



DURACARB SOLUTIONS

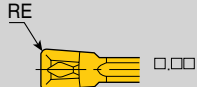
PARTING & GROOVING



<p>1. 듀라카브</p>	<p>2. 인서트 형상</p> <p>한날 인서트</p>  <p>S</p> <p>양날 인서트</p>  <p>D</p>	<p>3. 칩브레이커 형상</p> <p>M</p>  <p>중절삭용</p> <p>L</p>  <p>경절삭용</p> <p>G</p>  <p>선삭 및 홈 가공용</p> <p>T</p>  <p>칩브레이커 없는 형상</p>	<p>4. 인서트 승수</p> <p>좌승수</p>  <p>L</p> <p>우승수</p>  <p>R</p>	<p>5. 인서트 폭</p>  <p>CW</p> <p>2 = 2.0 mm 3 = 3.0 mm 4 = 4.0 mm 5 = 5.0 mm 6 = 6.0 mm</p>
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D D T R/L - 3.00 - 0.10 - 6RS

1 2 3 4 5 6 7 8 9

<p>6. 코너 R (mm)</p>  <p>RE</p>	<p>7. 리드각</p>  <p>PSIR</p>	<p>8. 리드각 인서트 승수</p> <p>좌승수</p>  <p>L</p> <p>우승수</p>  <p>R</p>	<p>9. 코너 형상</p> <p>날카로운 코너 형상</p>  <p>S</p> <p>표준 코너 형상</p>  <p>I</p>
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외경 선삭 및 홈가공용 홀더



Fig.1

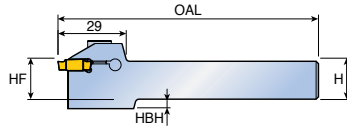
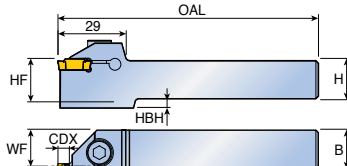


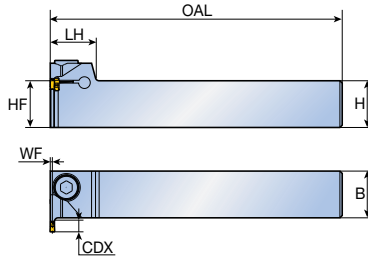
Fig.2



규격	치수(mm)								인서트 시트 사이즈	인서트		토크 (N·cm)	Fig.
	H	B	OAL	HF	WF	CDX	WB	HBH		DDT	DDTR/L		
DCER/L 1616-2T035	16	16	110	16	15.1	3.5	1.8	4.0	2	1.25-1.85	1.25-2.00	5.5	1
1616-2T05	16	16	110	16	15.1	5.0	1.8	-	2	2.00-2.80	2.50-2.80	8.0	2
2020-2T035	20	20	125	20	19.1	3.5	1.8	-	2	1.25-1.85	1.25-2.00	5.5	1
2020-2T05	20	20	125	20	19.1	5.0	1.8	-	2	2.00-2.80	2.50-2.80	8.0	2
2525-2T035	25	25	150	25	24.1	3.5	1.8	-	2	1.25-1.85	1.25-2.00	5.5	1
2525-2T05	25	25	150	25	24.1	5.0	1.8	-	2	2.00-2.80	2.50-2.80	8.0	2
1616-3T05	16	16	110	16	14.8	5.0	2.4	4.0	3	3.00-3.50		8.0	2
2020-3T05	20	20	125	20	18.8	5.0	2.4	-	3	3.00-3.50		8.0	2
2525-3T05	25	25	150	25	23.8	5.0	2.4	-	3	3.00-3.50		8.0	2
1616-4T05	16	16	110	16	14.5	5.0	3.0	4.0	4	4.00		8.0	2
2020-4T05	20	20	125	20	18.5	5.0	3.0	-	4	4.00		8.0	2
2525-4T05	25	25	150	25	23.5	5.0	3.0	-	4	4.00		8.0	2

