DORMER PRAMET

TORNALAMA

2024



PRAMET

ISO TORNALAMA

Pozitif uçlar



	P	M	K	N	S	H	
Talaş kırıcı navigatörler							6
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F Finiş	FM UR W	NF2 FM	UR FM	AL	NF2	.CMW	33
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HR Ağır kaba işleme	OR DR4	OR					67

TAKIMLAR

uç şekline göre — 69



bağlama stiline göre — 154



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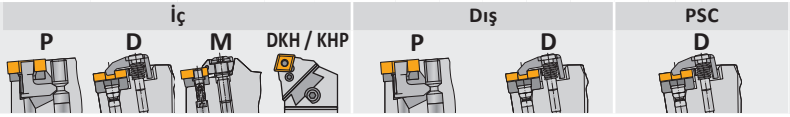
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DİŞ TORNALAMA

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BROŞLAMA & TORNA KALEMLERİ

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ÜRÜN GRUBU	🕮
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CNMG	194
DNMG	195
SNMG	196
TNMG	196
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CNMG	169
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SNMG	170
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TNMG	208
VNMG	208
WNMG	209
NMR	202
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DNMG	203
SNMG	204
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CNMM	224
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TNMM	232
WNMM	232
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SCMT	57
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WCMT	57
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SNMG	183
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ECGT	21
SCGT	21
TCGT	21
VCGT	22
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DCGT	55
TCGT	55
SI	198
CNMG	199
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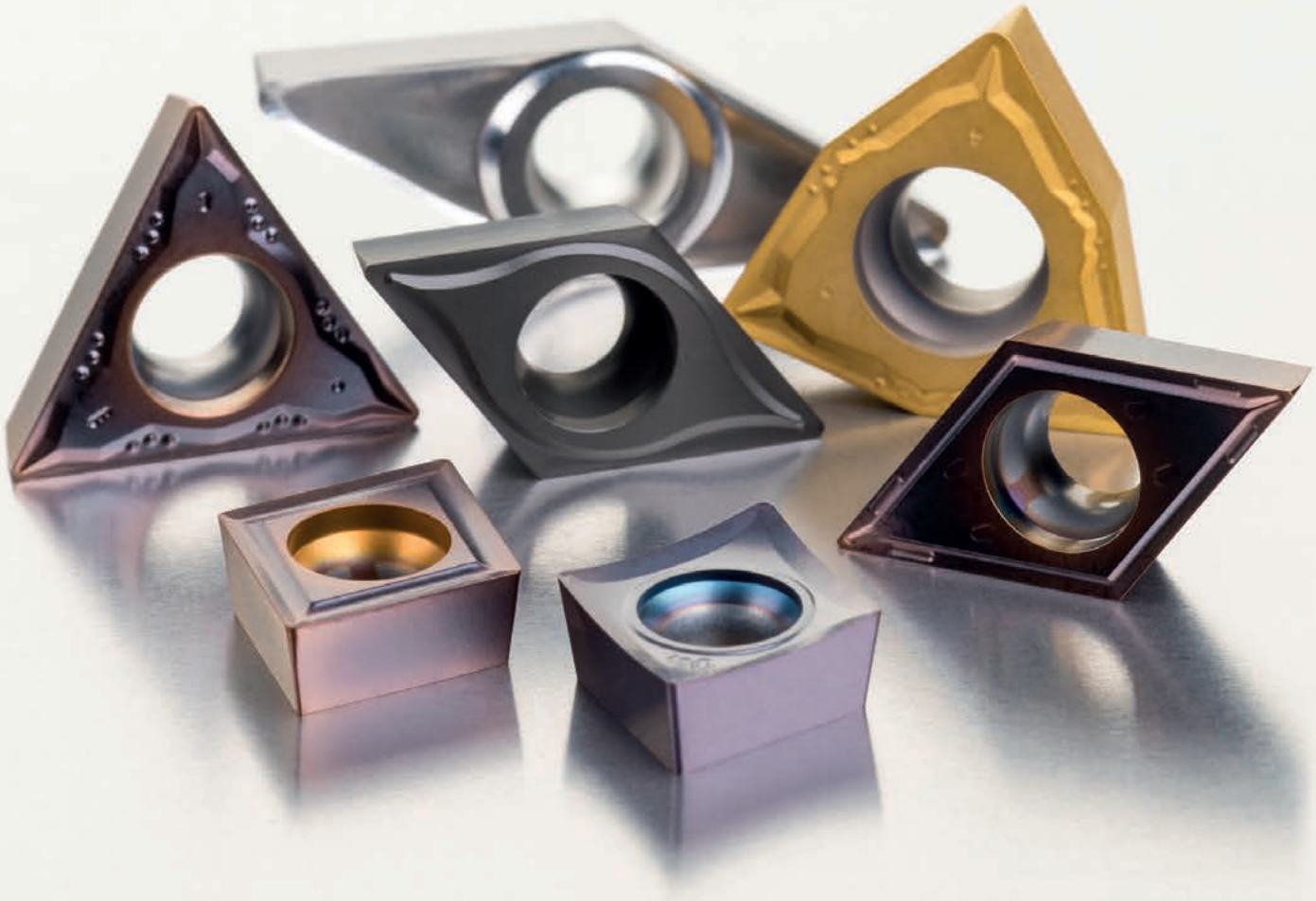
DEĞİŞTİRİLEBİLİR KESİCİ UÇLAR – İÇERİK (ALFABETİK)

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POZİTİF KESİCİ UÇLAR

P

Rijit olmayan işleme koşulları

Biraz daha kötü işleme koşulları

Rijit işleme koşulları

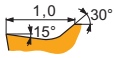
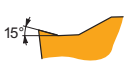
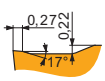
İnce cidarlı ve zayıf iş parçaları

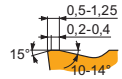
1. Tercih

Olası kullanım



	FF	F	M	R	HR
f	0.05 – 0.2 mm/dev	0.05 – 0.2 mm/dev	0.2 – 0.4 mm/dev	0.4 – 1.0 mm/dev	> 1.0 mm/dev
a_p	0.05 – 2 mm	0.05 – 2 mm	2 – 4 mm	4 – 10 mm	> 10 mm

UR		İnce talaşlı ve yüzey işleme, çelikler ve dökme demirler ve potansiyel olarak paslanmaz çelik, sürekli ve darbeli kesimler için tasarlanmıştır
FM		İnce talaşlı ve yarı kaba işleme, çelikler ve paslanmaz çelikler, potansiyel olarak dökme demirler ve demir içermeyen malzemeler, sürekli ve orta darbeli kesimler için tasarlanmıştır
RM		Yarı kaba işleme, çelikler, paslanmaz çelikler ve dökme demirler, potansiyel olarak süper alaşımlar ve sertleştirilmiş malzemeler, sürekli ve darbeli kesimler için tasarlanmıştır

OR		Kaba ve ağır kaba işleme, çelikler, paslanmaz çelikler ve dökme demirler, potansiyel olarak süper alaşımlar, sürekli ve darbeli kesimler için tasarlanmıştır

M

Rijit olmayan işleme koşulları

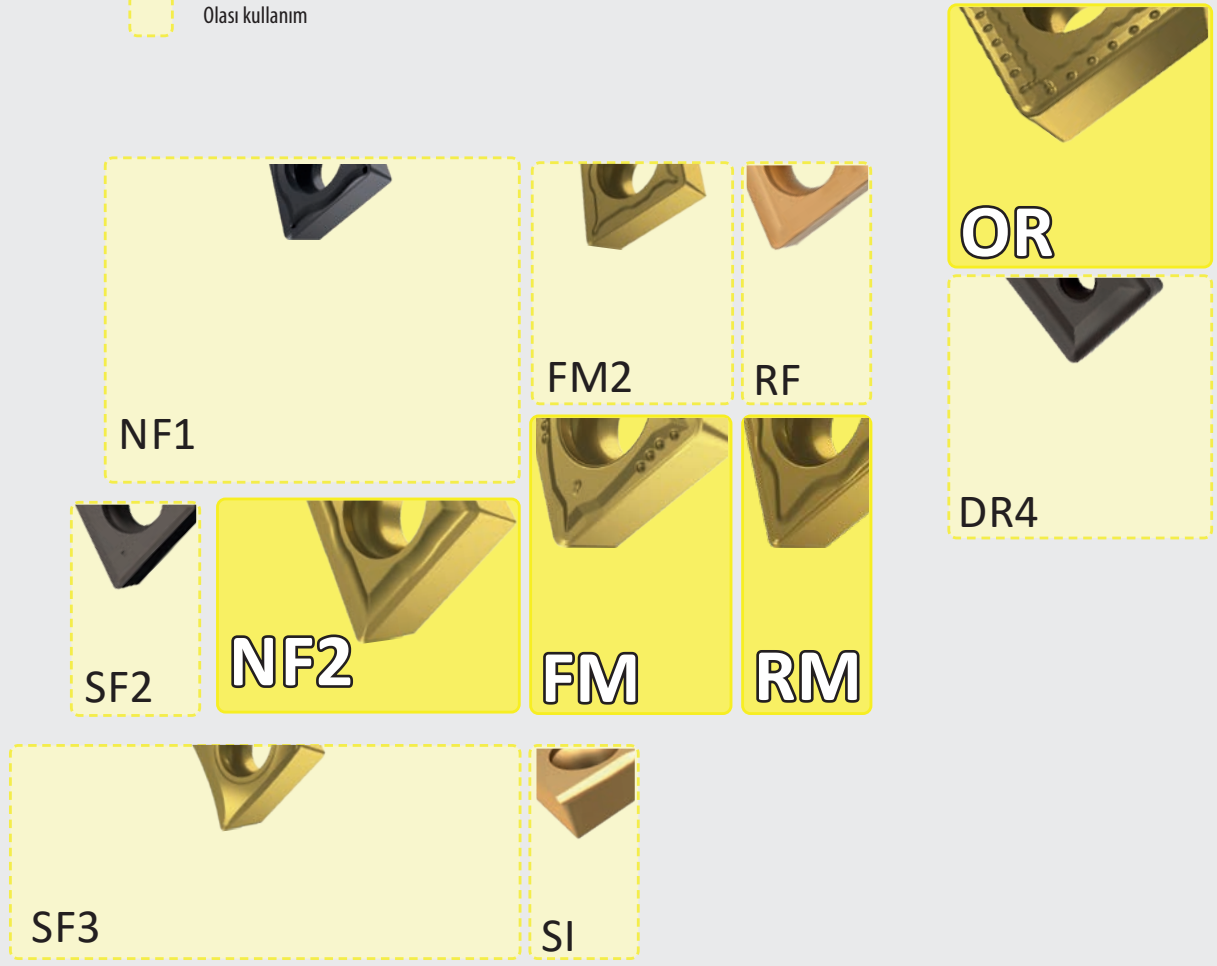
Biraz daha kötü işleme koşulları

Rijit işleme koşulları

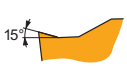
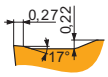
İnce cidarlı ve zayıf iş parçaları

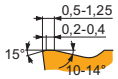
1. Tercih

Olası kullanım



	FF	F	M	R	HR
f	0.05 – 0.2 mm/dev	0.05 – 0.2 mm/dev	0.2 – 0.4 mm/dev	0.4 – 1.0 mm/dev	> 1.0 mm/dev
a_p	0.05 – 2 mm	0.05 – 2 mm	2 – 4 mm	4 – 10 mm	> 10 mm

NF2		İnce finiş işlemeden yarı kaba işlemeye, paslanmaz çelikler ve süper alaşımlar, sürekli kesim için pozitif tasarım
FM		İnce talaşlı ve yarı kaba işleme, çelikler ve paslanmaz çelikler, potansiyel olarak dökme demirler ve demir içermeyen malzemeler, sürekli ve orta darbeli kesimler için tasarlanmıştır
RM		Yarı kaba işleme, çelikler, paslanmaz çelikler ve dökme demirler, potansiyel olarak süper alaşımlar ve sertleştirilmiş malzemeler, sürekli ve darbeli kesimler için tasarlanmıştır

OR		Kaba ve ağır kaba işleme, çelikler, paslanmaz çelikler ve dökme demirler, potansiyel olarak süper alaşımlar, sürekli ve darbeli kesimler için tasarlanmıştır

K

Rijit olmayan işleme koşulları

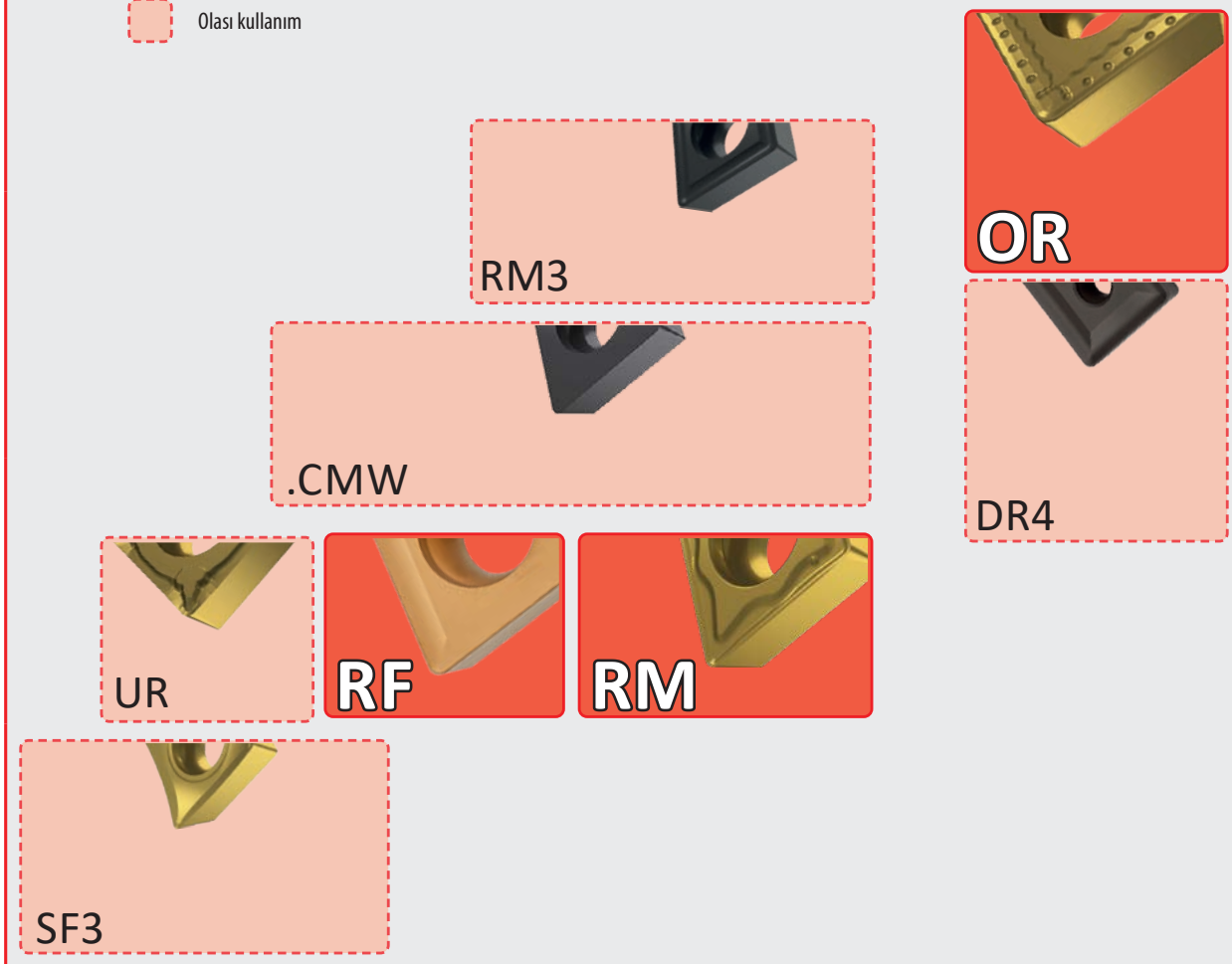
Biraz daha kötü işleme koşulları

Rijit işleme koşulları

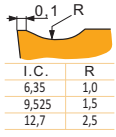
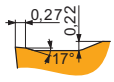
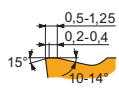
İnce cidarlı ve zayıf iş parçaları

1. Tercih

Olası kullanım



	FF	F	M	R	HR
f	0.05 – 0.2 mm/dev	0.05 – 0.2 mm/dev	0.2 – 0.4 mm/dev	0.4 – 1.0 mm/dev	> 1.0 mm/dev
a_p	0.05 – 2 mm	0.05 – 2 mm	2 – 4 mm	4 – 10 mm	> 10 mm

RF	 I.C. / R: 6,35 / 1,0; 9,525 / 1,5; 12,7 / 2,5	Kaba işleme, dökme demirler, potansiyel olarak çelikler paslanmaz çelikler ve sert malzemeler , sürekli ve darbeli kesimler için tasarlanmıştır
RM		Yarı kaba işleme, çelikler, paslanmaz çelikler ve dökme demirler, potansiyel olarak süper alaşımlar ve sertleştirilmiş malzemeler, sürekli ve darbeli kesimler için tasarlanmıştır
OR		Kaba ve ağır kaba işleme, çelikler, paslanmaz çelikler ve dökme demirler, potansiyel olarak süper alaşımlar, sürekli ve darbeli kesimler için tasarlanmıştır

N

Rijit olmayan işleme koşulları

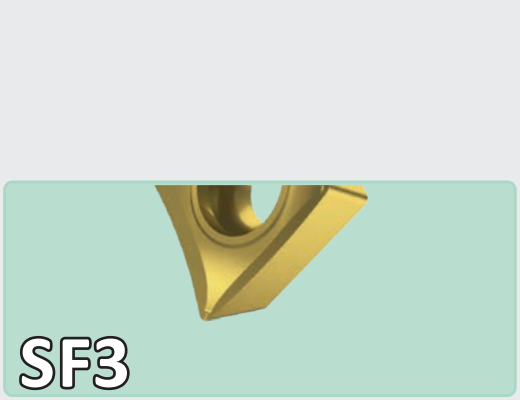
Biraz daha kötü işleme koşulları

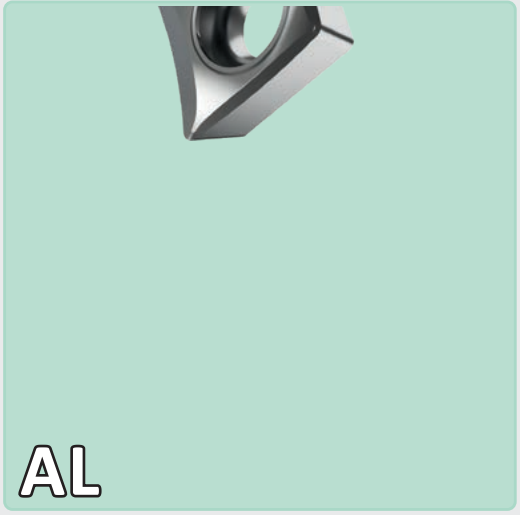
Rijit işleme koşulları

İnce cidarlı ve zayıf iş parçaları

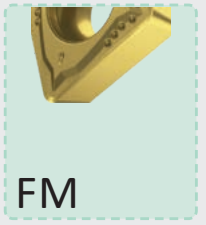
1. Tercih

Olası kullanım

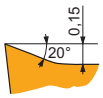








	FF	F	M	R	HR
f ⇨	0.05 – 0.2 mm/dev	0.05 – 0.2 mm/dev	0.2 – 0.4 mm/dev	0.4 – 1.0 mm/dev	> 1.0 mm/dev
a_p	0.05 – 2 mm	0.05 – 2 mm	2 – 4 mm	4 – 10 mm	> 10 mm

SF3		İnce ve finiş işleme, süper alaşımlar, paslanmaz çelikler ve demir içermeyen malzemeler, potansiyel olarak çelikler, dökme demirler ve sert malzemelerde sürekli kesimler için çok pozitif tasarım
AL		İnce finiş işlemeden kaba işlemeye, alüminyum, alüminyum alaşımları ve diğer demir içermeyen malzemeler, potansiyel olarak süper alaşımlar, sürekli kesimler için yüksek ölçüde pozitif tasarım

S

1. Tercih

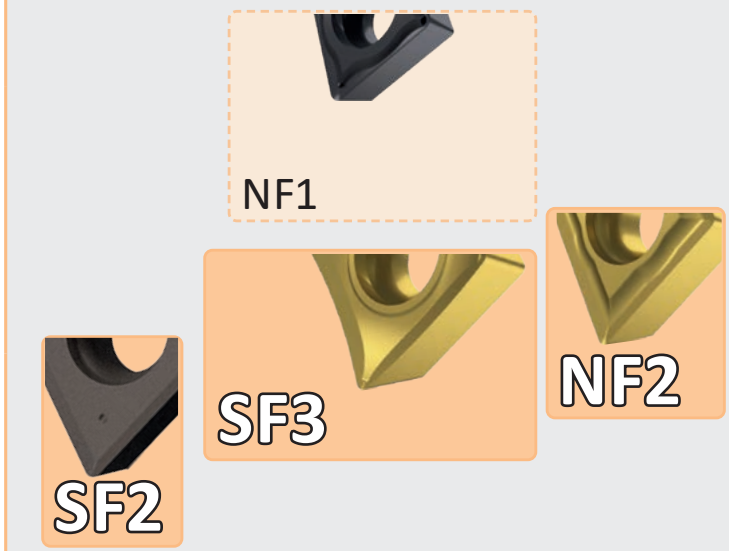
Olası kullanım

Rijit olmayan işleme koşulları

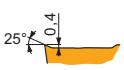
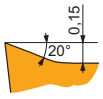
Biraz daha kötü işleme koşulları

Rijit işleme koşulları

İnce cidarlı ve zayıf iş parçaları



	FF	F	M	R	HR
f	0.05 – 0.2 mm/dev	0.05 – 0.2 mm/dev	0.2 – 0.4 mm/dev	0.4 – 1.0 mm/dev	> 1.0 mm/dev
a_p	0.05 – 2 mm	0.05 – 2 mm	2 – 4 mm	4 – 10 mm	> 10 mm

SF2		İnce ve finiş işleme, süper alaşımlar, potansiyel olarak paslanmaz çelikler, çelikler ve demir içermeyen malzemelerde sürekli kesimler için çok pozitif tasarım
SF3		İnce ve finiş işleme, süper alaşımlar, paslanmaz çelikler ve demir içermeyen malzemeler, potansiyel olarak çelikler, dökme demirler ve sert malzemelerde sürekli kesimler için çok pozitif tasarım
NF2		İnce finiş işlemeden yarı kaba işlemeye, paslanmaz çelikler ve süper alaşımlar, sürekli kesim için pozitif tasarım

H

1. Tercih

Olası kullanım

Rijit olmayan işleme koşulları

Biraz daha kötü işleme koşulları

Rijit işleme koşulları

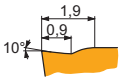
İnce cidarlı ve zayıf iş parçaları

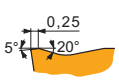


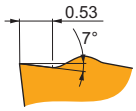
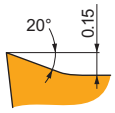
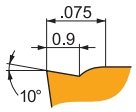
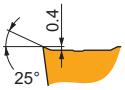
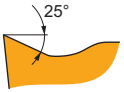
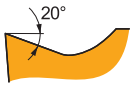




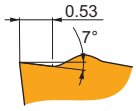
	FF	F	M	R	HR
f	0.05 – 0.2 mm/dev	0.05 – 0.2 mm/dev	0.2 – 0.4 mm/dev	0.4 – 1.0 mm/dev	> 1.0 mm/dev
a_p	0.05 – 2 mm	0.05 – 2 mm	2 – 4 mm	4 – 10 mm	> 10 mm

SF3		İnce ve finiş işleme, süper alaşımlar, paslanmaz çelikler ve demir içermeyen malzemeler, potansiyel olarak çelikler, dökme demirler ve sert malzemelerde sürekli kesimler için çok pozitif tasarım
NF1		İnce finiş işlemeden orta işlemeye, paslanmaz çelikler ve süper alaşımlar, potansiyel olarak çelikler, demir içermeyen ve sert malzemelerde sürekli kesimler için pozitif tasarım
.CMW		İnce finiş işlemeden yarı kaba işlemeye, dökme demirler, potansiyel olarak sert malzemeler, sürekli ve hafif darbeli kesimler için tasarlanmıştır

RM3		Kaba işleme, dökme demirler, potansiyel olarak çelikler paslanmaz çelikler ve sert malzemeler , sürekli ve darbeli kesimler için tasarlanmıştır

FF2			**FF2** talaş kırıcı, çeliklerin ince finiş işlemleri için ilk tercihtir. T-land olmadan hafif pozitif eğim açısına sahiptir. Dökme demirler için de uygundur.
SF3			**SF3** talaş kırıcı, Paslanmaz çeliklerin ve Süper alaşımların ince finiş işlemleri için ilk tercihtir. T-land olmadan son derece pozitif eğim açısına sahiptir. Ayrıca demir dışı alaşımlar ve koşullara uygun olarak Çelikler, Dökme demirler ve Sert malzemeler için de uygundur.
NF1			**NF1** talaş kırıcı keskindir ve Çeliklerin, Paslanmaz çeliklerin ve Süper alaşımların ince finişi için tasarlanmıştır. T-land olmadan pozitif eğim açısına sahiptir. Ayrıca demir dışı alaşımlar ve sert malzemeler için de şartlı olarak uygundur.
SF2			**SF2** talaş kırıcı keskindir ve Paslanmaz çeliklerin ve Süper alaşımların ince finişi için tasarlanmıştır. T-land olmadan son derece pozitif eğim açısına sahiptir. Çelikler ve demir dışı alaşımlar için de şartlı olarak uygundur.
AL			**AL** talaş kırıcı keskindir ve demir dışı alaşımların çok yönlü işlenmesi için ilk tercihtir. T-land olmadan son derece pozitif eğim açısına sahiptir. Süper alaşımlar için de şartlı olarak uygundur.
JQ **JR** **JZ**			**JQ** talaş kırıcı keskindir ve Çeliklerin ince finişi için tasarlanmıştır. T-land olmadan son derece pozitif eğim açısına sahiptir. Paslanmaz çelikler için de şartlı olarak uygundur.

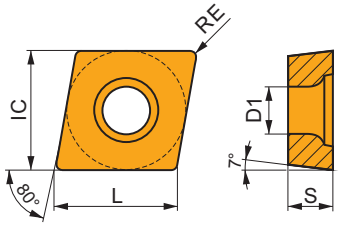
FF2



FF2 talaş kırıcı, çeliklerin ince finiş işlemleri için ilk tercihtir. T-land olmadan hafif pozitif eğim açısına sahiptir. Dökme demirler için de uygundur.

