

[図1]

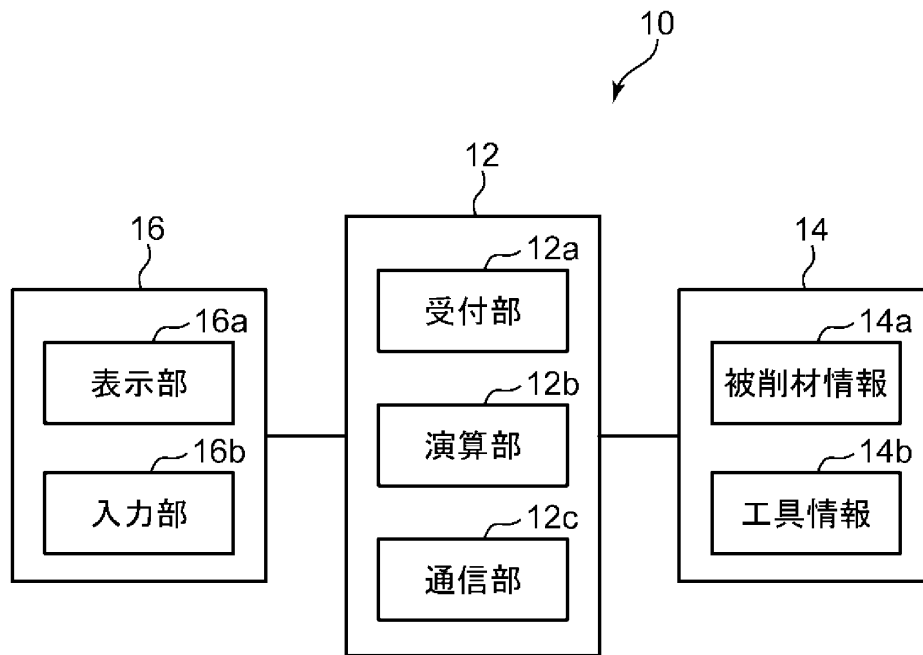


図2

入力履歴
呼び出し
保存
初期化

被削材
S45C

ホルダ形状
E22R-44B

リストから選択
手動入力
傾切れ対角
傾切れ傾さ角

チップ形状
06. 三菱マテリアル (TNMG220408 C)

カスタマイズ
ノーズR
先端角

切削条件
(参考) 切削速度
送り速度
半径切込み量

クーラント
(参考) あり

分断性
分断性
切れる
切れない

分断可否

分断予測値
0.095

破断境界
0.059

選択解除

ツール候補
メーカ
工具形状
VCM160404
CCMT060204
SANDVIK
CCMT060204

破断 (分断)
PSF
PSF
UF
PS

ヤング率
0.000
0.000
0.000
0.000

結果
分断予測

半径切込み量 mm

送り速度 mm/rev

チップ
三菱マテリアル (TNMG220408 C)

