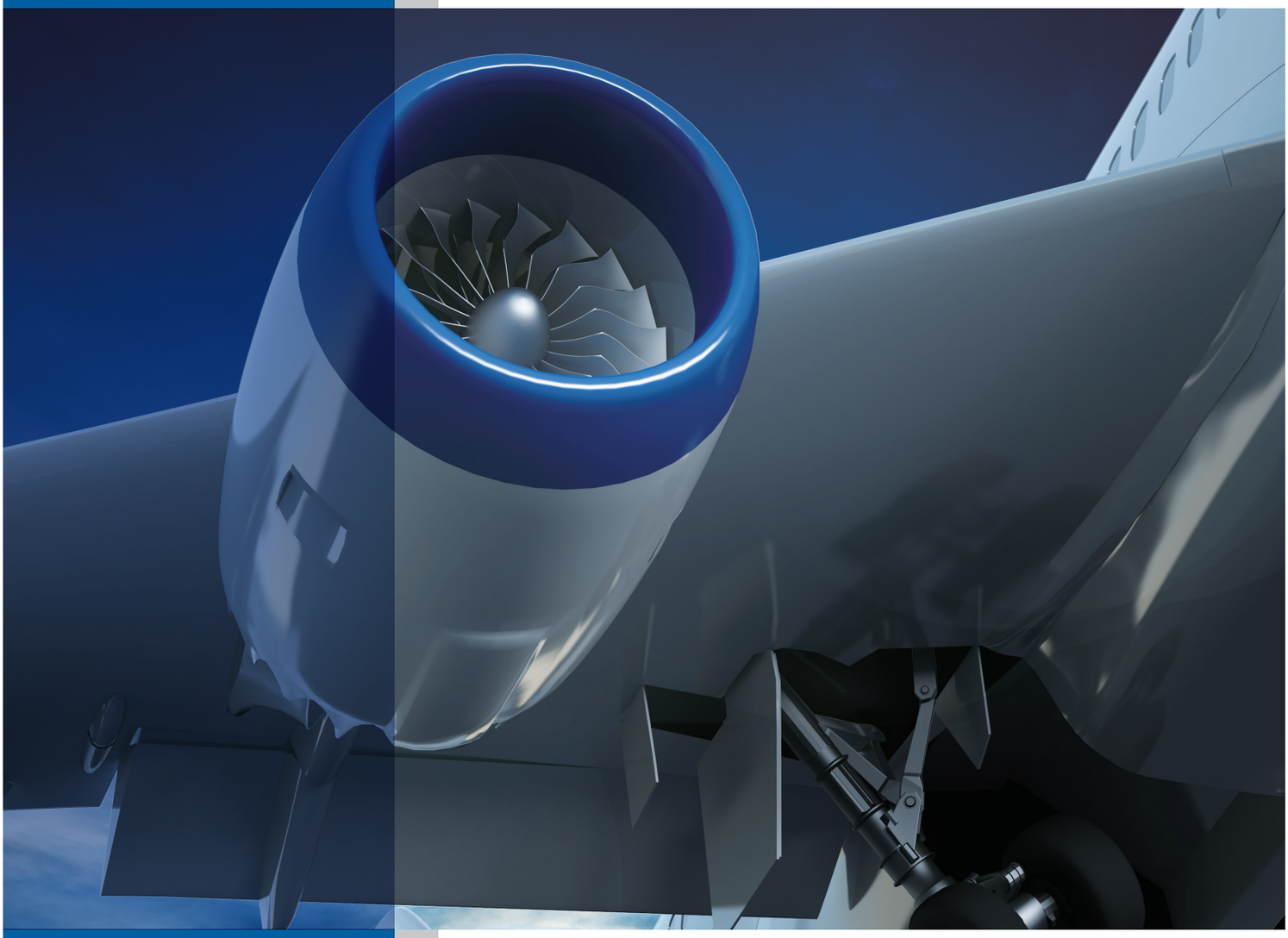
Evolved sharp cutting edges
进化型切削刃

HBC60

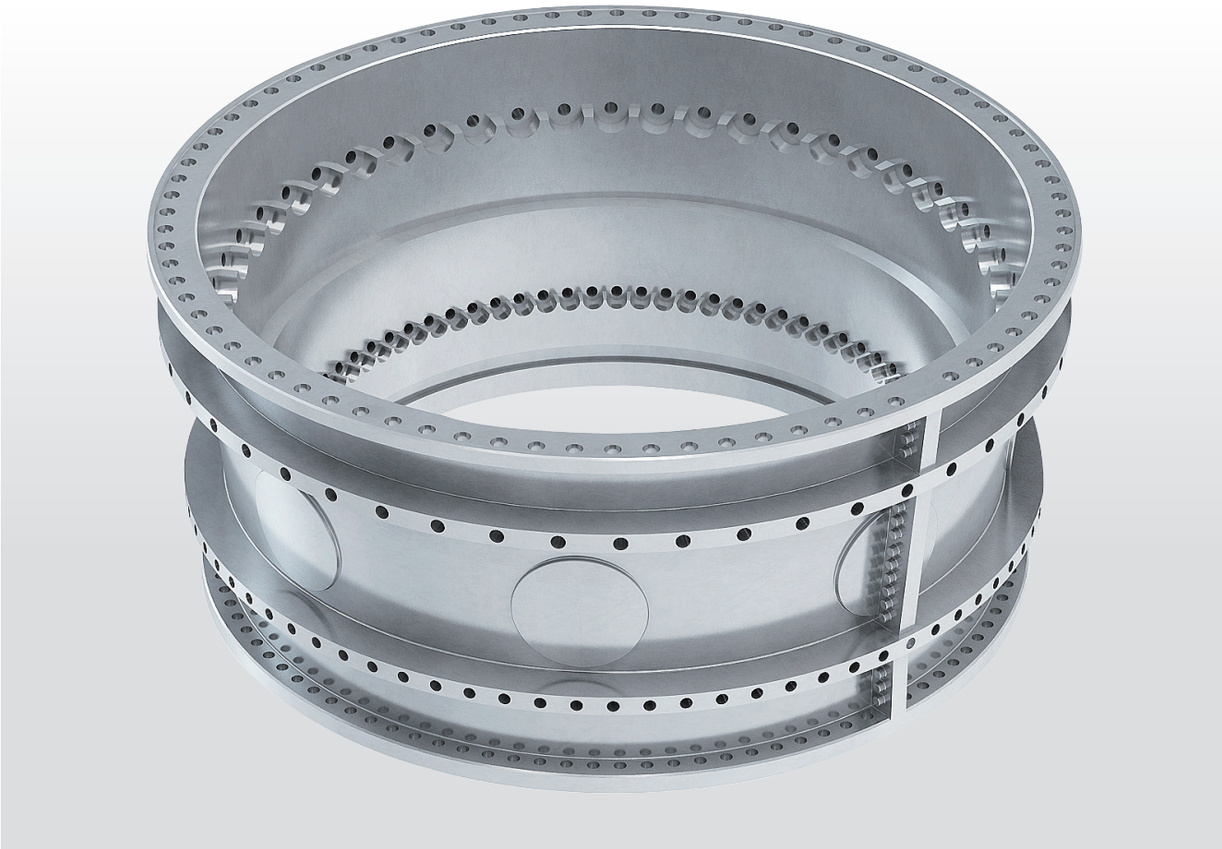
60 Degree Helix Compression Router
60度螺旋角挤压切削铣刀

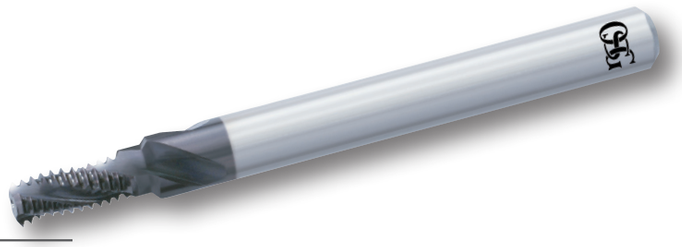


Engine 发动机



Drilling & Threading 孔 · 螺纹加工



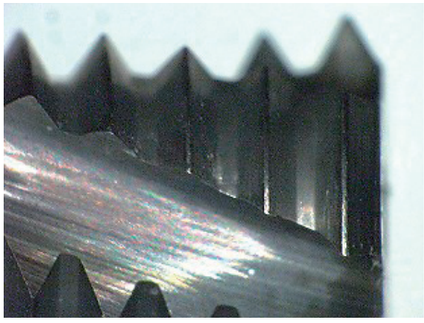


Guaranteed reliability
安心的加工

WX-PNC

Thread Mill for Non-ferrous Metal and Heat-Resistant Alloy
非铁 · 耐热合金用螺纹铣刀

Tool 使用工具	4.55×10 U28
Work Material 切削材质	Waspaloy
Cutting Speed 切削速度	20m/min (255min^{-1})
Feed Rate 进给速度	128mm/min (0.06mm/t)
Internal Thread Size 内螺纹尺寸	¼-28UNF for Helicoil/EG/STI 嵌套螺纹用
Tapping Length 螺纹长度	7.8mm
Drill Hole Size 下孔径尺寸	ϕ6.6
Coolant 切削油剂	Water-Soluble 水溶性切削油剂
Machine 使用机械	Horizontal Machining Center (BT40) 卧式加工中心