• 내경 단면홈 가공용 보링바는 Special로 공급 가능

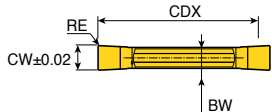
홀더	부품	
	스크류	렌치
...1616-2T035	DS M5X0.8X20-SH	DHLW-4
...2020-2T035	DS M5X0.8X20-SH	DHLW-4
...1616-2T05	DS M6X1X20-SH	DHLW-5
...2020-2T05	DS M6X1X20-SH	DHLW-5
...2525-2T035	DS M5X0.8X25-SH	DHLW-4
...2525-2T05	DS M6X1X25-SH	DHLW-5
...2525-3T05	DS M6X1X25-SH	DHLW-5
...2525-4T05	DS M6X1X25-SH	DHLW-5
...1616-3T05	DS M6X1X20-SH	DHLW-5
...2020-3T05	DS M6X1X20-SH	DHLW-5
...1616-4T05	DS M6X1X20-SH	DHLW-5
...2020-4T05	DS M6X1X20-SH	DHLW-5



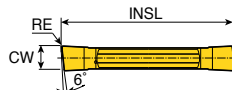
- 내경 단면홈 가공용 보링바는 Special로 공급 가능



Member IWC Group
Duracarb

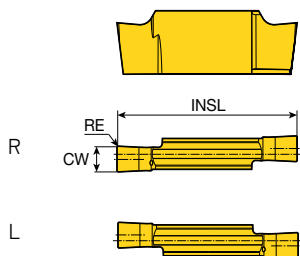


CW+0.0

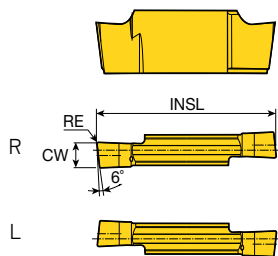


- 스페셜 공급가능
ex) DDT 2.00 - 0.10 - 6R

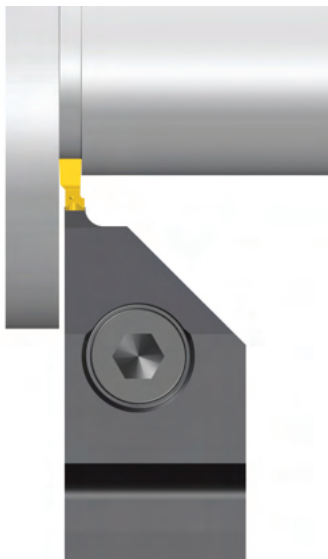
[illegible]



ex) DDTR 2.00 - 0.10



ex) DDTR 2.00 - 0.10 - 6R



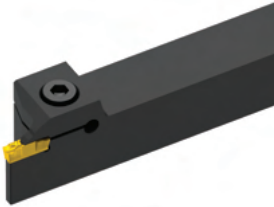
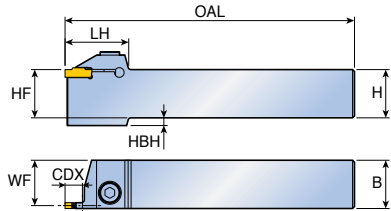
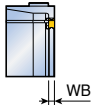
솔더 가공 표준형



솔더 가공 리드각형(6°)

- 솔더 가공용은 스페셜로 공급가능
- DDT 표준형과 동일한 적용 범위

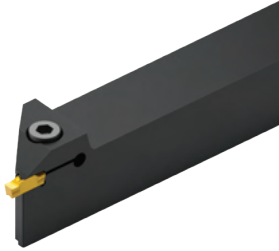
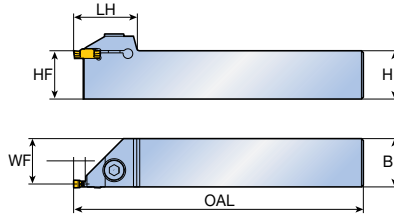
외경선삭 및 홈가공용 홀더