ツール候補
メーカ
工具形状
VCM160404
CCMT060204
SANDVIK
CCMT060204

破断 (分断)
PSF
PSF
UF
PS

ヤング率
0.000
0.000
0.000
0.000

終了時、自動保存

分断性
分断性
切れる
切れない

分断可否

分断予測値
0.095

破断境界
0.059

選択解除

ツール候補
メーカ
工具形状
VCM160404
CCMT060204
SANDVIK
CCMT060204

破断 (分断)
PSF
PSF
UF
PS

ヤング率
0.000
0.000
0.000
0.000

送り速度 f

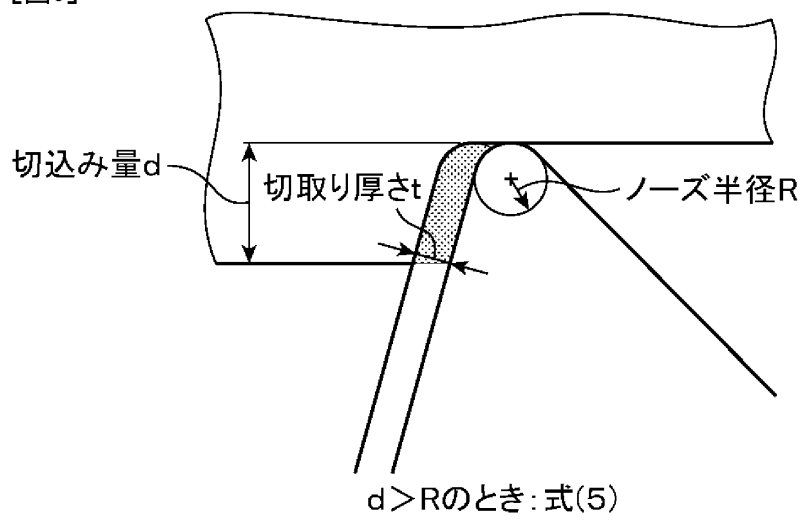
切込み量 d

ノーズ半径 R

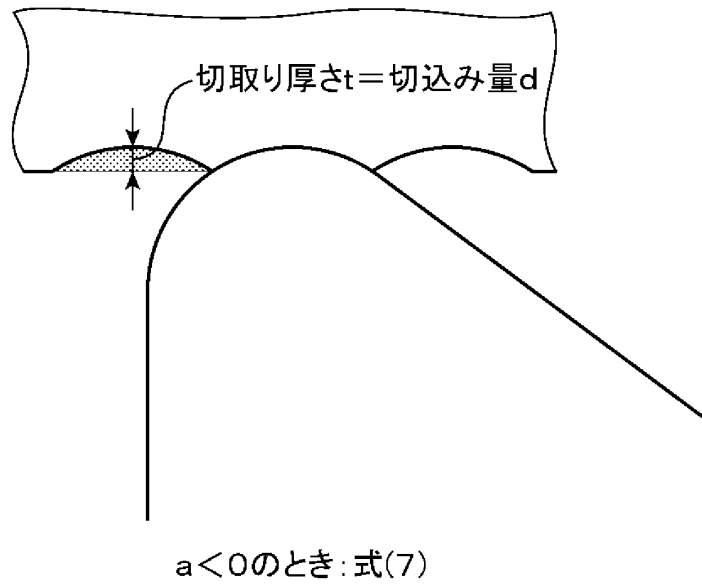
切取り厚さ t

切りくず流出方向 θ_d

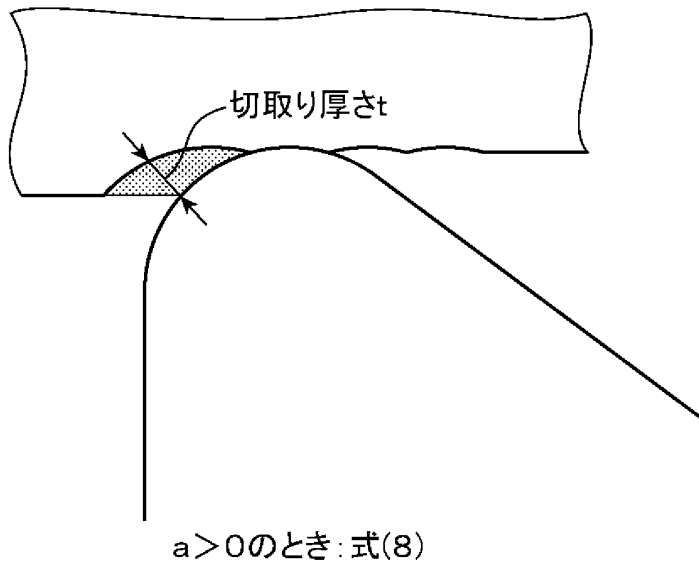
[図6]