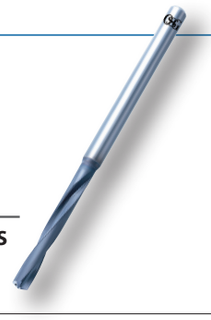


Gauge out after cutting 72 holes, but no chipping was found.
加工72孔后检测，通规不过。但是刃尖没有看到磨损。

Outstanding stability
超群的安定感

WHO55-3D

Coolant-Through Carbide Drills for High Hardness Steels
高硬度钢用内冷油孔钻头

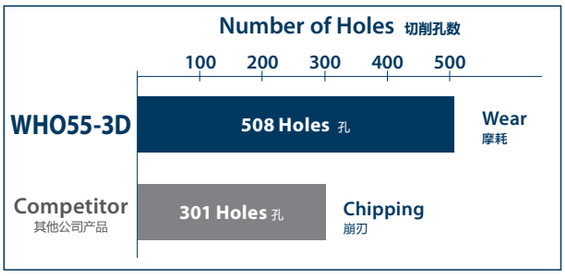


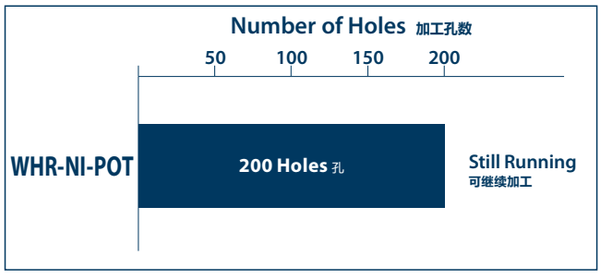
Exceptional productivity
令人叹服的加工孔数

WHR-NI-POT

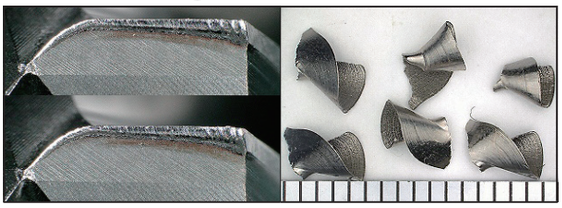
Spiral Point Tap for Ni-based Superalloy
Ni基超耐热合金用刃倾角丝锥

Tool 使用工具	ϕ7 (Special) 非标品	5/16-24UNJF (Special) 非标品
Work Material 切削材质	Inconel®718 (45HRC) 718	
Cutting Speed 切削速度	30m/min (1,364min^{-1})	3m/min (min^{-1})
Feed Rate 进给率	143mm/min (0.105mm/rev)	—
Hole Size 孔径	ϕ7×18mm, (Through), No Pecking 通孔 无停顿式	
Coolant 切削油剂	Water-Soluble (10%) 水溶性切削油剂	
Machine 使用机械	Horizontal Machining Center (BT40) 卧式加工中心	

