

ET シリーズ

ETA Cut-off and Grooving Inserts ET Series 突切り&溝入れ加工

高送り加工で、加工能率が格段に向上!
高剛性のクランプ力で、安定した品質を保持!

High feed rate machining with greatly improved cutting efficiency.
Highly rigid clamping, maintaining stable quality.

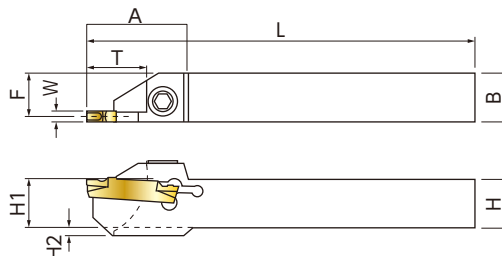
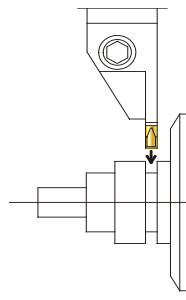
最大突切り径φ36
Maximum Cut-off Diameter φ36



高速の切削力
High-speed machining power

特徴 Feature

- 日進初の三次元ブレーカ採用!
- 抜群の切れ味で難削材に有効。
- 剛性があり、非常に強い工具。
- First-ever Nissin 3-dimensional chipbreaker adopted!
- Outstanding sharpness and is effective in machining difficult-to-cut materials.
- Extremely strong tool with rigidity.



適用ホルダー Applicable Holder

型番 Part Number	寸法 Dimensions (mm)							最大突切り径 Maximum Cut-off Diameter	適用チップ Applicable Insert	クランプネジ Clamp screw	レンチ Wrench	定価(円) Original Price (yen)			
	A	T	W	H/H1	B	F	H2						L		
ETKHR/L 10015-T10	20.5	10	1.5	10	10	9.5	2	125	φ8	CB416	LH30	18,000			
ETKHR/L 12020-T10			2	10	10	9.5			φ16			13,900			
ETKHR/L 12020-T13	22	13	2	12	12	11.2	2	125	φ22	CB416	LH30	13,900			
ETKHR/L 12020-T17	27	17	2	12	12	11.2			φ30			13,900			
ETKHR/L 16025-T17	27	17	2.5	16	16	14.8	—	125	φ30	CB515	LH40	14,300			
ETKHR/L 16030-T16			16			15.1			φ28			14,300			
ETKHR/L 16030-T20	30	20	3	20	20	18.7	—	125	φ36	ETA○5030○	HB520	14,300			
ETKHR/L 20030-T20	36					20						18.7	—	125	15,000
ETKHR/L 25030-T20	36					25						25	23.7	—	150

※ETA4310Kの最大突切り径はφ7です。
※ The maximum parting off diameter of the ETA4310K is up to 7mm.

推奨切削条件 Recommended cutting conditions

被削材 Work Material	SUS304	SUS316	S45C	SCM435	SS41	耐熱合金 Heat-resistant alloy
周速 Peripheral Speed(m/min)	60~110	50~80	80~160	80~130	80~150	15~40
送り量 Feed Rate (mm/rev)	RE0.2	0.05~0.12	0.05~0.1	0.05~0.15	0.05~0.15	0.04~0.08
	RE0.03	0.03~0.07	0.025~0.05	0.035~0.07	0.03~0.07	0.02~0.045

■ チップ素材 Insert Material

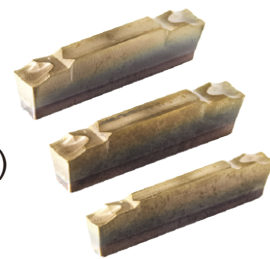
『SPC-30G』超硬超微粒子に高滑り性・耐熱性・高速切削性に優れたSPCコート

Ultrafine particle carbide with SPC coating that is superior in high-speed machining, heat resistance, and high lubricity.

『NC-35G』超硬超々微粒子で高靱性・高滑り性の高送り用チップ(PVDコート)

Super ultrafine particle carbide, high feed rate insert that is extremely tough and has high lubricity. (PVD coating)

「NC-35G」については受注生産となります。「NC-35G」 are made-to-order.