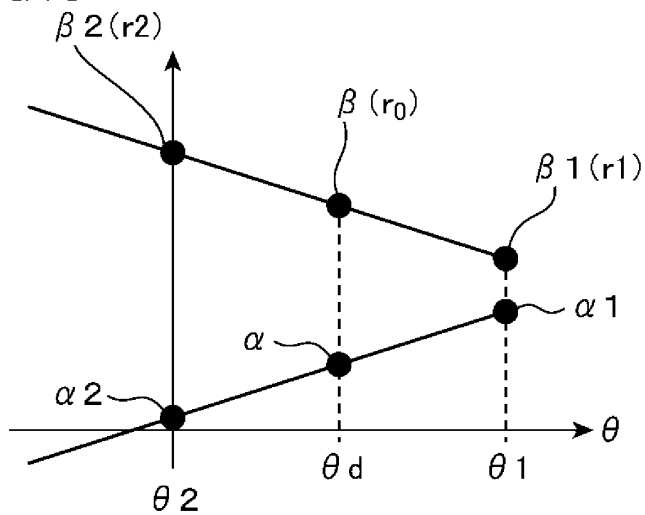
[図7]



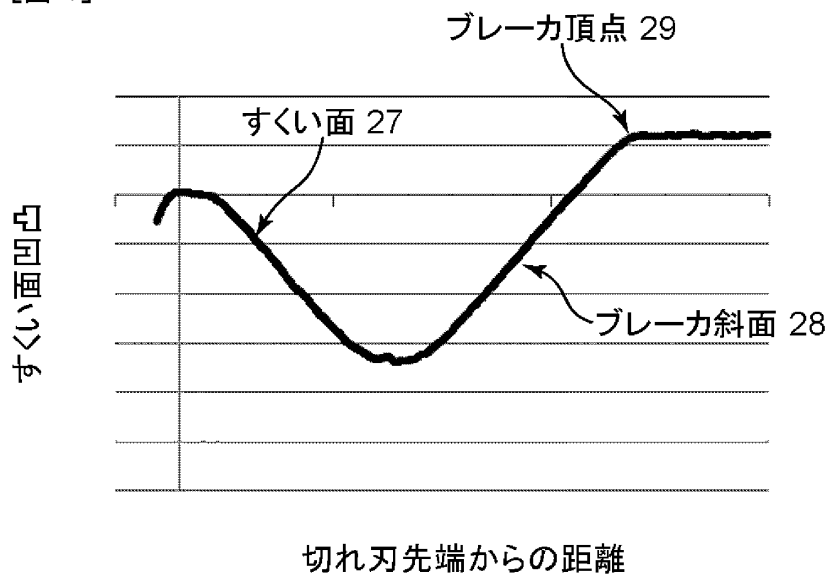
【図8】



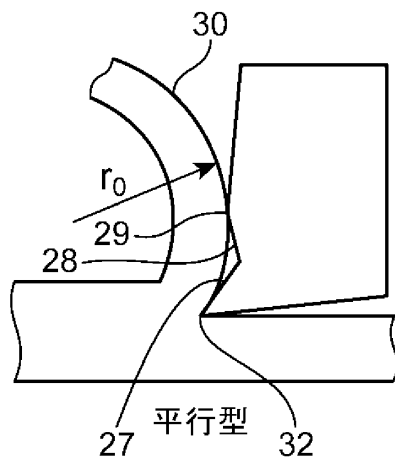
【図9】



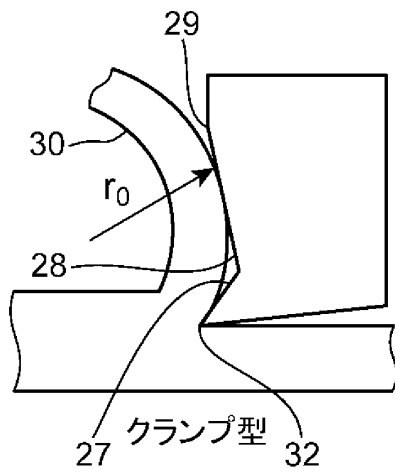
