

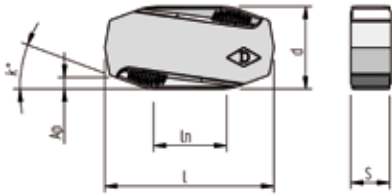


株洲奥凯沃硬质合金工具有限公司

Zhuzhou AoKai Wo Carbide Tool Co.Lt

# 钢管,棒剥皮刀片

## Steel pipe, Rod peeling insert



Cod.	k	ap	ln	T	l	d	s
LNMF 2006-2E	8°	1	9,5	4	20,4	8	6



Cod.	k	ap	ln	T	l	d	s
LNGF 2206-2D	15°	1,5	10	4	22,0	10,0	6,5
LNGF 3107-3D	15°	3,0	14	4	31,0	12,0	7,5
LNGF 3712-3D	15°	3,0	16	4	37,0	17,8	12,0



Cod.	k	ap	ln	T	l	d	s
LNGF 3108-2E	20°	2,0	17	4	31,0	12,0	7,5
LNGF 3712-2H	20°	2,0	18	4	37,0	17,8	12,0
LNGF 4312-2N	20°	2,0	26	4	43,2	17,8	12,0



Cod.	k	ap	ln	T	l	d	s
LNGF 3712-3H	20°	3,0	18	4	37,0	17,8	12,0



Cod.	k	ap	ln	T	l	d	s
LNGR 3812-2H	20°	2,5	25	2	38,1	17,46	12



Cod.	k	ap	ln	T	l	d	s
LNGR 3812-3F	20°	3,0	25	2	38,1	17,46	12,0

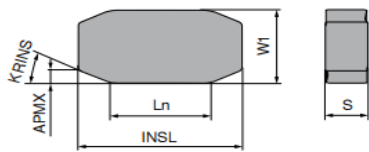


Cod.	k	ap	ln	T	l	d	s
LNGR 3812-2F	20°	3,0	25	2	38,1	17,46	12,0



Cod.	k	ap	ln	T	l	d	s
LNGF 4010-3F	25°	3,5	22	4	40,4	20,0	10,2
LNGF 4012-3F	25°	3,5	22	4	40,0	20,0	12,2

# LNGF

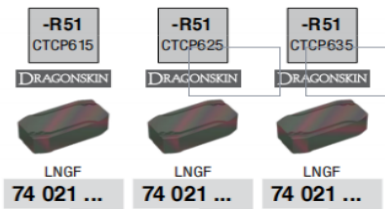
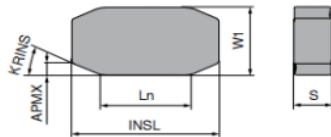


Designation	Ln mm	APMX mm	S mm	KRINS	INSL mm	W1 mm	NOI
LNGF 231025S42-R50	23	3	10.00	25°	40	20	4
LNGF 231025S50-R50	23	3	10.00	25°	40	20	4
LNGF 231225S42-R50	23	3	12.00	25°	40	20	4
LNGF 231225S50-R50	23	3	12.00	25°	40	20	4

LNGF 74 020 ...	LNGF 74 020 ...	LNGF 74 020 ...
	42300	
72400	42400	02400
	42500	
	42600	

P	•	•	•
M	•	•	•
K	○		
N			
S	•	•	•
H			

# LNGF

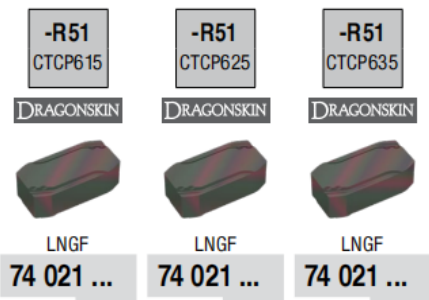
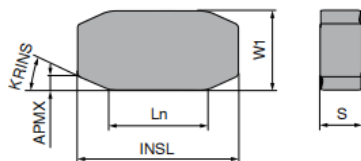