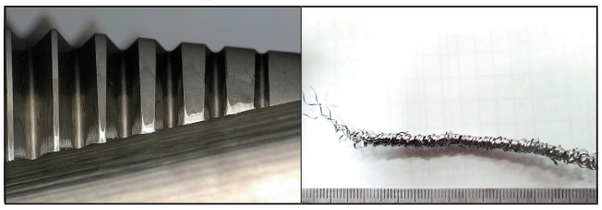


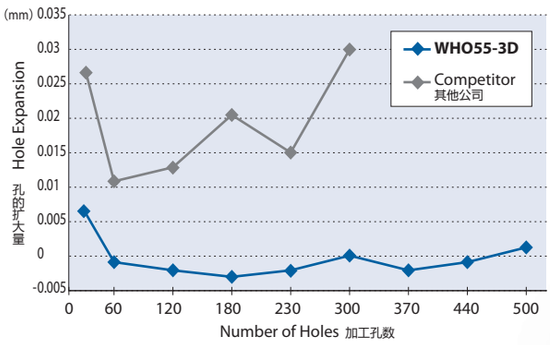


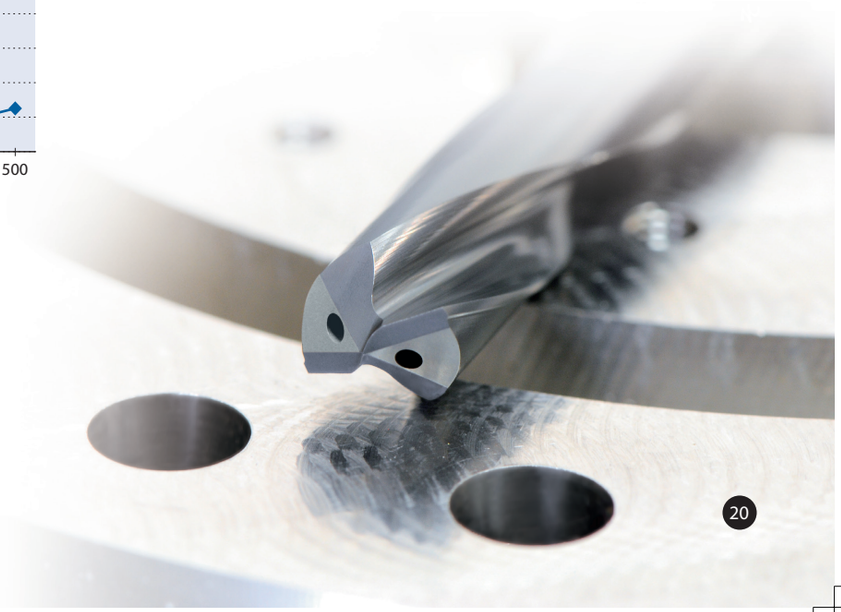
■ After Drilling 508 Holes 508 孔加工后



■ After Tapping 200 Holes 200 孔加工后







Milling 铣削

Best combination
最佳组合

PRC + XC5040

OSG Phoenix Radius Cutter
OSG Phoenix 圆弧铣刀

Tool 使用工具	PRC12R050M22-5 (ϕ50×6FL)
Insert (grade) 刀片类型(材质)	RPHT1204M8EN-SM (XC5040)
Work Material 切削材质	Inconel® 718
Cutting Speed 切削速度	30m/min (191min^{-1})
Feed Rate 进给率	172mm/min (0.18mm/t)
Depth of Cut 切深量	ap=Max6mm ae=22mm
Coolant 切削油剂	Non-Water-Soluble 非水溶性切削油剂
Machine 使用机械	Horizontal Machining Center (BT50) 卧式加工中心

Long lasting end mill
令人叹服的耐久性

UVX-NI-5FL

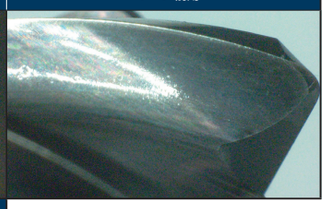
Multiple Length, 5 Flutes Corner Radius End Mill for Ni-based Superalloy
5刃 Ni 基超耐热合金加工用不等导程铣刀

Tool 使用工具	ϕ12× R1 5FL (Special) 非标品
Work Material 切削材质	Inconel® 718
Cutting Speed 切削速度	30m/min (800min^{-1})
Feed Rate 进给率	110mm/min (0.027mm/t)
Machining Time 加工时间	1.5 hours 1.5小时
Depth of Cut 切深量	ap=5mm ae=12mm
Coolant 切削油剂	Non-Water-Soluble 非水溶性切削油剂
Machine 使用机械	Horizontal Machining Center (BT50) 卧式加工中心