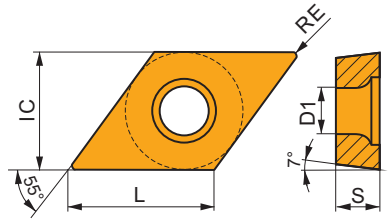
CCGT / CCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0602	6.350	2.80	6.40	2.38
0803	7.940	3.40	8.10	3.18
09T3	9.525	4.40	9.70	3.97



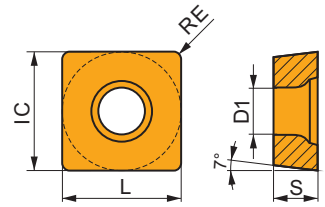
DCGT / DCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0702	6.350	2.80	7.80	2.38
11T3	9.525	4.40	11.60	3.97



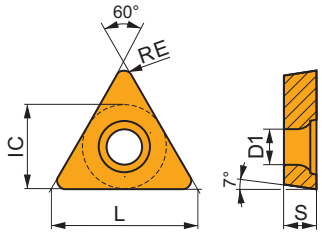
SCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
09T3	9.525	4.40	9.53	3.97



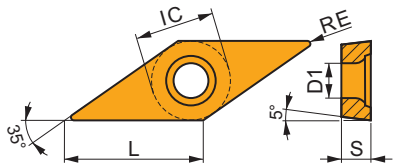
TCGT / TCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
06T1	3.970	2.20	6.90	1.98
0902	5.560	2.50	9.60	2.38
1102	6.350	2.80	11.00	2.38
16T3	9.525	4.40	16.50	3.97



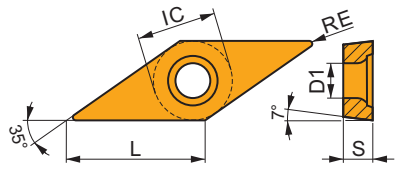
VBMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	4.40	16.60	4.76



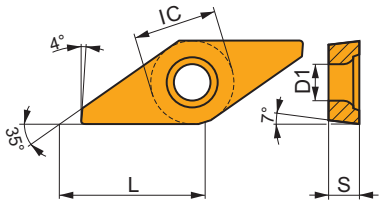
VCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0702	3.970	2.20	6.90	2.38
1303	7.940	3.40	13.80	3.18



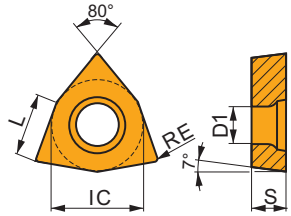
VCGX

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1303	7.940	3.40	13.80	3.18

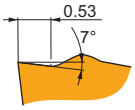
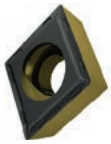
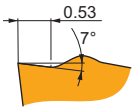
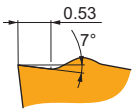
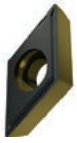
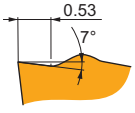


WCGT

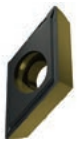
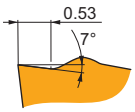
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0201	3.970	2.20	2.70	1.59



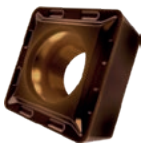
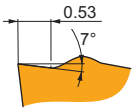
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
FF2 talaş kırıcı, çeliklerin ince finiş işlemleri için ilk tercihtir. T-land olmadan hafif pozitif eğim açısına sahiptir. Dökme demirler için de uygundur.																			
CCGT 09T302E-FF2:T9325	0.2	345	0.05	1.0	–	–	–	325	0.05	1.0	–	–	–	–	–	–	–	–	–
 																			
FF2 talaş kırıcı, çeliklerin ince finiş işlemleri için ilk tercihtir. T-land olmadan hafif pozitif eğim açısına sahiptir. Dökme demirler için de uygundur.																			
CCMT 060202E-FF2:T8430	0.2	280	0.05	0.8	–	–	–	230	0.05	0.8	–	–	–	–	–	–	–	–	–
CCMT 060202E-FF2:T9325	0.2	350	0.05	0.8	–	–	–	330	0.05	0.8	–	–	–	–	–	–	–	–	–
CCMT 060202E-FF2:T9415	0.2	395	0.05	0.8	–	–	–	375	0.05	0.8	–	–	–	–	–	–	–	–	–
CCMT 060202E-FF2:TT010	0.2	345	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 060204E-FF2:T7325	0.4	190	0.12	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 060204E-FF2:T8430	0.4	205	0.12	1.0	–	–	–	170	0.12	1.0	–	–	–	–	–	–	–	–	–
CCMT 060204E-FF2:T9325	0.4	255	0.12	1.0	–	–	–	240	0.12	1.0	–	–	–	–	–	–	–	–	–
CCMT 060204E-FF2:T9335	0.4	215	0.12	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 060204E-FF2:T9415	0.4	305	0.12	1.0	–	–	–	285	0.12	1.0	–	–	–	–	–	–	–	–	–
CCMT 060204E-FF2:TT010	0.4	280	0.12	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 080302E-FF2:T8430	0.2	280	0.05	0.8	–	–	–	230	0.05	0.8	–	–	–	–	–	–	–	–	–
CCMT 080302E-FF2:T9325	0.2	350	0.05	0.8	–	–	–	330	0.05	0.8	–	–	–	–	–	–	–	–	–
CCMT 080304E-FF2:T7325	0.4	190	0.12	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 080304E-FF2:T8430	0.4	205	0.12	1.0	–	–	–	170	0.12	1.0	–	–	–	–	–	–	–	–	–
CCMT 080304E-FF2:T9325	0.4	255	0.12	1.0	–	–	–	240	0.12	1.0	–	–	–	–	–	–	–	–	–
CCMT 080304E-FF2:TT010	0.4	350	0.06	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 080308E-FF2:T8430	0.8	210	0.17	1.0	–	–	–	175	0.17	1.0	–	–	–	–	–	–	–	–	–
CCMT 080308E-FF2:T9325	0.8	260	0.17	1.0	–	–	–	245	0.17	1.0	–	–	–	–	–	–	–	–	–
CCMT 09T304E-FF2:T8430	0.4	200	0.12	1.2	–	–	–	165	0.12	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T304E-FF2:T9325	0.4	250	0.12	1.2	–	–	–	235	0.12	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T304E-FF2:T9335	0.4	215	0.12	1.2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 09T304E-FF2:T9415	0.4	300	0.12	1.2	–	–	–	285	0.12	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T304E-FF2:TT010	0.4	350	0.06	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 09T308E-FF2:T8430	0.8	205	0.17	1.2	–	–	–	170	0.17	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T308E-FF2:T9325	0.8	255	0.17	1.2	–	–	–	240	0.17	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T308E-FF2:T9415	0.8	300	0.20	1.2	–	–	–	285	0.20	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T308E-FF2:TT010	0.8	350	0.10	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
 																			
FF2 talaş kırıcı, çeliklerin ince finiş işlemleri için ilk tercihtir. T-land olmadan hafif pozitif eğim açısına sahiptir. Dökme demirler için de uygundur.																			
DCGT 11T302E-FF2:T8430	0.2	225	0.05	0.8	–	–	–	185	0.05	0.8	–	–	–	–	–	–	–	–	–
DCGT 11T302E-FF2:T9325	0.2	280	0.05	0.8	–	–	–	265	0.05	0.8	–	–	–	–	–	–	–	–	–
DCGT 11T302E-FF2:TT010	0.2	275	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
 																			
FF2 talaş kırıcı, çeliklerin ince finiş işlemleri için ilk tercihtir. T-land olmadan hafif pozitif eğim açısına sahiptir. Dökme demirler için de uygundur.																			
DCMT 070202E-FF2:T7325	0.2	190	0.05	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 070202E-FF2:T8430	0.2	225	0.05	0.8	–	–	–	185	0.05	0.8	–	–	–	–	–	–	–	–	–
DCMT 070202E-FF2:T9325	0.2	280	0.05	0.8	–	–	–	265	0.05	0.8	–	–	–	–	–	–	–	–	–
DCMT 070202E-FF2:TT010	0.2	275	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 070204E-FF2:T7325	0.4	160	0.12	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 070204E-FF2:T8430	0.4	170	0.12	0.8	–	–	–	135	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 070204E-FF2:T9325	0.4	205	0.12	0.8	–	–	–	190	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 070204E-FF2:T9415	0.4	250	0.12	0.8	–	–	–	235	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 070208E-FF2:T7325	0.8	170	0.17	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 070208E-FF2:T8430	0.8	175	0.17	0.8	–	–	–	140	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 070208E-FF2:T9325	0.8	215	0.17	0.8	–	–	–	200	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 070208E-FF2:T9415	0.8	265	0.17	0.8	–	–	–	250	0.17	0.8	–	–	–	–	–	–	–	–	–

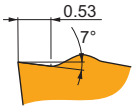
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P			M			K			N			S			H		
			vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)
																				
DCMT 11T304E-FF2:T7325	●	0.4	◪	160	0.12	0.8	–	–	–	◪	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T304E-FF2:T8430	●	0.4	■	170	0.12	0.8	–	–	–	◪	135	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T304E-FF2:T9325	●	0.4	■	205	0.12	0.8	–	–	–	◪	190	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T304E-FF2:T9415	●	0.4	■	250	0.12	0.8	–	–	–	◪	235	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T304E-FF2:TT010	●	0.4	■	280	0.06	0.5	–	–	–		–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T308E-FF2:T7325	●	0.8	◪	170	0.17	0.8	–	–	–		–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T308E-FF2:T8430	●	0.8	■	175	0.17	0.8	–	–	–	◪	140	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T308E-FF2:T9325	●	0.8	■	215	0.17	0.8	–	–	–	◪	200	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T308E-FF2:T9415	●	0.8	■	265	0.17	0.8	–	–	–	◪	250	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T308E-FF2:TT010	●	0.8	■	280	0.10	0.8	–	–	–		–	–	–	–	–	–	–	–	–	–	–	–

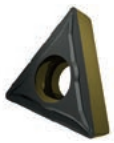
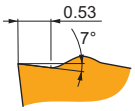
FF2 talaş kırıcı, çeliklerin ince finiş işlemleri için ilk tercihtir. T-land olmadan hafif pozitif eğim açısına sahiptir. Dökme demirler için de uygundur.

																						
SCMT 09T304E-FF2:T8430	●	0.4	■	210	0.12	1.2	–	–	–	◪	175	0.12	1.2	–	–	–	–	–	–	–	–	–
SCMT 09T304E-FF2:T9325	●	0.4	■	260	0.12	1.2	–	–	–	◪	245	0.12	1.2	–	–	–	–	–	–	–	–	–
SCMT 09T308E-FF2:T8430	⬌	0.8	■	220	0.17	1.2	–	–	–	◪	180	0.17	1.2	–	–	–	–	–	–	–	–	–
SCMT 09T308E-FF2:T9325	●	0.8	■	265	0.17	1.2	–	–	–	◪	250	0.17	1.2	–	–	–	–	–	–	–	–	–

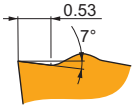
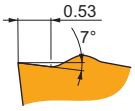
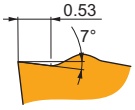
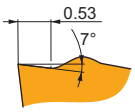
FF2 talaş kırıcı, çeliklerin ince finiş işlemleri için ilk tercihtir. T-land olmadan hafif pozitif eğim açısına sahiptir. Dökme demirler için de uygundur.

																						
TCGT 06T102E-FF2:T8430	●	0.2	■	235	0.05	0.8	–	–	–	◪	190	0.05	0.8	–	–	–	–	–	–	–	–	–
TCGT 06T102E-FF2:TT010	●	0.2	■	295	0.05	0.5	–	–	–		–	–	–	–	–	–	–	–	–	–	–	–
TCGT 090202E-FF2:TT010	●	0.2	■	295	0.05	0.5	–	–	–		–	–	–	–	–	–	–	–	–	–	–	–

FF2 talaş kırıcı, çeliklerin ince finiş işlemleri için ilk tercihtir. T-land olmadan hafif pozitif eğim açısına sahiptir. Dökme demirler için de uygundur.

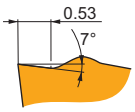
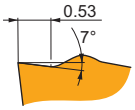
																						
TCMT 06T102E-FF2:T8430	●	0.2	■	235	0.05	0.8	–	–	–	◪	190	0.05	0.8	–	–	–	–	–	–	–	–	–
TCMT 06T102E-FF2:T9415	●	0.2	■	335	0.05	0.8	–	–	–	◪	315	0.05	0.8	–	–	–	–	–	–	–	–	–
TCMT 06T104E-FF2:T7325	●	0.4	◪	170	0.12	0.8	–	–	–		–	–	–	–	–	–	–	–	–	–	–	–
TCMT 06T104E-FF2:T8430	●	0.4	■	180	0.12	0.8	–	–	–	◪	145	0.12	0.8	–	–	–	–	–	–	–	–	–
TCMT 06T104E-FF2:T9325	●	0.4	■	220	0.12	0.8	–	–	–	◪	205	0.12	0.8	–	–	–	–	–	–	–	–	–
TCMT 06T104E-FF2:T9415	●	0.4	■	265	0.12	0.8	–	–	–	◪	250	0.12	0.8	–	–	–	–	–	–	–	–	–
TCMT 090204E-FF2:T5315	●	0.4	◪	240	0.12	1.0	–	–	–	■	225	0.12	1.0	–	–	–	–	–	–	–	–	–
TCMT 090204E-FF2:T7325	●	0.4	◪	165	0.12	1.0	–	–	–		–	–	–	–	–	–	–	–	–	–	–	–
TCMT 090204E-FF2:T8430	●	0.4	■	175	0.12	1.0	–	–	–	◪	140	0.12	1.0	–	–	–	–	–	–	–	–	–
TCMT 090204E-FF2:T9325	●	0.4	■	215	0.12	1.0	–	–	–	◪	200	0.12	1.0	–	–	–	–	–	–	–	–	–
TCMT 090204E-FF2:T9415	●	0.4	■	260	0.12	1.0	–	–	–	◪	245	0.12	1.0	–	–	–	–	–	–	–	–	–
TCMT 110204E-FF2:T8430	●	0.4	■	180	0.12	0.8	–	–	–	◪	145	0.12	0.8	–	–	–	–	–	–	–	–	–
TCMT 110204E-FF2:T9325	●	0.4	■	220	0.12	0.8	–	–	–	◪	205	0.12	0.8	–	–	–	–	–	–	–	–	–
TCMT 110204E-FF2:T9335	●	0.4	■	185	0.12	0.8	–	–	–		–	–	–	–	–	–	–	–	–	–	–	–
TCMT 110204E-FF2:T9415	●	0.4	■	265	0.12	0.8	–	–	–	◪	250	0.12	0.8	–	–	–	–	–	–	–	–	–
TCMT 110208E-FF2:T8430	●	0.8	■	185	0.17	0.8	–	–	–	◪	150	0.17	0.8	–	–	–	–	–	–	–	–	–
TCMT 110208E-FF2:T9325	●	0.8	■	225	0.17	0.8	–	–	–	◪	210	0.17	0.8	–	–	–	–	–	–	–	–	–
TCMT 110208E-FF2:T9415	●	0.8	■	280	0.17	0.8	–	–	–	◪	265	0.17	0.8	–	–	–	–	–	–	–	–	–
TCMT 16T304E-FF2:T8430	●	0.4	■	180	0.12	0.8	–	–	–	◪	145	0.12	0.8	–	–	–	–	–	–	–	–	–
TCMT 16T304E-FF2:T9325	●	0.4	■	220	0.12	0.8	–	–	–	◪	205	0.12	0.8	–	–	–	–	–	–	–	–	–
TCMT 16T304E-FF2:T9335	●	0.4	■	185	0.12	0.8	–	–	–		–	–	–	–	–	–	–	–	–	–	–	–
TCMT 16T304E-FF2:T9415	●	0.4	■	265	0.12	0.8	–	–	–	◪	250	0.12	0.8	–	–	–	–	–	–	–	–	–
TCMT 16T304E-FF2:TT010	●	0.4	■	295	0.06	0.5	–	–	–		–	–	–	–	–	–	–	–	–	–	–	–

Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

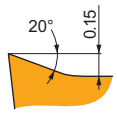
Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
TCMT 16T308E-FF2:T8430	0.8	185	0.17	0.8	–	–	–	150	0.17	0.8	–	–	–	–	–	–	–	–	–
TCMT 16T308E-FF2:T9325	0.8	225	0.17	0.8	–	–	–	210	0.17	0.8	–	–	–	–	–	–	–	–	–
TCMT 16T308E-FF2:T9335	0.8	195	0.17	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TCMT 16T308E-FF2:T9415	0.8	280	0.17	0.8	–	–	–	265	0.17	0.8	–	–	–	–	–	–	–	–	–
 																			
VBMT 160404E-FF2:T7325	0.4	145	0.12	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
VBMT 160404E-FF2:T8430	0.4	150	0.12	0.8	–	–	–	125	0.12	0.8	–	–	–	–	–	–	–	–	–
VBMT 160404E-FF2:T9325	0.4	190	0.12	0.8	–	–	–	180	0.12	0.8	–	–	–	–	–	–	–	–	–
VBMT 160404E-FF2:T9335	0.4	160	0.12	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
VBMT 160404E-FF2:T9415	0.4	230	0.12	0.8	–	–	–	215	0.12	0.8	–	–	–	–	–	–	–	–	–
 																			
VCGT 070202E-FF2:T8315	0.2	150	0.05	0.8	–	–	–	140	0.05	0.8	–	–	–	–	–	–	–	–	–
VCGT 070202E-FF2:T8415	0.2	185	0.05	0.8	–	–	–	165	0.05	0.8	–	–	–	–	–	–	–	–	–
VCGT 070202E-FF2:T8430	0.2	190	0.05	0.8	–	–	–	155	0.05	0.8	–	–	–	–	–	–	–	–	–
VCGT 070204E-FF2:T8315	0.4	125	0.12	0.8	–	–	–	115	0.12	0.8	–	–	–	–	–	–	–	–	–
VCGT 070204E-FF2:T8415	0.4	155	0.12	0.8	–	–	–	140	0.12	0.8	–	–	–	–	–	–	–	–	–
VCGT 070204E-FF2:T8430	0.4	145	0.12	0.8	–	–	–	120	0.12	0.8	–	–	–	–	–	–	–	–	–
VCGT 130302E-FF2:T5315	0.2	250	0.05	1.0	–	–	–	235	0.05	1.0	–	–	–	–	–	–	–	–	–
VCGT 130302E-FF2:T8430	0.2	185	0.05	1.0	–	–	–	150	0.05	1.0	–	–	–	–	–	–	–	–	–
VCGT 130302E-FF2:T9325	0.2	240	0.05	1.0	–	–	–	225	0.05	1.0	–	–	–	–	–	–	–	–	–
VCGT 130302E-FF2:T9415	0.2	270	0.05	1.0	–	–	–	255	0.05	1.0	–	–	–	–	–	–	–	–	–
VCGT 130302E-FF2:TT010	0.2	240	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
VCGT 130304E-FF2:T5315	0.4	195	0.12	1.0	–	–	–	185	0.12	1.0	–	–	–	–	–	–	–	–	–
VCGT 130304E-FF2:T7325	0.4	135	0.12	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
VCGT 130304E-FF2:T8430	0.4	140	0.12	1.0	–	–	–	115	0.12	1.0	–	–	–	–	–	–	–	–	–
VCGT 130304E-FF2:T9325	0.4	175	0.12	1.0	–	–	–	165	0.12	1.0	–	–	–	–	–	–	–	–	–
VCGT 130304E-FF2:T9415	0.4	215	0.12	1.0	–	–	–	200	0.12	1.0	–	–	–	–	–	–	–	–	–
VCGT 130304E-FF2:TT010	0.4	245	0.06	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
VCGT 130308E-FF2:T9325	0.8	180	0.17	1.0	–	–	–	170	0.17	1.0	–	–	–	–	–	–	–	–	–
VCGT 130308E-FF2:T9415	0.8	225	0.17	1.0	–	–	–	210	0.17	1.0	–	–	–	–	–	–	–	–	–
VCGT 130308E-FF2:TT010	0.8	245	0.10	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
 																			
VCGX 130300FR-FF2:T6310	0.0	140	0.05	1.0	–	–	–	110	0.05	1.0	–	–	–	–	–	–	–	–	–
VCGX 130300FR-FF2:T8315	0.0	150	0.05	1.0	–	–	–	140	0.05	1.0	–	–	–	–	–	–	–	–	–
VCGX 130300FR-FF2:T8415	0.0	180	0.05	1.0	–	–	–	160	0.05	1.0	–	–	–	–	–	–	–	–	–
VCGX 130300FR-FF2:TT010	0.0	240	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
VCGX 130301FR-FF2:T6310	0.1	140	0.05	1.0	–	–	–	110	0.05	1.0	–	–	–	–	–	–	–	–	–
VCGX 130301FR-FF2:T8315	0.1	150	0.05	1.0	–	–	–	140	0.05	1.0	–	–	–	–	–	–	–	–	–
VCGX 130301FR-FF2:T8415	0.1	180	0.05	1.0	–	–	–	160	0.05	1.0	–	–	–	–	–	–	–	–	–
VCGX 130301FR-FF2:TT010	0.1	240	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

FF2 talaş kırıcı, çeliklerin ince finiş işlemleri için ilk tercihtir. T-land olmadan hafif pozitif eğim açısına sahiptir. Dökme demirler için de uygundur.

Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P			M			K			N			S			H		
			vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)
			**FF2** talaş kırıcı, çeliklerin ince finiş işlemleri için ilk tercihtir. T-land olmadan hafif pozitif eğim açısına sahiptir. Dökme demirler için de uygundur.																	
VCGX 130300FL-FF2:T8315	●	0.0	◪	150	0.05	1.0	–	–	–	■	140	0.05	1.0	–	–	–	–	–	–	–	–	–
VCGX 130300FL-FF2:T8415	●	0.0	■	180	0.05	1.0	–	–	–	■	160	0.05	1.0	–	–	–	–	–	–	–	–	–
VCGX 130300FL-FF2:TT010	●	0.0	■	240	0.05	0.5	–	–	–		–	–	–	–	–	–	–	–	–	–	–	–
VCGX 130301FL-FF2:T8315	●	0.1	◪	150	0.05	1.0	–	–	–	■	140	0.05	1.0	–	–	–	–	–	–	–	–	–
VCGX 130301FL-FF2:T8415	●	0.1	■	180	0.05	1.0	–	–	–	■	160	0.05	1.0	–	–	–	–	–	–	–	–	–
			**FF2** talaş kırıcı, çeliklerin ince finiş işlemleri için ilk tercihtir. T-land olmadan hafif pozitif eğim açısına sahiptir. Dökme demirler için de uygundur.																	
WCGT 020102E-FF2:HF7	●	0.2	–	–	–	–	–	–	■	210	0.05	0.8	–	–	–	–	–	–	–	–	–	–
WCGT 020102E-FF2:T8430	●	0.2	■	280	0.05	0.8	–	–	–	◪	230	0.05	0.8	–	–	–	–	–	–	–	–	–
WCGT 020102E-FF2:TT010	●	0.2	■	345	0.05	0.5	–	–	–		–	–	–	–	–	–	–	–	–	–	–	–
WCGT 020104E-FF2:HF7	●	0.4	–	–	–	–	–	–	■	155	0.12	0.8	–	–	–	–	–	–	–	–	–	–
WCGT 020104E-FF2:T8430	●	0.4	■	205	0.12	0.8	–	–	–	◪	170	0.12	0.8	–	–	–	–	–	–	–	–	–
WCGT 020104E-FF2:TT010	●	0.4	■	350	0.06	0.5	–	–	–		–	–	–	–	–	–	–	–	–	–	–	–

SF3

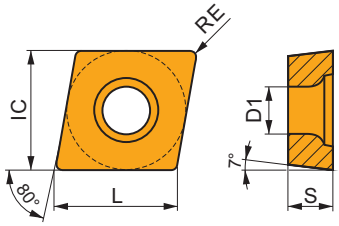




SF3 talaş kırıcı, Paslanmaz çeliklerin ve Süper alaşımların ince finiş işlemleri için ilk tercihtir. T-land olmadan son derece pozitif eğim açısına sahiptir. Ayrıca demir dışı alaşımlar ve koşullara uygun olarak Çelikler, Dökme demirler ve Sert malzemeler için de uygundur.

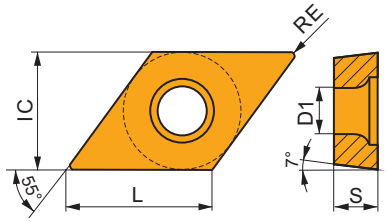
CCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0602-SF3	6.350	2.80	6.40	2.58
0803-SF3	7.940	3.40	8.10	3.43
09T3-SF3	9.525	4.40	9.70	4.22
1204-SF3	12.700	5.50	12.90	5.01



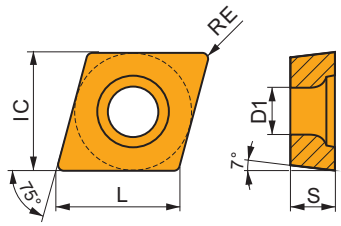
DCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0702-SF3	6.350	2.80	7.80	2.58
11T3-SF3	9.525	4.40	11.60	4.22



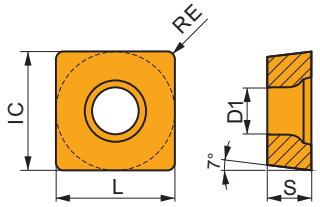
ECGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0602-SF3	6.350	2.80	6.50	2.58
0803-SF3	7.940	3.40	8.20	3.43



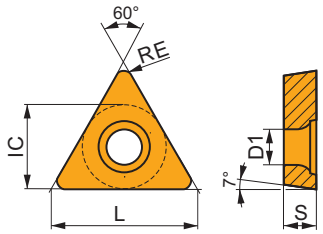
SCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
09T3-SF3	9.525	4.40	9.53	4.22



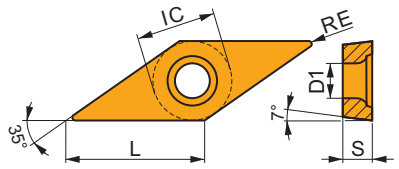
TCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1102-SF3	6.350	2.80	11.00	2.58
16T3-SF3	9.525	4.40	16.50	4.22

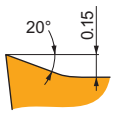
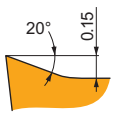


VCGT

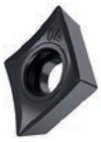
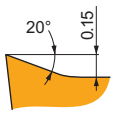
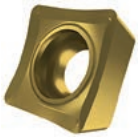
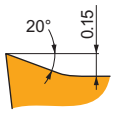
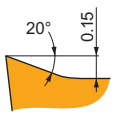
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0702	3.970	2.20	6.90	2.38
1102-SF3	6.350	2.80	11.10	2.58
1103-SF3	6.350	2.80	11.10	3.43
1303-SF3	7.940	3.40	13.80	3.43
1604-SF3	9.525	4.40	16.60	5.01



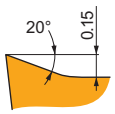
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
SF3 talaş kırıcı, Paslanmaz çeliklerin ve Süper alaşımların ince finiş işlemleri için ilk tercihtir. T-land olmadan son derece pozitif eğim açısına sahiptir. Ayrıca demir dışı alaşımlar ve koşullara uygun olarak Çelikler, Dökme demirler ve Sert malzemeler için de uygundur.																			
CCGT 060201E-SF3:T6310	0.1	200	0.05	0.5	140	0.05	0.5	160	0.05	0.5	600	0.06	0.5	60	0.04	0.4	40	0.05	0.1
CCGT 060202E-SF3:T6310	0.2	205	0.05	0.8	145	0.05	0.8	165	0.05	0.8	615	0.06	0.8	60	0.04	0.6	40	0.05	0.2
CCGT 060202E-SF3:T8315	0.2	215	0.05	0.8	125	0.05	0.8	200	0.05	0.8	645	0.06	0.8	50	0.04	0.6	40	0.05	0.2
CCGT 060202E-SF3:T8415	0.2	270	0.05	0.8	140	0.04	0.8	245	0.05	0.8	675	0.06	0.8	60	0.04	0.6	45	0.05	0.2
CCGT 060204E-SF3:H07	0.4	–	–	–	95	0.09	0.8	150	0.10	0.8	485	0.12	0.8	45	0.07	0.6	–	–	–
CCGT 060204E-SF3:T6310	0.4	180	0.10	0.8	125	0.09	0.8	145	0.10	0.8	540	0.12	0.8	50	0.07	0.6	35	0.07	0.3
CCGT 060204E-SF3:T8315	0.4	190	0.10	0.8	110	0.09	0.8	180	0.10	0.8	570	0.12	0.8	45	0.07	0.6	35	0.07	0.3
CCGT 060204E-SF3:T8415	0.4	230	0.10	0.8	120	0.09	0.8	210	0.10	0.8	585	0.12	0.8	50	0.07	0.6	40	0.07	0.3
CCGT 080302E-SF3:T6310	0.2	205	0.05	0.8	145	0.05	0.8	165	0.05	0.8	615	0.06	0.8	60	0.04	0.6	40	0.05	0.2
CCGT 080302E-SF3:T8315	0.2	215	0.05	0.8	125	0.05	0.8	200	0.05	0.8	645	0.06	0.8	50	0.04	0.6	40	0.05	0.2
CCGT 080302E-SF3:T8415	0.2	270	0.05	0.8	140	0.04	0.8	245	0.05	0.8	675	0.06	0.8	60	0.04	0.6	45	0.05	0.2
CCGT 080304E-SF3:T6310	0.4	180	0.10	1.0	125	0.09	1.0	145	0.10	1.0	540	0.12	1.0	50	0.07	0.8	35	0.10	0.3
CCGT 080304E-SF3:T8315	0.4	190	0.10	1.0	110	0.09	1.0	180	0.10	1.0	570	0.12	1.0	45	0.07	0.8	35	0.10	0.3
CCGT 080304E-SF3:T8415	0.4	225	0.10	1.0	115	0.09	1.0	205	0.10	1.0	570	0.12	1.0	50	0.07	0.8	35	0.10	0.3
CCGT 09T301E-SF3:T6310	0.1	200	0.05	0.5	140	0.05	0.5	160	0.05	0.5	600	0.06	0.5	60	0.04	0.4	40	0.05	0.1
CCGT 09T302E-SF3:T6310	0.2	205	0.05	0.8	145	0.05	0.8	165	0.05	0.8	615	0.06	0.8	60	0.04	0.6	40	0.05	0.2
CCGT 09T302E-SF3:T8315	0.2	215	0.05	0.8	125	0.05	0.8	200	0.05	0.8	645	0.06	0.8	50	0.04	0.6	40	0.05	0.2
CCGT 09T302E-SF3:T8415	0.2	270	0.05	0.8	140	0.04	0.8	245	0.05	0.8	675	0.06	0.8	60	0.04	0.6	45	0.05	0.2
CCGT 09T304E-SF3:H07	0.4	–	–	–	95	0.09	1.0	150	0.10	1.0	485	0.12	1.0	45	0.07	0.8	–	–	–
CCGT 09T304E-SF3:T6310	0.4	180	0.10	1.0	125	0.09	1.0	145	0.10	1.0	540	0.12	1.0	50	0.07	0.8	35	0.05	0.3
CCGT 09T304E-SF3:T8315	0.4	190	0.10	1.0	110	0.09	1.0	180	0.10	1.0	570	0.12	1.0	45	0.07	0.8	35	0.05	0.3
CCGT 09T304E-SF3:T8415	0.4	225	0.10	1.0	115	0.09	1.0	205	0.10	1.0	570	0.12	1.0	50	0.07	0.8	35	0.05	0.3
CCGT 09T308E-SF3:H07	0.8	–	–	–	110	0.09	1.0	175	0.10	1.0	565	0.12	1.0	55	0.08	0.8	–	–	–
CCGT 09T308E-SF3:T6310	0.8	210	0.10	1.0	150	0.09	1.0	165	0.10	1.0	630	0.12	1.0	60	0.08	0.8	40	0.08	0.7
CCGT 09T308E-SF3:T8315	0.8	225	0.10	1.0	135	0.09	1.0	210	0.10	1.0	675	0.12	1.0	55	0.08	0.8	45	0.08	0.7
CCGT 09T308E-SF3:T8415	0.8	275	0.10	1.0	140	0.09	1.0	250	0.10	1.0	690	0.12	1.0	60	0.08	0.8	45	0.08	0.7
CCGT 120404E-SF3:T6310	0.4	180	0.10	1.0	125	0.09	1.0	145	0.10	1.0	540	0.12	1.0	50	0.07	0.8	35	0.07	0.3
CCGT 120404E-SF3:T8415	0.4	225	0.10	1.0	115	0.09	1.0	205	0.10	1.0	570	0.12	1.0	50	0.07	0.8	35	0.07	0.3
CCGT 120408E-SF3:H07	0.8	–	–	–	105	0.12	1.0	165	0.12	1.0	525	0.14	1.0	50	0.11	0.8	–	–	–
CCGT 120408E-SF3:T6310	0.8	200	0.12	1.0	140	0.12	1.0	160	0.12	1.0	600	0.14	1.0	60	0.11	0.8	40	0.10	0.7
CCGT 120408E-SF3:T8315	0.8	210	0.12	1.0	125	0.12	1.0	195	0.12	1.0	630	0.14	1.0	50	0.11	0.8	40	0.10	0.7
CCGT 120408E-SF3:T8415	0.8	255	0.12	1.0	135	0.12	1.0	230	0.12	1.0	645	0.14	1.0	55	0.11	0.8	45	0.10	0.7
 																			
