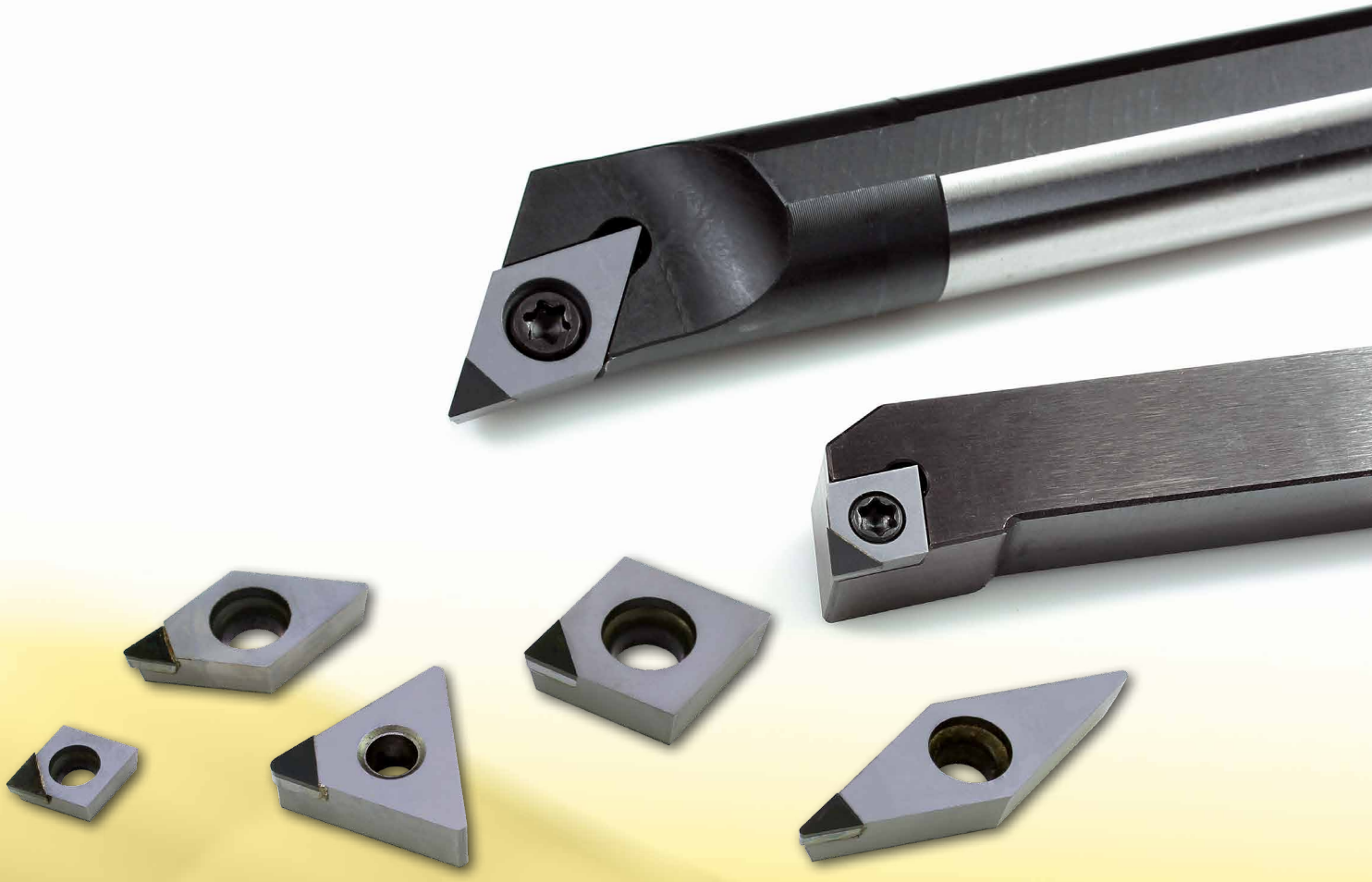
GCL INTERNATIONAL
UKAS MANAGEMENT SYSTEMS
ISO 9001 5965

