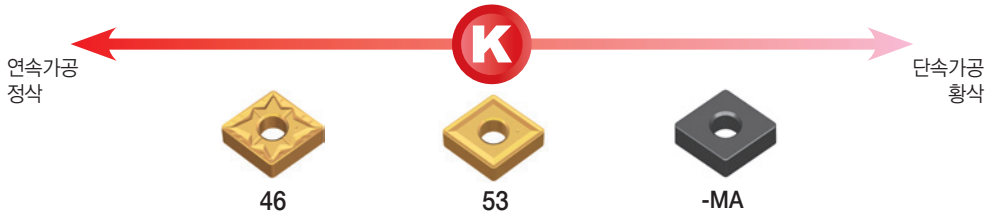
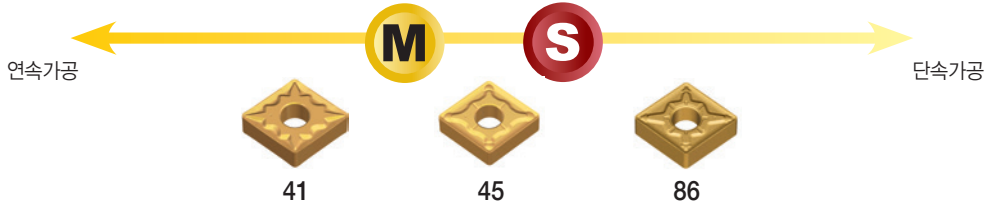


# 기술자료

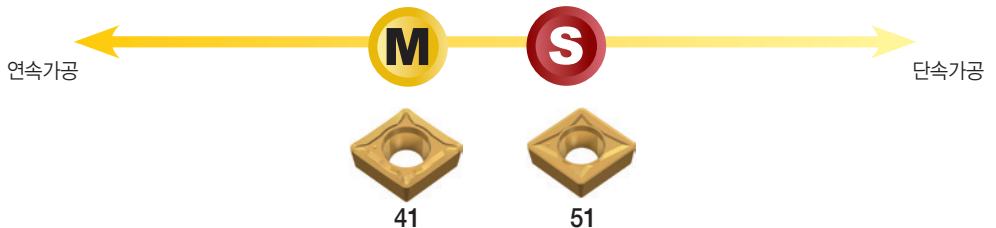
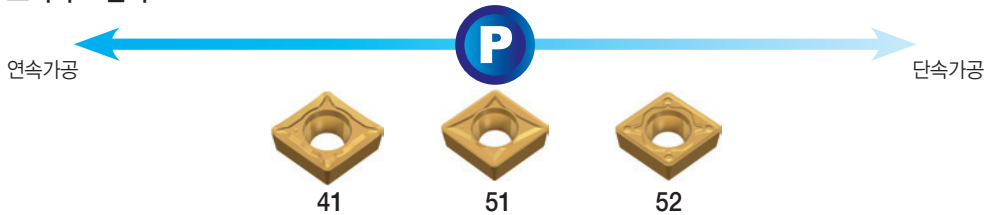
## 피삭재 형상별 칩브레이커 선정