SF3 talaş kırıcı, Paslanmaz çeliklerin ve Süper alaşımların ince finiş işlemleri için ilk tercihtir. T-land olmadan son derece pozitif eğim açısına sahiptir. Ayrıca demir dışı alaşımlar ve koşullara uygun olarak Çelikler, Dökme demirler ve Sert malzemeler için de uygundur.																			
DCGT 070201E-SF3:T6310	0.1	160	0.05	0.5	115	0.05	0.5	125	0.05	0.5	480	0.06	0.5	45	0.04	0.4	30	0.05	0.1
DCGT 070202E-SF3:T6310	0.2	165	0.05	0.8	115	0.05	0.8	130	0.05	0.8	495	0.06	0.8	45	0.04	0.6	30	0.05	0.2
DCGT 070202E-SF3:T8315	0.2	175	0.05	0.8	105	0.05	0.8	165	0.05	0.8	525	0.06	0.8	40	0.04	0.6	35	0.05	0.2
DCGT 070202E-SF3:T8415	0.2	215	0.05	0.8	110	0.04	0.8	195	0.05	0.8	540	0.06	0.8	45	0.04	0.6	35	0.05	0.2
DCGT 070204E-SF3:H07	0.4	–	–	–	75	0.09	0.8	120	0.10	0.8	390	0.12	0.8	35	0.07	0.6	–	–	–
DCGT 070204E-SF3:T6310	0.4	145	0.10	0.8	100	0.09	0.8	115	0.10	0.8	435	0.12	0.8	40	0.07	0.6	25	0.07	0.3
DCGT 070204E-SF3:T8315	0.4	155	0.10	0.8	90	0.09	0.8	145	0.10	0.8	465	0.12	0.8	35	0.07	0.6	30	0.07	0.3
DCGT 070204E-SF3:T8415	0.4	185	0.10	0.8	95	0.09	0.8	165	0.10	0.8	465	0.12	0.8	40	0.07	0.6	30	0.07	0.3
DCGT 11T301E-SF3:T6310	0.1	160	0.05	0.5	115	0.05	0.5	125	0.05	0.5	480	0.06	0.5	45	0.04	0.4	30	0.05	0.1
DCGT 11T302E-SF3:H07	0.2	–	–	–	95	0.05	0.8	150	0.05	0.8	485	0.06	0.8	45	0.04	0.6	–	–	–
DCGT 11T302E-SF3:T6310	0.2	165	0.05	0.8	115	0.05	0.8	130	0.05	0.8	495	0.06	0.8	45	0.04	0.6	30	0.05	0.2
DCGT 11T302E-SF3:T8415	0.2	215	0.05	0.8	110	0.04	0.8	195	0.05	0.8	540	0.06	0.8	45	0.04	0.6	35	0.05	0.2
DCGT 11T304E-SF3:H07	0.4	–	–	–	75	0.09	0.8	120	0.10	0.8	390	0.12	0.8	35	0.07	0.6	–	–	–
DCGT 11T304E-SF3:T6310	0.4	145	0.10	0.8	100	0.09	0.8	115	0.10	0.8	435	0.12	0.8	40	0.07	0.6	25	0.07	0.3
DCGT 11T304E-SF3:T8315	0.4	155	0.10	0.8	90	0.09	0.8	145	0.10	0.8	465	0.12	0.8	35	0.07	0.6	30	0.07	0.3
DCGT 11T304E-SF3:T8415	0.4	185	0.10	0.8	95	0.09	0.8	165	0.10	0.8	465	0.12	0.8	40	0.07	0.6	30	0.07	0.3
DCGT 11T308E-SF3:H07	0.8	–	–	–	90	0.09	0.8	145	0.10	0.8	455	0.12	0.8	45	0.08	0.6	–	–	–
DCGT 11T308E-SF3:T6310	0.8	170	0.10	0.8	120	0.09	0.8	135	0.10	0.8	510	0.12	0.8	50	0.08	0.6	30	0.08	0.7
DCGT 11T308E-SF3:T8315	0.8	180	0.10	0.8	105	0.09	0.8	170	0.10	0.8	540	0.12	0.8	45	0.08	0.6	35	0.08	0.7
DCGT 11T308E-SF3:T8415	0.8	220	0.10	0.8	115	0.09	0.8	200	0.10	0.8	555	0.12	0.8	50	0.08	0.6	35	0.08	0.7

Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

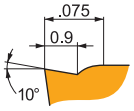
Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
  																			
SF3 talaş kırıcı, Paslanmaz çeliklerin ve Süper alaşımların ince finiş işlemleri için ilk tercihtir. T-land olmadan son derece pozitif eğim açısına sahiptir. Ayrıca demir dışı alaşımlar ve koşullara uygun olarak Çelikler, Dökme demirler ve Sert malzemeler için de uygundur.																			
ECGT 060202E-SF3:H07	0.2	–	–	–	105	0.05	0.8	170	0.05	0.8	540	0.06	0.8	55	0.04	0.6	–	–	–
ECGT 060202E-SF3:T6310	0.2	185	0.05	0.8	130	0.05	0.8	145	0.05	0.8	555	0.06	0.8	55	0.04	0.6	35	0.05	0.2
ECGT 060202E-SF3:T8415	0.2	240	0.05	0.8	125	0.04	0.8	215	0.05	0.8	600	0.06	0.8	55	0.04	0.6	40	0.05	0.2
ECGT 080304E-SF3:H07	0.4	–	–	–	85	0.09	1.0	135	0.10	1.0	430	0.12	1.0	40	0.07	0.8	–	–	–
ECGT 080304E-SF3:T6310	0.4	160	0.10	1.0	115	0.09	1.0	125	0.10	1.0	480	0.12	1.0	45	0.07	0.8	30	0.05	0.3
ECGT 080304E-SF3:T8415	0.4	200	0.10	1.0	105	0.09	1.0	185	0.10	1.0	510	0.12	1.0	45	0.07	0.8	35	0.05	0.3
  																			
SF3 talaş kırıcı, Paslanmaz çeliklerin ve Süper alaşımların ince finiş işlemleri için ilk tercihtir. T-land olmadan son derece pozitif eğim açısına sahiptir. Ayrıca demir dışı alaşımlar ve koşullara uygun olarak Çelikler, Dökme demirler ve Sert malzemeler için de uygundur.																			
SCGT 09T304E-SF3:H07	0.4	–	–	–	95	0.09	1.0	155	0.10	1.0	495	0.12	1.0	50	0.07	0.8	–	–	–
SCGT 09T304E-SF3:T6310	0.4	185	0.10	1.0	130	0.09	1.0	145	0.10	1.0	555	0.12	1.0	55	0.07	0.8	35	0.05	0.3
SCGT 09T304E-SF3:T8315	0.4	200	0.10	1.0	120	0.09	1.0	190	0.10	1.0	600	0.12	1.0	50	0.07	0.8	40	0.05	0.3
SCGT 09T304E-SF3:T8415	0.4	240	0.10	1.0	125	0.09	1.0	215	0.10	1.0	600	0.12	1.0	55	0.07	0.8	40	0.05	0.3
SCGT 09T308E-SF3:T6310	0.8	210	0.12	1.0	150	0.12	1.0	165	0.12	1.0	630	0.14	1.0	60	0.11	0.8	40	0.10	0.7
SCGT 09T308E-SF3:T8315	0.8	220	0.12	1.0	130	0.12	1.0	205	0.12	1.0	660	0.14	1.0	55	0.11	0.8	40	0.10	0.7
SCGT 09T308E-SF3:T8415	0.8	270	0.12	1.0	140	0.12	1.0	245	0.12	1.0	675	0.14	1.0	60	0.11	0.8	45	0.10	0.7
  																			
SF3 talaş kırıcı, Paslanmaz çeliklerin ve Süper alaşımların ince finiş işlemleri için ilk tercihtir. T-land olmadan son derece pozitif eğim açısına sahiptir. Ayrıca demir dışı alaşımlar ve koşullara uygun olarak Çelikler, Dökme demirler ve Sert malzemeler için de uygundur.																			
TCGT 110202E-SF3:T6310	0.2	175	0.05	0.8	125	0.05	0.8	140	0.05	0.8	525	0.06	0.8	50	0.04	0.6	35	0.05	0.2
TCGT 110202E-SF3:T8315	0.2	185	0.05	0.8	110	0.05	0.8	175	0.05	0.8	555	0.06	0.8	45	0.04	0.6	35	0.05	0.2
TCGT 110202E-SF3:T8415	0.2	225	0.05	0.8	115	0.04	0.8	205	0.05	0.8	570	0.06	0.8	50	0.04	0.6	35	0.05	0.2
TCGT 110204E-SF3:H07	0.4	–	–	–	80	0.09	0.8	130	0.10	0.8	415	0.12	0.8	40	0.07	0.6	–	–	–
TCGT 110204E-SF3:T6310	0.4	155	0.10	0.8	110	0.09	0.8	125	0.10	0.8	465	0.12	0.8	45	0.07	0.6	30	0.07	0.3
TCGT 110204E-SF3:T8315	0.4	165	0.10	0.8	95	0.09	0.8	155	0.10	0.8	495	0.12	0.8	40	0.07	0.6	30	0.07	0.3
TCGT 110204E-SF3:T8415	0.4	195	0.10	0.8	100	0.09	0.8	180	0.10	0.8	495	0.12	0.8	45	0.07	0.6	30	0.07	0.3
TCGT 16T304E-SF3:H07	0.4	–	–	–	80	0.09	1.0	125	0.10	1.0	405	0.12	1.0	40	0.07	0.8	–	–	–
TCGT 16T304E-SF3:T6310	0.4	150	0.10	1.0	105	0.09	1.0	120	0.10	1.0	450	0.12	1.0	45	0.07	0.8	30	0.07	0.3
TCGT 16T304E-SF3:T8315	0.4	160	0.10	1.0	95	0.09	1.0	150	0.10	1.0	480	0.12	1.0	40	0.07	0.8	30	0.07	0.3
TCGT 16T304E-SF3:T8415	0.4	195	0.10	1.0	100	0.09	1.0	180	0.10	1.0	495	0.12	1.0	45	0.07	0.8	30	0.07	0.3
TCGT 16T308E-SF3:H07	0.8	–	–	–	90	0.09	1.2	145	0.10	1.2	470	0.12	1.2	45	0.08	1.0	–	–	–
TCGT 16T308E-SF3:T6310	0.8	175	0.10	1.2	125	0.09	1.2	140	0.10	1.2	525	0.12	1.2	50	0.08	1.0	35	0.08	0.7
TCGT 16T308E-SF3:T8315	0.8	185	0.10	1.2	110	0.09	1.2	175	0.10	1.2	555	0.12	1.2	45	0.08	1.0	35	0.08	0.7
TCGT 16T308E-SF3:T8415	0.8	225	0.10	1.2	115	0.09	1.2	205	0.10	1.2	570	0.12	1.2	50	0.08	1.0	35	0.08	0.7
TCGT 16T312E-SF3:T6310	1.2	150	0.20	1.2	105	0.18	1.2	120	0.20	1.2	450	0.24	1.2	45	0.14	1.0	30	0.10	0.9
TCGT 16T312E-SF3:T8415	1.2	190	0.20	1.2	100	0.18	1.2	170	0.20	1.2	480	0.24	1.2	40	0.14	1.0	30	0.10	0.9

Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																			
VCGT 070202E-SF3:H07	0.2	–	–	–	80	0.05	0.8	130	0.05	0.8	415	0.06	0.8	40	0.04	0.6	–	–	–
VCGT 070202E-SF3:T6310	0.2	145	0.05	0.8	100	0.05	0.8	115	0.05	0.8	435	0.06	0.8	40	0.04	0.6	25	0.05	0.2
VCGT 070202E-SF3:T8415	0.2	185	0.05	0.8	95	0.04	0.8	165	0.05	0.8	465	0.06	0.8	40	0.04	0.6	30	0.05	0.2
VCGT 070204E-SF3:T6310	0.4	125	0.10	0.8	90	0.09	0.8	100	0.10	0.8	375	0.12	0.8	35	0.07	0.6	25	0.07	0.3
VCGT 070204E-SF3:T8415	0.4	160	0.10	0.8	85	0.09	0.8	145	0.10	0.8	405	0.12	0.8	35	0.07	0.6	25	0.07	0.3
VCGT 110202E-SF3:T6310	0.2	145	0.05	0.8	100	0.05	0.8	115	0.05	0.8	435	0.06	0.8	40	0.04	0.6	25	0.05	0.2
VCGT 110202E-SF3:T8315	0.2	150	0.05	0.8	90	0.05	0.8	140	0.05	0.8	450	0.06	0.8	35	0.04	0.6	30	0.05	0.2
VCGT 110202E-SF3:T8415	0.2	185	0.05	0.8	95	0.04	0.8	165	0.05	0.8	465	0.06	0.8	40	0.04	0.6	30	0.05	0.2
VCGT 110204E-SF3:H07	0.4	–	–	–	65	0.09	0.8	105	0.10	0.8	335	0.12	0.8	30	0.07	0.6	–	–	–
VCGT 110204E-SF3:T6310	0.4	125	0.10	0.8	90	0.09	0.8	100	0.10	0.8	375	0.12	0.8	35	0.07	0.6	25	0.07	0.3
VCGT 110204E-SF3:T8315	0.4	135	0.10	0.8	80	0.09	0.8	125	0.10	0.8	405	0.12	0.8	30	0.07	0.6	25	0.07	0.3
VCGT 110204E-SF3:T8415	0.4	160	0.10	0.8	85	0.09	0.8	145	0.10	0.8	405	0.12	0.8	35	0.07	0.6	25	0.07	0.3
VCGT 110301E-SF3:T6310	0.1	140	0.05	0.5	100	0.05	0.5	110	0.05	0.5	420	0.06	0.5	40	0.04	0.4	25	0.05	0.1
VCGT 110302E-SF3:T6310	0.2	145	0.05	0.8	100	0.05	0.8	115	0.05	0.8	435	0.06	0.8	40	0.04	0.6	25	0.05	0.2
VCGT 110304E-SF3:T6310	0.4	125	0.10	0.8	90	0.09	0.8	100	0.10	0.8	375	0.12	0.8	35	0.07	0.6	25	0.07	0.3
VCGT 110304E-SF3:T8415	0.4	160	0.10	0.8	85	0.09	0.8	145	0.10	0.8	405	0.12	0.8	35	0.07	0.6	25	0.07	0.3
VCGT 130302E-SF3:H07	0.2	–	–	–	80	0.05	0.8	130	0.05	0.8	415	0.06	0.8	40	0.04	0.6	–	–	–
VCGT 130302E-SF3:T6310	0.2	145	0.05	0.8	100	0.05	0.8	115	0.05	0.8	435	0.06	0.8	40	0.04	0.6	25	0.05	0.2
VCGT 130302E-SF3:T8315	0.2	150	0.05	0.8	90	0.05	0.8	140	0.05	0.8	450	0.06	0.8	35	0.04	0.6	30	0.05	0.2
VCGT 130302E-SF3:T8415	0.2	185	0.05	0.8	95	0.04	0.8	165	0.05	0.8	465	0.06	0.8	40	0.04	0.6	30	0.05	0.2
VCGT 130304E-SF3:H07	0.4	–	–	–	65	0.09	1.0	105	0.10	1.0	335	0.12	1.0	30	0.07	0.8	–	–	–
VCGT 130304E-SF3:T6310	0.4	125	0.10	1.0	90	0.09	1.0	100	0.10	1.0	375	0.12	1.0	35	0.07	0.8	25	0.07	0.3
VCGT 130304E-SF3:T8315	0.4	130	0.10	1.0	75	0.09	1.0	120	0.10	1.0	390	0.12	1.0	30	0.07	0.8	25	0.07	0.3
VCGT 130304E-SF3:T8415	0.4	160	0.10	1.0	85	0.09	1.0	145	0.10	1.0	405	0.12	1.0	35	0.07	0.8	25	0.07	0.3
VCGT 130308E-SF3:H07	0.8	–	–	–	75	0.09	1.0	120	0.10	1.0	390	0.12	1.0	35	0.08	0.8	–	–	–
VCGT 130308E-SF3:T6310	0.8	145	0.10	1.0	100	0.09	1.0	115	0.10	1.0	435	0.12	1.0	40	0.08	0.8	25	0.08	0.7
VCGT 130308E-SF3:T8315	0.8	155	0.10	1.0	90	0.09	1.0	145	0.10	1.0	465	0.12	1.0	35	0.08	0.8	30	0.08	0.7
VCGT 130308E-SF3:T8415	0.8	190	0.10	1.0	100	0.09	1.0	170	0.10	1.0	480	0.12	1.0	40	0.08	0.8	30	0.08	0.7
VCGT 160402E-SF3:T6310	0.2	145	0.05	0.8	100	0.05	0.8	115	0.05	0.8	435	0.06	0.8	40	0.04	0.6	25	0.05	0.2
VCGT 160402E-SF3:T8415	0.2	185	0.05	0.8	95	0.04	0.8	165	0.05	0.8	465	0.06	0.8	40	0.04	0.6	30	0.05	0.2
VCGT 160404E-SF3:H07	0.4	–	–	–	65	0.09	1.0	105	0.10	1.0	335	0.12	1.0	30	0.07	0.8	–	–	–
VCGT 160404E-SF3:T6310	0.4	125	0.10	1.0	90	0.09	1.0	100	0.10	1.0	375	0.12	1.0	35	0.07	0.8	25	0.07	0.3
VCGT 160404E-SF3:T8315	0.4	130	0.10	1.0	75	0.09	1.0	120	0.10	1.0	390	0.12	1.0	30	0.07	0.8	25	0.07	0.3
VCGT 160404E-SF3:T8415	0.4	160	0.10	1.0	85	0.09	1.0	145	0.10	1.0	405	0.12	1.0	35	0.07	0.8	25	0.07	0.3
VCGT 160408E-SF3:H07	0.8	–	–	–	75	0.09	1.2	120	0.10	1.2	390	0.12	1.2	35	0.08	1.0	–	–	–
VCGT 160408E-SF3:T6310	0.8	145	0.10	1.2	100	0.09	1.2	115	0.10	1.2	435	0.12	1.2	40	0.08	1.0	25	0.08	0.7
VCGT 160408E-SF3:T8315	0.8	155	0.10	1.2	90	0.09	1.2	145	0.10	1.2	465	0.12	1.2	35	0.08	1.0	30	0.08	0.7
VCGT 160408E-SF3:T8415	0.8	185	0.10	1.2	95	0.09	1.2	165	0.10	1.2	465	0.12	1.2	40	0.08	1.0	30	0.08	0.7
VCGT 160412E-SF3:H07	1.2	–	–	–	60	0.18	1.2	95	0.20	1.2	310	0.24	1.2	30	0.14	1.0	–	–	–
VCGT 160412E-SF3:T6310	1.2	125	0.20	1.2	90	0.18	1.2	100	0.20	1.2	375	0.24	1.2	35	0.14	1.0	25	0.10	0.9
VCGT 160412E-SF3:T8415	1.2	160	0.20	1.2	85	0.18	1.2	145	0.20	1.2	405	0.24	1.2	35	0.14	1.0	25	0.10	0.9

SF3 talaş kırıcı, Paslanmaz çeliklerin ve Süper alaşımların ince finiş işlemleri için ilk tercihtir. T-land olmadan son derece pozitif eğim açısına sahiptir. Ayrıca demir dışı alaşımlar ve koşullara uygun olarak Çelikler, Dökme demirler ve Sert malzemeler için de uygundur.

NF1

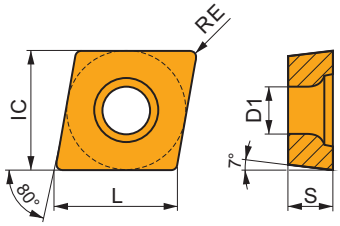




NF1 talaş kırıcı keskindir ve Çeliklerin, Paslanmaz çeliklerin ve Süper alaşımların ince finişi için tasarlanmıştır. T-land olmadan pozitif eğim açısına sahiptir. Ayrıca demir dışı alaşımlar ve sert malzemeler için de şartlı olarak uygundur.

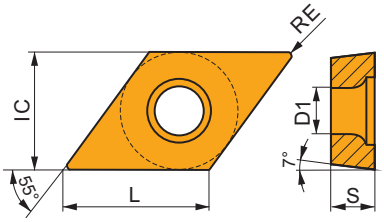
CCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0602	6.350	2.80	6.40	2.38
09T3	9.525	4.40	9.70	3.97



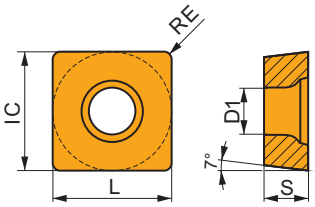
DCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
11T3	9.525	4.40	11.60	3.97



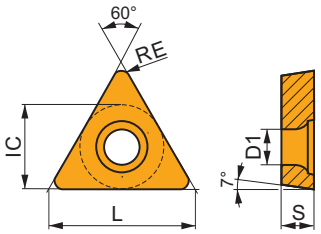
SCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
09T3	9.525	4.40	9.53	3.97
1204	12.700	5.50	12.70	4.76

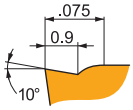
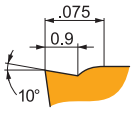
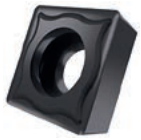
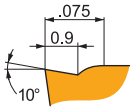
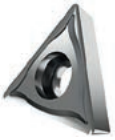
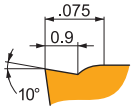


TCGT

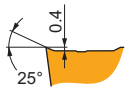
	IC (mm)	D1 (mm)	L (mm)	S (mm)
1102	6.350	2.80	11.00	2.38



Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P			M			K			N			S			H		
			vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)
																				
NF1 talaş kırıcı keskindir ve Çeliklerin, Paslanmaz çeliklerin ve Süper alaşımların ince finişi için tasarlanmıştır. T-land olmadan pozitif eğim açısına sahiptir. Ayrıca demir dışı alaşımlar ve sert malzemeler için de şartlı olarak uygundur.																				
CCGT 060204E-NF1:T6310	●	0.4	■ 180	0.10	0.8	■ 125	0.09	0.8	–	–	–	◪ 540	0.12	0.8	■ 50	0.07	0.6	◪ 35	0.08	0.3
CCGT 060204E-NF1:T7325	●	0.4	◪ 210	0.10	0.8	■ 160	0.09	0.8	–	–	–	–	–	–	■ 65	0.07	0.6	–	–	–
CCGT 060208E-NF1:T6310	●●	0.8	■ 205	0.12	0.8	■ 145	0.11	0.8	–	–	–	◪ 615	0.14	0.8	■ 60	0.11	0.6	◪ 40	0.09	0.7
CCGT 09T304E-NF1:T6310	●	0.4	■ 175	0.10	1.2	■ 125	0.09	1.2	–	–	–	◪ 525	0.12	1.2	■ 50	0.07	1.0	◪ 35	0.08	0.3
CCGT 09T304E-NF1:T7325	●	0.4	◪ 200	0.10	1.2	■ 155	0.09	1.2	–	–	–	–	–	–	■ 65	0.07	1.0	–	–	–
CCGT 09T308E-NF1:T6310	●●	0.8	■ 190	0.14	1.2	■ 135	0.13	1.2	–	–	–	◪ 570	0.17	1.2	■ 55	0.13	1.0	◪ 35	0.11	0.7
CCGT 09T308E-NF1:T7325	●●	0.8	◪ 215	0.14	1.2	■ 165	0.13	1.2	–	–	–	–	–	–	■ 65	0.13	1.0	–	–	–
																				
NF1 talaş kırıcı keskindir ve Çeliklerin, Paslanmaz çeliklerin ve Süper alaşımların ince finişi için tasarlanmıştır. T-land olmadan pozitif eğim açısına sahiptir. Ayrıca demir dışı alaşımlar ve sert malzemeler için de şartlı olarak uygundur.																				
DCGT 11T304E-NF1:T6310	●	0.4	■ 145	0.10	0.8	■ 100	0.09	0.8	–	–	–	◪ 435	0.12	0.8	■ 40	0.07	0.6	◪ 25	0.07	0.3
DCGT 11T304E-NF1:T7325	●	0.4	◪ 165	0.10	0.8	■ 125	0.09	0.8	–	–	–	–	–	–	■ 50	0.07	0.6	–	–	–
DCGT 11T308E-NF1:T6310	●●	0.8	■ 155	0.14	0.8	■ 110	0.13	0.8	–	–	–	◪ 465	0.17	0.8	■ 45	0.13	0.6	◪ 30	0.10	0.7
DCGT 11T308E-NF1:T7325	●●	0.8	◪ 180	0.14	0.8	■ 140	0.13	0.8	–	–	–	–	–	–	■ 55	0.13	0.6	–	–	–
																				
NF1 talaş kırıcı keskindir ve Çeliklerin, Paslanmaz çeliklerin ve Süper alaşımların ince finişi için tasarlanmıştır. T-land olmadan pozitif eğim açısına sahiptir. Ayrıca demir dışı alaşımlar ve sert malzemeler için de şartlı olarak uygundur.																				
SCGT 09T308E-NF1:T6310	●●	0.8	■ 200	0.14	1.2	■ 140	0.13	1.2	–	–	–	◪ 600	0.17	1.2	■ 60	0.13	1.0	◪ 40	0.10	0.7
SCGT 120408E-NF1:T6310	●●	0.8	■ 180	0.18	1.4	■ 125	0.16	1.4	–	–	–	◪ 540	0.22	1.4	■ 50	0.16	1.1	◪ 35	0.13	0.7
SCGT 120408E-NF1:T7325	●●	0.8	◪ 205	0.18	1.4	■ 155	0.16	1.4	–	–	–	–	–	–	■ 65	0.16	1.1	–	–	–
																				
NF1 talaş kırıcı keskindir ve Çeliklerin, Paslanmaz çeliklerin ve Süper alaşımların ince finişi için tasarlanmıştır. T-land olmadan pozitif eğim açısına sahiptir. Ayrıca demir dışı alaşımlar ve sert malzemeler için de şartlı olarak uygundur.																				
TCGT 110204E-NF1:T6310	●	0.4	■ 155	0.10	0.8	■ 110	0.09	0.8	–	–	–	◪ 465	0.12	0.8	■ 45	0.08	0.6	◪ 30	0.08	0.3

SF2





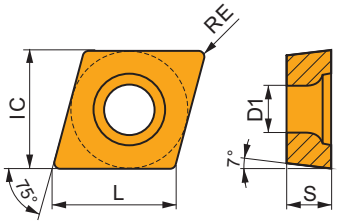
SF2 talaş kırıcı keskindir ve Paslanmaz çeliklerin ve Süper alaşımların ince finişi için tasarlanmıştır. T-land olmadan son derece pozitif eğim açısına sahiptir. Çelikler ve demir dışı alaşımlar için de şartlı olarak uygundur.