■ チップ型番 Insert Number

形状 Part Number	型番 Part Number	寸法 Dimensions (mm)				θ°	適用ホルダー Applicable Holder	定価(円) Original Price (yen)		
		W	RE	L	h					
フラットタイプ Flat type 	ETAF 4310K*	1.0	0.03	19.6	4.3	0	ETKHR/L 10015-T10	2,700		
	ETAF 4314K*	1.4	0.03	19.6	4.3			2,700		
	ETAF 4315K	1.5	0.03	19.6	4.3			2,500		
	ETAF 4315K02*	1.5	0.2	20	4.3			3,300		
	ETAF 4320K	2	0.03	19.6	4.3			ETKHR/L 12020-T10 ETKHR/L 12020-T17 ETKHR/L 12020-T13	1,900	
	ETAF 4320K02	2	0.2	20	4.3				1,900	
	ETAF 5022K*	2.2	0.03	19.6	4.3				2,600	
	ETAF 5025K	2.5	0.03	19.6	5			0	ETKHR/L 16025-T17	2,100
	ETAF 5030K	3	0.03	19.6	5				ETKHR/L 16030-T16 ETKHR/L 20030-T20 ETKHR/L 16030-T20 ETKHR/L 25030-T20	2,100
	ETAF 5030K02	3	0.2	20	5				2,100	
リード角付 θ° Lead Angle θ° 	ETAR 4310K-20	1.0	0.03	19.6	4.3	20	ETKHR/L 10015-T10	2,700		
	ETAR 4314K-6	1.4	0.03	19.6	4.3	6		2,700		
	ETAR 4320K-6	2	0.03	19.6	4.3	6	ETKHR/L 12020-T10 ETKHR/L 12020-T17 ETKHR/L 12020-T13	1,900		
	ETAR 4320K02-6	2	0.2	20	4.3			1,900		
	ETAR 5022K-6	2.2	0.03	19.6	4.3			2,600		
	ETAR 5025K-6	2.5	0.03	19.6	5	ETKHR/L 16025-T17	2,100			
	ETAR 5030K-6	3	0.03	19.6	5		ETKHR/L 16030-T16 ETKHR/L 20030-T20 ETKHR/L 16030-T20 ETKHR/L 25030-T20	2,100		
	ETAR 5030K02-6	3	0.2	20	5		2,100			
	ETAR 4315K-15	1.5	0.03	19.6	4.3	15	ETKHR/L 10015-T10	2,600		
	ETAR 4320K-15	2	0.03	19.6	4.3		ETKHR/L 12020-T10 ETKHR/L 12020-T17 ETKHR/L 12020-T13	1,900		
	ETAR 4320K02-15	2	0.2	20	4.3			1,900		
	ETAR 5025K-15	2.5	0.03	19.6	5		ETKHR/L 16025-T17	2,100		
	ETAR 5030K-15	3	0.03	19.6	5		ETKHR/L 16030-T16 ETKHR/L 20030-T20 ETKHR/L 16030-T20 ETKHR/L 25030-T20	2,100		
	ETAR 5030K02-15	3	0.2	20	5			2,100		

※★印は標準在庫品。在庫量が少ないため、即納でない可能性があります。※ The ★ mark is for semi-standard stocked parts. Prompt delivery may not be available due to low levels of stock.

■ ET突切りシリーズ 切削事例 ET Cut-off Series Machining Case Study

被削材 Work Material	切削条件 Cutting Conditions	ユーザーのコメント User comments	使用チップ Applied insert
SUS304 (C社 20型) Company C Model 20	$\phi 10$ 材 workpiece $\phi 10$ 3,000回転(90m) 3,000 revolutions (90m) $f=0.12\text{mm/rev}$	加工時間が大幅に短縮でき、生産能率が向上した。 Greatly reduced processing time and improved production efficiency.	ETAF 4320K02
S45C (S社 20型) Company S Model 20	$\phi 12$ 材 workpiece $\phi 12$ 4000回転(150m) 4,000 revolutions (150m) $f=0.1\text{mm/rev}$	生産効率の向上と工具費の費用対効果が3割減になった。 Improved production efficiency and reduced the cost of tool expenses versus effectiveness by 30%.	ETAR 4320K-6
SCM435 (S社 20型) Company S Model 20	$\phi 10$ 材 workpiece $\phi 10$ 3,800回転(119m) 3,800 revolutions (119m) $f=0.08\text{mm/rev}$	面粗度が良くなり、不良率が大幅に下がり客先との信頼関係が増した。 Surface roughness improved, defect rates dropped dramatically, and mutual trust with clients increased.	ETAF 4320K
SUJ2 (S社 32型) Company S Model 32	$\phi 29$ 材 workpiece $\phi 29$ 2,000回転(182m) 2,000 revolutions (182m) $f=0.05\text{mm/rev}$	他メーカーで300個の寿命が600~700個の寿命になった。 作業効率も上がり大変良し。 The tool life of 300 pieces from another manufacture became a tool life of 600-700 pieces. Work efficiency increased and are very satisfied.	ETAF 5025K