WINSTAR

Turning Tools
PCD (Polycrystalline Diamond) Turning Inserts
聚晶鑽石車刀片

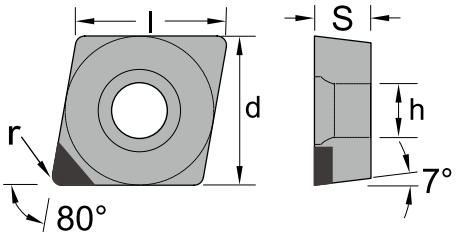
- ***For aluminum alloy and carbide cutting.***
  適用於鋁合金及碳化鎢加工
- ***Outstanding brazing strength.***
  優秀的焊接強度
- ***The PCD tools provide long tool life, more economical.***
  PCD 超硬刀具可延長刀具切削壽命，更加經濟



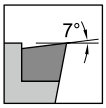
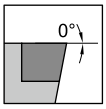
W200302EC

Insert Specification 刀片規格

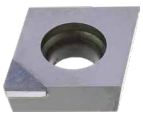
Insert	Dimensions (mm)			
	d	l	S	h
CCGW0602	6.35	6.4	2.38	2.8
CCGW09T3	9.53	9.7	3.97	4.4
CCGW1204	12.7	12.9	4.76	5.5



Insert Geometry 刀片幾何

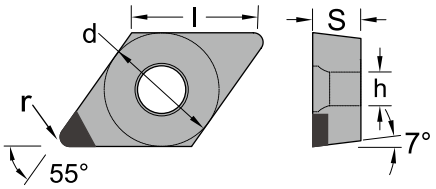
Chipbreaker 斷屑槽	Application 特 性
 **FG**	Sharp geometry design for finishing cutting.
 **MG**	Low cutting force for medium.

Order Code 刀片訂購碼

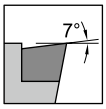
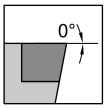
Insert	Order No. 訂購編碼	Designation 名 稱	r	Working Material					
				P	M	K	N	S	H
	ICCGW060202FG30	CCGW060202-FG-DIA30	0.2				●		
	ICCGW060204FG30	CCGW060204-FG-DIA30	0.4				●		
	ICCGW09T302FG30	CCGW09T302-FG-DIA30	0.2				●		
	ICCGW09T304FG30	CCGW09T304-FG-DIA30	0.4				●		
	ICCGW09T308FG30	CCGW09T308-FG-DIA30	0.8				●		
	ICCGW120402FG30	CCGW120402-FG-DIA30	0.2				●		
	ICCGW120404FG30	CCGW120404-FG-DIA30	0.4				●		
	ICCGW120408FG30	CCGW120408-FG-DIA30	0.8				●		
	ICCGW060202MG30	CCGW060202-MG-DIA30	0.2				●		
	ICCGW060204MG30	CCGW060204-MG-DIA30	0.4				●		
	ICCGW09T302MG30	CCGW09T302-MG-DIA30	0.2				●		
	ICCGW09T304MG30	CCGW09T304-MG-DIA30	0.4				●		
	ICCGW09T308MG30	CCGW09T308-MG-DIA30	0.8				●		
	ICCGW120402MG30	CCGW120402-MG-DIA30	0.2				●		
	ICCGW120404MG30	CCGW120404-MG-DIA30	0.4				●		
	ICCGW120408MG30	CCGW120408-MG-DIA30	0.8				●		

Insert Specification 刀片規格

Insert	Dimensions (mm)			
	d	l	S	h
DCGW0702	6.35	7.75	2.38	2.8
DCGW11T3	9.53	11.6	3.97	4.4



Insert Geometry 刀片幾何

Chipbreaker 斷屑槽	Application 特　性
 **FG**	Sharp geometry design for finishing cutting.
 **MG**	Low cutting force for medium.