규격	치수(mm)								인서트 시트 사이즈	토크 (N·cm)
	H(HF)	B	OAL	WF	LH	WB	HBH	CDX		
DCER/L 16T09-2	16	16	110	15.1	33	1.80	4	9	2	8.0
16T16-2	16	16	110	15.1	35	1.80	4	16	2	8.0
16T09-3	16	16	110	14.8	33	2.40	4	9	3	8.0
16T16-3	16	16	110	14.8	35	2.40	4	16	3	8.0
16T10-4	16	16	110	14.5	33	3.00	4	10	4	8.0
20T09-2	20	20	125	19.1	33	1.80	-	9	2	8.0
20T16-2	20	20	125	19.1	35	1.80	-	16	2	8.0
20T09-3	20	20	125	18.8	33	2.40	-	9	3	8.0
20T16-3	20	20	125	18.8	35	2.40	-	16	3	8.0
20T10-4	20	20	125	18.5	33	3.00	-	10	4	8.0
20T16-4	20	20	125	18.5	35	3.00	-	16	4	8.0
20T12-5	20	20	125	18.075	37	3.85	-	12	5	8.0
20T20-5	20	20	125	18.1	37	3.85	-	20	5	8.0
25T09-2	25	25	150	24.1	33	1.80	-	9	2	8.0
25T16-2	25	25	150	24.1	35	1.80	-	16	2	8.0
25T09-3	25	25	150	23.8	33	2.40	-	9	3	8.0
25T16-3	25	25	150	23.8	35	2.40	-	16	3	8.0
25T10-4	25	25	150	23.5	33	3.00	-	10	4	8.0
25T16-4	25	25	150	23.5	35	3.00	-	16	4	8.0
25T12-5	25	25	150	23.075	37	3.85	-	12	5	8.0
25T20-5	25	25	150	23.1	37	3.85	-	20	5	8.0

홀더	부품	
	스크류	렌치
...16T09-2,3	DS M6X1X25-SH	DHLW-5
...16T16-2,3	DS M6X1X20-SH	DHLW-5
...16T10-4	DS M6X1X20-SH	DHLW-5
...20T...	DS M6X1X25-SH	DHLW-5
...25T10-4	DS M6X1X20-SH	DHLW-5
...25T12-5	DS M6X1X20-SH	DHLW-5
...25T09-2,3	DS M6X1X25-SH	DHLW-5
...25T16-2,3,4	DS M6X1X25-SH	DHLW-5
...25T20-5	DS M6X1X25-SH	DHLW-5

단면 홈가공 홀더

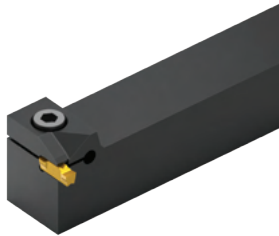
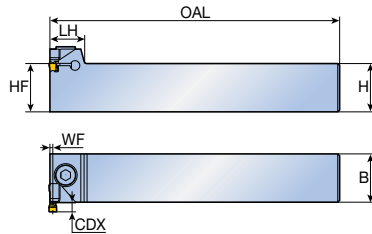


규격	치수(mm)						인서트 시트 사이즈	토크 (N·cm)
	H(HF)	B	OAL	LH	WF	CDX		
DCFR 2525-4T05	25	25	150	33	23.5	4.8	4	8.0

홀더	부품	
	스크류	렌치
...2525-4T05	DS M6X1X25-SH	DHLW-5

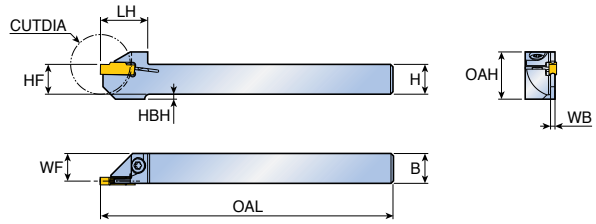
DCFPR

단면 직각 홈가공 홀더

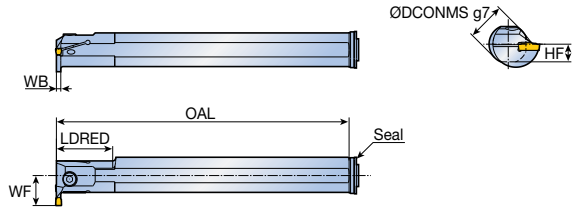


규격	치수(mm)							인서트 시트 사이즈	토크 (N·cm)
	H	HF	B	OAL	LH	WF	CDX		
DCFPR 2525-4T05	25	25	25	150	18	1.5	4.8	4	8.0

홀더	부품	
	스크류	렌치
...2525-4T05	DS M6X1X25-SH	DHLW-5

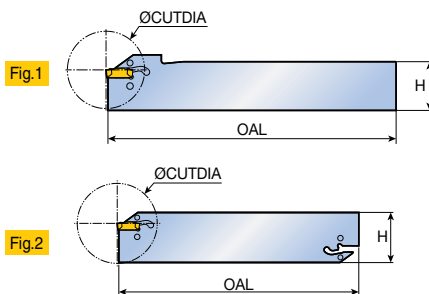
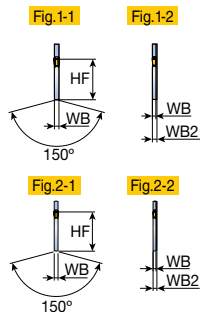
[illegible]