### 네가티브 인서트



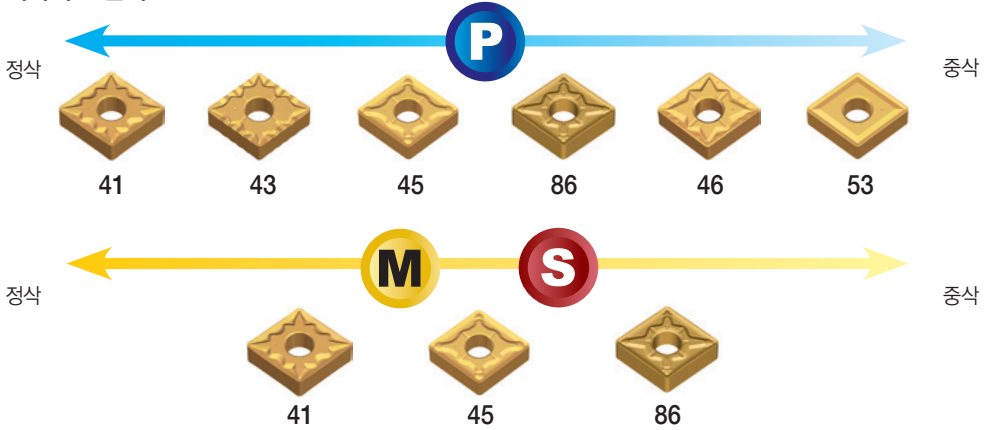
### 포지티브 인서트



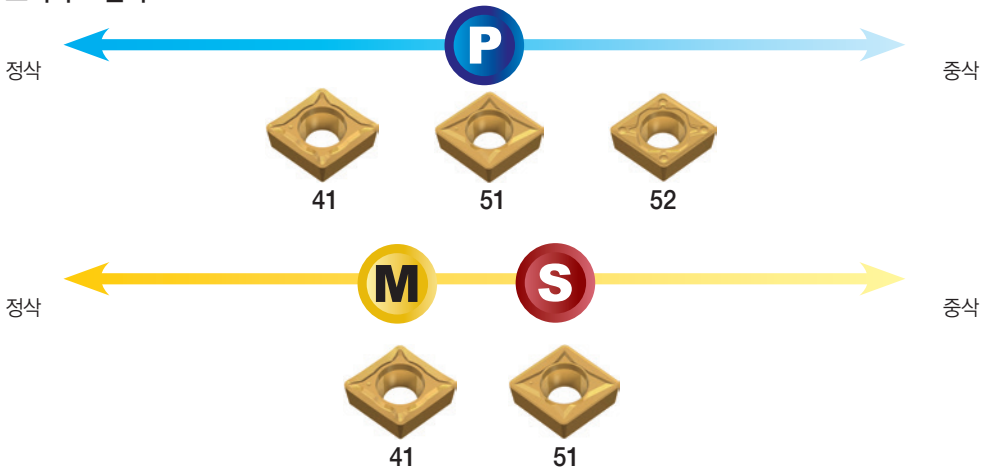
# 기술자료

## 가공별 칩브레이커 선정

### 네가티브 인서트



### 포지티브 인서트



# 기술자료

피삭재	가공	제1추천 칩브레이커	제2추천 칩브레이커
탄소강 & 합금강 (S45C, SCM4.....)	정삭	41	43
	중삭	86	43 / 46
	황삭	86 / 46	53
저 탄소강 & 저 합금강 (S20C, SCM415...)	정삭	41	43
	중삭	86	45
	황삭	86	46
스테인리스강	정삭	41	
	중삭	45	86
	황삭	46	
주철	정삭	46	
	중삭	53	46
	황삭	MA	53

# 기술자료

## 터닝 재종 비교표

	ISO	듀라카브	한국야금	미쯔비시	스미토모	교세라	탕가로이	세코	발터	케나메탈	샌드빅	대구텍	이스카
터닝	P	DC9015	NC3010 NC3015	MC6015 UE6110 UE6010	AC1000 AC700G	CA515 CA5515	T9115 T9015	TP1501 TP1500 TP1000	WPP10S WPP10	KCP10 KCP10B KC9110	GC4315 GC4215	TT8115	IC8150 IC9150
		DC9025 DC8035	NC3220 NC3120 NC3020	MC6025 UE6020	AC820P AC2000 ACZ310	CA525 CA5525	T9125 T9025	TP2501 TP2500 TP2000	WPP20S WMP20S	KCP25 KCP25B KC9125	GC4325 GC4225	TT8125 TT5100	IC8250 IC9250
	M	DC8035	NC9125	MC7025	AC6030M	CA6525	T6130	CP500	WMP20S	KCM25	GC2025	TT5100	IC6025
		DP5010	PC8105	MP9005	AC510U	PR1305	AH8005	TH1000	WSM10	KC5510	GC1105	TT5030	IC807
	K	DC820	NC6210 NC6110	MC5015 UC5115	AC415K AC500G	CA4515 CA4115 CA4120	T5115 T5020	TK2001 TK2000	WKK20S WAK20	KCK15 KCK15B KC9325	GC3210 GC3015	TT7015 TT7310	IC5005
	S H	DP5010	PC8110	MP9005 MP9015 VP05RT VP10RT	AC510U EH510Z EH10Z	PR1005 PR930	AH110	TH1000 TH1500 TS2000 TS2500 CP200	WSM10	KCU10 KC5510 KC5010	GCS05F GC1105 GC1115	TT5080	IC807 IC907
DP5320		PC5300 PC9530 PC5400	VP15TF VP20RT	AC520U EH20Z	PR1025 PR1125 PR1225 PR1425	AH120	CP500	WSM21 WSM20 WSM30	KCU25 KC5525 KC5025	GC15 GC1125 GC1025 GC1515 GC1525	TT9080	IC808 IC908	
컷그립	DC210	H01	HT10	H1 EH10			G1F TH10	HX			H10 H10A	K10	IC20
	DC154	PC3500									GC1025 GC4125	TT7220	IC350
	DC9235	PC9030 PC9530		ACZ350		AH140 GH330	CP600 F40M	WXP43	KC935M KC722	GC2145	TT8020	IC328	
	DC9800	PC9530	VP15TF	ACP200	PR830 PR925 PR1025	GH330 AH720	F30M	WAM30	KC522M KC635M	GC1030 GC2030	TT9030	IC808 IC908	