LNGF 231025S50-R51	23	3	10.00	25°	40	20	4
LNGF 231025P50-R51	23	3	10.00	25°	40	20	4
LNGF 231225S42-R51	23	3	12.00	25°	40	20	4
LNGF 231225S50-R51	23	3	12.00	25°	40	20	4
LNGF 231225P50-R51	23	3	12.00	25°	40	20	4
LNGF 231225P60-R51	23	3	12.00	25°	40	20	4

LNGF 74 021 ...	LNGF 74 021 ...	LNGF 74 021 ...
72400	42400	
	42200	
72800	42800	
72900	42900	
	42600	02600
	42700	02700

P	•	•	•
M	•	•	•
K	○		
N			
S	•	•	•
H			
O			

# LNGF

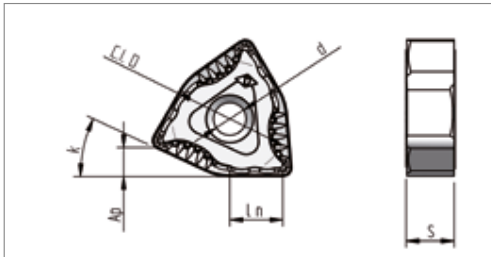


Designation	Ln mm	APMX mm	S mm	KRINS	INSL mm	W1 mm	NOI
LNGF 231025S42-R51	23	3	10.00	25°	40	20	4
LNGF 231025S50-R51	23	3	10.00	25°	40	20	4
LNGF 231025P50-R51	23	3	10.00	25°	40	20	4
LNGF 231225S42-R51	23	3	12.00	25°	40	20	4
LNGF 231225S50-R51	23	3	12.00	25°	40	20	4
LNGF 231225P50-R51	23	3	12.00	25°	40	20	4
LNGF 231225P60-R51	23	3	12.00	25°	40	20	4

LNGF 74 021 ...	LNGF 74 021 ...	LNGF 74 021 ...
72300	42300	
72400	42400	
	42200	
72800	42800	
72900	42900	
	42600	02600
	42700	02700

P	•	•	•
M	•	•	•
K	○		
N			
S	•	•	•
H			
O			

# 钢管,棒剥皮刀片 Steel pipe, Rod peelin insert



Cod./Код	k	ap	T	ln	C.i.D.	d	s
WNGJ 2209-3A	15°	3,0	6	10	22,22	8,0	9,5



Cod./Код	k	ap	T	ln	C.i.D.	d	s
TNGJ 2208-1C	20°	1,5	6	16	22,0	7,0	8,0
TNGJ 2810-2G	20°	2,5	6	20	28,5	7,0	10,0



Cod./Код	k	ap	T	ln	C.i.D.	d	s
TNGJ 2810-3F	20°	3,0	6	20	28,5	7,0	10,0



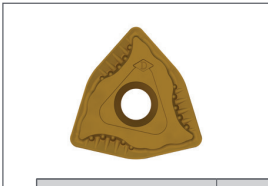
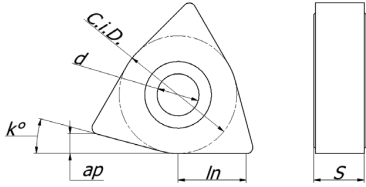
Cod./Код	k	ap	T	ln	C.i.D.	s
WNGF 2210-4A	25°	4,5	6	10	22,0	10,0
WNGF 3113-5A	25°	5,5	6	17	31,75	13,0
WNGF 3114-5A	25°	5,5	6	17	31,75	14,0



Cod./Код	k	ap	T	ln	C.i.D.	d	s
WNGJ 3113-5A	25°	5,5	6	17	31,75	9,0	13,0
WNGJ 3114-5A	25°	5,5	6	17	31,75	9,0	14,0