■ After Milling 1.5 hours 1.5小时加工后

Peripheral Cutting Edge 外周刃

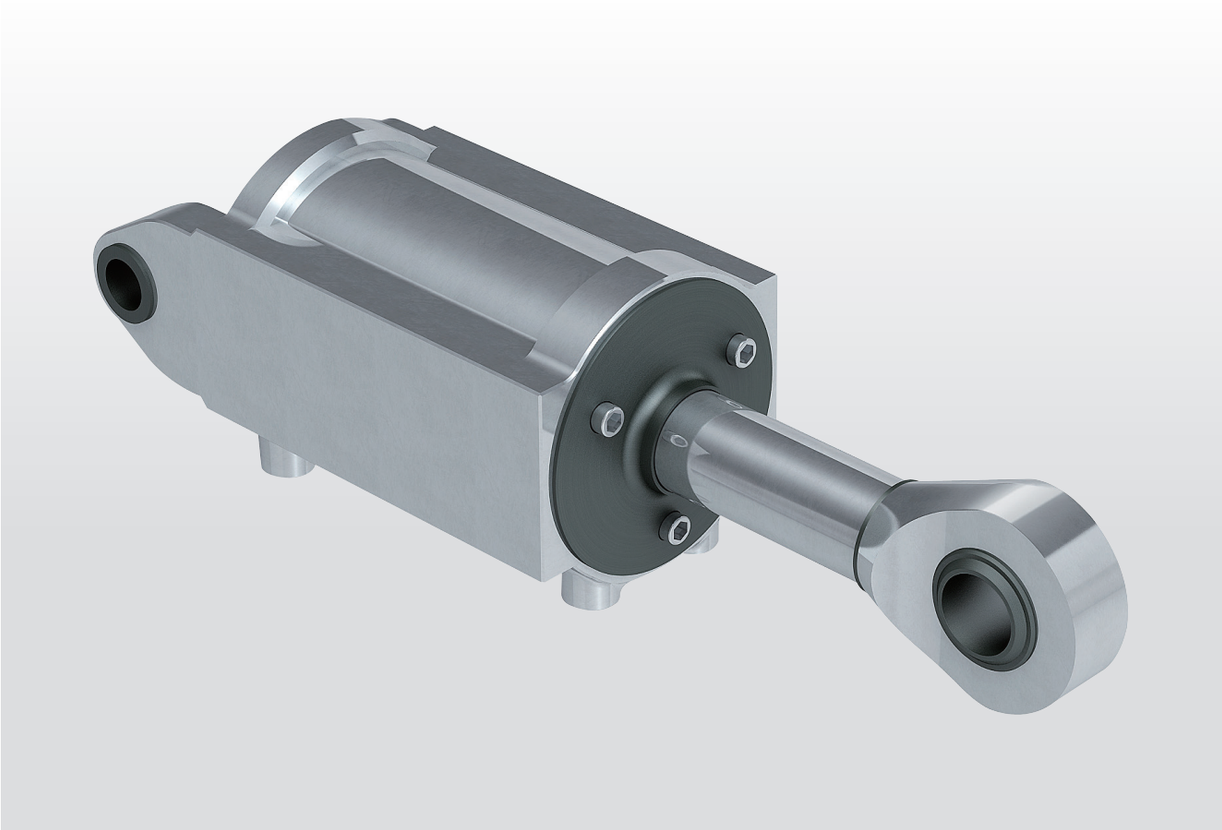
Rake 前角



End Tooth 底刃

Other Parts 其他零部件

Actuator 作动筒



Long lasting end mill
令人叹服的耐久性

UVX-NI-5FL

Multiple Length, 5 Flutes Corner Radius End Mill for Ni-based Superalloy
5刃Ni超耐热合金加工用不等导程铣刀

Tool 使用工具	ϕ20×R1 5FL (Special) 非标品
Work Material 切削材质	15-5PH H1025 40HRC / AMS5659
Cutting Speed 切削速度	56.5m/min (900min^{-1})
Feed Rate 进给率	275mm/min (0.061mm/t)
Depth of Cut 切深量	ap=10mm ae=20mm
Overhang Length 悬长	64mm (3.2D)
Coolant 切削油剂	Water-Soluble 水溶性切削油剂
Holder 刀柄类型	Shrink Holder 热缩刀柄
Machine 使用机械	Horizontal Machining Center (BT50) 卧式加工中心

■ After Milling 10.5m 10.5m加工后

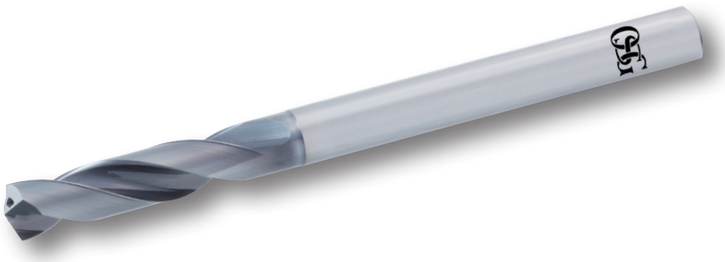
	Max. Wear 最大损伤部	Corner 角
Flank 后角面		
Rake 前角		