【図10】



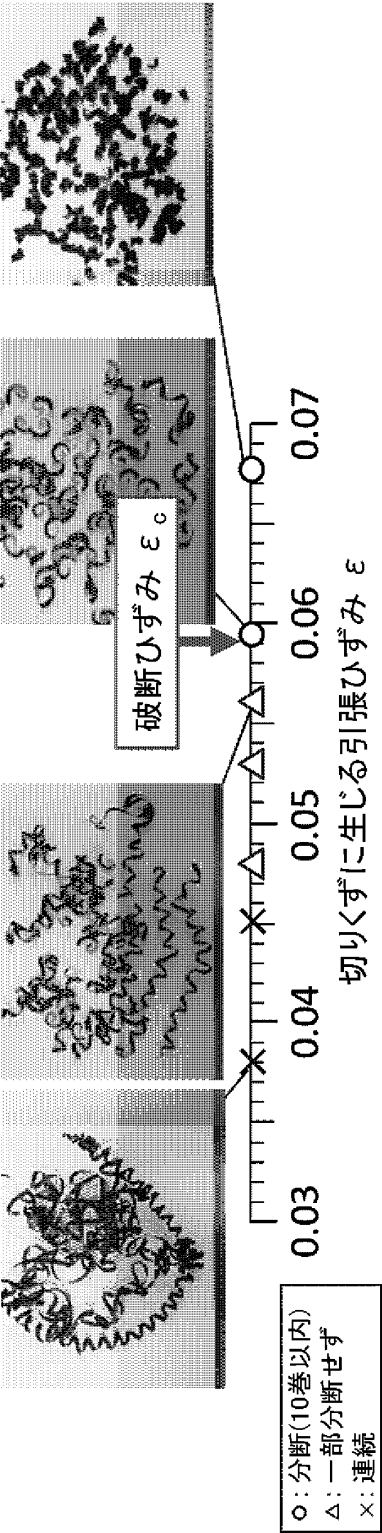
[図11A]



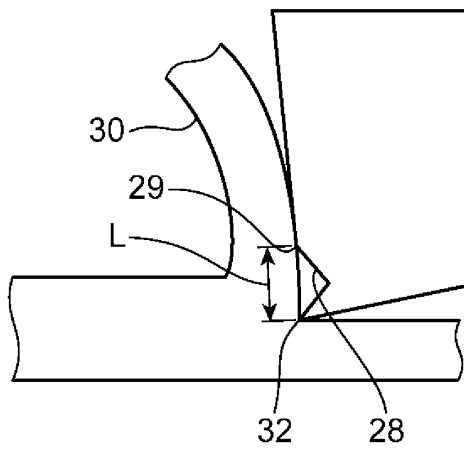
[図11B]



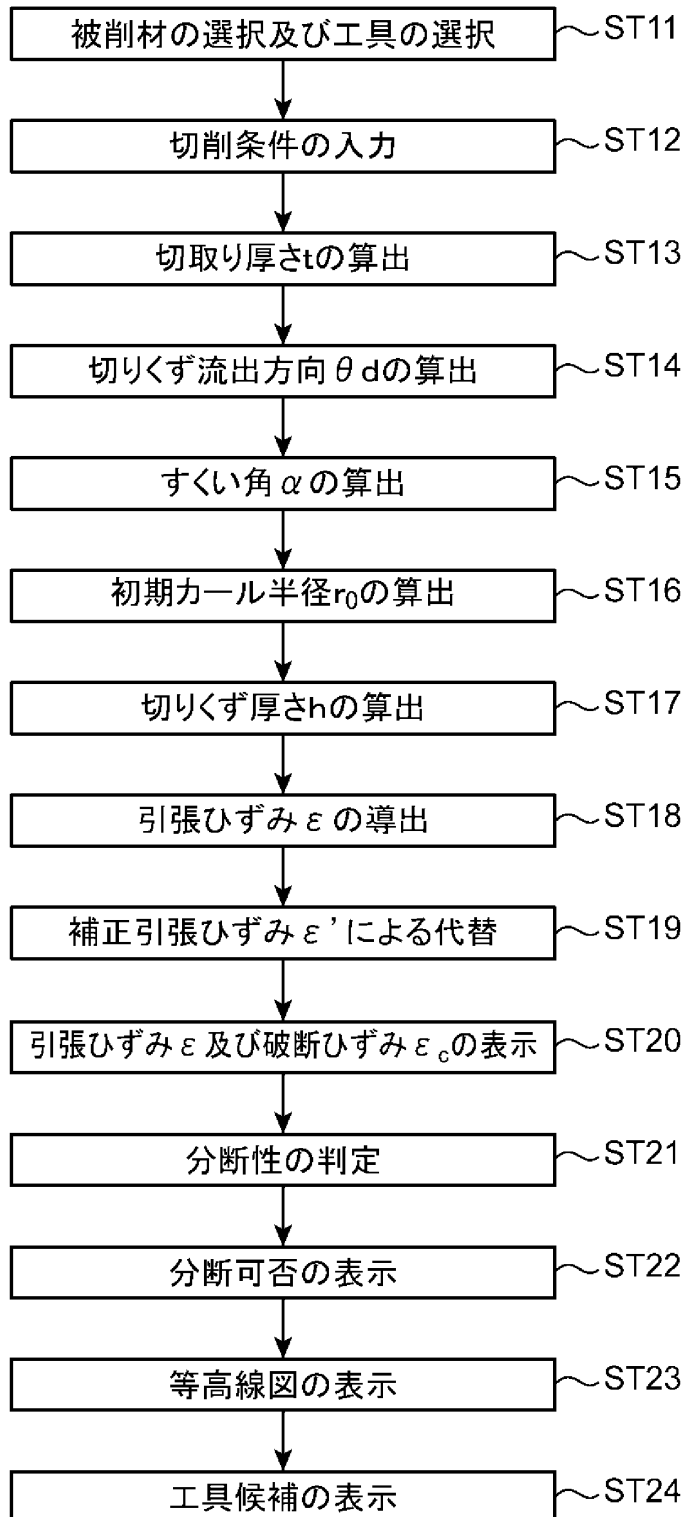
[図12]