# 钢管,棒剥皮刀片 Steel pipe, Rod peegling insert



Code	k	ap	T	ln	C.i.D	d	s
WNGF 2210-3F	25°	4,5	6	10	22,0	-	10
WNGF 3113-3F	25°	5,5	6	17	31,75	-	13,0
WNGF 3114-3F	25°	5,5	6	17	31,75	-	14,0



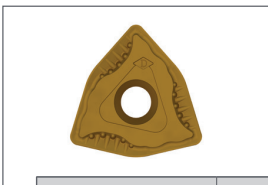
Code	k	ap	T	ln	C.i.D	d	s
WNGF 2809-2N	30°	3,0	6	16,9	28,58	-	9,0
WNGF 2809-2F	30°	3,0	6	16,9	28,58	-	9,0



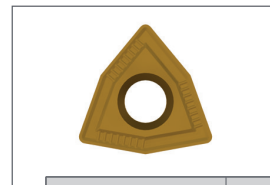
Code	k	ap	T	ln	C.i.D	d	s
WNGJ 1106-2H	15°	1,5	6	8	15,88	6,4	6,5
WNGJ 2209-2H	15°	3,0	6	10	22,22	8,0	9,5
WNGJ 2209-2F	15°	3,0	6	10	22,22	8,0	9,5



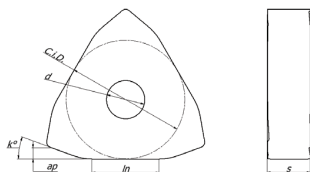
Code	k	ap	T	ln	C.i.D	d	s
WNGJ 1806-2H	24°	2,0	6	11,2	18,00	5,4	6,4



Code	k	ap	T	ln	C.i.D	d	s
WNGJ 3113-3F	25°	5,5	6	17	31,75	9,0	13,0
WNGJ 3114-3F	25°	5,5	6	17	31,75	9,0	14,0

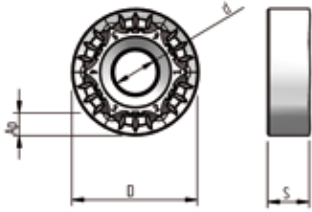


Code	k	ap	T	ln	C.i.D	d	s
WNMU 0804-2N	20°	1,0	6	7,7	12,70	5,2	4,8



Code	k	ap	T	ln	C.i.D	d	s
TNGJ 2208-2H	20°	1,5	6	16	22,0	7,0	8,0
TNGJ 2208-3F	20°	1,5	6	16	22,0	7,0	8,0
TNGJ 2810-2H	20°	2,5	6	20	28,5	7,0	10,0
TNGJ 2810-3F	20°	3,0	6	20	28,5	7,0	10,0

# 钢管,棒剥皮刀片 Steel pipe, Rod peegling insert



Cod.	ap	D	d	s
RNMJ 250900-3I	3,0	25,4	9,12	9,5



Cod.	ap	D	d	s
RNGH 381200-7I	4,0	38,1	12,8	12,7



Cod.	ap	D	d	s
RNGH 381200-7G	4,0	38,1	12,8	12,7



Cod.	ap	D	d	s
RNGH 381200-4I	4,0	38,1	12,8	12,7



Cod.	ap	D	d	s
RNGH 501800-5I	5,0	50,0	12,8	18,0



Cod.	ap	D	d	s
RNGH 501800-9I	7,0	50,0	12,8	18,0

## Inserimento di sbavatura 毛刺修边刀片

AKO开发了两种类型的用于剥离钢管和钢筋的双金属丝插件。这种类型对毛刺的处理直接剥离直径在4.5mm到15mm之间的碎屑。由于切割凹槽的新功能，这些刀片将由我们提供  
 AKO has developed two types of bimetallic wire inserts for stripping steel pipes and steel bars. This type of treatment for burrs directly peels off debris with a diameter between 4.5mm and 15mm. Due to the new function of cutting grooves, these blades will be provided by us



