

CER-2TL铣刀 样品

产品名称	CER-2TL铣刀 样品
公司名称	中山市盈易贸易有限公司
价格	80.00/支
规格参数	样品或现货:样品 是否标准件:标准件 标准编号:多款
公司地址	中山市小榄镇小榄大道南66号首层
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产品详情

样品或现货	样品	是否标准件	标准件
标准编号	多款	品牌	多款供选
型号	多款供选	材质	钨钢
类型	端铣刀	规格	多款
是否进口	是	是否涂层	涂层
适用机床	其他	是否库存	非库存
是否批发	非批发		

2刃超微粒子全钨钢r角端铣，35度

订购指南 精工细琢 专业品牌									
wa	46	k	5	v	5	a	350x40x127		
磨料	粒度	结合剂	组织号	制法	形状	缘形	尺寸(dtxh)		
磨料粒度:							grit		
精度是用来表示磨料颗粒几何尺寸的大小,其选择							grit is designated to represent the geometrical size of		
依据主要是加工工件所需要的表面粗糙度,同时也需							abrasive grain.the grit size is chosen for customer"s		
考虑其他一些因素.以外圆磨为例,常用粒度与表面							required surface finish as well as other conditions.for		
粗糙度有下面的大致关系:							example,in cylindricai grinding,there is relationship		
							between grit and surface finishes listed as bellow;		
粒度	36-46	54-60	70-80	90-100	grit				
粗糙度	ra 1.6	ra 0.8	ra 0.4	ra 0.2	finish	ra 1.6	ra 0.8	ra 0.4	ra 0.2

粗料度的磨料适用于磨削:	use coarse grit:
1) 材质较软, 延伸率大以及类似软铁和有色金属等材料	1. for soft, ductile, stringy material such as soft steel and nonferrous material
2) 进给量大, 磨削速度要求高的场合.	2. for rapid stock removal, high grinding speed
3) 表面粗糙度要求不高的场合.	3. where finish is not important
4) 磨削接触面大的场合.	4. for large areas of contact
细粒度的磨料适用于磨削:	use fine grit:
1) 硬度较高以及类似高碳工具钢, 硬质合金类的金属材料 and 玻璃等脆性材料.	1. for hard, brittle materials such as hard tool steels, cemented carbide and glass.
2) 表面粗糙度及精度要求高的场合.	2. for fine finishes
3) 磨削接触面小的场合.	3. for small areas of contact
4) 工件半径或弧度小的场合.	4. for holding small corner radii
硬度: e f g h i j k l m n o p q r 软-----硬	grade: e f g h i j k l m n o p q r soft-----hard
砂轮的硬度是指磨料之间的结合度, 砂轮中结合剂量的多少决定了砂轮的硬度大小. 用户需根据具体的磨削(如进刀量, 粗糙度, 材质)要求来灵活选择砂轮的硬度	the grade indicates the relative holding power of the bond which holds abrasive grains in a wheel. In general, with a given type of bond it is the amount of bond which determines a wheel's should select the grade of a wheel
一般砂轮硬度选择的原则是:	based on the grinding parameters such as feed rate, finish requirements, materials i.e..the following rules should be followed with regard to grade
较软的硬度	use soft grade:
1) 进刀量大的粗磨.	1. for rapid stock removal
2) 磨削接触面大的场合.	2. for large areas of contact
3) 材质较硬的工件, 如高硬度工具钢和硬质合金钢等.	3. for hard materials such as hard tool steels and carbide.
4) 工件抗热性能差, 严防表面烧伤和磨削.	4. for heat sensitive workpieces and grinding can not have burning and discoloration on surface
较硬的硬度	use hard grade:
1) 进刀量小的精磨.	1. for fine finish with little feed
2) 延长砂轮寿命.	2. for longer wheel life
3) 材质较软的工件.	3. for soft materials
4) 磨削接触面小或窄的场合.	4. for small or narrow areas of contact
组织号: 5 6 7 8 9 10 11 12 13 密-----疏	structure: 5 6 7 8 9 10 11 12 13 close-----open
组织号用以表示砂轮内相邻的磨料颗粒之间的距离也就是间隙的大小. 砂轮中磨料颗粒所占的体积百分比, 也就是其浓度的大小, 决定的砂轮的的组织号. 陶	the structure number indicates the space between neighboring grains which can also be called grain spacing in a wheel the volume percentage of abrasive grains which represents the

瓷砂轮组织号变化范围一般是从5到13,数字越小表示砂轮组织越密,数字越大表示砂轮组织越疏松.组织11,12和13通常是指气孔砂轮.

density of grain in a wheel determines the structure number of a wheel.the structure of vitrified sheels ranges from 5 to 13.the smaller the number,the more closed structure the wheel the large the number,the more open structure wheel the number 11.12.13normally indicate porous wheels.