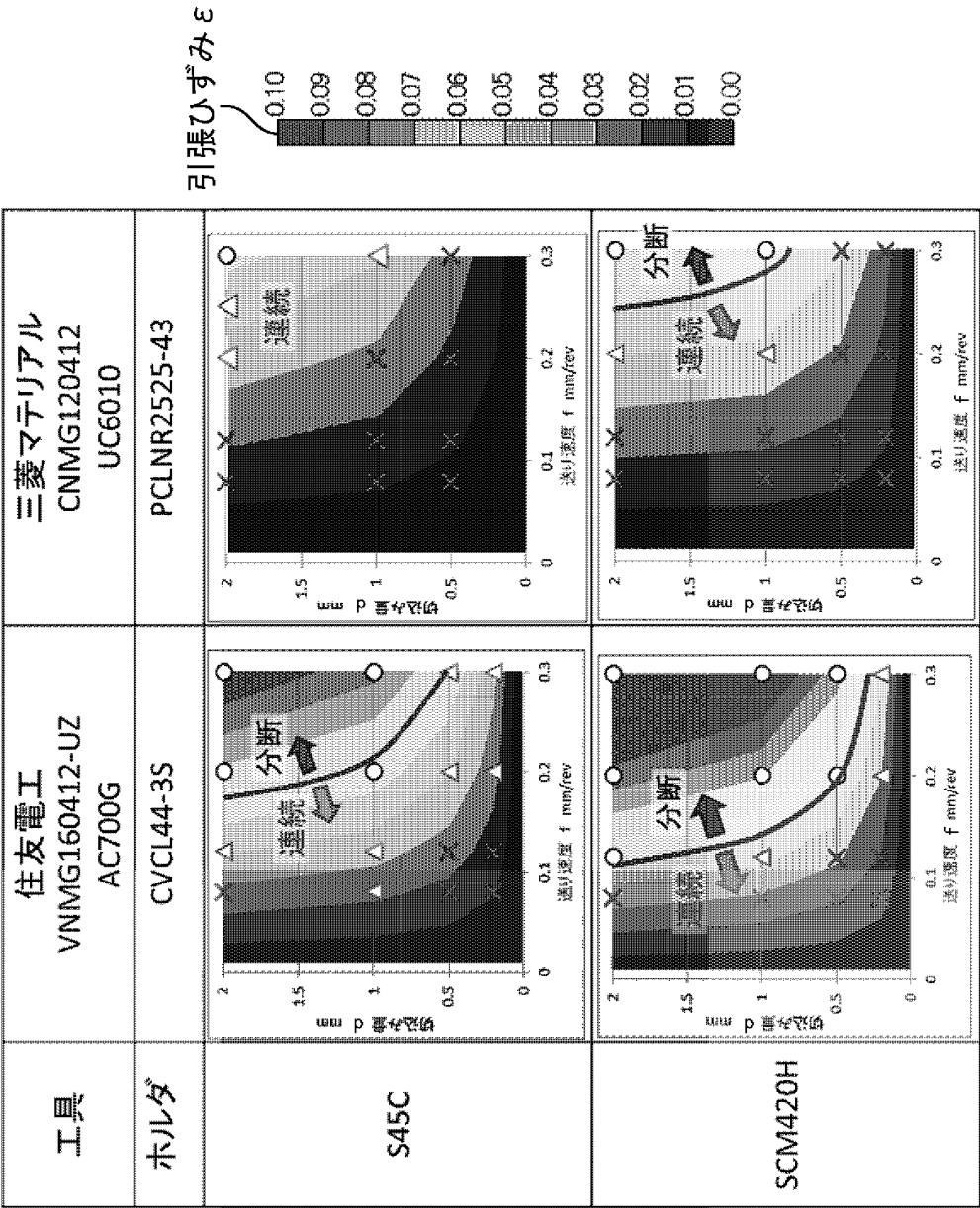
[図13]