홀더	부품	
	스크류	렌치
		
...ST	DS 40A115I-TS	DTFW-15

[illegible]

홀더	부품		
	스크류	렌치	실
			
DCIR/L 16-2	DS M5X0.8X10-SH	DHLW-4	DPL 16 (M6)
DCIR/L 20-2/3/4	DS M5X0.8X12-SH	DHLW-4	DPL 20 (M6)
DCIR/L 25-2/3/4	DS M5X0.8X16-SH	DHLW-4	DPL 25 (R1/8)
DCIR/L 32-2/3/4	DS M5X0.8X16-SH	DHLW-4	DPL 32 (R1/8)
DCIR/L 40-3/4	DS M5X0.8X16-SH	DHLW-4	DPL 40 (R1/8)

A close-up photograph of a silver-colored metal bracket. A yellow pin is inserted into a hole on the left side of the bracket. The bracket has a flat base and a vertical flange.

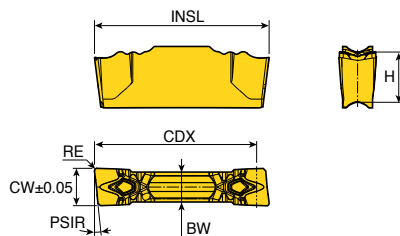
[illegible]

홀더	부품
	익스트랙터
	
DCB	EDG 33B

70

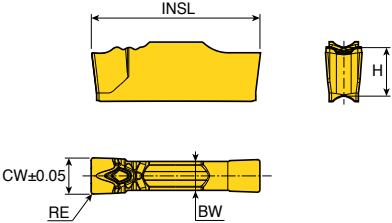
Technical drawing of a yellow metal part. The top view shows a trapezoidal shape with a central rectangular section. The bottom view shows a cylindrical shape with a central rectangular section. Dimensions are labeled: INSL (top view), CDX (bottom view), RE (bottom view), PSIR (bottom view), BW (bottom view), CW±0.05 (bottom view), and H (side view).

▶타입 형상의 절단 및 홈가공용 양날 인서트

[illegible]



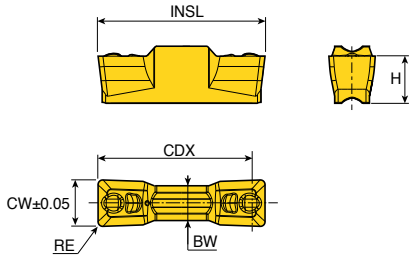
L타입 형상의 절단 및 흡가공용 한날 인서트



인서트	규격	인서트	치수(mm)					재종		
		시트 사이즈	CW	RE	BW	INSL	H	DP5320	DC154	DC9235
	DSL 2	2	2.0	0.20	1.6	14.0	4.0	●	●	●
	3	3	3.0	0.20	2.4	14.0	4.0	●	●	●
	4	4	4.0	0.30	3.0	14.0	4.0	●	●	●
	5	5	5.0	0.30	4.0	17.5	5.1	●	●	●

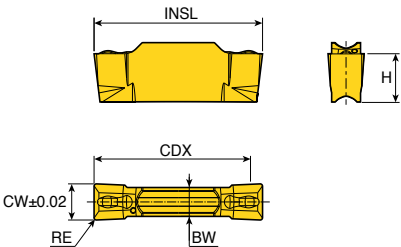
DDG

선삭 및 흡가공용 양날 인서트



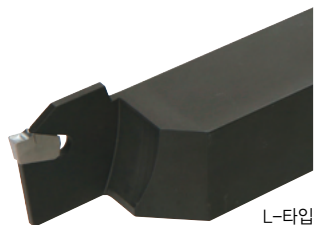
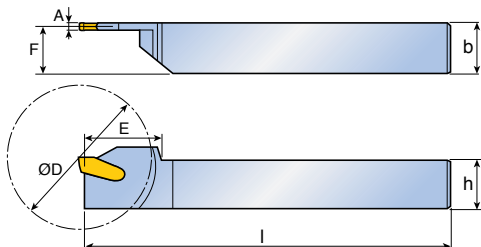
인서트	규격	인서트	치수(mm)						재종		
		시트 사이즈	CW	RE	BW	INSL	H	CDX	DP5320	DC154	DC9235
	DDG 30040	3	3.0	0.4	2.4	14.0	4.0	13	●	●	
	40040	4	4.0	0.4	3.0	14.0	4.0	13	●	●	
	50040	5	5.0	0.4	4.0	17.5	5.1	17	●	●	