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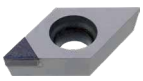
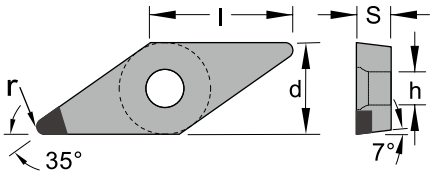
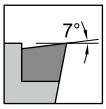
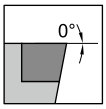
	IDCGW070202FG30	DCGW070202-FG-DIA30	0.2				●		
	IDCGW070204FG30	DCGW070204-FG-DIA30	0.4				●		
	IDCGW11T302FG30	DCGW11T302-FG-DIA30	0.2				●		
	IDCGW11T304FG30	DCGW11T304-FG-DIA30	0.4				●		
	IDCGW070202MG30	DCGW070202-MG-DIA30	0.2				●		
	IDCGW070204MG30	DCGW070204-MG-DIA30	0.4				●		
	IDCGW11T302MG30	DCGW11T302-MG-DIA30	0.2				●		
	IDCGW11T304MG30	DCGW11T304-MG-DIA30	0.4				●		

Insert Specification 刀片規格

Insert	Dimensions (mm)			
	d	l	S	h
VCGW1103	11.1	6.35	3.18	2.8
VCGW1604	9.525	16.6	4.76	4.4



Insert Geometry 刀片幾何

Chipbreaker 斷屑槽	Application 特　性
 **FG**	Sharp geometry design for finishing cutting.
 **MG**	Low cutting force for medium.

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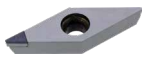
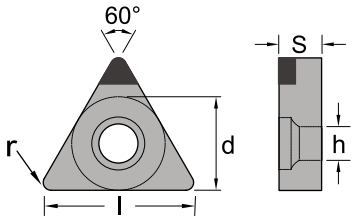
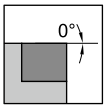
Insert	Order No. 訂購編碼	Designation 名　稱	r	Working Material					
				P	M	K	N	S	H
	IVCGW110302FG30	VCGW110302-FG-DIA30	0.2				●		
	IVCGW110304FG30	VCGW110304-FG-DIA30	0.4				●		
	IVCGW160402FG30	VCGW160402-FG-DIA30	0.2				●		
	IVCGW160404FG30	VCGW160404-FG-DIA30	0.4				●		
	IVCGW110302MG30	VCGW110302-MG-DIA30	0.2				●		
	IVCGW110304MG30	VCGW110304-MG-DIA30	0.4				●		
	IVCGW160402MG30	VCGW160402-MG-DIA30	0.2				●		
	IVCGW160404MG30	VCGW160404-MG-DIA30	0.4				●		

Insert Specification 刀片規格

Insert	Dimensions (mm)			
	d	l	S	h
TNGA1604	9.53	16.5	4.76	3.81



Insert Geometry 刀片幾何

Chipbreaker 斷屑槽	Application 特　性
 MG	Low cutting force for medium.

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Insert	Order No. 訂購編碼	Designation 名　稱	r	Working Material					
				P	M	K	N	S	H
	ITNGA160402MG30	TNGA160402-MG-DIA30	0.2				●		
	ITNGA160404MG30	TNGA160404-MG-DIA30	0.4				●		
	ITNGA160408MG30	TNGA160408-MG-DIA30	0.8				●		

Recommended Cutting Conditions 建議切削參數

Material 工件材料	**Aluminum alloys** (Si < 12%) 鋁合金		**Aluminum alloys** (Si > 12%) 鋁合金		**Brass** 黃銅		**Carbide** (HRA < 85) 碳化鎢	
Application 應用	Finishing	Roughing	Finishing	Roughing	Finishing	Roughing	Finishing	Roughing
VC (m/min) 線速度	700 ~ 2700	600 ~ 2400	270 ~ 800	200 ~ 700	600 ~ 1300	400 ~ 900	20 ~ 30	20 ~ 25
fr (mm/rev)	0.03 ~ 0.18	0.09 ~ 0.54	0.03 ~ 0.18	0.09 ~ 0.36	0.05 ~ 0.36	0.09 ~ 0.36	0.05 ~ 0.18	0.09 ~ 0.27
AP (mm)	0.05 ~ 0.90	0.27 ~ 4.50	0.05 ~ 0.07	0.09 ~ 2.25	0.05 ~ 0.45	0.45 ~ 1.80	0.05 ~ 0.18	0.09 ~ 0.45

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