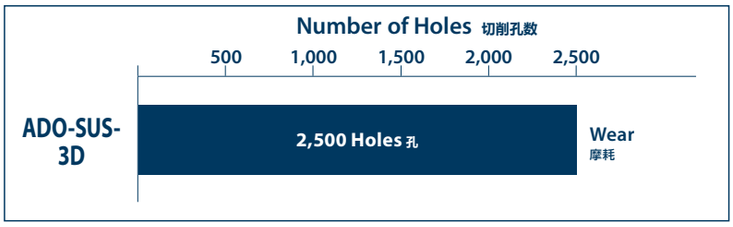
Incredible coolant supply
惊人的给油量

ADO-SUS-3D

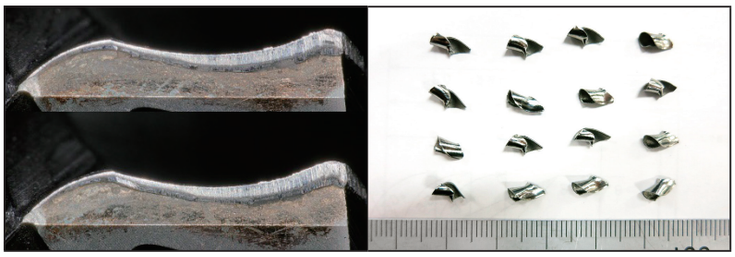
Coolant-Through Carbide Drill Series for Stainless Steels and Titanium Alloy
不锈钢，钛合金加工用钻头

Tool 使用工具	ϕ8
Work Material 切削材质	15-5PH H1025 40HRC / AMS5659
Cutting Speed 切削速度	70m/min (2,785min^{-1})
Feed Rate 进给率	668mm/min (0.24mm/rev)
Depth of Hole 孔深	24m (Blind) No Pecking 盲孔 无停顿式
Coolant 切削油剂	Internal Water-Soluble 水溶性切削油剂（内部给油）
Machine 使用机械	Horizontal Machining Center (BT40) 卧式





■ After Drilling 2,500 Holes 2,500孔加工后

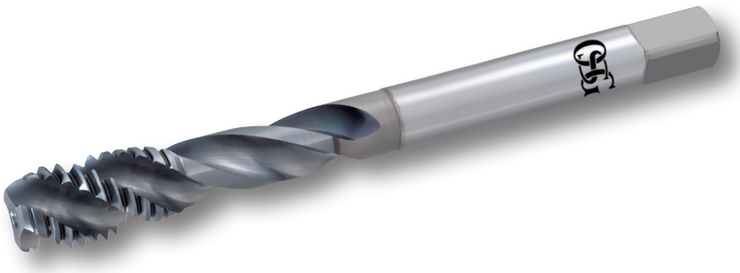


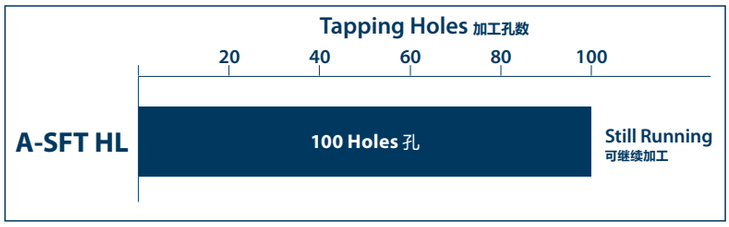
A-Tap also works well in 15-5PH
适用于加工15-5PH的A 丝锥

A-SFT HL

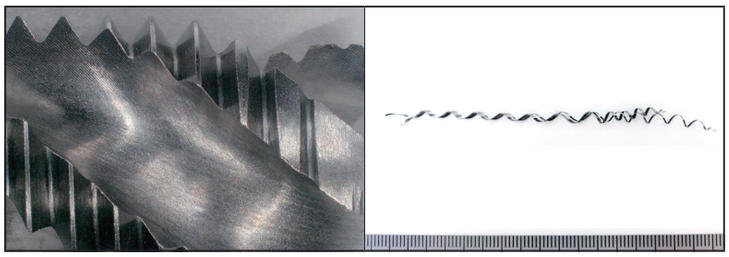
High Efficienty Multi-Purpose Tap Series for Helicoil/EG/STI
高效率，高通用性丝锥系列（嵌套螺纹用）