선삭 및 홈가공용 연삭급 양날 인서트

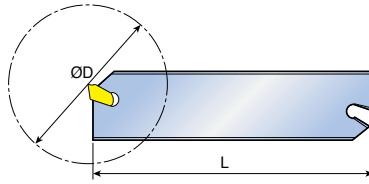
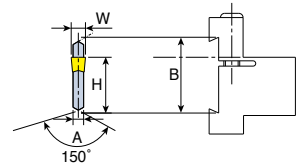


인서트	규격	인서트 시트 사이즈	치수(mm)							재종		
			CW	RE	BW	INSL	H	CDX		DP5320	DC154	DC9235
	DDG-G 2.00E-0.10	2	2.00	0.10	1.7	14	4.0	13		●		
	2.00E-0.20	2	2.00	0.20	1.7	14	4.0	13		●		
	2.00E-1.00	2	2.00	1.00	1.7	14	4.0	13		●		
	3.00E-0.20	3	3.00	0.20	2.4	14	4.0	13		●		
	3.00E-0.40	3	3.00	0.40	2.4	14	4.0	13		●		
	3.00E-1.50	3	3.00	1.50	2.4	14	4.0	13		●		
	4.00E-0.40	4	4.00	0.40	3	14	4.0	13		●		
	4.00E-0.80	4	4.00	0.80	3	14	4.0	13		●		
	4.00E-2.00	4	4.00	2.00	3	14	4.0	13		●		

• 절삭폭(CW)은 요청에 따라 Special로 공급 가능

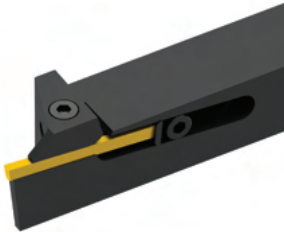
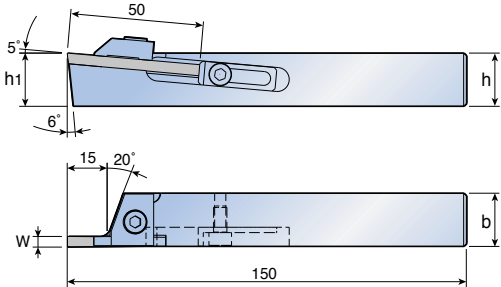
[illegible]