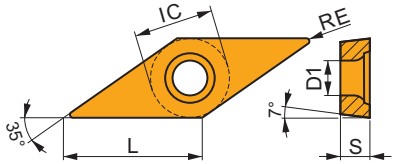
ECGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0602	6.350	2.80	6.50	2.38
0803	7.940	3.40	8.20	3.18

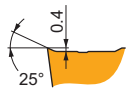
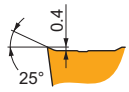
VCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1303	7.940	3.40	13.80	3.18

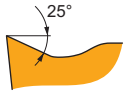




Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																			
																			
																			
SF2 talaş kırıcı keskindir ve Paslanmaz çeliklerin ve Süper alaşımların ince finişi için tasarlanmıştır. T-land olmadan son derece pozitif eğim açısına sahiptir. Çelikler ve demir dışı alaşımlar için de şartlı olarak uygundur.																			
ECGT 060202E-SF2:H07	0.2	–	–	–	105	0.05	1.0	–	–	–	525	0.06	1.0	50	0.04	0.8	–	–	–
ECGT 060202E-SF2:T6310	0.2	185	0.05	1.0	130	0.05	1.0	–	–	–	555	0.06	1.0	55	0.04	0.8	–	–	–
ECGT 060204E-SF2:H07	0.4	–	–	–	85	0.09	1.0	–	–	–	430	0.12	1.0	40	0.07	0.8	–	–	–
ECGT 060204E-SF2:T6310	0.4	160	0.10	1.0	115	0.09	1.0	–	–	–	480	0.12	1.0	45	0.07	0.8	–	–	–
ECGT 080302E-SF2:H07	0.2	–	–	–	105	0.05	1.0	–	–	–	525	0.06	1.0	50	0.04	0.8	–	–	–
ECGT 080302E-SF2:T6310	0.2	185	0.05	1.0	130	0.05	1.0	–	–	–	555	0.06	1.0	55	0.04	0.8	–	–	–
ECGT 080304E-SF2:H07	0.4	–	–	–	85	0.09	1.0	–	–	–	430	0.12	1.0	40	0.07	0.8	–	–	–
ECGT 080304E-SF2:T6310	0.4	160	0.10	1.0	115	0.09	1.0	–	–	–	480	0.12	1.0	45	0.07	0.8	–	–	–
																			
																			
																			
SF2 talaş kırıcı keskindir ve Paslanmaz çeliklerin ve Süper alaşımların ince finişi için tasarlanmıştır. T-land olmadan son derece pozitif eğim açısına sahiptir. Çelikler ve demir dışı alaşımlar için de şartlı olarak uygundur.																			
VCGT 130301E-SF2:H07	0.1	–	–	–	80	0.05	1.0	–	–	–	405	0.06	1.0	40	0.04	0.8	–	–	–
VCGT 130301E-SF2:T6310	0.1	140	0.05	1.0	100	0.05	1.0	–	–	–	420	0.06	1.0	40	0.04	0.8	–	–	–
VCGT 130302E-SF2:H07	0.2	–	–	–	80	0.05	1.0	–	–	–	405	0.06	1.0	40	0.04	0.8	–	–	–
VCGT 130302E-SF2:HF7	0.2	–	–	–	90	0.05	1.0	–	–	–	450	0.06	1.0	–	–	–	–	–	–
VCGT 130302E-SF2:T6310	0.2	140	0.05	1.0	100	0.05	1.0	–	–	–	420	0.06	1.0	40	0.04	0.8	–	–	–
VCGT 130304E-SF2:H07	0.4	–	–	–	65	0.09	1.0	–	–	–	335	0.12	1.0	30	0.07	0.8	–	–	–
VCGT 130304E-SF2:HF7	0.4	–	–	–	75	0.09	1.0	–	–	–	375	0.12	1.0	–	–	–	–	–	–
VCGT 130304E-SF2:T6310	0.4	125	0.10	1.0	90	0.09	1.0	–	–	–	375	0.12	1.0	35	0.07	0.8	–	–	–
VCGT 130308E-SF2:HF7	0.8	–	–	–	85	0.09	1.0	–	–	–	435	0.12	1.0	–	–	–	–	–	–
VCGT 130308E-SF2:T6310	0.8	145	0.10	1.0	100	0.09	1.0	–	–	–	435	0.12	1.0	40	0.08	0.8	–	–	–

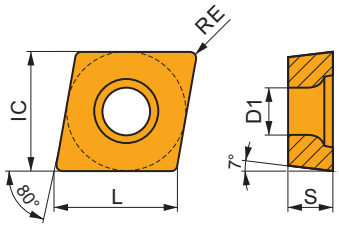
AL



AL talaş kırıcı keskindir ve demir dışı alaşımların çok yönlü işlenmesi için ilk tercihtir. T-land olmadan son derece pozitif eğim açısına sahiptir. Süper alaşımlar için de şartlı olarak uygundur.

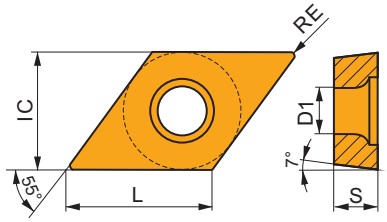
CCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0602	6.350	2.80	6.40	2.38
0803-AL	7.940	3.40	8.10	3.43
09T3	9.525	4.40	9.70	3.97
1204	12.700	5.50	12.90	4.76



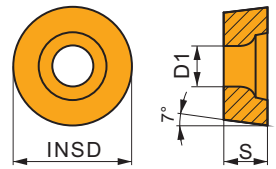
DCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0702	6.350	2.80	7.80	2.38
11T3	9.525	4.40	11.60	3.97



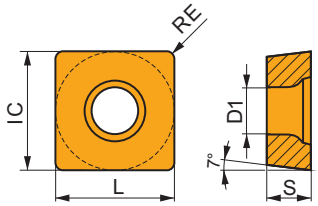
RCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0803	8.000	3.40	3.18	3.97
1003	10.000	4.40	3.18	



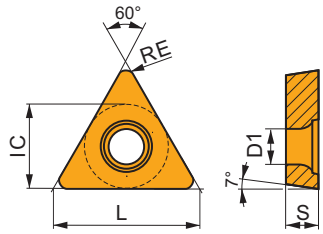
SCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.50	12.70	4.76



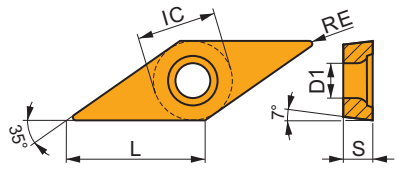
TCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0902	5.560	2.50	9.60	2.38
1102	6.350	2.80	11.00	2.38
16T3	9.525	4.40	16.50	3.97



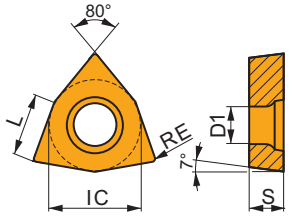
VCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0702	3.970	2.20	6.90	2.38
1103	6.350	2.80	11.10	3.18
1303-AL	7.940	3.40	13.80	3.43
1604	9.525	4.40	16.60	4.76

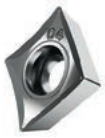
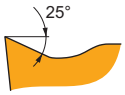
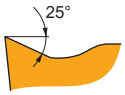
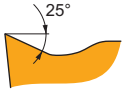
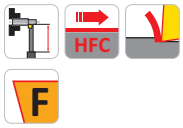
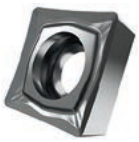
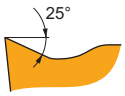


WCGT

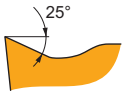
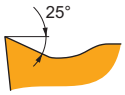
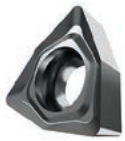
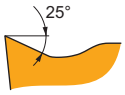
	IC (mm)	D1 (mm)	L (mm)	S (mm)
06T3	9.525	4.40	6.50	3.97
0804	12.700	5.50	8.70	4.76



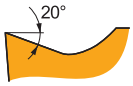
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P			M			K			N			S			H		
		(mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)
																				
AL talaş kırıcı keskindir ve demir dışı alaşımların çok yönlü işlenmesi için ilk tercihtir. T-land olmadan son derece pozitif eğim açısına sahiptir. Süper alaşımlar için de şartlı olarak uygundur.																				
CCGT 060202F-AL:HF7	●	0.2	–	–	–	–	–	–	–	–	–	■ 450	0.12	1.0	–	–	–	–	–	–
CCGT 060202F-AL:T0315	●	0.2	–	–	–	–	–	–	–	–	–	■ 645	0.12	1.0	–	–	–	–	–	–
CCGT 060204F-AL:HF7	●	0.4	–	–	–	–	–	–	–	–	–	■ 360	0.24	1.0	–	–	–	–	–	–
CCGT 060204F-AL:T0315	●	0.4	–	–	–	–	–	–	–	–	–	■ 525	0.24	1.0	–	–	–	–	–	–
CCGT 080302F-AL:T0315	●	0.2	–	–	–	–	–	–	–	–	–	■ 645	0.12	1.0	–	–	–	–	–	–
CCGT 080304F-AL:HF7	●	0.4	–	–	–	–	–	–	–	–	–	■ 360	0.24	1.0	–	–	–	–	–	–
CCGT 080304F-AL:T0315	●	0.4	–	–	–	–	–	–	–	–	–	■ 525	0.24	1.0	–	–	–	–	–	–
CCGT 09T302F-AL:HF7	●	0.2	–	–	–	–	–	–	–	–	–	■ 450	0.12	1.0	–	–	–	–	–	–
CCGT 09T302F-AL:T0315	●	0.2	–	–	–	–	–	–	–	–	–	■ 645	0.12	1.0	–	–	–	–	–	–
CCGT 09T304F-AL:HF7	●	0.4	–	–	–	–	–	–	–	–	–	■ 345	0.24	1.5	–	–	–	–	–	–
CCGT 09T304F-AL:T0315	●	0.4	–	–	–	–	–	–	–	–	–	■ 495	0.24	1.5	–	–	–	–	–	–
CCGT 09T308F-AL:HF7	●	0.8	–	–	–	–	–	–	–	–	–	■ 315	0.48	1.5	–	–	–	–	–	–
CCGT 09T308F-AL:T0315	●	0.8	–	–	–	–	–	–	–	–	–	■ 450	0.48	1.5	–	–	–	–	–	–
CCGT 120404F-AL:HF7	●	0.4	–	–	–	–	–	–	–	–	–	■ 330	0.24	2.4	–	–	–	–	–	–
CCGT 120404F-AL:T0315	●	0.4	–	–	–	–	–	–	–	–	–	■ 480	0.24	2.4	–	–	–	–	–	–
CCGT 120408F-AL:HF7	●	0.8	–	–	–	–	–	–	–	–	–	■ 300	0.48	2.4	–	–	–	–	–	–
CCGT 120408F-AL:T0315	●	0.8	–	–	–	–	–	–	–	–	–	■ 435	0.48	2.4	–	–	–	–	–	–
																				
AL talaş kırıcı keskindir ve demir dışı alaşımların çok yönlü işlenmesi için ilk tercihtir. T-land olmadan son derece pozitif eğim açısına sahiptir. Süper alaşımlar için de şartlı olarak uygundur.																				
DCGT 070202F-AL:HF7	●	0.2	–	–	–	–	–	–	–	–	–	■ 360	0.12	1.0	–	–	–	–	–	–
DCGT 070202F-AL:T0315	●	0.2	–	–	–	–	–	–	–	–	–	■ 510	0.12	1.0	–	–	–	–	–	–
DCGT 070204F-AL:HF7	●	0.4	–	–	–	–	–	–	–	–	–	■ 285	0.24	1.0	–	–	–	–	–	–
DCGT 070204F-AL:T0315	●	0.4	–	–	–	–	–	–	–	–	–	■ 420	0.24	1.0	–	–	–	–	–	–
DCGT 11T302F-AL:HF7	●	0.2	–	–	–	–	–	–	–	–	–	■ 345	0.12	1.5	–	–	–	–	–	–
DCGT 11T302F-AL:T0315	●	0.2	–	–	–	–	–	–	–	–	–	■ 495	0.12	1.5	–	–	–	–	–	–
DCGT 11T304F-AL:HF7	●	0.4	–	–	–	–	–	–	–	–	–	■ 270	0.24	1.5	–	–	–	–	–	–
DCGT 11T304F-AL:T0315	●	0.4	–	–	–	–	–	–	–	–	–	■ 390	0.24	1.5	–	–	–	–	–	–
DCGT 11T308F-AL:HF7	●	0.8	–	–	–	–	–	–	–	–	–	■ 255	0.48	1.5	–	–	–	–	–	–
DCGT 11T308F-AL:T0315	●	0.8	–	–	–	–	–	–	–	–	–	■ 360	0.48	1.5	–	–	–	–	–	–
																				
AL talaş kırıcı keskindir ve demir dışı alaşımların çok yönlü işlenmesi için ilk tercihtir. T-land olmadan son derece pozitif eğim açısına sahiptir. Süper alaşımlar için de şartlı olarak uygundur.																				
RCGT 0803MOF-AL:HF7	●	–	–	–	–	–	–	–	–	–	–	■ 285	1.20	1.0	–	–	–	–	–	–
RCGT 0803MOF-AL:T0315	●	–	–	–	–	–	–	–	–	–	–	■ 420	1.20	1.0	–	–	–	–	–	–
RCGT 1003MOF-AL:HF7	●	–	–	–	–	–	–	–	–	–	–	■ 255	1.50	1.0	–	–	–	–	–	–
RCGT 1003MOF-AL:T0315	●	–	–	–	–	–	–	–	–	–	–	■ 390	1.50	1.0	–	–	–	–	–	–
																				
AL talaş kırıcı keskindir ve demir dışı alaşımların çok yönlü işlenmesi için ilk tercihtir. T-land olmadan son derece pozitif eğim açısına sahiptir. Süper alaşımlar için de şartlı olarak uygundur.																				
SCGT 120408F-AL:HF7	●	0.8	–	–	–	–	–	–	–	–	–	■ 315	0.48	2.0	–	–	–	–	–	–
SCGT 120408F-AL:T0315	●	0.8	–	–	–	–	–	–	–	–	–	■ 465	0.48	2.0	–	–	–	–	–	–

Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
   **AL** talaş kırıcı keskindir ve demir dışı alaşımların çok yönlü işlenmesi için ilk tercihtir. T-land olmadan son derece pozitif eğim açısına sahiptir. Süper alaşımlar için de şartlı olarak uygundur.																			
TCGT 090202F-AL:HF7	0.2	–	–	–	–	–	–	–	–	–	375	0.12	1.0	–	–	–	–	–	–
TCGT 090202F-AL:T0315	0.2	–	–	–	–	–	–	–	–	–	555	0.12	1.0	–	–	–	–	–	–
TCGT 090204F-AL:HF7	0.4	–	–	–	–	–	–	–	–	–	300	0.24	1.0	–	–	–	–	–	–
TCGT 090204F-AL:T0315	0.4	–	–	–	–	–	–	–	–	–	450	0.24	1.0	–	–	–	–	–	–
TCGT 110202F-AL:HF7	0.2	–	–	–	–	–	–	–	–	–	360	0.12	1.5	–	–	–	–	–	–
TCGT 110202F-AL:T0315	0.2	–	–	–	–	–	–	–	–	–	525	0.12	1.5	–	–	–	–	–	–
TCGT 110204F-AL:HF7	0.4	–	–	–	–	–	–	–	–	–	285	0.24	1.5	–	–	–	–	–	–
TCGT 110204F-AL:T0315	0.4	–	–	–	–	–	–	–	–	–	420	0.24	1.5	–	–	–	–	–	–
TCGT 110208F-AL:HF7	0.8	–	–	–	–	–	–	–	–	–	270	0.48	1.5	–	–	–	–	–	–
TCGT 16T304F-AL:HF7	0.4	–	–	–	–	–	–	–	–	–	285	0.24	2.4	–	–	–	–	–	–
TCGT 16T304F-AL:T0315	0.4	–	–	–	–	–	–	–	–	–	405	0.24	2.4	–	–	–	–	–	–
TCGT 16T308F-AL:HF7	0.8	–	–	–	–	–	–	–	–	–	255	0.48	2.4	–	–	–	–	–	–
TCGT 16T308F-AL:T0315	0.8	–	–	–	–	–	–	–	–	–	360	0.48	2.4	–	–	–	–	–	–
   **AL** talaş kırıcı keskindir ve demir dışı alaşımların çok yönlü işlenmesi için ilk tercihtir. T-land olmadan son derece pozitif eğim açısına sahiptir. Süper alaşımlar için de şartlı olarak uygundur.																			
VCGT 070202F-AL:HF7	0.2	–	–	–	–	–	–	–	–	–	315	0.12	1.0	–	–	–	–	–	–
VCGT 110302F-AL:HF7	0.2	–	–	–	–	–	–	–	–	–	300	0.12	1.5	–	–	–	–	–	–
VCGT 110302F-AL:T0315	0.2	–	–	–	–	–	–	–	–	–	465	0.12	0.8	–	–	–	–	–	–
VCGT 110304F-AL:HF7	0.4	–	–	–	–	–	–	–	–	–	240	0.24	1.5	–	–	–	–	–	–
VCGT 110304F-AL:T0315	0.4	–	–	–	–	–	–	–	–	–	375	0.24	0.8	–	–	–	–	–	–
VCGT 130302F-AL:HF7	0.2	–	–	–	–	–	–	–	–	–	285	0.12	1.7	–	–	–	–	–	–
VCGT 130302F-AL:T0315	0.2	–	–	–	–	–	–	–	–	–	420	0.12	1.7	–	–	–	–	–	–
VCGT 130304F-AL:HF7	0.4	–	–	–	–	–	–	–	–	–	240	0.24	1.7	–	–	–	–	–	–
VCGT 130304F-AL:T0315	0.4	–	–	–	–	–	–	–	–	–	345	0.24	1.7	–	–	–	–	–	–
VCGT 130308F-AL:HF7	0.8	–	–	–	–	–	–	–	–	–	210	0.48	1.7	–	–	–	–	–	–
VCGT 130308F-AL:T0315	0.8	–	–	–	–	–	–	–	–	–	315	0.48	1.7	–	–	–	–	–	–
VCGT 160402F-AL:HF7	0.2	–	–	–	–	–	–	–	–	–	285	0.12	2.4	–	–	–	–	–	–
VCGT 160402F-AL:T0315	0.2	–	–	–	–	–	–	–	–	–	420	0.12	2.4	–	–	–	–	–	–
VCGT 160404F-AL:HF7	0.4	–	–	–	–	–	–	–	–	–	225	0.24	2.4	–	–	–	–	–	–
VCGT 160404F-AL:T0315	0.4	–	–	–	–	–	–	–	–	–	330	0.24	2.4	–	–	–	–	–	–
VCGT 160408F-AL:HF7	0.8	–	–	–	–	–	–	–	–	–	210	0.48	2.4	–	–	–	–	–	–
VCGT 160408F-AL:T0315	0.8	–	–	–	–	–	–	–	–	–	300	0.48	2.4	–	–	–	–	–	–
VCGT 160412F-AL:HF7	1.2	–	–	–	–	–	–	–	–	–	180	0.72	2.4	–	–	–	–	–	–
VCGT 160412F-AL:T0315	1.2	–	–	–	–	–	–	–	–	–	270	0.72	2.4	–	–	–	–	–	–
   **AL** talaş kırıcı keskindir ve demir dışı alaşımların çok yönlü işlenmesi için ilk tercihtir. T-land olmadan son derece pozitif eğim açısına sahiptir. Süper alaşımlar için de şartlı olarak uygundur.																			
WCGT 06T302F-AL:HF7	0.2	–	–	–	–	–	–	–	–	–	450	0.12	1.0	–	–	–	–	–	–
WCGT 06T304F-AL:HF7	0.4	–	–	–	–	–	–	–	–	–	360	0.24	1.0	–	–	–	–	–	–
WCGT 06T304F-AL:T0315	0.4	–	–	–	–	–	–	–	–	–	525	0.24	1.0	–	–	–	–	–	–
WCGT 06T308F-AL:HF7	0.8	–	–	–	–	–	–	–	–	–	315	0.48	1.5	–	–	–	–	–	–
WCGT 080412F-AL:HF7	1.2	–	–	–	–	–	–	–	–	–	255	0.72	2.4	–	–	–	–	–	–

JQ JR JZ



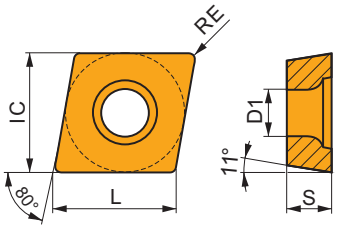


JQ, JR, JZ talaş kırıcı keskindir ve Çeliklerin ince finişi için tasarlanmıştır. T-land olmadan son derece pozitif eğim açısına sahiptir. Paslanmaz çelikler için de şartlı olarak uygundur.

PRAMET

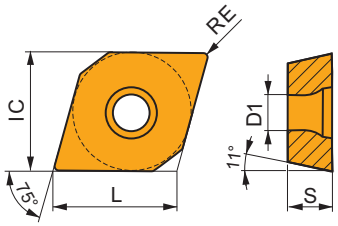
CPGX

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0602	6.350	2.80	6.40	2.38
0803	7.940	3.40	8.10	3.18
09T3	9.525	4.40	9.70	3.97



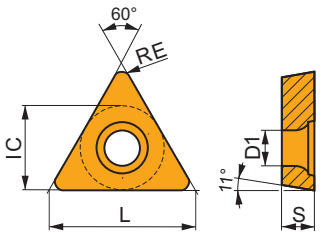
EPGX

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0502	5.560	2.50	5.70	2.38



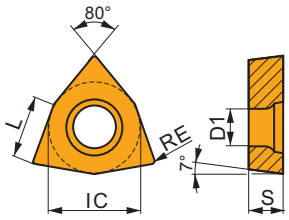
TPGX

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0902	5.560	2.50	9.60	2.38
1102	6.350	2.80	11.00	2.38
16T3	9.525	4.40	16.50	3.97

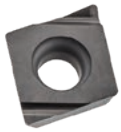
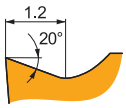
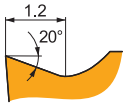
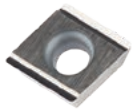
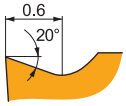
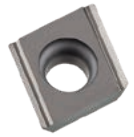
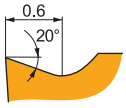
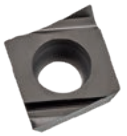
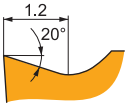
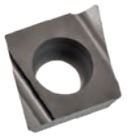
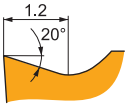
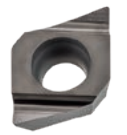
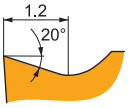
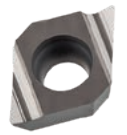
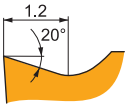
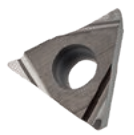
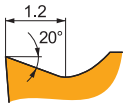


WCGX

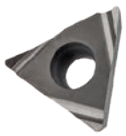
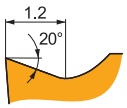
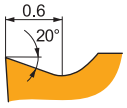
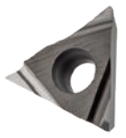
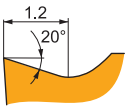
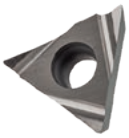
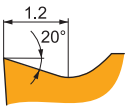
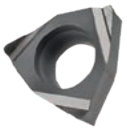
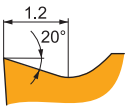
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0201	3.970	2.20	2.70	1.59



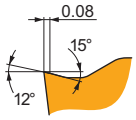
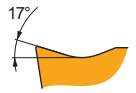
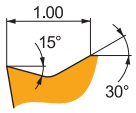
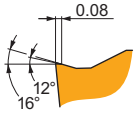
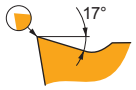
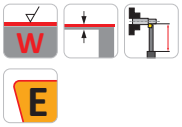
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
  																			
JQ talaş kırıcı keskindir ve Çeliklerin ince finişi için tasarlanmıştır. T-land olmadan son derece pozitif eğim açısına sahiptir. Paslanmaz çelikler için de şartlı olarak uygundur.																			
CPGX 080304FR-JQ:TT010	● 0.4	350	0.06	0.5	210	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–
  																			
JQ talaş kırıcı keskindir ve Çeliklerin ince finişi için tasarlanmıştır. T-land olmadan son derece pozitif eğim açısına sahiptir. Paslanmaz çelikler için de şartlı olarak uygundur.																			
CPGX 080304FL-JQ:TT010	● 0.4	350	0.06	0.5	210	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–
CPGX 09T304FL-JQ:TT010	● 0.4	350	0.06	0.5	210	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–
  																			
JR talaş kırıcı keskindir ve Çeliklerin ince finişi için tasarlanmıştır. T-land olmadan son derece pozitif eğim açısına sahiptir. Paslanmaz çelikler için de şartlı olarak uygundur.																			
CPGX 060204FR-JR:TT010	● 0.4	350	0.06	0.5	210	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–
CPGX 080304FR-JR:TT010	● 0.4	350	0.06	0.5	210	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–
  																			
JR talaş kırıcı keskindir ve Çeliklerin ince finişi için tasarlanmıştır. T-land olmadan son derece pozitif eğim açısına sahiptir. Paslanmaz çelikler için de şartlı olarak uygundur.																			
CPGX 060204FL-JR:TT010	● 0.4	350	0.06	0.5	210	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–
CPGX 080304FL-JR:TT010	● 0.4	350	0.06	0.5	210	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–
  																			
JZ talaş kırıcı keskindir ve Çeliklerin ince finişi için tasarlanmıştır. T-land olmadan son derece pozitif eğim açısına sahiptir. Paslanmaz çelikler için de şartlı olarak uygundur.																			
CPGX 060202FR-JZ:TT010	● 0.2	330	0.06	0.5	195	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–
  																			
JZ talaş kırıcı keskindir ve Çeliklerin ince finişi için tasarlanmıştır. T-land olmadan son derece pozitif eğim açısına sahiptir. Paslanmaz çelikler için de şartlı olarak uygundur.																			
CPGX 060202FL-JZ:TT010	● 0.2	330	0.06	0.5	195	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–
  																			
JZ talaş kırıcı keskindir ve Çeliklerin ince finişi için tasarlanmıştır. T-land olmadan son derece pozitif eğim açısına sahiptir. Paslanmaz çelikler için de şartlı olarak uygundur.																			
EPGX 050202FR-JZ:TT010	● 0.2	295	0.06	0.5	175	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–
  																			
JZ talaş kırıcı keskindir ve Çeliklerin ince finişi için tasarlanmıştır. T-land olmadan son derece pozitif eğim açısına sahiptir. Paslanmaz çelikler için de şartlı olarak uygundur.																			
EPGX 050202FL-JZ:TT010	● 0.2	295	0.06	0.5	175	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–
  																			
JQ talaş kırıcı keskindir ve Çeliklerin ince finişi için tasarlanmıştır. T-land olmadan son derece pozitif eğim açısına sahiptir. Paslanmaz çelikler için de şartlı olarak uygundur.																			
TPGX 110204FR-JQ:TT010	● 0.4	295	0.06	0.5	175	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–

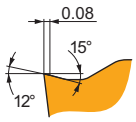
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P			M			K			N			S			H		
			vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)
																				
JQ talaş kırıcı keskindir ve Çeliklerin ince finişi için tasarlanmıştır. T-land olmadan son derece pozitif eğim açısına sahiptir. Paslanmaz çelikler için de şartlı olarak uygundur.																				
TPGX 090204FL-JQ:TT010	●	0.4	295	0.06	0.5	175	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–
TPGX 110204FL-JQ:TT010	●	0.4	295	0.06	0.5	175	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–
																				
JR talaş kırıcı keskindir ve Çeliklerin ince finişi için tasarlanmıştır. T-land olmadan son derece pozitif eğim açısına sahiptir. Paslanmaz çelikler için de şartlı olarak uygundur.																				
TPGX 16T304FL-JR:TT010	●	0.4	295	0.06	0.5	175	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–
																				
JZ talaş kırıcı keskindir ve Çeliklerin ince finişi için tasarlanmıştır. T-land olmadan son derece pozitif eğim açısına sahiptir. Paslanmaz çelikler için de şartlı olarak uygundur.																				
TPGX 090202FR-JZ:TT010	●	0.2	280	0.06	0.5	165	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–
																				
JZ talaş kırıcı keskindir ve Çeliklerin ince finişi için tasarlanmıştır. T-land olmadan son derece pozitif eğim açısına sahiptir. Paslanmaz çelikler için de şartlı olarak uygundur.																				
TPGX 090202FL-JZ:TT010	●	0.2	280	0.06	0.5	165	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–
																				
JZ talaş kırıcı keskindir ve Çeliklerin ince finişi için tasarlanmıştır. T-land olmadan son derece pozitif eğim açısına sahiptir. Paslanmaz çelikler için de şartlı olarak uygundur.																				
WCGX 020102FL-JZ:TT010	●	0.2	330	0.06	0.5	195	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–

FİNİŞ - REHBER

FM			**FM** talaş kırıcı çok yönlüdür ve çeliklerin finiş işlemleri için ilk tercihtir. Pozitif eğim açısı ve pozitif, dar T-land özelliğine sahiptir. Paslanmaz çelikler için ve şartlara bağlı oalrak dökme demirler ve demir dışı alaşımlar için de uygundur.
NF2			**NF2** talaş kırıcı keskin ve paslanmaz çeliklerin finiş işlemi için ilk tercihtir. T-land olmadan pozitif eğim açısına sahiptir. Ayrıca süper alaşımlar ve şartlara bağlı olarak çelikler, dökme demirler ve demir dışı alaşımlar için de uygundur.
UR			**UR** talaş kırıcı çok yönlüdür ve dökme demirlerin finiş işlemleri için ilk tercihtir. T-land olmadan pozitif eğim açısına sahiptir. Çelikler için ve koşullara göre paslanmaz çelikler için de uygundur.
W -FM			**W-FM** talaş kırıcı silici kenara sahiptir ve Çeliklerin, Paslanmaz çeliklerin ve Dökme demirlerin finişi için tasarlanmıştır. Pozitif eğim açısı ve pozitif, dar T-land özelliğine sahiptir.
W -UR			**W-UR** talaş kırıcı silici kenara sahiptir ve Çeliklerin ve Dökme demirlerin finişi için tasarlanmıştır. T-land olmadan pozitif eğim açısına sahiptir. Paslanmaz çelikler için de şartlı olarak uygundur.