[図14]



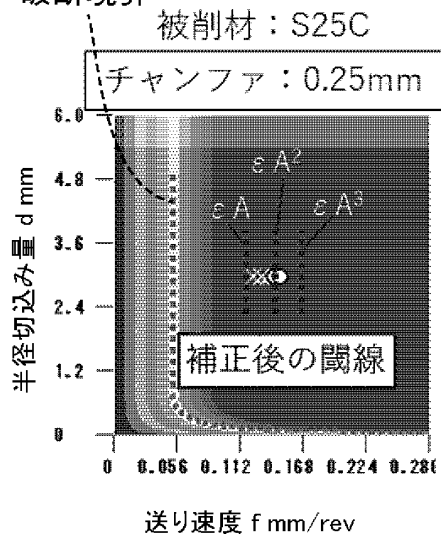
[図15]



WO 2025/110065

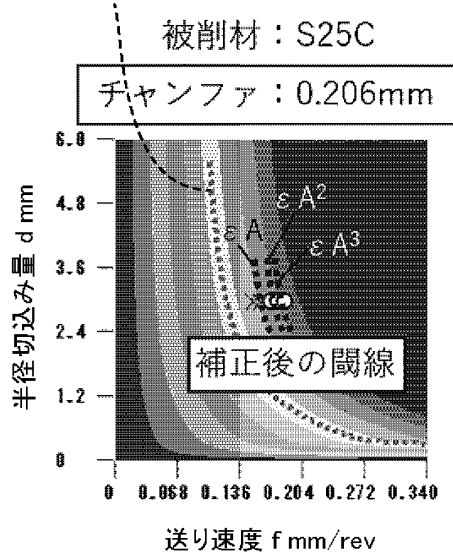
PCT/JP2024/040204

[図16A]
補正前の
破断境界



[図16B]