Tool 使用工具	No.10-32UNF
Work Material 切削材质	15-5PH H1025 40HRC / AMS5659
Drill Hole Size 下孔径尺寸尺寸	ϕ5×16mm (Blind) 盲孔
Tapping Length 螺纹长度	10mm
Cutting Speed 切削速度	5m/min (275min^{-1})
Coolant 切削油剂	Water-Soluble Chlorine-Free (10%) 无氯 10倍
Machine 使用机械	Vertical Synchronized Machining Center 立式加工中心（带同步进给）

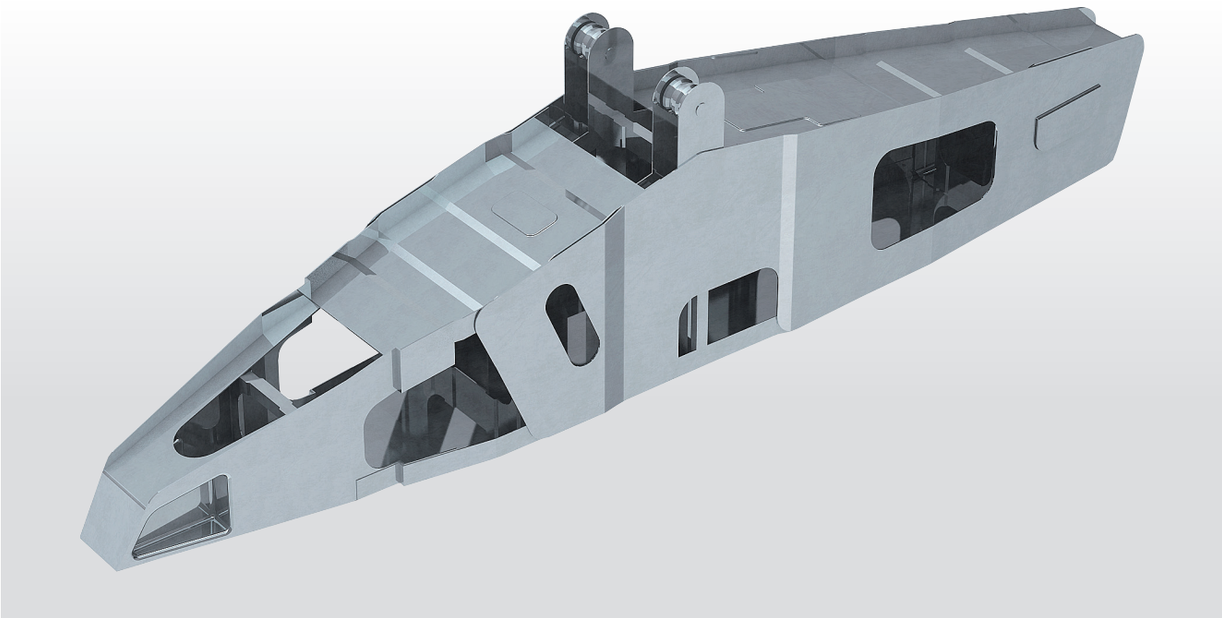




■ Cutting Edge After Tapping 100 Holes 100孔加工后



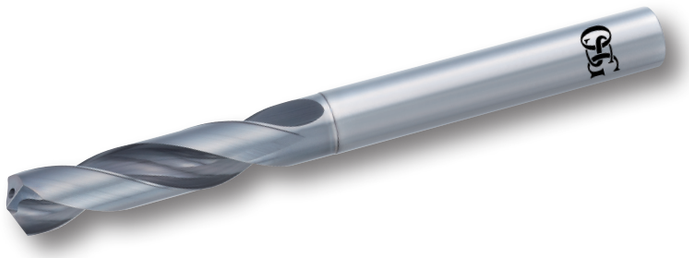
Pylon 机身挂架



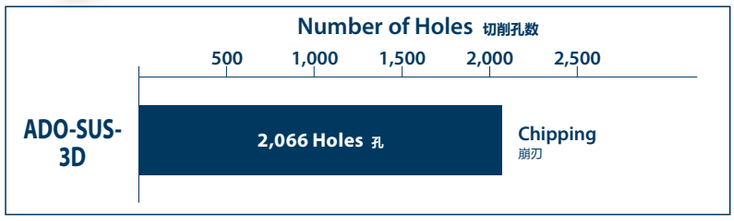
ADO-SUS also works well in Titanium alloy
适用于钛合金加工的ADO-SUS

ADO-SUS-3D

Coolant-Through Carbide Drill Series for Stainless Steels and Titanium Alloy
不锈钢 钛合金用钻头