Cod.	T	C.I.D.	s
SNGX1906-OLD	8	19,05	6,35



Cod.	T	C.I.D.	s
SNGX1906-NEW	15°	3,0	6



## 剥刀片螺丝配套数据 Peeling inserting screws matching data

材料编号 Material-No.	类型、名称 Type, Designation	长度 Length	螺纹尺寸 Size of thread	扳手尺寸 Wrench size
1342301	M8X30 DIN 7991 12.9	30	M8	SW5
6210871	C/26381 DIN7991 M8X25 10.9	25	M8	SW5
11181940	10006286/M8,0X30 SW5	30	M8	SW5
11227329	M6X16-25IP/10003048	16	M6	T25IP
11363595	M10X20 DIN 7991 10.9	20	M10	SW6
11363596	M10X35 DIN 7991 10.9	35	M10	SW6
11365730	M5X8 DIN 7991 10.9	8	M5	SW3
11377574	M6X12 SW4 DIN7991 10.9	6	M6	SW4
11417617	10006285/M8,0X20 SW5	20	M8	SW5
11450042	10006887/M3,5x8,6/15IP	8.6	M3.5	T15IP
11801691	M5X20 DIN 7991 10.9	20	M5	SW3
12535687	S-M6X18/T20 12.9 50060196	18	M6	T20
12535753	S-M4X8 ISO 10642 10.9	8	M4	SW2.5
11880977	M8X16 DIN 6912 10.9	16	M8	

螺丝  
SCREWS



# 钢管钢棒剥皮刀编码

Code for steel pipe and rod peeling knife

T	N	G	J	22	08		E	R	-	1C
1	2	3	4	5	6	7	8	9		10

源自ISO18322004-06-15

## 1

插入形状 Insert shape	
H = 120°	
O = 135°	
P = 108°	
S = 90°	
T = 60°	
C = 80° D = 55° E = 75° M = 86° V = 35°	
W = 80°	
L = 90°	
A = 85° B = 82° K = 55°	
R =	
X = Spec	

## 2

插入角度 Insertion angle	
A = 3° B = 5° C = 7° D = 15° E = 20° F = 25° G = 30° N = 0° P = 11° O = 特别的Special	

## 3

公差等级符号 Tolerance level symbol				公差 (mm) Tolerance in mm		刀片公差 Tolerance in mm		
符号 Symbol	内切圆公差 Inscribed circle tolerance $\phi$ D1 (mm)	公差 Tolerance m (mm)	刀片厚度 Insert thickness	D <sub>1</sub>		等级公差 Grade tolerance	等级公差 Grade tolerance	
				D <sub>1</sub> (mm)	J.K.L.M.N.	U	M - N	U
A	± 0,025	± 0,005	± 0,025	4,76	± 0,05	± 0,08	± 0,08	± 0,13
F	± 0,013			5,56				
C	± 0,025	6						
H	± 0,013	6,35						
E	± 0,025	± 0,025	7,94	± 0,08	± 0,13	± 0,13	± 0,20	
G		8						
J		± 0,005	8,525					
K		± 0,013	10					
L	± 0,05/0,15	± 0,025	± 0,025	12	± 0,10	± 0,18	± 0,15	± 0,27
M		± 0,08/0,20		12,7				
N		± 0,005	± 0,025	15,875	± 0,13	± 0,25	± 0,18	± 0,38
U	± 0,08/0,25	± 0,13/0,38		16				
			± 0,13	19,05	± 0,15	± 0,20	± 0,38	
			± 0,025	20				