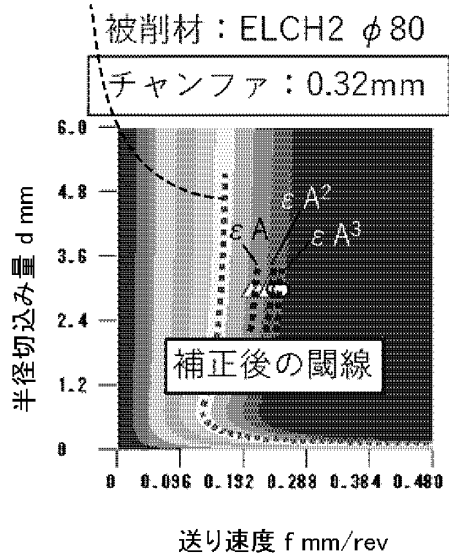
補正前の
破断境界



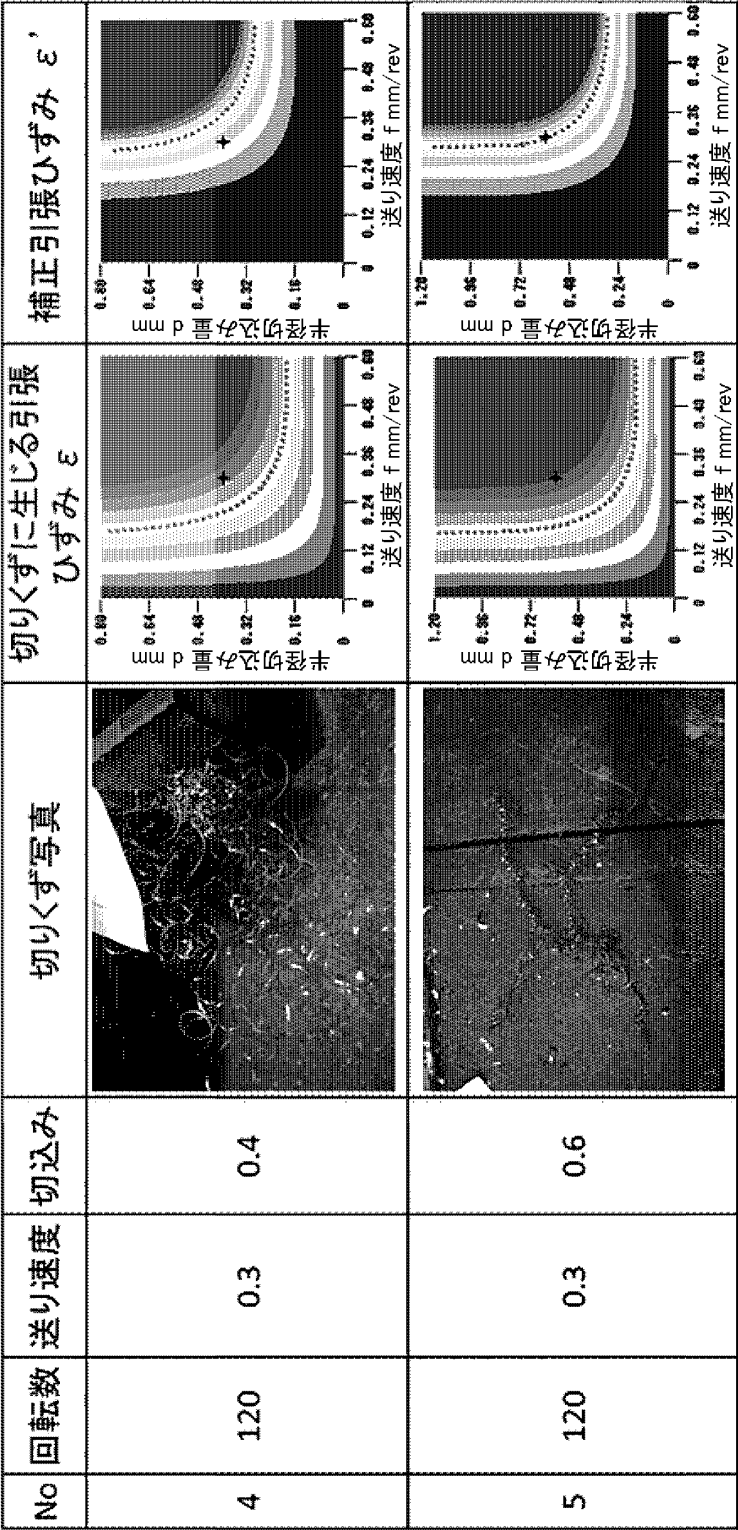
WO 2025/110065

PCT/JP2024/040204

[図16C]
補正前の
破断境界

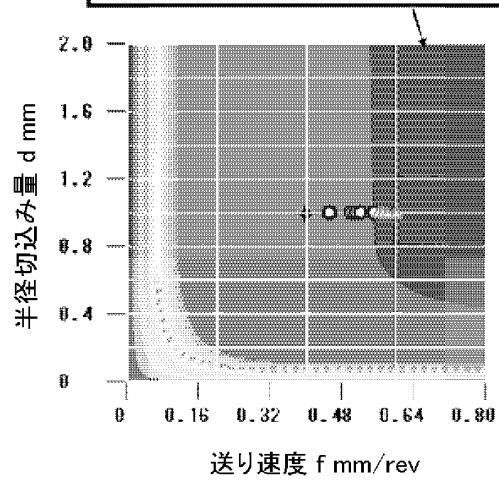


[図17]