블레이드	부품
	인서트 익스트렉터
	
DHTR...	DCW R1



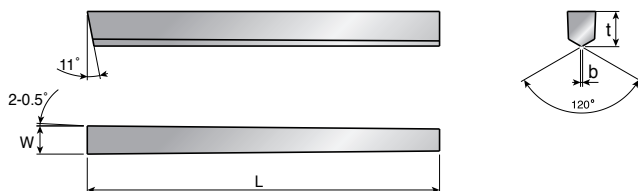
블레이드	부품
	인서트 익스트렉터
	
DH301...	ESG1

조절형 절단 가공용 홀더



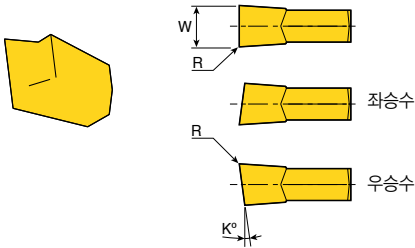
규격	치수(mm)			인서트	부품				
	h1=h	b	W		클램프	클램프 스크류	조정 멈치	조정 스크류	렌치
GVR/L 2020-3	20	20	3	GV 503	CL 503R/L	DS M5X0.8X10-SH	GVAU 504	DS M5X0.8X10-SH	DHLW 4
2525-3	25	25	3	GV 503	CL 503R/L	DS M5X0.8X10-SH	GVAU 504	DS M5X0.8X10-SH	DHLW 4
3232-3	32	32	3	GV 503	CL 503R/L	DS M5X0.8X10-SH	GVAU 504	DS M5X0.8X10-SH	DHLW 4
2020-4	20	20	4	GV 504	CL 504R/L	DS M5X0.8X10-SH	GVAU 504	DS M5X0.8X10-SH	DHLW 4
2525-4	25	25	4	GV 504	CL 504R/L	DS M5X0.8X10-SH	GVAU 504	DS M5X0.8X10-SH	DHLW 4
3232-4	32	32	4	GV 504	CL 504R/L	DS M5X0.8X10-SH	GVAU 504	DS M5X0.8X10-SH	DHLW 4
2020-5	20	20	5	GV 505	CL 504R/L	DS M5X0.8X10-SH	GVAU 504	DS M5X0.8X10-SH	DHLW 4
2525-5	25	25	5	GV 505	CL 504R/L	DS M5X0.8X10-SH	GVAU 504	DS M5X0.8X10-SH	DHLW 4
3232-5	32	32	5	GV 505	CL 504R/L	DS M5X0.8X10-SH	GVAU 504	DS M5X0.8X10-SH	DHLW 4
2525-6	25	25	6	GV 506	CL 504R/L	DS M5X0.8X10-SH	GVAU 504	DS M5X0.8X10-SH	DHLW 4
3232-6	32	32	6	GV 506	CL 504R/L	DS M5X0.8X10-SH	GVAU 504	DS M5X0.8X10-SH	DHLW 4

홀더	부품				
	클램프	클램프 스크류	조정 멈치	조정 스크류	렌치
					
...-3	CL 503R/L	DS M5X0.8X10-SH	GVAU 504	DS M5X0.8X10-SH	DHLW 4
...-4	CL 504R/L	DS M5X0.8X10-SH	GVAU 504	DS M5X0.8X10-SH	DHLW 4
...-5	CL 504R/L	DS M5X0.8X10-SH	GVAU 504	DS M5X0.8X10-SH	DHLW 4
...-6	CL 504R/L	DS M5X0.8X10-SH	GVAU 504	DS M5X0.8X10-SH	DHLW 4

[illegible]

• 공급 가능한 재종은 문의 하시기 바랍니다.

절단 및 흡가공용 한날 인서트



인서트	규격	치수(mm)			재종		
		W±0.10	R	K°	DC210	DC154	DC9235
	DIMN 2	2.2	0.16	-	●	●	●
	3	3.1	0.20	-	●	●	●
	4	4.1	0.24	-	●	●	●
	5	5.1	0.28	-	●	●	●
	6	6.4	0.35	-		●	
	8	8.0	0.42	-		●	
	9	9.6	0.47	-		●	
	2.4	2.4	0.16	-		●	
	2B	2.2	0.20	-			●
	3A	3.1	0.20	-	●		
	3B	3.1	0.30	-		●	●
	4.8	4.8	0.28	-		●	
	4A	4.1	0.24	-	●		
	4B	4.1	0.40	-			●
	DIML 2-15D	2.2	0.16	15°		●	
	3-8D	3.1	0.20	8°		●	
	3-15D	3.1	0.20	15°		●	
	DIMR 2-4D	2.2	0.16	4°		●	
	2-8D	2.2	0.16	8°	●	●	
	2-15D	2.2	0.16	15°		●	
	DIMR 3-4D	3.1	0.20	4°		●	
	3-8D	3.1	0.20	8°	●	●	
	3-15D	3.1	0.20	15°	●	●	
	DIMR 4-4D	4.1	0.24	4°		●	
	4-8D	4.1	0.24	8°		●	

- A타입 : 경사면이 포지티브한 알루미늄 가공 인서트
- B타입 : 표준 제품에서 코너 R이 커진(강화된) 제품

ISO	피삭재		열처리 조건	경도 (HB)	재종	
					DC154	DC9235
P	일반강, 탄소강, 쾌삭강	< 0.25%C	어닐링	125	110-170	80-120
		>= 0.25%C	어닐링	190	100-150	80-110
		< 0.55%C	QT	250	90-140	70-90
		>= 0.55%C	어닐링	220	100-220	70-100
			QT	300	70-170	40-70
	저합금강 (5%이하의 불순물 함량)	QT	어닐링	200	90-120	70-100
				275	80-170	50-70
				300	70-130	40-60
				350	50-120	30-50
	고합금강, 단조강, 공구강	QT	어닐링	200	60-140	50-80
				325	50-70	30-60
M	스테인리스 스틸, 단조강	페라이트계/ 마르텐사이트계		135	70-170	80-120
		마르텐사이트계		70	60-170	60-90
		오스테나이트계		-	90-180	60-90