# 기술자료

## 밀링 재종 비교표

	ISO	듀라카브	한국아금	미쯔비시	스미토모	교세라	탕가로이	세코	발터	케나메탈	샌드빅	대구택	이스카
밀링	P	DP9320 DC7070 DC9300			ACP100		T3130 AH330	MP1500 MP2500 T250M T25M	WKP25 WAM10 WAM20		GC4220 GC4230	TT7080 TT7030	IC950
		DP5320 DC9800	PC3500 PC5300	VP15TF VP20RT UP20M	ACP200	PR830 PR1225 PR1230 PR9925	AH725 AH730 GH330 AH120	F25M F30M MP3000	WAM30	KC522M KC635M	GC1030 GC4240	TT9080 TT9030	IC808 IC908
		DP8330 DC9235	PC5400 PC3545	VP30RT FH7020 F7030	ACP300 ACZ350	PR1525	AH140 T3130 AH130 AH3035 AH9030	F40M T350M	WKP35 WXP45 WSP45	KC725M KC735M KC935M KCPM20	GC4240 GC1040	TT8080 TT8020 TT7800	IC830 IC330 IC928
	M S	DP5320 DC9800	PC5300 PC9530	VP15TF VP20RT UP20M	ACP100 ACP200 ACP300	PR830 PR1210 PR1025 PR1225 PR905	T3130 AH725 AH120 AH4035	MS2050 MP2500 F25M F30M	WAM30 WXM35	KC635M	GC1030 GC2030 S30T GC1025	TT9080 TT9030	IC808 IC908
		DP8330 DC9235	PC5300 PC5400	F7030 MP7030 VP30RT MP9130	ACM100 ACM200 ACM300	PR1225 PR905	AH130 AH140 SH730 AH3035	F40M MS2500 MM4500	WXM35 WSM35 WSP45	KC725M	GC2040 S40T	TT8080 TT8020	IC830 IC330 IC928
	K	DP7320	PC6510 PC5300 PC5400	MP8010 VP15TF VP20RT F5010	ACK200 ACK300 ACZ310	PR905 PR1210 PR1510	T1115 AH110 AH120	MK2050	WKP25S WKP35S WKK25S WKK25	KCK15 KC520M	GC1020 GC4230 GC3040 GC4240	TT6080	IC810 IC910
	H	DP5320	PC210F	MP8010 VP15TF MP9130				MH1000 F15M MP1500 F30M MP3000	WHH15	KC510M KC522M KC635M	GC1010 GC1030	TT9080	IC903 IC900
	드릴링	DC9800 DP5030	PC9530	VP15TF	ACP200	PR830 PR925 PR1025	GH330	F30M	WAM30	KC522M KC635M	GC1030 GC2030	TT9030	IC808 IC908
		DC154	PC3500								GC1025 GC4125	TT7220	IC350
		DC9235	PC9030 PC9530		ACZ350		AH140 GH330	CP600 F40M	WXP43	KC935M KC722	GC2145	TT8020	IC328

	듀라카브	한국아금	미쯔비시	스미토모	교세라	탕가로이	세코	NTK	케나메탈	샌드빅	대구택	세라텍
서멧	DC610	CN1500 CN2000 CC125	MP3025 UP35N	T1500A T1200A T2000Z	PV7020 PV7025 PV60 TN6010 TN6020 TN60 TN620	GT730 GT530 NS520 NS720	TP1030 CMP CM	T15 C30 Q50	KT5020 KT125 KT150	CT5005 CT5015 CT525 GC1525	CT3000	SC15 SC8015 SC7035 SC40
	DC630	CN20 CN30	VP45N NX99 NX3035	T3000Z T130Z	TN100M TC60M PV90	NS730 NS530	TP1020 C15M	N20 Z15 C50 C7X	KT1120 KT175	CT530	CT7000	SC7015 SC60

# 기술자료

## 칩 브레이커 비교표

분류			듀라카브	대구텍	미쯔비시	스미토모	교세라	탕가로이	한국야금	샌드빅	케나메탈	세코	발터	이스카
네가티브 인서트	강용	양면	41	FG	SY	SU	HQ	TSF	VF	QF	FP	MF2	NF3	NF
				FC	SH	LU		TF	GF	PF	FN			
			43	FC	SA	GE	CQ	TSF	VC	PF	FN	MF3	NS6	TF
				PC	SH		PS	TM						
			86	MM	MA	GU	PS	TM	HS,GS	PM,QM	P	MF5,M3	NM4	TF
			46	MT		UX,GX	HS		HM,GM	HM,XMR	MP		NM6	GN
	53	-MG	MG-	UZ	C	MG-	B25		MG		MG			
	스테인리스 강용	양면	42	ML	MS	EX	MU, MS	SS	HS	MM	UP	MF4	NMS	TMN
			45	EM	MA	GU	HU	SM	GS	MR	RP	MF5	NR4	
	포지티브 인서트	강용	양면	53	-MG	MG-	UZ	C	MG-	B25		MG		MG
41				FG	SQ	LU	GP	PF	HPF	PF	FP, LF	F1	PS4	SM
51				MT	MT	SU	GK	PS	HMP	PM	MP		PF2	17
알루미늄용	양면	52	FM	SV	MU	HQ	PM	C25	UM	MF	F2	PM5	19	
		AU	FL	AZ	AG	AH	AL	AR	AL	HP	AL	PM2	AF,AS	