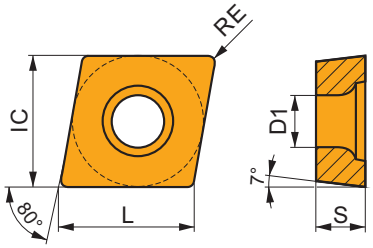
FM



FM talaş kırıcı çok yönlüdür ve çeliklerin finiş işlemleri için ilk tercihtir. Pozitif eğim açısı ve pozitif, dar T-land özelliğine sahiptir. Paslanmaz çelikler için ve şartlara bağlı oalrak dökme demirler ve demir dışı alaşımlar için de uygundur.

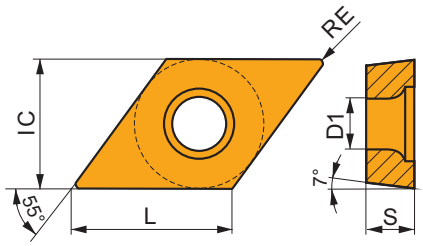
CCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0602	6.350	2.80	6.40	2.38
09T3	9.525	4.40	9.70	3.97
1204	12.700	5.50	12.90	4.76



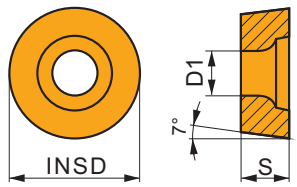
DCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0702	6.350	2.80	7.80	2.38
11T3	9.525	4.40	11.60	3.97



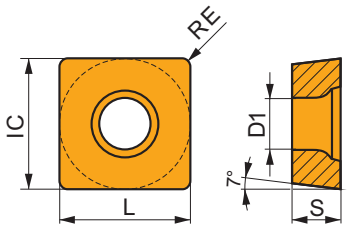
RCMT

	IC (mm)	D1 (mm)	S (mm)
0602	6.000	2.80	2.38
0803	8.000	3.40	3.18
10T3	10.000	4.40	3.97
1204	12.000	4.40	4.76



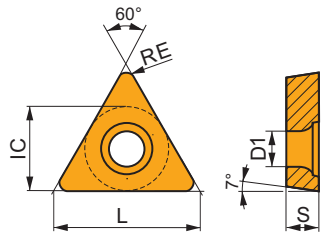
SCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
09T3	9.525	4.40	9.53	3.97
1204	12.700	5.50	12.70	4.76



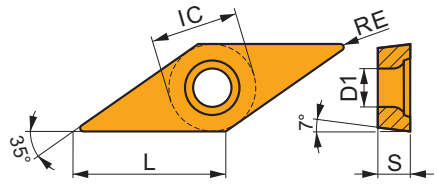
TCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1102	6.350	2.80	11.00	2.38
16T3	9.525	4.40	16.50	3.97



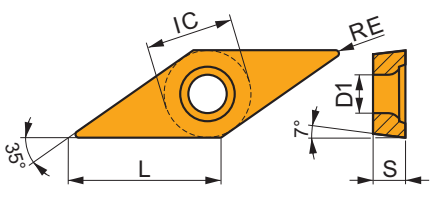
VBMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1103	6.350	2.80	11.10	3.18
1604	9.525	4.40	16.60	4.76



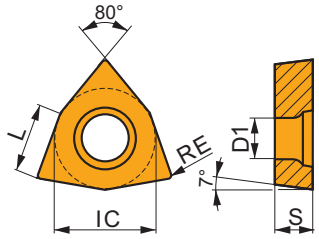
VCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	4.40	16.60	4.76



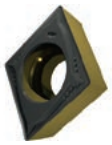
WCMT

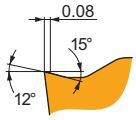
	IC (mm)	D1 (mm)	L (mm)	S (mm)
06T3	9.525	4.40	6.50	3.97
0804	12.700	5.50	8.70	4.76



Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

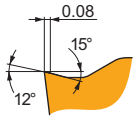
Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
CCMT 060202E-FM:T7325	●	0.2	210	0.10	1.0	160	0.09	1.0	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 060202E-FM:T7335	●	0.2	210	0.10	1.0	160	0.09	1.0	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 060202E-FM:T8315	●	0.2	195	0.10	1.0	115	0.09	1.0	185	0.10	1.0	585	0.12	1.0	–	–	–	–	–	–
CCMT 060202E-FM:T8415	●	0.2	240	0.10	1.0	125	0.09	1.0	215	0.10	1.0	600	0.12	1.0	–	–	–	–	–	–
CCMT 060202E-FM:T8430	●	0.2	230	0.10	1.0	125	0.09	1.0	185	0.10	1.0	630	0.12	1.0	–	–	–	–	–	–
CCMT 060202E-FM:T9325	●	0.2	285	0.10	1.0	170	0.09	1.0	270	0.10	1.0	–	–	–	–	–	–	–	–	–
CCMT 060202E-FM:T9415	●	0.2	335	0.10	1.0	–	–	–	315	0.10	1.0	–	–	–	–	–	–	–	–	–
CCMT 060204E-FM:T7325	●	0.4	200	0.15	1.0	155	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 060204E-FM:T7335	●	0.4	195	0.15	1.0	150	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 060204E-FM:T8315	●	0.4	185	0.15	1.0	110	0.14	1.0	175	0.15	1.0	555	0.18	1.0	–	–	–	–	–	–
CCMT 060204E-FM:T8415	●	0.4	225	0.15	1.0	115	0.14	1.0	205	0.15	1.0	570	0.18	1.0	–	–	–	–	–	–
CCMT 060204E-FM:T8430	●	0.4	205	0.15	1.0	110	0.14	1.0	170	0.15	1.0	570	0.18	1.0	–	–	–	–	–	–
CCMT 060204E-FM:T9315	●	0.4	285	0.15	1.0	–	–	–	270	0.15	1.0	–	–	–	–	–	–	–	–	–
CCMT 060204E-FM:T9325	●	0.4	250	0.15	1.0	150	0.15	1.0	235	0.15	1.0	–	–	–	–	–	–	–	–	–
CCMT 060204E-FM:T9415	●	0.4	310	0.15	1.0	–	–	–	290	0.15	1.0	–	–	–	–	–	–	–	–	–
CCMT 060208E-FM:T7325	●	0.8	220	0.20	1.0	170	0.18	1.0	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 060208E-FM:T8430	⬢	0.8	220	0.20	1.0	120	0.18	1.0	180	0.20	1.0	600	0.24	1.0	–	–	–	–	–	–
CCMT 060208E-FM:T9325	●	0.8	265	0.20	1.0	155	0.18	1.0	250	0.20	1.0	–	–	–	–	–	–	–	–	–
CCMT 060208E-FM:T9415	●	0.8	335	0.20	1.0	–	–	–	315	0.20	1.0	–	–	–	–	–	–	–	–	–
CCMT 09T302E-FM:T7325	●	0.2	205	0.10	1.2	155	0.09	1.2	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 09T302E-FM:T7335	●	0.2	205	0.10	1.2	155	0.09	1.2	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 09T302E-FM:T8315	●	0.2	190	0.10	1.2	110	0.09	1.2	180	0.10	1.2	570	0.12	1.2	–	–	–	–	–	–
CCMT 09T302E-FM:T8415	●	0.2	230	0.10	1.2	120	0.09	1.2	210	0.10	1.2	585	0.12	1.2	–	–	–	–	–	–
CCMT 09T302E-FM:T8430	●	0.2	225	0.10	1.2	120	0.09	1.2	185	0.10	1.2	615	0.12	1.2	–	–	–	–	–	–
CCMT 09T302E-FM:T9325	●	0.2	275	0.10	1.2	165	0.09	1.2	260	0.10	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T302E-FM:T9415	●	0.2	330	0.10	1.2	–	–	–	310	0.10	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T304E-FM:T7325	●	0.4	195	0.15	1.2	150	0.15	1.2	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 09T304E-FM:T7335	●	0.4	190	0.15	1.2	145	0.15	1.2	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 09T304E-FM:T8315	●	0.4	180	0.15	1.2	105	0.14	1.2	170	0.15	1.2	540	0.18	1.2	–	–	–	–	–	–
CCMT 09T304E-FM:T8415	●	0.4	220	0.15	1.2	115	0.14	1.2	200	0.15	1.2	555	0.18	1.2	–	–	–	–	–	–
CCMT 09T304E-FM:T8430	●	0.4	200	0.15	1.2	110	0.14	1.2	165	0.15	1.2	555	0.18	1.2	–	–	–	–	–	–
CCMT 09T304E-FM:T9315	●	0.4	275	0.15	1.2	–	–	–	260	0.15	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T304E-FM:T9325	●	0.4	245	0.15	1.2	145	0.15	1.2	230	0.15	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T304E-FM:T9415	●	0.4	305	0.15	1.2	–	–	–	285	0.15	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T308E-FM:T7325	●	0.8	215	0.20	1.2	165	0.18	1.2	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 09T308E-FM:T7335	●	0.8	205	0.20	1.2	155	0.18	1.2	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 09T308E-FM:T8315	●	0.8	195	0.20	1.2	115	0.18	1.2	185	0.20	1.2	585	0.24	1.2	–	–	–	–	–	–
CCMT 09T308E-FM:T8415	●	0.8	240	0.20	1.2	125	0.18	1.2	215	0.20	1.2	600	0.24	1.2	–	–	–	–	–	–
CCMT 09T308E-FM:T8430	⬢	0.8	210	0.20	1.2	115	0.18	1.2	175	0.20	1.2	585	0.24	1.2	–	–	–	–	–	–
CCMT 09T308E-FM:T9325	●	0.8	260	0.20	1.2	155	0.18	1.2	245	0.20	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T308E-FM:T9415	●	0.8	330	0.20	1.2	–	–	–	310	0.20	1.2	–	–	–	–	–	–	–	–	–
CCMT 120404E-FM:T7325	●	0.4	190	0.15	1.7	145	0.15	1.7	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 120404E-FM:T7335	●	0.4	185	0.15	1.7	140	0.15	1.7	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 120404E-FM:T8315	●	0.4	170	0.15	1.7	100	0.14	1.7	160	0.15	1.7	510	0.18	1.7	–	–	–	–	–	–
CCMT 120404E-FM:T8415	●	0.4	210	0.15	1.7	110	0.14	1.7	190	0.15	1.7	525	0.18	1.7	–	–	–	–	–	–
CCMT 120404E-FM:T8430	●	0.4	195	0.15	1.7	105	0.14	1.7	160	0.15	1.7	540	0.18	1.7	–	–	–	–	–	–
CCMT 120404E-FM:T9325	●	0.4	240	0.15	1.7	140	0.15	1.7	225	0.15	1.7	–	–	–	–	–	–	–	–	–
CCMT 120404E-FM:T9415	●	0.4	295	0.15	1.7	–	–	–	280	0.15	1.7	–	–	–	–	–	–	–	–	–
CCMT 120408E-FM:T7325	●	0.8	205	0.20	1.7	155	0.18	1.7	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 120408E-FM:T7335	●	0.8	200	0.20	1.7	155	0.18	1.7	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 120408E-FM:T8315	●	0.8	190	0.20	1.7	110	0.18	1.7	180	0.20	1.7	570	0.24	1.7	–	–	–	–	–	–
CCMT 120408E-FM:T8415	●	0.8	230	0.20	1.7	120	0.18	1.7	210	0.20	1.7	585	0.24	1.7	–	–	–	–	–	–
CCMT 120408E-FM:T8430	⬢	0.8	205	0.20	1.7	110	0.18	1.7	170	0.20	1.7	570	0.24	1.7	–	–	–	–	–	–
CCMT 120408E-FM:T9325	●	0.8	250	0.20	1.7	150	0.18	1.7	235	0.20	1.7	–	–	–	–	–	–	–	–	–
CCMT 120408E-FM:T9415	●	0.8	315	0.20	1.7	–	–	–	295	0.20	1.7	–	–	–	–	–	–	–	–	–
CCMT 120412E-FM:T8430	⬢	1.2	190	0.27	1.7	105	0.24	1.7	155	0.27	1.7	525	0.32	1.7	–	–	–	–	–	–
CCMT 120412E-FM:T9325	⬢	1.2	235	0.27	1.7	140	0.24	1.7	220	0.27	1.7	–	–	–	–	–	–	–	–	–



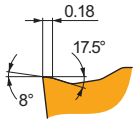
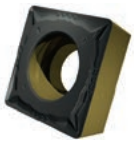
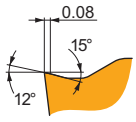


FM talaş kırıcı çok yönlüdür ve çeliklerin finiş işlemleri için ilk tercihtir. Pozitif eğim açısı ve pozitif, dar T-land özelliğine sahiptir. Paslanmaz çelikler için ve şartlara bağlı oalrak dökme demirler ve demir dışı alaşımlar için de uygundur.

Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																			
FM talaş kırıcı çok yönlüdür ve çeliklerin finiş işlemleri için ilk tercihtir. Pozitif eğim açısı ve pozitif, dar T-land özelliğine sahiptir. Paslanmaz çelikler için ve şartlara bağlı oalrak dökme demirler ve demir dışı alaşımlar için de uygundur.																			
DCMT 070202E-FM:T7325	0.2	175	0.10	0.8	135	0.09	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 070202E-FM:T8315	0.2	160	0.10	0.8	95	0.09	0.8	150	0.10	0.8	480	0.12	0.8	–	–	–	–	–	–
DCMT 070202E-FM:T8415	0.2	190	0.10	0.8	100	0.09	0.8	170	0.10	0.8	480	0.12	0.8	–	–	–	–	–	–
DCMT 070202E-FM:T8430	0.2	185	0.10	0.8	100	0.09	0.8	150	0.10	0.8	510	0.12	0.8	–	–	–	–	–	–
DCMT 070202E-FM:T9325	0.2	230	0.10	0.8	135	0.09	0.8	215	0.10	0.8	–	–	–	–	–	–	–	–	–
DCMT 070202E-FM:T9415	0.2	275	0.10	0.8	–	–	–	260	0.10	0.8	–	–	–	–	–	–	–	–	–
DCMT 070204E-FM:T7325	0.4	155	0.17	0.8	120	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 070204E-FM:T7335	0.4	155	0.17	0.8	120	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 070204E-FM:T8315	0.4	160	0.12	0.8	95	0.11	0.8	150	0.12	0.8	480	0.14	0.8	–	–	–	–	–	–
DCMT 070204E-FM:T8415	0.4	190	0.12	0.8	100	0.11	0.8	170	0.12	0.8	480	0.14	0.8	–	–	–	–	–	–
DCMT 070204E-FM:T8430	0.4	185	0.12	0.8	100	0.11	0.8	150	0.12	0.8	510	0.14	0.8	–	–	–	–	–	–
DCMT 070204E-FM:T9325	0.4	190	0.18	0.8	110	0.16	0.8	180	0.18	0.8	–	–	–	–	–	–	–	–	–
DCMT 070204E-FM:T9415	0.4	275	0.12	0.8	–	–	–	260	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T302E-FM:T7325	0.2	175	0.10	0.8	135	0.09	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T302E-FM:T8315	0.2	160	0.10	0.8	95	0.09	0.8	150	0.10	0.8	480	0.12	0.8	–	–	–	–	–	–
DCMT 11T302E-FM:T8415	0.2	190	0.10	0.8	100	0.09	0.8	170	0.10	0.8	480	0.12	0.8	–	–	–	–	–	–
DCMT 11T302E-FM:T8430	0.2	185	0.10	0.8	100	0.09	0.8	150	0.10	0.8	510	0.12	0.8	–	–	–	–	–	–
DCMT 11T302E-FM:T9325	0.2	230	0.10	0.8	135	0.09	0.8	215	0.10	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T302E-FM:T9415	0.2	275	0.10	0.8	–	–	–	260	0.10	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T304E-FM:T7325	0.4	155	0.17	0.8	120	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T304E-FM:T7335	0.4	155	0.17	0.8	120	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T304E-FM:T8315	0.4	160	0.12	0.8	95	0.11	0.8	150	0.12	0.8	480	0.14	0.8	–	–	–	–	–	–
DCMT 11T304E-FM:T8415	0.4	190	0.12	0.8	100	0.11	0.8	170	0.12	0.8	480	0.14	0.8	–	–	–	–	–	–
DCMT 11T304E-FM:T8430	0.4	155	0.17	0.8	85	0.15	0.8	130	0.17	0.8	435	0.20	0.8	–	–	–	–	–	–
DCMT 11T304E-FM:T9310	0.4	285	0.12	0.8	–	–	–	270	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T304E-FM:T9315	0.4	255	0.12	0.8	–	–	–	240	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T304E-FM:T9325	0.4	190	0.18	0.8	110	0.16	0.8	180	0.18	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T304E-FM:T9415	0.4	275	0.12	0.8	–	–	–	260	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T308E-FM:T7325	0.8	185	0.17	0.8	140	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T308E-FM:T7335	0.8	180	0.17	0.8	140	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T308E-FM:T8315	0.8	170	0.17	0.8	100	0.15	0.8	160	0.17	0.8	510	0.20	0.8	–	–	–	–	–	–
DCMT 11T308E-FM:T8415	0.8	210	0.17	0.8	110	0.15	0.8	190	0.17	0.8	525	0.20	0.8	–	–	–	–	–	–
DCMT 11T308E-FM:T8430	0.8	190	0.17	0.8	105	0.15	0.8	155	0.17	0.8	525	0.20	0.8	–	–	–	–	–	–
DCMT 11T308E-FM:T9310	0.8	285	0.17	0.8	–	–	–	270	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T308E-FM:T9315	0.8	260	0.17	0.8	–	–	–	245	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T308E-FM:T9325	0.8	235	0.17	0.8	140	0.15	0.8	220	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T308E-FM:T9415	0.8	290	0.17	0.8	–	–	–	275	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T312E-FM:T8430	1.2	175	0.22	1.2	95	0.22	1.2	140	0.22	1.2	480	0.26	1.2	–	–	–	–	–	–
DCMT 11T312E-FM:T9325	1.2	210	0.22	1.2	125	0.22	1.2	195	0.22	1.2	–	–	–	–	–	–	–	–	–
DCMT 11T312E-FM:T9415	1.2	265	0.22	1.2	–	–	–	250	0.22	1.2	–	–	–	–	–	–	–	–	–

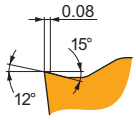
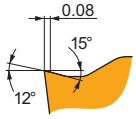
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
RCMT 0602MOE-FM:T7325	–	215	0.45	1.2	165	0.41	1.2	–	–	–	–	–	–	–	–	–	–	–	–
RCMT 0602MOE-FM:T8430	–	200	0.45	1.2	110	0.41	1.2	165	0.45	1.2	555	0.54	1.2	–	–	–	–	–	–
RCMT 0602MOE-FM:T9325	–	235	0.45	1.2	140	0.41	1.2	220	0.45	1.2	–	–	–	–	–	–	–	–	–
RCMT 0602MOE-FM:T9415	–	320	0.45	1.2	–	–	–	300	0.45	1.2	–	–	–	–	–	–	–	–	–
RCMT 0803MOE-FM:T7325	–	190	0.60	1.6	145	0.54	1.6	–	–	–	–	–	–	–	–	–	–	–	–
RCMT 0803MOE-FM:T8430	–	175	0.60	1.6	95	0.54	1.6	140	0.60	1.6	480	0.72	1.6	–	–	–	–	–	–
RCMT 0803MOE-FM:T9325	–	200	0.60	1.6	120	0.54	1.6	190	0.60	1.6	–	–	–	–	–	–	–	–	–
RCMT 0803MOE-FM:T9415	–	280	0.60	1.6	–	–	–	265	0.60	1.6	–	–	–	–	–	–	–	–	–
RCMT 10T3MOE-FM:T7325	–	185	0.65	1.7	140	0.59	1.7	–	–	–	–	–	–	–	–	–	–	–	–
RCMT 10T3MOE-FM:T8430	–	170	0.65	1.7	90	0.59	1.7	135	0.65	1.7	465	0.78	1.7	–	–	–	–	–	–
RCMT 10T3MOE-FM:T9325	–	195	0.65	1.7	115	0.59	1.7	185	0.65	1.7	–	–	–	–	–	–	–	–	–
RCMT 10T3MOE-FM:T9415	–	275	0.65	1.7	–	–	–	260	0.65	1.7	–	–	–	–	–	–	–	–	–
RCMT 1204MOE-FM:T7325	–	175	0.70	1.8	135	0.63	1.8	–	–	–	–	–	–	–	–	–	–	–	–
RCMT 1204MOE-FM:T8430	–	155	0.70	1.8	85	0.63	1.8	130	0.70	1.8	435	0.84	1.8	–	–	–	–	–	–
RCMT 1204MOE-FM:T9325	–	190	0.70	1.8	110	0.63	1.8	180	0.70	1.8	–	–	–	–	–	–	–	–	–
RCMT 1204MOE-FM:T9415	–	260	0.70	1.8	–	–	–	245	0.70	1.8	–	–	–	–	–	–	–	–	–
 																			
SCMT 09T304E-FM:T7325	● 0.4	205	0.15	1.2	155	0.15	1.2	–	–	–	–	–	–	–	–	–	–	–	–
SCMT 09T304E-FM:T7335	● 0.4	200	0.15	1.2	155	0.15	1.2	–	–	–	–	–	–	–	–	–	–	–	–
SCMT 09T304E-FM:T8315	● 0.4	190	0.15	1.2	110	0.14	1.2	180	0.15	1.2	570	0.18	1.2	–	–	–	–	–	–
SCMT 09T304E-FM:T8415	● 0.4	230	0.15	1.2	120	0.14	1.2	210	0.15	1.2	585	0.18	1.2	–	–	–	–	–	–
SCMT 09T304E-FM:T8430	● 0.4	210	0.15	1.2	115	0.14	1.2	175	0.15	1.2	585	0.18	1.2	–	–	–	–	–	–
SCMT 09T304E-FM:T9325	● 0.4	260	0.15	1.2	155	0.15	1.2	245	0.15	1.2	–	–	–	–	–	–	–	–	–
SCMT 09T304E-FM:T9415	● 0.4	320	0.15	1.2	–	–	–	300	0.15	1.2	–	–	–	–	–	–	–	–	–
SCMT 09T308E-FM:T7325	● 0.8	225	0.20	1.2	175	0.18	1.2	–	–	–	–	–	–	–	–	–	–	–	–
SCMT 09T308E-FM:T7335	● 0.8	215	0.20	1.2	165	0.18	1.2	–	–	–	–	–	–	–	–	–	–	–	–
SCMT 09T308E-FM:T8315	● 0.8	205	0.20	1.2	120	0.18	1.2	190	0.20	1.2	615	0.24	1.2	–	–	–	–	–	–
SCMT 09T308E-FM:T8415	● 0.8	250	0.20	1.2	130	0.18	1.2	225	0.20	1.2	630	0.24	1.2	–	–	–	–	–	–
SCMT 09T308E-FM:T8430	● 0.8	225	0.20	1.2	120	0.18	1.2	185	0.20	1.2	615	0.24	1.2	–	–	–	–	–	–
SCMT 09T308E-FM:T9325	● 0.8	275	0.20	1.2	165	0.18	1.2	260	0.20	1.2	–	–	–	–	–	–	–	–	–
SCMT 09T308E-FM:T9415	● 0.8	350	0.20	1.2	–	–	–	330	0.20	1.2	–	–	–	–	–	–	–	–	–
SCMT 120404E-FM:T7325	● 0.4	195	0.15	1.6	150	0.15	1.6	–	–	–	–	–	–	–	–	–	–	–	–
SCMT 120404E-FM:T8315	● 0.4	185	0.15	1.6	110	0.14	1.6	175	0.15	1.6	555	0.18	1.6	–	–	–	–	–	–
SCMT 120404E-FM:T8415	● 0.4	225	0.15	1.6	115	0.14	1.6	205	0.15	1.6	570	0.18	1.6	–	–	–	–	–	–
SCMT 120404E-FM:T8430	● 0.4	205	0.15	1.6	110	0.14	1.6	170	0.15	1.6	570	0.18	1.6	–	–	–	–	–	–
SCMT 120404E-FM:T9325	● 0.4	250	0.15	1.6	150	0.15	1.6	235	0.15	1.6	–	–	–	–	–	–	–	–	–
SCMT 120404E-FM:T9415	● 0.4	315	0.15	1.6	–	–	–	295	0.15	1.6	–	–	–	–	–	–	–	–	–
SCMT 120408E-FM:T7325	● 0.8	215	0.20	1.6	165	0.18	1.6	–	–	–	–	–	–	–	–	–	–	–	–
SCMT 120408E-FM:T7335	● 0.8	210	0.20	1.6	160	0.18	1.6	–	–	–	–	–	–	–	–	–	–	–	–
SCMT 120408E-FM:T8315	● 0.8	200	0.20	1.6	120	0.18	1.6	190	0.20	1.6	600	0.24	1.6	–	–	–	–	–	–
SCMT 120408E-FM:T8415	● 0.8	245	0.20	1.6	125	0.18	1.6	220	0.20	1.6	615	0.24	1.6	–	–	–	–	–	–
SCMT 120408E-FM:T8430	● 0.8	220	0.20	1.6	120	0.18	1.6	180	0.20	1.6	600	0.24	1.6	–	–	–	–	–	–
SCMT 120408E-FM:T9325	● 0.8	265	0.20	1.6	155	0.18	1.6	250	0.20	1.6	–	–	–	–	–	–	–	–	–
SCMT 120408E-FM:T9415	● 0.8	340	0.20	1.6	–	–	–	320	0.20	1.6	–	–	–	–	–	–	–	–	–
SCMT 120412E-FM:T8430	● 1.2	200	0.27	1.6	110	0.24	1.6	165	0.27	1.6	555	0.32	1.6	–	–	–	–	–	–
SCMT 120412E-FM:T9325	● 1.2	245	0.27	1.6	145	0.24	1.6	230	0.27	1.6	–	–	–	–	–	–	–	–	–
SCMT 120412E-FM:T9415	● 1.2	320	0.27	1.6	–	–	–	300	0.27	1.6	–	–	–	–	–	–	–	–	–

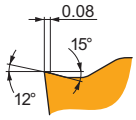
FM talaş kırıcı çok yönlüdür ve çeliklerin finiş işlemleri için ilk tercihtir. Pozitif eğim açısı ve pozitif, dar T-land özelliğine sahiptir. Paslanmaz çelikler için ve şartlara bağlı oalrak dökme demirler ve demir dışı alaşımlar için de uygundur.

FM talaş kırıcı çok yönlüdür ve çeliklerin finiş işlemleri için ilk tercihtir. Pozitif eğim açısı ve pozitif, dar T-land özelliğine sahiptir. Paslanmaz çelikler için ve şartlara bağlı oalrak dökme demirler ve demir dışı alaşımlar için de uygundur.

Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE	P			M			K			N			S			H		
	(mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)
																			
FM talaş kırıcı çok yönlüdür ve çeliklerin finiş işlemleri için ilk tercihtir. Pozitif eğim açısı ve pozitif, dar T-land özelliğine sahiptir. Paslanmaz çelikler için ve şartlara bağlı oalrak dökme demirler ve demir dışı alaşımlar için de uygundur.																			
TCMT 110202E-FM:T7325	0.2	185	0.10	0.8	140	0.09	0.8	–	–	–	–	–	–	–	–	–	–	–	–
TCMT 110202E-FM:T7335	0.2	185	0.10	0.8	140	0.09	0.8	–	–	–	–	–	–	–	–	–	–	–	–
TCMT 110202E-FM:T8315	0.2	170	0.10	0.8	100	0.09	0.8	160	0.10	0.8	510	0.12	0.8	–	–	–	–	–	–
TCMT 110202E-FM:T8415	0.2	200	0.10	0.8	105	0.09	0.8	185	0.10	0.8	510	0.12	0.8	–	–	–	–	–	–
TCMT 110202E-FM:T8430	0.2	195	0.10	0.8	105	0.09	0.8	160	0.10	0.8	540	0.12	0.8	–	–	–	–	–	–
TCMT 110202E-FM:T9325	0.2	245	0.10	0.8	145	0.09	0.8	230	0.10	0.8	–	–	–	–	–	–	–	–	–
TCMT 110202E-FM:T9415	0.2	290	0.10	0.8	–	–	–	275	0.10	0.8	–	–	–	–	–	–	–	–	–
TCMT 110204E-FM:T7325	0.4	160	0.19	0.8	120	0.17	0.8	–	–	–	–	–	–	–	–	–	–	–	–
TCMT 110204E-FM:T7335	0.4	155	0.19	0.8	120	0.17	0.8	–	–	–	–	–	–	–	–	–	–	–	–
TCMT 110204E-FM:T8315	0.4	170	0.12	0.8	100	0.11	0.8	160	0.12	0.8	510	0.14	0.8	–	–	–	–	–	–
TCMT 110204E-FM:T8415	0.4	210	0.12	0.8	110	0.11	0.8	190	0.12	0.8	525	0.14	0.8	–	–	–	–	–	–
TCMT 110204E-FM:T8430	0.4	195	0.12	0.8	105	0.11	0.8	160	0.12	0.8	540	0.14	0.8	–	–	–	–	–	–
TCMT 110204E-FM:T9315	0.4	270	0.12	0.8	–	–	–	255	0.12	0.8	–	–	–	–	–	–	–	–	–
TCMT 110204E-FM:T9325	0.4	205	0.18	0.8	120	0.16	0.8	190	0.18	0.8	–	–	–	–	–	–	–	–	–
TCMT 110204E-FM:T9415	0.4	295	0.12	0.8	–	–	–	280	0.12	0.8	–	–	–	–	–	–	–	–	–
TCMT 110208E-FM:T7325	0.8	195	0.17	0.8	150	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
TCMT 110208E-FM:T8430	0.8	200	0.17	0.8	110	0.15	0.8	165	0.17	0.8	555	0.20	0.8	–	–	–	–	–	–
TCMT 110208E-FM:T9325	0.8	250	0.17	0.8	150	0.15	0.8	235	0.17	0.8	–	–	–	–	–	–	–	–	–
TCMT 110208E-FM:T9415	0.8	310	0.17	0.8	–	–	–	290	0.17	0.8	–	–	–	–	–	–	–	–	–
TCMT 16T304E-FM:T7325	0.4	150	0.19	1.7	115	0.17	1.7	–	–	–	–	–	–	–	–	–	–	–	–
TCMT 16T304E-FM:T7335	0.4	145	0.19	1.7	110	0.17	1.7	–	–	–	–	–	–	–	–	–	–	–	–
TCMT 16T304E-FM:T8315	0.4	155	0.12	1.7	90	0.11	1.7	145	0.12	1.7	465	0.14	1.7	–	–	–	–	–	–
TCMT 16T304E-FM:T8415	0.4	190	0.12	1.7	100	0.11	1.7	170	0.12	1.7	480	0.14	1.7	–	–	–	–	–	–
TCMT 16T304E-FM:T8430	0.4	180	0.12	1.7	95	0.11	1.7	145	0.12	1.7	495	0.14	1.7	–	–	–	–	–	–
TCMT 16T304E-FM:T9325	0.4	190	0.18	1.7	110	0.16	1.7	180	0.18	1.7	–	–	–	–	–	–	–	–	–
TCMT 16T304E-FM:T9415	0.4	270	0.12	1.7	–	–	–	255	0.12	1.7	–	–	–	–	–	–	–	–	–
TCMT 16T308E-FM:T7325	0.8	180	0.17	1.7	140	0.15	1.7	–	–	–	–	–	–	–	–	–	–	–	–
TCMT 16T308E-FM:T7335	0.8	175	0.17	1.7	135	0.15	1.7	–	–	–	–	–	–	–	–	–	–	–	–
TCMT 16T308E-FM:T8315	0.8	170	0.17	1.7	100	0.15	1.7	160	0.17	1.7	510	0.20	1.7	–	–	–	–	–	–
TCMT 16T308E-FM:T8415	0.8	210	0.17	1.7	110	0.15	1.7	190	0.17	1.7	525	0.20	1.7	–	–	–	–	–	–
TCMT 16T308E-FM:T8430	0.8	185	0.17	1.7	100	0.15	1.7	150	0.17	1.7	510	0.20	1.7	–	–	–	–	–	–
TCMT 16T308E-FM:T9325	0.8	230	0.17	1.7	135	0.15	1.7	215	0.17	1.7	–	–	–	–	–	–	–	–	–
TCMT 16T308E-FM:T9415	0.8	285	0.17	1.7	–	–	–	270	0.17	1.7	–	–	–	–	–	–	–	–	–
																			
FM talaş kırıcı çok yönlüdür ve çeliklerin finiş işlemleri için ilk tercihtir. Pozitif eğim açısı ve pozitif, dar T-land özelliğine sahiptir. Paslanmaz çelikler için ve şartlara bağlı oalrak dökme demirler ve demir dışı alaşımlar için de uygundur.																			
VBMT 110302E-FM:T7325	0.2	160	0.10	0.8	120	0.09	0.8	–	–	–	–	–	–	–	–	–	–	–	–
VBMT 110302E-FM:T8315	0.2	145	0.10	0.8	85	0.09	0.8	135	0.10	0.8	435	0.12	0.8	–	–	–	–	–	–
VBMT 110302E-FM:T8415	0.2	180	0.10	0.8	90	0.09	0.8	160	0.10	0.8	450	0.12	0.8	–	–	–	–	–	–
VBMT 110302E-FM:T8430	0.2	170	0.10	0.8	90	0.09	0.8	135	0.10	0.8	465	0.12	0.8	–	–	–	–	–	–
VBMT 110302E-FM:T9325	0.2	210	0.10	0.8	125	0.09	0.8	195	0.10	0.8	–	–	–	–	–	–	–	–	–
VBMT 110304E-FM:T7325	0.4	140	0.19	0.8	105	0.17	0.8	–	–	–	–	–	–	–	–	–	–	–	–
VBMT 110304E-FM:T7335	0.4	135	0.19	0.8	105	0.17	0.8	–	–	–	–	–	–	–	–	–	–	–	–
VBMT 110304E-FM:T8315	0.4	145	0.12	0.8	85	0.11	0.8	135	0.12	0.8	435	0.14	0.8	–	–	–	–	–	–
VBMT 110304E-FM:T8415	0.4	180	0.12	0.8	90	0.11	0.8	160	0.12	0.8	450	0.14	0.8	–	–	–	–	–	–
VBMT 110304E-FM:T8430	0.4	170	0.12	0.8	90	0.11	0.8	135	0.12	0.8	465	0.14	0.8	–	–	–	–	–	–
VBMT 110304E-FM:T9325	0.4	175	0.19	0.8	105	0.17	0.8	165	0.19	0.8	–	–	–	–	–	–	–	–	–
VBMT 110304E-FM:T9415	0.4	255	0.12	0.8	–	–	–	240	0.12	0.8	–	–	–	–	–	–	–	–	–
VBMT 110308E-FM:T7325	0.8	170	0.17	0.8	130	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
VBMT 110308E-FM:T8430	0.8	175	0.17	0.8	95	0.15	0.8	140	0.17	0.8	480	0.20	0.8	–	–	–	–	–	–
VBMT 110308E-FM:T9315	0.8	240	0.17	0.8	–	–	–	225	0.17	0.8	–	–	–	–	–	–	–	–	–
VBMT 110308E-FM:T9325	0.8	215	0.17	0.8	125	0.15	0.8	200	0.17	0.8	–	–	–	–	–	–	–	–	–
VBMT 110308E-FM:T9415	0.8	270	0.17	0.8	–	–	–	255	0.17	0.8	–	–	–	–	–	–	–	–	–
VBMT 160402E-FM:T7325	0.2	150	0.10	1.2	115	0.09	1.2	–	–	–	–	–	–	–	–	–	–	–	–
VBMT 160402E-FM:T8430	0.2	165	0.10	1.2	90	0.09	1.2	135	0.10	1.2	450	0.12	1.2	–	–	–	–	–	–
VBMT 160402E-FM:T9325	0.2	205	0.10	1.2	120	0.09	1.2	190	0.10	1.2	–	–	–	–	–	–	–	–	–
VBMT 160402E-FM:T9415	0.2	245	0.10	1.2	–	–	–	230	0.10	1.2	–	–	–	–	–	–	–	–	–

Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

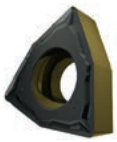
Product		RE	P			M			K			N			S			H		
			vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)
																				
VBMT 160404E-FM:T5315	●	0.4	225	0.12	1.2	–	–	–	210	0.12	1.2	–	–	–	–	–	–	–	–	–
VBMT 160404E-FM:T7325	●	0.4	130	0.19	1.2	100	0.17	1.2	–	–	–	–	–	–	–	–	–	–	–	–
VBMT 160404E-FM:T7335	●	0.4	130	0.19	1.2	100	0.17	1.2	–	–	–	–	–	–	–	–	–	–	–	–
VBMT 160404E-FM:T8315	●	0.4	140	0.12	1.2	80	0.11	1.2	130	0.12	1.2	420	0.14	1.2	–	–	–	–	–	–
VBMT 160404E-FM:T8415	●	0.4	170	0.12	1.2	90	0.11	1.2	155	0.12	1.2	435	0.14	1.2	–	–	–	–	–	–
VBMT 160404E-FM:T8430	●	0.4	165	0.12	1.2	90	0.11	1.2	135	0.12	1.2	450	0.14	1.2	–	–	–	–	–	–
VBMT 160404E-FM:T9315	●	0.4	225	0.12	1.2	–	–	–	210	0.12	1.2	–	–	–	–	–	–	–	–	–
VBMT 160404E-FM:T9325	●	0.4	165	0.19	1.2	95	0.17	1.2	155	0.19	1.2	–	–	–	–	–	–	–	–	–
VBMT 160404E-FM:T9415	●	0.4	245	0.12	1.2	–	–	–	230	0.12	1.2	–	–	–	–	–	–	–	–	–
VBMT 160408E-FM:T5315	●	0.8	235	0.17	1.2	–	–	–	220	0.17	1.2	–	–	–	–	–	–	–	–	–
VBMT 160408E-FM:T7325	●	0.8	165	0.17	1.2	125	0.15	1.2	–	–	–	–	–	–	–	–	–	–	–	–
VBMT 160408E-FM:T7335	●	0.8	160	0.17	1.2	120	0.15	1.2	–	–	–	–	–	–	–	–	–	–	–	–
VBMT 160408E-FM:T8315	●	0.8	150	0.17	1.2	90	0.15	1.2	140	0.17	1.2	450	0.20	1.2	–	–	–	–	–	–
VBMT 160408E-FM:T8415	●	0.8	185	0.17	1.2	95	0.15	1.2	165	0.17	1.2	465	0.20	1.2	–	–	–	–	–	–
VBMT 160408E-FM:T8430	●	0.8	170	0.17	1.2	90	0.15	1.2	135	0.17	1.2	465	0.20	1.2	–	–	–	–	–	–
VBMT 160408E-FM:T9315	●	0.8	230	0.17	1.2	–	–	–	215	0.17	1.2	–	–	–	–	–	–	–	–	–
VBMT 160408E-FM:T9325	●	0.8	205	0.17	1.2	120	0.15	1.2	190	0.17	1.2	–	–	–	–	–	–	–	–	–
VBMT 160408E-FM:T9415	●	0.8	260	0.17	1.2	–	–	–	245	0.17	1.2	–	–	–	–	–	–	–	–	–
VBMT 160412E-FM:T7325	●	1.2	160	0.22	1.2	120	0.22	1.2	–	–	–	–	–	–	–	–	–	–	–	–
VBMT 160412E-FM:T8430	●	1.2	155	0.22	1.2	85	0.22	1.2	130	0.22	1.2	435	0.26	1.2	–	–	–	–	–	–
VBMT 160412E-FM:T9315	●	1.2	215	0.22	1.2	–	–	–	200	0.22	1.2	–	–	–	–	–	–	–	–	–
VBMT 160412E-FM:T9325	●	1.2	195	0.22	1.2	115	0.22	1.2	185	0.22	1.2	–	–	–	–	–	–	–	–	–
VBMT 160412E-FM:T9415	●	1.2	245	0.22	1.2	–	–	–	230	0.22	1.2	–	–	–	–	–	–	–	–	–

FM talaş kırıcı çok yönlüdür ve çeliklerin finiş işlemleri için ilk tercihtir. Pozitif eğim açısı ve pozitif, dar T-land özelliğine sahiptir. Paslanmaz çelikler için ve şartlara bağlı oalrak dökme demirler ve demir dışı alaşımlar için de uygundur.



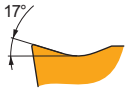
VCMT 160404E-FM:T7325	●	0.4	125	0.19	1.2	95	0.17	1.2	–	–	–	–	–	–	–	–	–	–	–	–
VCMT 160404E-FM:T8430	●	0.4	150	0.12	1.2	80	0.11	1.2	125	0.12	1.2	420	0.14	1.2	–	–	–	–	–	–
VCMT 160404E-FM:T9325	●	0.4	155	0.19	1.2	90	0.17	1.2	145	0.19	1.2	–	–	–	–	–	–	–	–	–
VCMT 160404E-FM:T9415	●	0.4	230	0.12	1.2	–	–	–	215	0.12	1.2	–	–	–	–	–	–	–	–	–
VCMT 160408E-FM:T7325	●	0.8	155	0.17	1.2	120	0.15	1.2	–	–	–	–	–	–	–	–	–	–	–	–
VCMT 160408E-FM:T8430	●	0.8	155	0.17	1.2	85	0.15	1.2	130	0.17	1.2	435	0.20	1.2	–	–	–	–	–	–
VCMT 160408E-FM:T9325	●	0.8	195	0.17	1.2	115	0.15	1.2	185	0.17	1.2	–	–	–	–	–	–	–	–	–
VCMT 160408E-FM:T9415	●	0.8	245	0.17	1.2	–	–	–	230	0.17	1.2	–	–	–	–	–	–	–	–	–

FM talaş kırıcı çok yönlüdür ve çeliklerin finiş işlemleri için ilk tercihtir. Pozitif eğim açısı ve pozitif, dar T-land özelliğine sahiptir. Paslanmaz çelikler için ve şartlara bağlı oalrak dökme demirler ve demir dışı alaşımlar için de uygundur.



WCMT 06T304E-FM:T8315	●	0.4	180	0.15	1.2	105	0.14	1.2	170	0.15	1.2	540	0.18	1.2	–	–	–	–	–	–
WCMT 06T304E-FM:T8415	●	0.4	220	0.15	1.2	115	0.14	1.2	200	0.15	1.2	555	0.18	1.2	–	–	–	–	–	–
WCMT 06T304E-FM:T8430	●	0.4	200	0.15	1.2	110	0.14	1.2	165	0.15	1.2	555	0.18	1.2	–	–	–	–	–	–
WCMT 06T304E-FM:T9325	●	0.4	245	0.15	1.2	145	0.15	1.2	230	0.15	1.2	–	–	–	–	–	–	–	–	–
WCMT 06T304E-FM:T9415	●	0.4	305	0.15	1.2	–	–	–	285	0.15	1.2	–	–	–	–	–	–	–	–	–
WCMT 06T308E-FM:T7325	●	0.8	215	0.20	1.2	165	0.18	1.2	–	–	–	–	–	–	–	–	–	–	–	–
WCMT 06T308E-FM:T7335	●	0.8	205	0.20	1.2	155	0.18	1.2	–	–	–	–	–	–	–	–	–	–	–	–
WCMT 06T308E-FM:T8315	●	0.8	195	0.20	1.2	115	0.18	1.2	185	0.20	1.2	585	0.24	1.2	–	–	–	–	–	–
WCMT 06T308E-FM:T8415	●	0.8	240	0.20	1.2	125	0.18	1.2	215	0.20	1.2	600	0.24	1.2	–	–	–	–	–	–
WCMT 06T308E-FM:T8430	◆	0.8	210	0.20	1.2	115	0.18	1.2	175	0.20	1.2	585	0.24	1.2	–	–	–	–	–	–
WCMT 06T308E-FM:T9325	●	0.8	260	0.20	1.2	155	0.18	1.2	245	0.20	1.2	–	–	–	–	–	–	–	–	–
WCMT 06T308E-FM:T9415	●	0.8	330	0.20	1.2	–	–	–	310	0.20	1.2	–	–	–	–	–	–	–	–	–
WCMT 080404E-FM:T8430	●	0.4	195	0.15	1.7	105	0.14	1.7	160	0.15	1.7	540	0.18	1.7	–	–	–	–	–	–
WCMT 080404E-FM:T9325	●	0.4	240	0.15	1.7	140	0.15	1.7	225	0.15	1.7	–	–	–	–	–	–	–	–	–
WCMT 080408E-FM:T8430	◆	0.8	205	0.20	1.7	110	0.18	1.7	170	0.20	1.7	570	0.24	1.7	–	–	–	–	–	–
WCMT 080408E-FM:T9325	●	0.8	250	0.20	1.7	150	0.18	1.7	235	0.20	1.7	–	–	–	–	–	–	–	–	–
WCMT 080408E-FM:T9415	●	0.8	315	0.20	1.7	–	–	–	295	0.20	1.7	–	–	–	–	–	–	–	–	–
WCMT 080412E-FM:T8430	◆	1.2	190	0.27	1.7	105	0.24	1.7	155	0.27	1.7	525	0.32	1.7	–	–	–	–	–	–
WCMT 080412E-FM:T9325	◆	1.2	235	0.27	1.7	140	0.24	1.7	220	0.27	1.7	–	–	–	–	–	–	–	–	–

NF2





NF2 talaş kırıcı keskin ve paslanmaz çeliklerin finiş işlemi için ilk tercihtir. T-land olmadan pozitif eğim açısına sahiptir. Ayrıca süper alaşımlar ve şartlara bağlı olarak çelikler, dökme demirler ve demir dışı alaşımlar için de uygundur.

CCMT

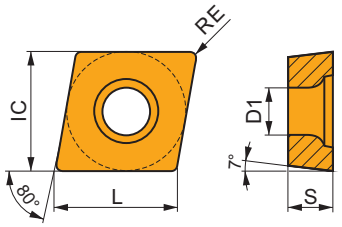
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0602	6.350	2.80	6.40	2.38
0803	7.940	3.40	8.10	3.18
09T3	9.525	4.40	9.70	3.97

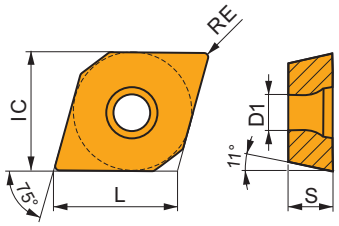
EPMT

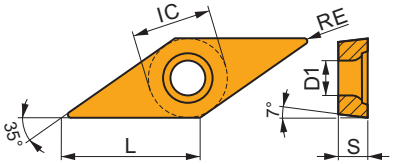
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0502	5.560	2.50	5.70	2.38

VCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1303	7.940	3.40	13.80	3.18

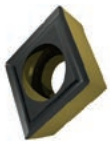


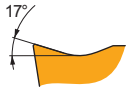




Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
CCMT 060202E-NF2:T6310	●	0.2	170	0.10	0.8	120	0.09	0.8	135	0.10	0.8	510	0.12	0.8	50	0.08	0.6	–	–	–
CCMT 060202E-NF2:T7325	●	0.2	195	0.10	0.8	150	0.09	0.8	–	–	–	–	–	–	60	0.08	0.6	–	–	–
CCMT 060202E-NF2:T8415	●	0.2	220	0.10	0.8	115	0.09	0.8	200	0.10	0.8	555	0.12	0.8	50	0.08	0.6	–	–	–
CCMT 060202E-NF2:T8430	●	0.2	210	0.10	0.8	115	0.09	0.8	175	0.10	0.8	585	0.12	0.8	45	0.08	0.6	–	–	–
CCMT 060202E-NF2:T9325	●	0.2	260	0.10	0.8	155	0.09	0.8	245	0.10	0.8	–	–	–	55	0.08	0.6	–	–	–
CCMT 060204E-NF2:T6310	●	0.4	170	0.12	0.8	120	0.11	0.8	135	0.12	0.8	510	0.14	0.8	50	0.11	0.6	–	–	–
CCMT 060204E-NF2:T7325	●	0.4	200	0.12	0.8	155	0.11	0.8	–	–	–	–	–	–	65	0.11	0.6	–	–	–
CCMT 060204E-NF2:T8415	●	0.4	220	0.12	0.8	115	0.11	0.8	200	0.12	0.8	555	0.14	0.8	50	0.11	0.6	–	–	–
CCMT 060204E-NF2:T8430	●	0.4	205	0.12	0.8	110	0.11	0.8	170	0.12	0.8	570	0.14	0.8	45	0.11	0.6	–	–	–
CCMT 060204E-NF2:T9325	●	0.4	255	0.12	0.8	150	0.11	0.8	240	0.12	0.8	–	–	–	55	0.11	0.6	–	–	–
CCMT 060204E-NF2:T9335	●	0.4	220	0.12	0.8	130	0.11	0.8	–	–	–	–	–	–	45	0.11	0.6	–	–	–
CCMT 060204E-NF2:T9415	●	0.4	315	0.12	0.8	–	–	–	295	0.12	0.8	–	–	–	–	–	–	–	–	–
CCMT 080304E-NF2:T5315	●	0.4	280	0.12	1.0	–	–	–	265	0.12	1.0	–	–	–	–	–	–	–	–	–
CCMT 080304E-NF2:T7325	●	0.4	190	0.12	1.0	145	0.11	1.0	–	–	–	–	–	–	60	0.11	0.8	–	–	–
CCMT 080304E-NF2:T7335	●	0.4	190	0.12	1.0	145	0.11	1.0	–	–	–	–	–	–	60	0.11	0.8	–	–	–
CCMT 080304E-NF2:T9325	●	0.4	255	0.12	1.0	150	0.11	1.0	240	0.12	1.0	–	–	–	55	0.11	0.8	–	–	–
CCMT 080304E-NF2:T9335	●	0.4	215	0.12	1.2	125	0.11	1.2	–	–	–	–	–	–	45	0.11	1.0	–	–	–
CCMT 080304E-NF2:T9415	●	0.4	305	0.12	1.0	–	–	–	285	0.12	1.0	–	–	–	–	–	–	–	–	–
CCMT 080308E-NF2:H07	●	0.8	–	–	–	95	0.13	1.2	150	0.14	1.2	485	0.17	1.2	45	0.13	1.0	–	–	–
CCMT 080308E-NF2:T5315	●	0.8	295	0.17	1.0	–	–	–	280	0.17	1.0	–	–	–	–	–	–	–	–	–
CCMT 080308E-NF2:T7325	❋	0.8	205	0.17	1.0	155	0.15	1.0	–	–	–	–	–	–	65	0.14	0.8	–	–	–
CCMT 080308E-NF2:T7335	❋	0.8	205	0.17	1.0	155	0.15	1.0	–	–	–	–	–	–	65	0.14	0.8	–	–	–
CCMT 080308E-NF2:T9325	❋	0.8	260	0.17	1.0	155	0.15	1.0	245	0.17	1.0	–	–	–	55	0.14	0.8	–	–	–
CCMT 09T304E-NF2:H07	●	0.4	–	–	–	85	0.11	1.2	135	0.12	1.2	430	0.14	1.2	40	0.11	1.0	–	–	–
CCMT 09T304E-NF2:T6310	●	0.4	165	0.12	1.2	115	0.11	1.2	130	0.12	1.2	495	0.14	1.2	45	0.11	1.0	–	–	–
CCMT 09T304E-NF2:T7325	●	0.4	190	0.12	1.2	145	0.11	1.2	–	–	–	–	–	–	60	0.11	1.0	–	–	–
CCMT 09T304E-NF2:T8415	●	0.4	215	0.12	1.2	110	0.11	1.2	195	0.12	1.2	540	0.14	1.2	45	0.11	1.0	–	–	–
CCMT 09T304E-NF2:T8430	●	0.4	200	0.12	1.2	110	0.11	1.2	165	0.12	1.2	555	0.14	1.2	40	0.11	1.0	–	–	–
CCMT 09T304E-NF2:T9325	●	0.4	250	0.12	1.2	150	0.11	1.2	235	0.12	1.2	–	–	–	55	0.11	1.0	–	–	–
CCMT 09T304E-NF2:T9415	●	0.4	300	0.12	1.2	–	–	–	285	0.12	1.2	–	–	–	–	–	–	–	–	–

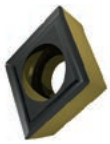
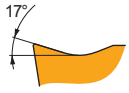
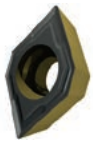
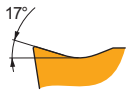
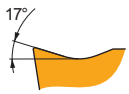




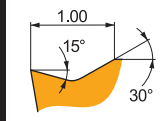


NF2 talaş kırıcı keskin ve paslanmaz çeliklerin finiş işlemi için ilk tercihtir. T-land olmadan pozitif eğim açısına sahiptir. Ayrıca süper alaşımlar ve şartlara bağlı olarak çelikler, dökme demirler ve demir dışı alaşımlar için de uygundur.

Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
			**NF2** talaş kırıcı keskin ve paslanmaz çeliklerin finiş işlemi için ilk tercihtir. T-land olmadan pozitif eğim açısına sahiptir. Ayrıca süper alaşımlar ve şartlara bağlı olarak çelikler, dökme demirler ve demir dışı alaşımlar için de uygundur.																	
CCMT 09T308E-NF2:H07	●	0.8	–	–	–	95	0.13	1.2	150	0.14	1.2	485	0.17	1.2	45	0.13	1.0	–	–	–
CCMT 09T308E-NF2:T6310	●	0.8	190	0.14	1.2	135	0.13	1.2	150	0.14	1.2	570	0.17	1.2	55	0.13	1.0	–	–	–
CCMT 09T308E-NF2:T7325	●	0.8	215	0.14	1.2	165	0.13	1.2	–	–	–	–	–	–	65	0.13	1.0	–	–	–
CCMT 09T308E-NF2:T8415	●	0.8	245	0.14	1.2	125	0.13	1.2	220	0.14	1.2	615	0.17	1.2	55	0.13	1.0	–	–	–
CCMT 09T308E-NF2:T8430	●	0.8	225	0.14	1.2	120	0.13	1.2	185	0.14	1.2	615	0.17	1.2	45	0.13	1.0	–	–	–
CCMT 09T308E-NF2:T9325	●	0.8	275	0.14	1.2	165	0.13	1.2	260	0.14	1.2	–	–	–	60	0.13	1.0	–	–	–
CCMT 09T308E-NF2:T9335	●	0.8	235	0.14	1.2	140	0.13	1.2	–	–	–	–	–	–	50	0.13	1.0	–	–	–
CCMT 09T308E-NF2:T9415	●	0.8	340	0.14	1.2	–	–	–	320	0.14	1.2	–	–	–	–	–	–	–	–	–
			**NF2** talaş kırıcı keskin ve paslanmaz çeliklerin finiş işlemi için ilk tercihtir. T-land olmadan pozitif eğim açısına sahiptir. Ayrıca süper alaşımlar ve şartlara bağlı olarak çelikler, dökme demirler ve demir dışı alaşımlar için de uygundur.																	
EPMT 050202E-NF2:H07	●	0.2	–	–	–	80	0.09	0.8	125	0.10	0.8	405	0.12	0.8	40	0.07	0.6	–	–	–
EPMT 050202E-NF2:T7325	●	0.2	215	0.07	0.8	165	0.06	0.8	–	–	–	–	–	–	65	0.06	0.6	–	–	–
EPMT 050202E-NF2:T7335	●	0.2	220	0.07	0.8	170	0.06	0.8	–	–	–	–	–	–	70	0.06	0.6	–	–	–
EPMT 050202E-NF2:T9325	●	0.2	305	0.07	0.8	180	0.06	0.8	285	0.07	0.8	–	–	–	65	0.06	0.6	–	–	–
EPMT 050202E-NF2:T9335	●	0.2	200	0.10	0.8	120	0.09	0.8	–	–	–	–	–	–	45	0.07	0.6	–	–	–
EPMT 050202E-NF2:T9415	●	0.2	355	0.05	0.8	–	–	–	335	0.05	0.8	–	–	–	–	–	–	–	–	–
EPMT 050202E-NF2:TT010	●	0.2	345	0.05	0.5	205	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–
			**NF2** talaş kırıcı keskin ve paslanmaz çeliklerin finiş işlemi için ilk tercihtir. T-land olmadan pozitif eğim açısına sahiptir. Ayrıca süper alaşımlar ve şartlara bağlı olarak çelikler, dökme demirler ve demir dışı alaşımlar için de uygundur.																	
VCGT 130302E-NF2:H07	●	0.2	–	–	–	60	0.09	1.0	95	0.10	1.0	310	0.12	1.0	30	0.07	0.8	–	–	–
VCGT 130302E-NF2:T6310	●	0.2	125	0.07	1.0	90	0.06	1.0	100	0.07	1.0	375	0.08	1.0	35	0.06	0.8	–	–	–
VCGT 130302E-NF2:T7325	●	0.2	150	0.07	1.0	115	0.06	1.0	–	–	–	–	–	–	45	0.06	0.8	–	–	–
VCGT 130302E-NF2:T7335	●	0.2	150	0.07	1.0	115	0.06	1.0	–	–	–	–	–	–	45	0.06	0.8	–	–	–
VCGT 130302E-NF2:T8415	●	0.2	160	0.07	1.0	85	0.06	1.0	145	0.07	1.0	405	0.08	1.0	35	0.06	0.8	–	–	–
VCGT 130302E-NF2:T9325	●	0.2	210	0.07	1.0	125	0.06	1.0	195	0.07	1.0	–	–	–	45	0.06	0.8	–	–	–
VCGT 130302E-NF2:T9335	●	0.2	155	0.10	1.0	90	0.09	1.0	–	–	–	–	–	–	30	0.07	0.8	–	–	–
VCGT 130302E-NF2:TT010	●	0.2	240	0.05	0.5	140	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–
VCGT 130304E-NF2:H07	●	0.4	–	–	–	60	0.11	1.0	95	0.12	1.0	310	0.14	1.0	30	0.11	0.8	–	–	–
VCGT 130304E-NF2:T5315	●	0.4	195	0.12	1.0	–	–	–	185	0.12	1.0	–	–	–	–	–	–	–	–	–
VCGT 130304E-NF2:T6310	●	0.4	115	0.12	1.0	80	0.11	1.0	90	0.12	1.0	345	0.14	1.0	30	0.11	0.8	–	–	–
VCGT 130304E-NF2:T7325	●	0.4	135	0.12	1.0	105	0.11	1.0	–	–	–	–	–	–	40	0.08	0.8	–	–	–
VCGT 130304E-NF2:T7335	●	0.4	135	0.12	1.0	105	0.11	1.0	–	–	–	–	–	–	40	0.08	0.8	–	–	–
VCGT 130304E-NF2:T8415	●	0.4	150	0.12	1.0	75	0.11	1.0	135	0.12	1.0	375	0.14	1.0	30	0.11	0.8	–	–	–
VCGT 130304E-NF2:T9325	●	0.4	175	0.12	1.0	105	0.11	1.0	165	0.12	1.0	–	–	–	35	0.08	0.8	–	–	–
VCGT 130304E-NF2:T9335	●	0.4	150	0.12	1.0	90	0.11	1.0	–	–	–	–	–	–	30	0.11	0.8	–	–	–
VCGT 130304E-NF2:T9415	●	0.4	225	0.10	1.0	–	–	–	210	0.10	1.0	–	–	–	–	–	–	–	–	–
VCGT 130304E-NF2:TT010	●	0.4	245	0.06	0.5	145	0.06	0.5	–	–	–	–	–	–	–	–	–	–	–	–
VCGT 130308E-NF2:T5315	●	0.8	205	0.17	1.0	–	–	–	190	0.17	1.0	–	–	–	–	–	–	–	–	–
VCGT 130308E-NF2:T6310	●	0.8	125	0.17	1.0	90	0.15	1.0	100	0.17	1.0	375	0.20	1.0	35	0.12	0.8	–	–	–
VCGT 130308E-NF2:T7325	●	0.8	145	0.17	1.0	110	0.15	1.0	–	–	–	–	–	–	45	0.12	0.8	–	–	–
VCGT 130308E-NF2:T7335	●	0.8	140	0.17	1.0	105	0.15	1.0	–	–	–	–	–	–	45	0.12	0.8	–	–	–
VCGT 130308E-NF2:T8415	●	0.8	160	0.17	1.0	85	0.15	1.0	145	0.17	1.0	405	0.20	1.0	35	0.12	0.8	–	–	–
VCGT 130308E-NF2:T9325	●	0.8	180	0.17	1.0	105	0.15	1.0	170	0.17	1.0	–	–	–	40	0.12	0.8	–	–	–
VCGT 130308E-NF2:T9335	●	0.8	155	0.18	1.0	90	0.16	1.0	–	–	–	–	–	–	30	0.16	0.8	–	–	–
VCGT 130308E-NF2:T9415	●	0.8	225	0.17	1.0	–	–	–	210	0.17	1.0	–	–	–	–	–	–	–	–	–
VCGT 130308E-NF2:TT010	●	0.8	245	0.10	0.8	145	0.09	0.8	–	–	–	–	–	–	–	–	–	–	–	–

UR



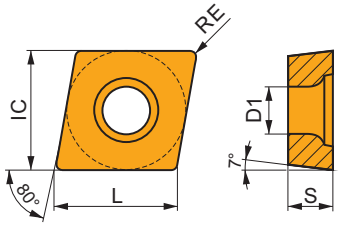


UR talaş kırıcı çok yönlüdür ve dökme demirlerin finiş işlemleri için ilk tercihtir. T-land olmadan pozitif eğim açısına sahiptir. Çelikler için ve koşullara göre paslanmaz çelikler için de uygundur.