## 4

切削槽代码 Codice scanalatura di taglio				
符号 Symbol	Hole ✓	形状 Fixing type	断削槽 Chip breaker	图形 Figure
W	✓	圆柱形孔 Cylindrical hole (40° -60°)	NO	
T	✓	圆柱形孔 Cylindrical hole (40° -60°)	单面 Single side	
Q	✓	圆柱形孔 Cylindrical hole (40° -60°)	No	
U	✓	圆柱形孔 Cylindrical hole (40° -60°)	两边 Both sides	
B	✓	圆柱形孔 Cylindrical hole (70° -90°)	No	
H	✓	圆柱形孔 Cylindrical hole (70° -90°)	单面 Single side	
C	✓	圆柱形孔 Cylindrical hole (70° -90°)	NO	
J	✓	圆柱形孔 Cylindrical hole (70° -90°)	两边 Both sides	

公差等级符号 Tolerance level symbol				
符号 Symbol	✓	形状 Fixing type	断削槽 Chip breaker	图形 Figure
	✓	圆柱形孔 Cylindrical hole	.No	
M	✓	圆柱形孔 Cylindrical hole	单面 Single side	
G	✓		两边 Both sides	
N	-		NO	
R	-		单面 Single side	
F	-		两边 Both sides	
X		特殊形状 Special shape		



## 5

内切圆直径 Diameter of inscribed circle	符号示例Symbol-examples i											
D <sub>1</sub>	插入形状 (侧面尺寸) Insert shape (dimensions from side to side)											
	H	O	P	S	T	C	D	E	M	V	W	R
3,97	-	-	-	03	06	-	04	-	-	06	02	-
4,76	-	-	-	04	08	04	05	04	04	08	L3	-
5,56	-	-	-	05	09	05	06	05	05	09	03	-
6,35	03	02	04	06	11	06	07	06	06	11	04	06
7,94	04	03	05	07	13	08	09	08	07	13	05	07
9,525	05	04	07	09	16	09	11	09	09	16	06	09
12,7	07	05	09	12	22	12	15	13	12	22	08	12
15,875	09	06	11	15	27	16	19	16	15	27	10	15
19,05	11	07	13	19	33	19	23	19	19	33	13	19
25,4	14	10	18	25	44	25	31	26	25	44	17	25
31,75	18	13	23	31	54	32	38	32	31	54	21	31

## 6

插入件厚度Spessoreinserto		
01	1,59	厚度参考 长度介于 底座和切削刃。 厚度为 从底座测量 刀片到零件的上边缘。 Thickness is referred to the length between base and cutting edge. Lo spessore è misurato dalla base dell' inserto alla parte superiore del tagliente.
T1	1,98	
02	2,38	
03	3,175	
T3	3,97	
04	4,76	
05	5,56	
06	6,35	
07	7,94	
08	8,00	
09	9,525	
11	11,11	
12	12,70	

## 7

刀片角配置/形成垂直刀片Insert corner configuration		
拐角半径符号Corner radius Symbol		倒角Chamfer
00		
	<b>Sharp edge</b>	A = 45° D = 60° E = 75° F = 85° P = 90° Z = 特殊的special
V3	0,03	
V5	0,05	
01	0,1	
02	0,2	
04	0,4	
08	0,8	
12	1,2	
16	1,6	
20	2,0	
24	2,4	
28	2,8	
32	3,2	
00 = Inch 英制 MO = metric 公制	圆形插入件Round insert	
		主偏角Cutting edge angle
		A = 3° B = 5° C = 7° D = 15° E = 20° F = 25° G = 30° N = 0° P = 11° O = Special / Speciale

## 8

前沿刀面形状Cutting edge condition		
符号Symbol	图形Figure	Condition
F		锋利刃口Sharpedge
E		园型刃口Rounded edge
T		刃口边缘倒角Chamfered edge
S		刃口倒角和倒圆边缘 Chamfered and rounded edge
K		双倒角边缘Double chamfered edge
P		双倒角和圆形边缘 Double chamfered and round edge

## 9

切割方向 Cutting direction

## 10

生产者内部代码 Producer internal code
断屑槽代码 Chip breaker code (P1-P2-03 ecc.)
非强制性代码 Not compulsory data



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**E-mail:grand@akotool.com**