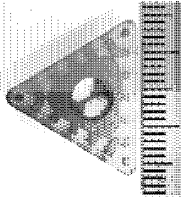
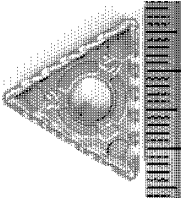
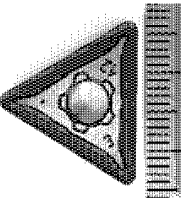
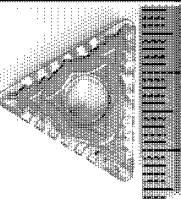
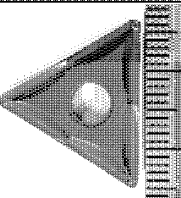
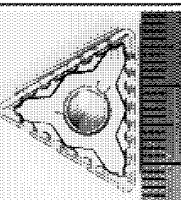
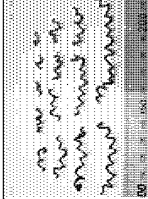
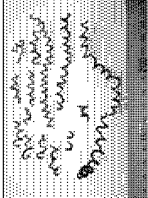
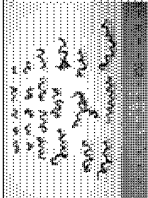
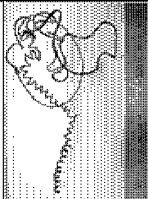
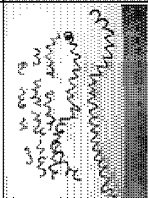
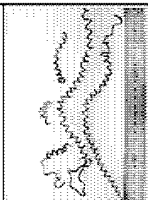
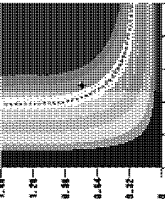
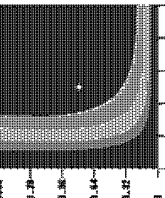
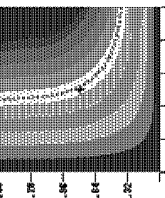
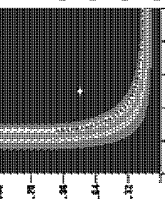
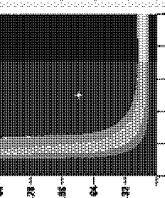
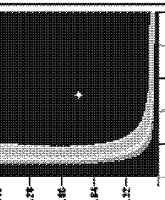
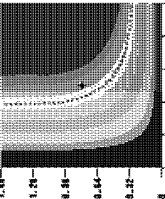
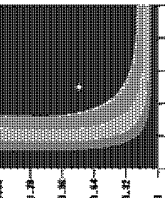
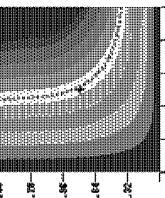
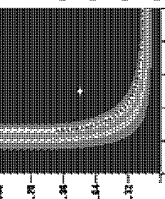
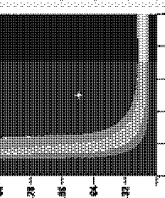
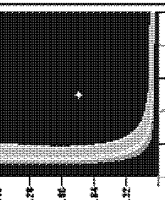


[図18]

サンドビック CNMG120408-SF H13A

切りくず厚さ h >ブレーカ頂点までの距離 L 

[図19]

メーカー	タンガロイ	タンガロイ	イ斯卡ル	京セラ	三菱マテリアル	三菱マテリアル
チップ型番	TNMG220412	TNMG220412	TNMG220412	TNMG220412	TNMG220408	TNMG220412
チップブレード記号(材種)	27	ZM(T9125)	M3M(IC6015)	CQ(OA515)	C(NX3035)	SA(UE6110)
工具写真						
						
切りくず写真 V:200 m/min f:0.35 mm/rev						
分断予測結果						

[図20]