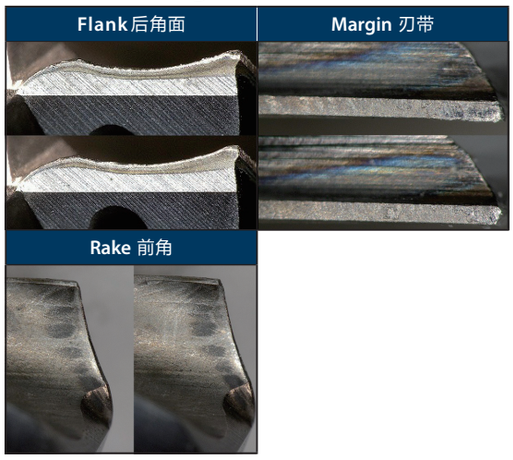


Tool 使用工具	ϕ5.1
Work Material 切削材质	Ti-6Al-4V
Cutting Speed 切削速度	40m/min (2,500min^{-1})
Feed Rate 进给率	300mm/min (0.12mm/rev)
Depth of Cut 孔深	17mm (Through) 通孔
Coolant 切削油剂	Internal Water-Soluble 水溶性切削油剂(内部给油)
Machine 使用机械	Vertical Machining Center (BT30) 立式加工中心



Cutting Chips Shapes 切りくず形状

■After Drilling 1,200 Holes 1,200孔加工后



Landing Gear 起落架

Strong cutter body and insert
强韧的刀体及刀片

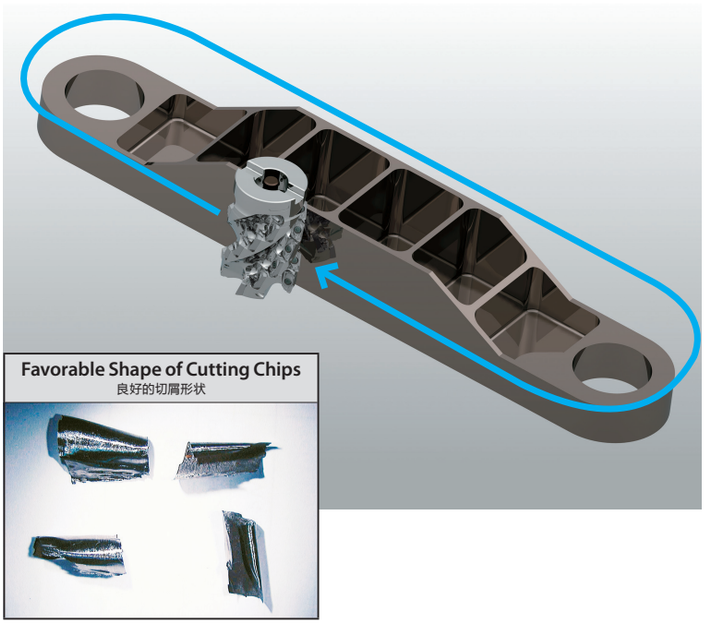
PSEL + XC5040

OSG Phoenix Roughing End Mill
OSG Phoenix 粗加工铣刀

Tool 使用工具	15R063M27-3-50（ϕ63×3FL）刃	Competitor（ϕ63×4FL）其他公司 刃
Insert（grade）刀片类型（材质）	ZDKT150508ER-SM (XC5040)	Coated Carbide Insert 硬质合金涂层刀片
Work Material 切削材质	Ti-6Al-4V (35HRC)	
Cutting Speed 切削速度	50m/min (250min^{-1})	
Feed Rate 进给率	150mm/min (0.2mm/t)	150mm/min (0.15mm/t)
Depth of Cut 切深量	ap=21- 45mm ae=7.5 - 25mm	
Coolant 切削油剂	Water-Soluble 水溶性切削油剂	
Overhang Length 悬长	300mm	
Machine 使用机械	Horizontal Machining Center（HSK100A）卧式加工中心	

The PSEL achieved 3 times longer tool life (3 workpieces and welding wear after 276 mins) than the competitor tool (1 workpiece and chipping after 92 mins). Moreover, the PSEL was able to maintain consistent chip shape and minimize the risk of sudden chipping.

PSEL加工3个工件（276分后出现熔接磨损，其他公司产品加工1个工件（92分后出现熔接磨损），PSEL达到了其他公司产品3倍的工具寿命。并且，PESL可以保持良好的切屑形状，减少突然崩刃情况的发生。



shaping your dreams

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OSG Corporation

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