PRAMET

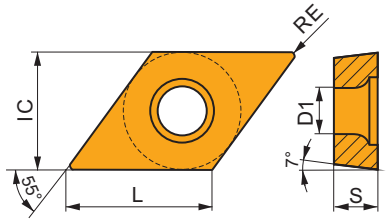
CCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0602	6.350	2.80	6.40	2.38
09T3	9.525	4.40	9.70	3.97
1204	12.700	5.50	12.90	4.76



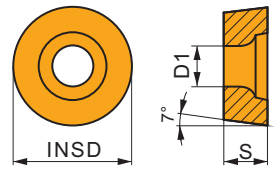
DCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0702	6.350	2.80	7.80	2.38
11T3	9.525	4.40	11.60	3.97



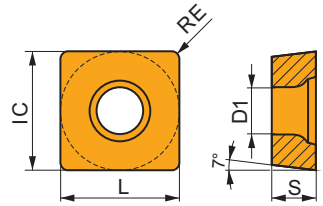
RCMT

	INSD (mm)	D1 (mm)	S (mm)
0602	6.000	2.80	2.38
0803	8.000	3.40	3.18
10T3	10.000	4.40	3.97
1204	12.000	4.40	4.76



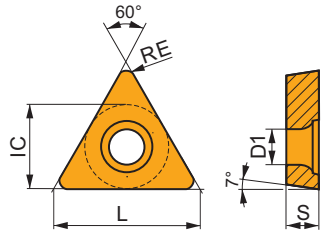
SCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
09T3	9.525	4.40	9.53	3.97
1204	12.700	5.50	12.70	4.76



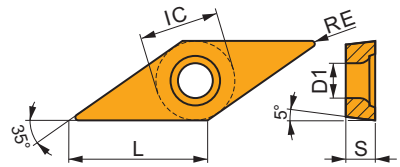
TCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1102	6.350	2.80	11.00	2.38
16T3	9.525	4.40	16.50	3.97



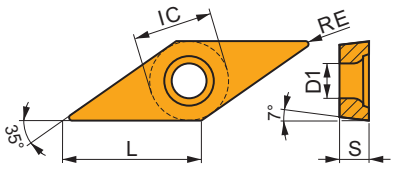
VBMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1102	6.350	2.80	11.10	2.38
1604	9.525	4.40	16.60	4.76



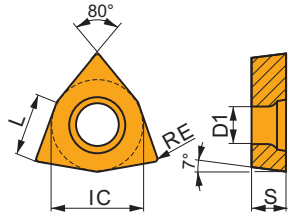
VCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1103	6.350	2.80	11.10	3.18
1604	9.525	4.40	16.60	4.76

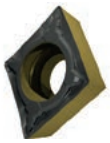
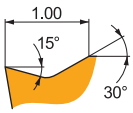


WCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
06T3	9.525	4.40	6.50	3.97



Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

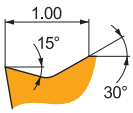
Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																			
CCMT 060202E-UR:T8315	0.2	170	0.10	0.8	100	0.09	0.8	160	0.10	0.8	–	–	–	–	–	–	–	–	–
CCMT 060202E-UR:T8415	0.2	210	0.10	0.8	110	0.09	0.8	190	0.10	0.8	–	–	–	–	–	–	–	–	–
CCMT 060202E-UR:T8430	0.2	200	0.10	0.8	110	0.09	0.8	165	0.10	0.8	–	–	–	–	–	–	–	–	–
CCMT 060202E-UR:T9325	0.2	250	0.10	0.8	150	0.09	0.8	235	0.10	0.8	–	–	–	–	–	–	–	–	–
CCMT 060202E-UR:T9415	0.2	295	0.10	0.8	–	–	–	280	0.10	0.8	–	–	–	–	–	–	–	–	–
CCMT 060202E-UR:TT310	0.2	275	0.10	0.5	165	0.09	0.5	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 060204E-UR:T5315	0.4	245	0.15	1.0	–	–	–	230	0.15	1.0	–	–	–	–	–	–	–	–	–
CCMT 060204E-UR:T7325	0.4	170	0.15	1.0	130	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 060204E-UR:T7335	0.4	170	0.15	1.0	130	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 060204E-UR:T8315	0.4	160	0.15	1.0	95	0.14	1.0	150	0.15	1.0	–	–	–	–	–	–	–	–	–
CCMT 060204E-UR:T8415	0.4	190	0.15	1.0	100	0.14	1.0	170	0.15	1.0	–	–	–	–	–	–	–	–	–
CCMT 060204E-UR:T8430	0.4	175	0.15	1.0	95	0.14	1.0	140	0.15	1.0	–	–	–	–	–	–	–	–	–
CCMT 060204E-UR:T9325	0.4	215	0.15	1.0	125	0.15	1.0	200	0.15	1.0	–	–	–	–	–	–	–	–	–
CCMT 060204E-UR:T9415	0.4	270	0.15	1.0	–	–	–	255	0.15	1.0	–	–	–	–	–	–	–	–	–
CCMT 060204E-UR:TT310	0.4	255	0.15	0.5	150	0.14	0.5	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 060208E-UR:T5315	0.8	270	0.20	1.0	–	–	–	255	0.20	1.0	–	–	–	–	–	–	–	–	–
CCMT 060208E-UR:T8430	0.8	185	0.20	1.0	100	0.18	1.0	150	0.20	1.0	–	–	–	–	–	–	–	–	–
CCMT 060208E-UR:T9325	0.8	230	0.20	1.0	135	0.18	1.0	215	0.20	1.0	–	–	–	–	–	–	–	–	–
CCMT 060208E-UR:T9415	0.8	290	0.20	1.0	–	–	–	275	0.20	1.0	–	–	–	–	–	–	–	–	–
CCMT 09T302E-UR:T6310	0.2	160	0.10	1.0	115	0.09	1.0	125	0.10	1.0	–	–	–	–	–	–	–	–	–
CCMT 09T302E-UR:T8415	0.2	200	0.10	1.0	105	0.09	1.0	185	0.10	1.0	–	–	–	–	–	–	–	–	–
CCMT 09T302E-UR:T8430	0.2	195	0.10	1.0	105	0.09	1.0	160	0.10	1.0	–	–	–	–	–	–	–	–	–
CCMT 09T302E-UR:TT310	0.2	255	0.10	1.0	150	0.09	1.0	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 09T304E-UR:T5315	0.4	245	0.15	1.2	–	–	–	230	0.15	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T304E-UR:T7325	0.4	170	0.15	1.2	130	0.15	1.2	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 09T304E-UR:T7335	0.4	165	0.15	1.2	125	0.15	1.2	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 09T304E-UR:T8315	0.4	155	0.15	1.2	90	0.14	1.2	145	0.15	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T304E-UR:T8415	0.4	190	0.15	1.2	100	0.14	1.2	170	0.15	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T304E-UR:T8430	0.4	175	0.15	1.2	95	0.14	1.2	140	0.15	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T304E-UR:T9315	0.4	235	0.15	1.2	–	–	–	220	0.15	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T304E-UR:T9325	0.4	215	0.15	1.2	125	0.15	1.2	200	0.15	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T304E-UR:T9415	0.4	265	0.15	1.2	–	–	–	250	0.15	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T304E-UR:TT310	0.4	235	0.15	1.2	140	0.14	1.2	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 09T308E-UR:T5315	0.8	265	0.20	1.2	–	–	–	250	0.20	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T308E-UR:T7325	0.8	185	0.20	1.2	140	0.18	1.2	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 09T308E-UR:T7335	0.8	175	0.20	1.2	135	0.18	1.2	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 09T308E-UR:T8315	0.8	170	0.20	1.2	100	0.18	1.2	160	0.20	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T308E-UR:T8415	0.8	200	0.20	1.2	105	0.18	1.2	185	0.20	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T308E-UR:T8430	0.8	185	0.20	1.2	100	0.18	1.2	150	0.20	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T308E-UR:T9325	0.8	225	0.20	1.2	135	0.18	1.2	210	0.20	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T308E-UR:T9415	0.8	285	0.20	1.2	–	–	–	270	0.20	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T308E-UR:TT310	0.8	255	0.20	1.2	150	0.18	1.2	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 120404E-UR:T5315	0.4	235	0.15	1.7	–	–	–	220	0.15	1.7	–	–	–	–	–	–	–	–	–
CCMT 120404E-UR:T7325	0.4	160	0.15	1.7	120	0.15	1.7	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 120404E-UR:T8430	0.4	170	0.15	1.7	90	0.14	1.7	135	0.15	1.7	–	–	–	–	–	–	–	–	–
CCMT 120404E-UR:T9325	0.4	205	0.15	1.7	120	0.15	1.7	190	0.15	1.7	–	–	–	–	–	–	–	–	–
CCMT 120404E-UR:T9415	0.4	255	0.15	1.7	–	–	–	240	0.15	1.7	–	–	–	–	–	–	–	–	–
CCMT 120408E-UR:T5315	0.8	255	0.20	1.7	–	–	–	240	0.20	1.7	–	–	–	–	–	–	–	–	–
CCMT 120408E-UR:T7325	0.8	175	0.20	1.7	135	0.18	1.7	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 120408E-UR:T8430	0.8	180	0.20	1.7	95	0.18	1.7	145	0.20	1.7	–	–	–	–	–	–	–	–	–
CCMT 120408E-UR:T9325	0.8	215	0.20	1.7	125	0.18	1.7	200	0.20	1.7	–	–	–	–	–	–	–	–	–
CCMT 120408E-UR:T9415	0.8	275	0.20	1.7	–	–	–	260	0.20	1.7	–	–	–	–	–	–	–	–	–
CCMT 120412E-UR:T5315	1.2	240	0.27	1.7	–	–	–	225	0.27	1.7	–	–	–	–	–	–	–	–	–
CCMT 120412E-UR:T8430	1.2	165	0.27	1.7	90	0.24	1.7	135	0.27	1.7	–	–	–	–	–	–	–	–	–
CCMT 120412E-UR:T9325	1.2	205	0.27	1.7	120	0.24	1.7	190	0.27	1.7	–	–	–	–	–	–	–	–	–
CCMT 120412E-UR:T9415	1.2	265	0.27	1.7	–	–	–	250	0.27	1.7	–	–	–	–	–	–	–	–	–

UR talaş kırıcı çok yönlüdür ve dökme demirlerin finiş işlemleri için ilk tercihtir. T-land olmadan pozitif eğim açısına sahiptir. Çelikler için ve koşullara göre paslanmaz çelikler için de uygundur.

Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

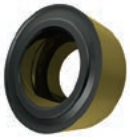
Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
DCMT 070202E-UR:T7325	●	0.2	150	0.10	0.8	115	0.09	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 070202E-UR:T8315	●	0.2	135	0.10	0.8	80	0.09	0.8	125	0.10	0.8	–	–	–	–	–	–	–	–	–
DCMT 070202E-UR:T8415	●	0.2	165	0.10	0.8	85	0.09	0.8	150	0.10	0.8	–	–	–	–	–	–	–	–	–
DCMT 070202E-UR:T8430	●	0.2	155	0.10	0.8	85	0.09	0.8	130	0.10	0.8	–	–	–	–	–	–	–	–	–
DCMT 070202E-UR:T9325	●	0.2	200	0.10	0.8	120	0.09	0.8	190	0.10	0.8	–	–	–	–	–	–	–	–	–
DCMT 070202E-UR:T9415	●	0.2	235	0.10	0.8	–	–	–	220	0.10	0.8	–	–	–	–	–	–	–	–	–
DCMT 070204E-UR:T7325	●	0.4	135	0.17	0.8	105	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 070204E-UR:T8315	●	0.4	135	0.12	0.8	80	0.11	0.8	125	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 070204E-UR:T8415	●	0.4	165	0.12	0.8	85	0.11	0.8	150	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 070204E-UR:T8430	●	0.4	155	0.12	0.8	85	0.11	0.8	130	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 070204E-UR:T9325	●	0.4	165	0.18	0.8	95	0.16	0.8	155	0.18	0.8	–	–	–	–	–	–	–	–	–
DCMT 070204E-UR:T9415	●	0.4	240	0.12	0.8	–	–	–	225	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T302E-UR:T7325	●	0.2	150	0.10	0.8	115	0.09	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T302E-UR:T8430	●	0.2	155	0.10	0.8	85	0.09	0.8	130	0.10	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T302E-UR:T9325	●	0.2	200	0.10	0.8	120	0.09	0.8	190	0.10	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T302E-UR:T9415	●	0.2	235	0.10	0.8	–	–	–	220	0.10	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T302E-UR:TT310	●	0.2	210	0.10	0.8	125	0.09	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T304E-UR:T5315	●	0.4	220	0.12	0.8	–	–	–	205	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T304E-UR:T7325	●	0.4	135	0.17	0.8	105	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T304E-UR:T7335	●	0.4	130	0.17	0.8	100	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T304E-UR:T8315	●	0.4	135	0.12	0.8	80	0.11	0.8	125	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T304E-UR:T8415	●	0.4	165	0.12	0.8	85	0.11	0.8	150	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T304E-UR:T8430	●	0.4	155	0.12	0.8	85	0.11	0.8	130	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T304E-UR:T9325	●	0.4	165	0.18	0.8	95	0.16	0.8	155	0.18	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T304E-UR:T9415	●	0.4	240	0.12	0.8	–	–	–	225	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T304E-UR:TT310	●	0.4	210	0.12	0.8	125	0.11	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T308E-UR:T5315	●	0.8	230	0.17	0.8	–	–	–	215	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T308E-UR:T7325	●	0.8	160	0.17	0.8	120	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T308E-UR:T7335	●	0.8	155	0.17	0.8	120	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T308E-UR:T8315	●	0.8	145	0.17	0.8	85	0.15	0.8	135	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T308E-UR:T8415	●	0.8	180	0.17	0.8	90	0.15	0.8	160	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T308E-UR:T8430	●	0.8	165	0.17	0.8	90	0.15	0.8	135	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T308E-UR:T9325	●	0.8	200	0.17	0.8	120	0.15	0.8	190	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T308E-UR:T9415	●	0.8	250	0.17	0.8	–	–	–	235	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T308E-UR:TT310	●	0.8	225	0.17	0.8	135	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T312E-UR:T9325	●	1.2	180	0.22	1.2	105	0.20	1.2	170	0.22	1.2	–	–	–	–	–	–	–	–	–
DCMT 11T312E-UR:T9415	●	1.2	230	0.22	1.2	–	–	–	215	0.22	1.2	–	–	–	–	–	–	–	–	–

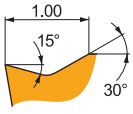




UR talaş kırıcı çok yönlüdür ve dökme demirlerin finiş işlemleri için ilk tercihtir. T-land olmadan pozitif eğim açısına sahiptir. Çelikler için ve koşullara göre paslanmaz çelikler için de uygundur.

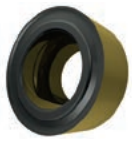
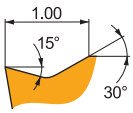
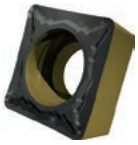
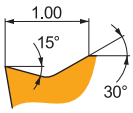
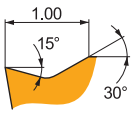
Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
RCMT 0602MOE-UR:T6310	●	–	170	0.40	1.2	120	0.36	1.2	135	0.40	1.2	–	–	–	–	–	–	–	–	–
RCMT 0602MOE-UR:T8415	●	–	220	0.40	1.2	115	0.36	1.2	200	0.40	1.2	–	–	–	–	–	–	–	–	–
RCMT 0602MOE-UR:T8430	●	–	180	0.40	1.2	95	0.36	1.2	145	0.40	1.2	–	–	–	–	–	–	–	–	–
RCMT 0602MOE-UR:T9325	●	–	215	0.40	1.2	125	0.36	1.2	200	0.40	1.2	–	–	–	–	–	–	–	–	–
RCMT 0602MOE-UR:T9415	●	–	285	0.40	1.2	–	–	–	270	0.40	1.2	–	–	–	–	–	–	–	–	–
RCMT 0803MOE-UR:T6310	●	–	160	0.45	1.6	115	0.41	1.6	125	0.45	1.6	–	–	–	–	–	–	–	–	–
RCMT 0803MOE-UR:T7325	●	–	180	0.45	1.6	140	0.41	1.6	–	–	–	–	–	–	–	–	–	–	–	–
RCMT 0803MOE-UR:T8415	●	–	200	0.45	1.6	105	0.41	1.6	185	0.45	1.6	–	–	–	–	–	–	–	–	–
RCMT 0803MOE-UR:T8430	●	–	170	0.45	1.6	90	0.41	1.6	135	0.45	1.6	–	–	–	–	–	–	–	–	–
RCMT 0803MOE-UR:T9325	●	–	200	0.45	1.6	120	0.41	1.6	190	0.45	1.6	–	–	–	–	–	–	–	–	–
RCMT 0803MOE-UR:T9415	●	–	265	0.45	1.6	–	–	–	250	0.45	1.6	–	–	–	–	–	–	–	–	–



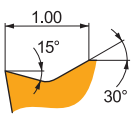
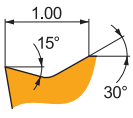
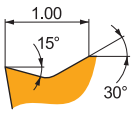


UR talaş kırıcı çok yönlüdür ve dökme demirlerin finiş işlemleri için ilk tercihtir. T-land olmadan pozitif eğim açısına sahiptir. Çelikler için ve koşullara göre paslanmaz çelikler için de uygundur.

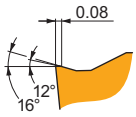
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P			M			K			N			S			H		
		(mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)
																				
UR talaş kırıcı çok yönlüdür ve dökme demirlerin finiş işlemleri için ilk tercihtir. T-land olmadan pozitif eğim açısına sahiptir. Çelikler için ve koşullara göre paslanmaz çelikler için de uygundur.																				
RCMT 10T3MOE-UR:T6310	●	–	■	160	0.50	1.4	◪	115	0.45	1.4	■	125	0.50	1.4	–	–	–	–	–	–	–	–	–
RCMT 10T3MOE-UR:T7325	●	–	◪	175	0.50	1.4	◪	135	0.45	1.4		–	–	–	–	–	–	–	–	–	–	–	–
RCMT 10T3MOE-UR:T8415	●	–	■	200	0.50	1.4	◪	105	0.45	1.4	■	185	0.50	1.4	–	–	–	–	–	–	–	–	–
RCMT 10T3MOE-UR:T8430	●	–	■	165	0.50	1.4	◪	90	0.45	1.4	◪	135	0.50	1.4	–	–	–	–	–	–	–	–	–
RCMT 10T3MOE-UR:T9325	●	–	■	190	0.50	1.4	◪	110	0.45	1.4	◪	180	0.50	1.4	–	–	–	–	–	–	–	–	–
RCMT 10T3MOE-UR:T9415	●	–	■	260	0.50	1.4		–	–	–	◪	245	0.50	1.4	–	–	–	–	–	–	–	–	–
RCMT 1204MOE-UR:T6310	●	–	■	150	0.55	1.8	◪	105	0.50	1.8	■	120	0.55	1.8	–	–	–	–	–	–	–	–	–
RCMT 1204MOE-UR:T8415	●	–	■	190	0.55	1.8	◪	100	0.49	1.8	■	170	0.55	1.8	–	–	–	–	–	–	–	–	–
RCMT 1204MOE-UR:T8430	●	–	■	145	0.55	1.8	◪	80	0.50	1.8	◪	120	0.55	1.8	–	–	–	–	–	–	–	–	–
RCMT 1204MOE-UR:T9315	●	–	■	200	0.55	1.8		–	–	–	◪	190	0.55	1.8	–	–	–	–	–	–	–	–	–
RCMT 1204MOE-UR:T9325	●	–	■	180	0.55	1.8	◪	105	0.50	1.8	◪	170	0.55	1.8	–	–	–	–	–	–	–	–	–
RCMT 1204MOE-UR:T9415	●	–	■	245	0.55	1.8		–	–	–	◪	230	0.55	1.8	–	–	–	–	–	–	–	–	–
																				
UR talaş kırıcı çok yönlüdür ve dökme demirlerin finiş işlemleri için ilk tercihtir. T-land olmadan pozitif eğim açısına sahiptir. Çelikler için ve koşullara göre paslanmaz çelikler için de uygundur.																				
SCMT 09T304E-UR:T8430	●	0.4	■	180	0.15	1.2	◪	95	0.14	1.2	◪	145	0.15	1.2	–	–	–	–	–	–	–	–	–
SCMT 09T304E-UR:T9325	●	0.4	■	225	0.15	1.2	◪	135	0.15	1.2	◪	210	0.15	1.2	–	–	–	–	–	–	–	–	–
SCMT 09T304E-UR:T9415	●	0.4	■	280	0.15	1.2		–	–	–	◪	265	0.15	1.2	–	–	–	–	–	–	–	–	–
SCMT 09T308E-UR:T5315	●	0.8	◪	280	0.20	1.2		–	–	–	■	265	0.20	1.2	–	–	–	–	–	–	–	–	–
SCMT 09T308E-UR:T8430	●	0.8	■	190	0.20	1.2	◪	105	0.18	1.2	◪	155	0.20	1.2	–	–	–	–	–	–	–	–	–
SCMT 09T308E-UR:T9325	●	0.8	■	235	0.20	1.2	◪	140	0.18	1.2	◪	220	0.20	1.2	–	–	–	–	–	–	–	–	–
SCMT 09T308E-UR:T9415	●	0.8	■	300	0.20	1.2		–	–	–	◪	285	0.20	1.2	–	–	–	–	–	–	–	–	–
SCMT 09T308E-UR:TT310	●	0.8	■	270	0.20	1.2	◪	160	0.18	1.2		–	–	–	–	–	–	–	–	–	–	–	–
SCMT 120408E-UR:T5315	●	0.8	◪	270	0.20	1.6		–	–	–	■	255	0.20	1.6	–	–	–	–	–	–	–	–	–
SCMT 120408E-UR:T8430	●	0.8	■	185	0.20	1.6	◪	100	0.18	1.6	◪	150	0.20	1.6	–	–	–	–	–	–	–	–	–
SCMT 120408E-UR:T9325	●	0.8	■	230	0.20	1.6	◪	135	0.18	1.6	◪	215	0.20	1.6	–	–	–	–	–	–	–	–	–
SCMT 120412E-UR:T8430	●	1.2	■	175	0.27	1.6	◪	95	0.24	1.6	◪	140	0.27	1.6	–	–	–	–	–	–	–	–	–
																				
UR talaş kırıcı çok yönlüdür ve dökme demirlerin finiş işlemleri için ilk tercihtir. T-land olmadan pozitif eğim açısına sahiptir. Çelikler için ve koşullara göre paslanmaz çelikler için de uygundur.																				
TCMT 110204E-UR:T7325	●	0.4	◪	135	0.19	0.8	◪	105	0.17	0.8		–	–	–	–	–	–	–	–	–	–	–	–
TCMT 110204E-UR:T8430	●	0.4	■	170	0.12	0.8	◪	90	0.11	0.8	◪	135	0.12	0.8	–	–	–	–	–	–	–	–	–
TCMT 110204E-UR:T9325	●	0.4	■	175	0.18	0.8	◪	105	0.16	0.8	◪	165	0.18	0.8	–	–	–	–	–	–	–	–	–
TCMT 110204E-UR:T9415	●	0.4	■	255	0.12	0.8		–	–	–	◪	240	0.12	0.8	–	–	–	–	–	–	–	–	–
TCMT 16T304E-UR:T8430	●	0.4	■	170	0.12	0.8	◪	90	0.11	0.8	◪	135	0.12	0.8	–	–	–	–	–	–	–	–	–
TCMT 16T304E-UR:T9325	●	0.4	■	175	0.18	0.8	◪	105	0.16	0.8	◪	165	0.18	0.8	–	–	–	–	–	–	–	–	–
TCMT 16T304E-UR:T9415	●	0.4	■	255	0.12	0.8		–	–	–	◪	240	0.12	0.8	–	–	–	–	–	–	–	–	–
TCMT 16T304E-UR:TT310	●	0.4	■	225	0.12	0.8	◪	135	0.11	0.8		–	–	–	–	–	–	–	–	–	–	–	–
TCMT 16T308E-UR:T5315	●	0.8	◪	245	0.17	0.8		–	–	–	■	230	0.17	0.8	–	–	–	–	–	–	–	–	–
TCMT 16T308E-UR:T7325	●	0.8	◪	170	0.17	0.8	◪	130	0.15	0.8		–	–	–	–	–	–	–	–	–	–	–	–
TCMT 16T308E-UR:T8430	●	0.8	■	175	0.17	0.8	◪	95	0.15	0.8	◪	140	0.17	0.8	–	–	–	–	–	–	–	–	–
TCMT 16T308E-UR:T9325	●	0.8	■	215	0.17	0.8	◪	125	0.15	0.8	◪	200	0.17	0.8	–	–	–	–	–	–	–	–	–
TCMT 16T308E-UR:T9415	●	0.8	■	265	0.17	0.8		–	–	–	◪	250	0.17	0.8	–	–	–	–	–	–	–	–	–

Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
UR talaş kırıcı çok yönlüdür ve dökme demirlerin finiş işlemleri için ilk tercihtir. T-land olmadan pozitif eğim açısına sahiptir. Çelikler için ve koşullara göre paslanmaz çelikler için de uygundur.																			
VBMT 110202E-UR:TT310	0.2	195	0.10	0.8	115	0.09	0.8	–	–	–	–	–	–	–	–	–	–	–	–
VBMT 110204E-UR:T8430	0.4	145	0.12	0.8	80	0.11	0.8	120	0.12	0.8	–	–	–	–	–	–	–	–	–
VBMT 110204E-UR:T9325	0.4	150	0.19	0.8	90	0.17	0.8	140	0.19	0.8	–	–	–	–	–	–	–	–	–
VBMT 160402E-UR:T8430	0.2	140	0.10	1.2	75	0.09	1.2	115	0.10	1.2	–	–	–	–	–	–	–	–	–
VBMT 160404E-UR:T5315	0.4	195	0.12	1.2	–	–	–	185	0.12	1.2	–	–	–	–	–	–	–	–	–
VBMT 160404E-UR:T7325	0.4	115	0.19	1.2	85	0.17	1.2	–	–	–	–	–	–	–	–	–	–	–	–
VBMT 160404E-UR:T8430	0.4	140	0.12	1.2	75	0.11	1.2	115	0.12	1.2	–	–	–	–	–	–	–	–	–
VBMT 160404E-UR:T9325	0.4	145	0.18	1.2	85	0.16	1.2	135	0.18	1.2	–	–	–	–	–	–	–	–	–
VBMT 160404E-UR:T9415	0.4	210	0.12	1.2	–	–	–	195	0.12	1.2	–	–	–	–	–	–	–	–	–
VBMT 160404E-UR:TT310	0.4	185	0.12	1.2	110	0.11	1.2	–	–	–	–	–	–	–	–	–	–	–	–
VBMT 160408E-UR:T5315	0.8	205	0.17	1.2	–	–	–	190	0.17	1.2	–	–	–	–	–	–	–	–	–
VBMT 160408E-UR:T7325	0.8	140	0.17	1.2	105	0.15	1.2	–	–	–	–	–	–	–	–	–	–	–	–
VBMT 160408E-UR:T8430	0.8	145	0.17	1.2	80	0.15	1.2	120	0.17	1.2	–	–	–	–	–	–	–	–	–
VBMT 160408E-UR:T9310	0.8	220	0.17	1.2	–	–	–	205	0.17	1.2	–	–	–	–	–	–	–	–	–
VBMT 160408E-UR:T9325	0.8	180	0.17	1.2	105	0.15	1.2	170	0.17	1.2	–	–	–	–	–	–	–	–	–
VBMT 160408E-UR:T9415	0.8	225	0.17	1.2	–	–	–	210	0.17	1.2	–	–	–	–	–	–	–	–	–
VBMT 160408E-UR:TT310	0.8	200	0.17	1.2	120	0.15	1.2	–	–	–	–	–	–	–	–	–	–	–	–
VBMT 160412E-UR:T8430	1.2	135	0.22	1.2	75	0.20	1.2	110	0.22	1.2	–	–	–	–	–	–	–	–	–
VBMT 160412E-UR:T9325	1.2	170	0.22	1.2	100	0.20	1.2	160	0.22	1.2	–	–	–	–	–	–	–	–	–
VBMT 160412E-UR:T9415	1.2	210	0.22	1.2	–	–	–	195	0.22	1.2	–	–	–	–	–	–	–	–	–
 																			
UR talaş kırıcı çok yönlüdür ve dökme demirlerin finiş işlemleri için ilk tercihtir. T-land olmadan pozitif eğim açısına sahiptir. Çelikler için ve koşullara göre paslanmaz çelikler için de uygundur.																			
VCMT 110304E-UR:T7325	0.4	110	0.19	0.8	85	0.17	0.8	–	–	–	–	–	–	–	–	–	–	–	–
VCMT 110304E-UR:T8430	0.4	135	0.12	0.8	75	0.11	0.8	110	0.12	0.8	–	–	–	–	–	–	–	–	–
VCMT 110304E-UR:T9325	0.4	140	0.19	0.8	80	0.17	0.8	130	0.19	0.8	–	–	–	–	–	–	–	–	–
VCMT 110304E-UR:T9415	0.4	210	0.12	0.8	–	–	–	195	0.12	0.8	–	–	–	–	–	–	–	–	–
VCMT 110308E-UR:T7325	0.8	140	0.17	0.8	105	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
VCMT 110308E-UR:T8430	0.8	140	0.17	0.8	75	0.15	0.8	115	0.17	0.8	–	–	–	–	–	–	–	–	–
VCMT 110308E-UR:T9325	0.8	175	0.17	0.8	105	0.15	0.8	165	0.17	0.8	–	–	–	–	–	–	–	–	–
VCMT 110308E-UR:T9415	0.8	220	0.17	0.8	–	–	–	205	0.17	0.8	–	–	–	–	–	–	–	–	–
VCMT 160404E-UR:T7325	0.4	110	0.19	1.2	85	0.17	1.2	–	–	–	–	–	–	–	–	–	–	–	–
VCMT 160404E-UR:T8430	0.4	130	0.12	1.2	70	0.11	1.2	105	0.12	1.2	–	–	–	–	–	–	–	–	–
VCMT 160404E-UR:T9325	0.4	135	0.19	1.2	80	0.17	1.2	125	0.19	1.2	–	–	–	–	–	–	–	–	–
VCMT 160404E-UR:T9415	0.4	200	0.12	1.2	–	–	–	190	0.12	1.2	–	–	–	–	–	–	–	–	–
VCMT 160408E-UR:T7325	0.8	135	0.17	1.2	105	0.15	1.2	–	–	–	–	–	–	–	–	–	–	–	–
VCMT 160408E-UR:T8430	0.8	135	0.17	1.2	75	0.15	1.2	110	0.17	1.2	–	–	–	–	–	–	–	–	–
VCMT 160408E-UR:T9325	0.8	170	0.17	1.2	100	0.15	1.2	160	0.17	1.2	–	–	–	–	–	–	–	–	–
VCMT 160408E-UR:T9415	0.8	210	0.17	1.2	–	–	–	195	0.17	1.2	–	–	–	–	–	–	–	–	–
 																			
UR talaş kırıcı çok yönlüdür ve dökme demirlerin finiş işlemleri için ilk tercihtir. T-land olmadan pozitif eğim açısına sahiptir. Çelikler için ve koşullara göre paslanmaz çelikler için de uygundur.																			
WCMT 06T308E-UR:T7325	0.8	185	0.20	1.2	140	0.18	1.2	–	–	–	–	–	–	–	–	–	–	–	–
WCMT 06T308E-UR:T9325	0.8	225	0.20	1.2	135	0.18	1.2	210	0.20	1.2	–	–	–	–	–	–	–	–	–

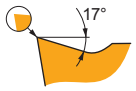
W -FM



W-FM talaş kırıcı silici kenara sahiptir ve Çeliklerin, Paslanmaz çeliklerin ve Dökme demirlerin finişi için tasarlanmıştır. Pozitif eğim açısı ve pozitif, dar T-land özelliğine sahiptir.

PRAMET

W -UR



W-UR talaş kırıcı silici kenara sahiptir ve Çeliklerin ve Dökme demirlerin finişi için tasarlanmıştır. T-land olmadan pozitif eğim açısına sahiptir. Paslanmaz çelikler için de şartlı olarak uygundur.

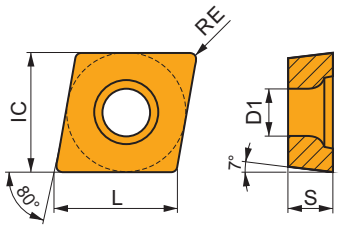
PRAMET

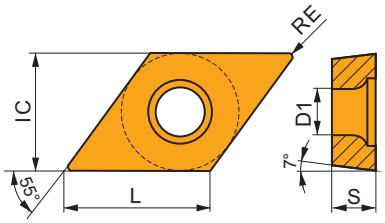
CCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0602	6.350	2.80	6.40	2.38
09T3	9.525	4.40	9.70	3.97

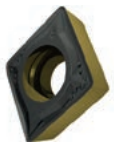
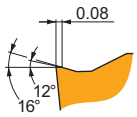
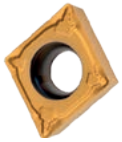
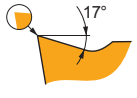
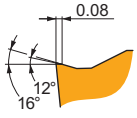
DCMX

	IC (mm)	D1 (mm)	L (mm)	S (mm)
11T3	9.525	4.40	11.60	3.97



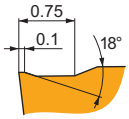


Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
W-FM talaş kırıcı silici kenara sahiptir ve Çeliklerin, Paslanmaz çeliklerin ve Dökme demirlerin finişi için tasarlanmıştır. Pozitif eğim açısı ve pozitif, dar T-land özelliğine sahiptir.																			
CCMT 060204W-FM:T8430	● 0.4	165	0.30	0.8	90	0.27	0.8	135	0.30	0.8	–	–	–	–	–	–	–	–	–
CCMT 060204W-FM:T9325	● 0.4	190	0.30	0.8	110	0.27	0.8	180	0.30	0.8	–	–	–	–	–	–	–	–	–
CCMT 060204W-FM:T9415	● 0.4	250	0.30	0.8	–	–	–	235	0.30	0.8	–	–	–	–	–	–	–	–	–
CCMT 09T304W-FM:T8430	● 0.4	165	0.30	0.8	90	0.27	0.8	135	0.30	0.8	–	–	–	–	–	–	–	–	–
CCMT 09T304W-FM:T9325	● 0.4	190	0.30	0.8	110	0.27	0.8	180	0.30	0.8	–	–	–	–	–	–	–	–	–
CCMT 09T304W-FM:T9415	● 0.4	305	0.15	1.2	–	–	–	285	0.15	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T308W-FM:T8430	● 0.8	170	0.40	1.0	90	0.36	1.0	135	0.40	1.0	–	–	–	–	–	–	–	–	–
CCMT 09T308W-FM:T9325	● 0.8	200	0.40	1.0	120	0.36	1.0	190	0.40	1.0	–	–	–	–	–	–	–	–	–
 																			
W-UR talaş kırıcı silici kenara sahiptir ve Çeliklerin ve Dökme demirlerin finişi için tasarlanmıştır. T-land olmadan pozitif eğim açısına sahiptir. Paslanmaz çelikler için de şartlı olarak uygundur.																			
CCMT 060204W-UR:TT310	● 0.4	255	0.15	0.5	150	0.14	0.5	–	–	–	–	–	–	–	–	–	–	–	–
 																			
W-FM talaş kırıcı silici kenara sahiptir ve Çeliklerin, Paslanmaz çeliklerin ve Dökme demirlerin finişi için tasarlanmıştır. Pozitif eğim açısı ve pozitif, dar T-land özelliğine sahiptir.																			
DCMX 11T304W-FM:T7325	● 0.4	130	0.30	0.8	100	0.27	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMX 11T304W-FM:T8430	● 0.4	130	0.30	0.8	70	0.27	0.8	105	0.30	0.8	–	–	–	–	–	–	–	–	–
DCMX 11T304W-FM:T9325	● 0.4	155	0.30	0.8	90	0.27	0.8	145	0.30	0.8	–	–	–	–	–	–	–	–	–
DCMX 11T304W-FM:T9415	● 0.4	200	0.30	0.8	–	–	–	190	0.30	0.8	–	–	–	–	–	–	–	–	–
DCMX 11T308W-FM:T8430	● 0.8	130	0.40	1.0	70	0.36	1.0	105	0.40	1.0	–	–	–	–	–	–	–	–	–
DCMX 11T308W-FM:T9325	● 0.8	160	0.40	1.0	95	0.36	1.0	150	0.40	1.0	–	–	–	–	–	–	–	–	–

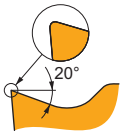
ORTA - REHBER

FM2



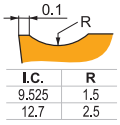
FM2 talaş kırıcı sağlamdır ve Çeliklerin orta düzeyde işlenmesi için ilk tercihtir. Pozitif eğim açısı ve dengeli, ılımlı T-land özelliğine sahiptir. Dökme demirler ve şartlı olarak Paslanmaz çelikler için de uygundur.

SI



SI talaş kırıcı keskin ve Paslanmaz çeliklerin orta düzeyde işlenmesi için ilk tercihtir. T-land olmadan son derece pozitif eğim açısına sahiptir. Çelikler ve Süper alaşımlar için ve şartlı olarak Dökme demirler için de uygundur.

RF



I.C.	R
9.525	1.5
12.7	2.5

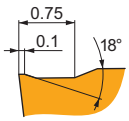
RF talaş kırıcı sağlamdır ve Dökme demirlerin orta düzeyde işlenmesi için ilk tercihtir. Hafif pozitif eğim açısı ve dengeli, ılımlı T-land özelliğine sahiptir. Çelikler için ve şartlı olarak Paslanmaz çelikler ve Sert malzemeler için de uygundur.

.CMW



.CMW düz kesici uç, dökme demirlerin orta düzeyde işlenmesi için tasarlanmıştır. T-land olmadan nötr eğim açısına sahiptir. Sert malzemeler için de şartlara bağlı olarak uygundur.

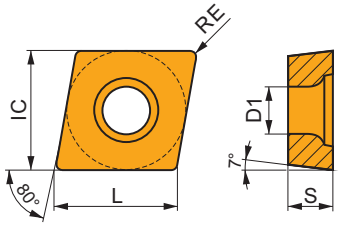
FM2



FM2 talaş kırıcı sağlamdır ve Çeliklerin orta düzeyde işlenmesi için ilk tercihtir. Pozitif eğim açısı ve dengeli, ılımlı T-land özelliğine sahiptir. Dökme demirler ve şartlı olarak Paslanmaz çelikler için de uygundur.

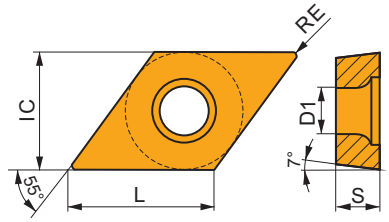
CCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0803	7.940	3.40	8.10	3.18
09T3	9.525	4.40	9.70	3.97
1204	12.700	5.50	12.90	4.76



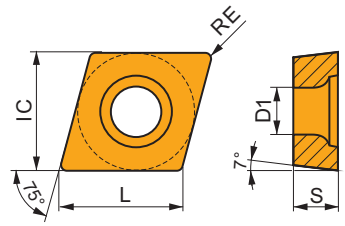
DCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0702	6.350	2.80	7.80	2.38
11T3	9.525	4.40	11.60	3.97
1504	12.700	5.50	15.50	4.76



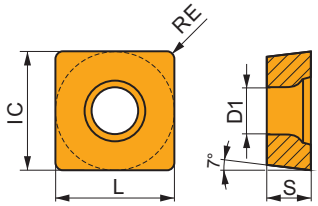
ECMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0602	6.350	2.80	6.50	2.38
0803	7.940	3.40	8.20	3.18



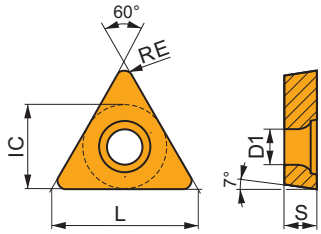
SCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
09T3	9.525	4.40	9.53	3.97



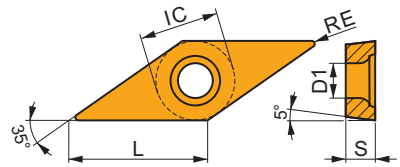
TCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1102	6.350	2.80	11.00	2.38
16T3	9.525	4.40	16.50	3.97



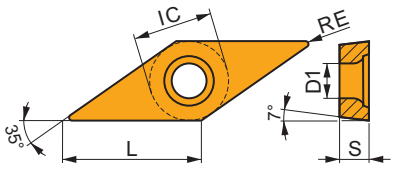
VBMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	4.40	16.60	4.76

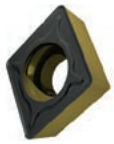
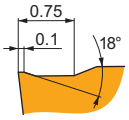
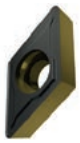
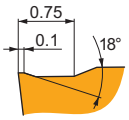


VCGT

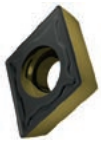
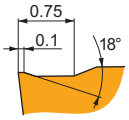
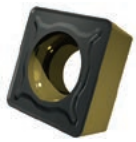
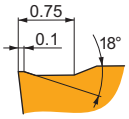
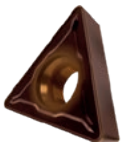
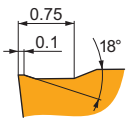
	IC (mm)	D1 (mm)	L (mm)	S (mm)
1303	7.940	3.40	13.80	3.18



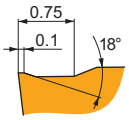
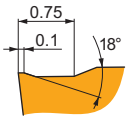
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
			**FM2** talaş kırıcı sağlamdır ve Çeliklerin orta düzeyde işlenmesi için ilk tercihtir. Pozitif eğim açısı ve dengeli, ılımlı T-land özelliğine sahiptir. Dökme demirler ve şartlı olarak Paslanmaz çelikler için de uygundur.																	
CCMT 080304E-FM2:T8430	●	0.4	205	0.12	1.0	110	0.11	1.0	170	0.12	1.0	–	–	–	–	–	–	–	–	–
CCMT 080304E-FM2:T9325	●	0.4	255	0.12	1.0	150	0.11	1.0	240	0.12	1.0	–	–	–	–	–	–	–	–	–
CCMT 080304E-FM2:T9335	●	0.4	215	0.12	1.0	125	0.11	1.0	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 080304E-FM2:T9415	●	0.4	305	0.12	1.0	–	–	–	285	0.12	1.0	–	–	–	–	–	–	–	–	–
CCMT 080308E-FM2:T8430	●●	0.8	210	0.17	1.0	115	0.15	1.0	175	0.17	1.0	–	–	–	–	–	–	–	–	–
CCMT 080308E-FM2:T9325	●●	0.8	260	0.17	1.0	155	0.15	1.0	245	0.17	1.0	–	–	–	–	–	–	–	–	–
CCMT 080308E-FM2:T9335	●●	0.8	225	0.17	1.0	135	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 09T304E-FM2:T6310	●	0.4	165	0.12	1.0	115	0.11	1.0	130	0.12	1.0	–	–	–	–	–	–	–	–	–
CCMT 09T304E-FM2:T8430	●	0.4	205	0.12	1.0	110	0.11	1.0	170	0.12	1.0	–	–	–	–	–	–	–	–	–
CCMT 09T304E-FM2:T9325	●	0.4	255	0.12	1.0	150	0.11	1.0	240	0.12	1.0	–	–	–	–	–	–	–	–	–
CCMT 09T304E-FM2:T9415	●	0.4	305	0.12	1.0	–	–	–	285	0.12	1.0	–	–	–	–	–	–	–	–	–
CCMT 09T308E-FM2:T6310	●●	0.8	180	0.17	1.0	125	0.15	1.0	145	0.17	1.0	–	–	–	–	–	–	–	–	–
CCMT 09T308E-FM2:T7325	●●	0.8	205	0.17	1.0	155	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 09T308E-FM2:T8430	●●	0.8	210	0.17	1.0	115	0.15	1.0	175	0.17	1.0	–	–	–	–	–	–	–	–	–
CCMT 09T308E-FM2:T9325	●●	0.8	260	0.17	1.0	155	0.15	1.0	245	0.17	1.0	–	–	–	–	–	–	–	–	–
CCMT 09T308E-FM2:T9335	●●	0.8	225	0.17	1.0	135	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 09T308E-FM2:T9415	●	0.8	320	0.17	1.0	–	–	–	300	0.17	1.0	–	–	–	–	–	–	–	–	–
CCMT 120408E-FM2:T7325	●●	0.8	190	0.20	1.5	145	0.18	1.5	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 120408E-FM2:T8430	●●	0.8	190	0.20	1.5	105	0.18	1.5	155	0.20	1.5	–	–	–	–	–	–	–	–	–
CCMT 120408E-FM2:T9325	●●	0.8	235	0.20	1.5	140	0.18	1.5	220	0.20	1.5	–	–	–	–	–	–	–	–	–
CCMT 120408E-FM2:T9335	●●	0.8	200	0.20	1.5	120	0.18	1.5	–	–	–	–	–	–	–	–	–	–	–	–
			**FM2** talaş kırıcı sağlamdır ve Çeliklerin orta düzeyde işlenmesi için ilk tercihtir. Pozitif eğim açısı ve dengeli, ılımlı T-land özelliğine sahiptir. Dökme demirler ve şartlı olarak Paslanmaz çelikler için de uygundur.																	
DCMT 070204E-FM2:T6310	●	0.4	135	0.12	0.8	95	0.11	0.8	105	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 070204E-FM2:T7325	●	0.4	160	0.12	0.8	120	0.11	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 070204E-FM2:T8430	●	0.4	170	0.12	0.8	90	0.11	0.8	135	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 070204E-FM2:T9325	●	0.4	205	0.12	0.8	120	0.11	0.8	190	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 070204E-FM2:T9415	●	0.4	250	0.12	0.8	–	–	–	235	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T304E-FM2:T6310	●	0.4	135	0.12	0.8	95	0.11	0.8	105	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T304E-FM2:T7325	●	0.4	160	0.12	0.8	120	0.11	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T304E-FM2:T8430	●	0.4	170	0.12	0.8	90	0.11	0.8	135	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T304E-FM2:T9325	●	0.4	205	0.12	0.8	120	0.11	0.8	190	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T304E-FM2:T9335	●	0.4	175	0.12	0.8	105	0.11	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T304E-FM2:T9415	●	0.4	250	0.12	0.8	–	–	–	235	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T308E-FM2:T6310	●●	0.8	150	0.17	0.8	105	0.15	0.8	120	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T308E-FM2:T7325	●●	0.8	170	0.17	0.8	130	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T308E-FM2:T8430	●●	0.8	175	0.17	0.8	95	0.15	0.8	140	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T308E-FM2:T9325	●●	0.8	215	0.17	0.8	125	0.15	0.8	200	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T308E-FM2:T9335	●●	0.8	180	0.17	0.8	105	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T308E-FM2:T9415	●●	0.8	265	0.17	0.8	–	–	–	250	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T312E-FM2:T8430	●●	1.2	155	0.22	1.2	85	0.20	1.2	130	0.22	1.2	–	–	–	–	–	–	–	–	–
DCMT 11T312E-FM2:T9325	●●	1.2	190	0.22	1.2	110	0.20	1.2	180	0.22	1.2	–	–	–	–	–	–	–	–	–
DCMT 150408E-FM2:T9325	●●	0.8	185	0.20	1.5	110	0.18	1.5	175	0.20	1.5	–	–	–	–	–	–	–	–	–
DCMT 150408E-FM2:T9335	●●	0.8	160	0.20	1.5	95	0.18	1.5	–	–	–	–	–	–	–	–	–	–	–	–

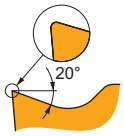
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
FM2 talaş kırıcı sağlamdır ve Çeliklerin orta düzeyde işlenmesi için ilk tercihtir. Pozitif eğim açısı ve dengeli, ılımlı T-land özelliğine sahiptir. Dökme demirler ve şartlı olarak Paslanmaz çelikler için de uygundur.																			
ECMT 060204E-FM2:T7325	0.4	180	0.12	0.8	140	0.11	0.8	–	–	–	–	–	–	–	–	–	–	–	–
ECMT 060204E-FM2:T8430	0.4	205	0.12	0.8	110	0.11	0.8	170	0.12	0.8	–	–	–	–	–	–	–	–	–
ECMT 060204E-FM2:T9325	0.4	255	0.12	0.8	150	0.11	0.8	240	0.12	0.8	–	–	–	–	–	–	–	–	–
ECMT 060204E-FM2:T9335	0.4	220	0.12	0.8	130	0.11	0.8	–	–	–	–	–	–	–	–	–	–	–	–
ECMT 060204E-FM2:T9415	0.4	285	0.12	0.8	–	–	–	270	0.12	0.8	–	–	–	–	–	–	–	–	–
ECMT 080304E-FM2:T5315	0.4	280	0.12	1.0	–	–	–	265	0.12	1.0	–	–	–	–	–	–	–	–	–
ECMT 080304E-FM2:T7325	0.4	170	0.12	1.0	130	0.11	1.0	–	–	–	–	–	–	–	–	–	–	–	–
ECMT 080304E-FM2:T8430	0.4	205	0.12	1.0	110	0.11	1.0	170	0.12	1.0	–	–	–	–	–	–	–	–	–
ECMT 080304E-FM2:T9325	0.4	255	0.12	1.0	150	0.11	1.0	240	0.12	1.0	–	–	–	–	–	–	–	–	–
ECMT 080304E-FM2:T9335	0.4	215	0.12	1.0	125	0.11	1.0	–	–	–	–	–	–	–	–	–	–	–	–
ECMT 080304E-FM2:T9415	0.4	275	0.12	1.0	–	–	–	260	0.12	1.0	–	–	–	–	–	–	–	–	–
ECMT 080308E-FM2:T7325	0.8	185	0.17	1.0	140	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–
ECMT 080308E-FM2:T8430	0.8	210	0.17	1.0	115	0.15	1.0	175	0.17	1.0	–	–	–	–	–	–	–	–	–
ECMT 080308E-FM2:T9325	0.8	260	0.17	1.0	155	0.15	1.0	245	0.17	1.0	–	–	–	–	–	–	–	–	–
ECMT 080308E-FM2:T9335	0.8	225	0.17	1.0	135	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–
ECMT 080308E-FM2:T9415	0.8	290	0.17	1.0	–	–	–	275	0.17	1.0	–	–	–	–	–	–	–	–	–
 																			
FM2 talaş kırıcı sağlamdır ve Çeliklerin orta düzeyde işlenmesi için ilk tercihtir. Pozitif eğim açısı ve dengeli, ılımlı T-land özelliğine sahiptir. Dökme demirler ve şartlı olarak Paslanmaz çelikler için de uygundur.																			
SCMT 09T304E-FM2:T8430	0.4	220	0.12	1.0	120	0.11	1.0	180	0.12	1.0	–	–	–	–	–	–	–	–	–
SCMT 09T304E-FM2:T9325	0.4	265	0.12	1.0	155	0.11	1.0	250	0.12	1.0	–	–	–	–	–	–	–	–	–
SCMT 09T308E-FM2:T8430	0.8	225	0.17	1.0	120	0.15	1.0	185	0.17	1.0	–	–	–	–	–	–	–	–	–
SCMT 09T308E-FM2:T9325	0.8	270	0.17	1.0	160	0.15	1.0	255	0.17	1.0	–	–	–	–	–	–	–	–	–
SCMT 09T308E-FM2:T9415	0.8	340	0.17	1.0	–	–	–	320	0.17	1.0	–	–	–	–	–	–	–	–	–
 																			
FM2 talaş kırıcı sağlamdır ve Çeliklerin orta düzeyde işlenmesi için ilk tercihtir. Pozitif eğim açısı ve dengeli, ılımlı T-land özelliğine sahiptir. Dökme demirler ve şartlı olarak Paslanmaz çelikler için de uygundur.																			
TCMT 110204E-FM2:T8430	0.4	180	0.12	0.8	95	0.11	0.8	145	0.12	0.8	–	–	–	–	–	–	–	–	–
TCMT 110204E-FM2:T9325	0.4	220	0.12	0.8	130	0.11	0.8	205	0.12	0.8	–	–	–	–	–	–	–	–	–
TCMT 110208E-FM2:T8430	0.8	185	0.17	0.8	100	0.15	0.8	150	0.17	0.8	–	–	–	–	–	–	–	–	–
TCMT 110208E-FM2:T9325	0.8	225	0.17	0.8	135	0.15	0.8	210	0.17	0.8	–	–	–	–	–	–	–	–	–
TCMT 16T308E-FM2:T7325	0.8	170	0.20	1.0	130	0.18	1.0	–	–	–	–	–	–	–	–	–	–	–	–
TCMT 16T308E-FM2:T8430	0.8	170	0.20	1.0	90	0.18	1.0	135	0.20	1.0	–	–	–	–	–	–	–	–	–
TCMT 16T308E-FM2:T9325	0.8	205	0.20	1.0	120	0.18	1.0	190	0.20	1.0	–	–	–	–	–	–	–	–	–
TCMT 16T308E-FM2:T9335	0.8	175	0.20	1.0	105	0.18	1.0	–	–	–	–	–	–	–	–	–	–	–	–

Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE	P			M			K			N			S			H		
	(mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)
 		**FM2** talaş kırıcı sağlamdır ve Çeliklerin orta düzeyde işlenmesi için ilk tercihtir. Pozitif eğim açısı ve dengeli, ılımlı T-land özelliğine sahiptir. Dökme demirler ve şartlı olarak Paslanmaz çelikler için de uygundur.																	
VBMT 160404E-FM2:T6310	0.4	120	0.12	1.2	85	0.11	1.2	95	0.12	1.2	–	–	–	–	–	–	–	–	–
VBMT 160404E-FM2:T7325	0.4	140	0.12	1.2	105	0.11	1.2	–	–	–	–	–	–	–	–	–	–	–	–
VBMT 160404E-FM2:T8430	0.4	145	0.12	1.2	80	0.11	1.2	120	0.12	1.2	–	–	–	–	–	–	–	–	–
VBMT 160404E-FM2:T9325	0.4	185	0.12	1.2	110	0.11	1.2	175	0.12	1.2	–	–	–	–	–	–	–	–	–
VBMT 160404E-FM2:T9335	0.4	155	0.12	1.2	90	0.11	1.2	–	–	–	–	–	–	–	–	–	–	–	–
VBMT 160404E-FM2:T9415	0.4	220	0.12	1.2	–	–	–	205	0.12	1.2	–	–	–	–	–	–	–	–	–
VBMT 160408E-FM2:T6310	0.8	125	0.20	1.2	90	0.18	1.2	100	0.20	1.2	–	–	–	–	–	–	–	–	–
VBMT 160408E-FM2:T7325	0.8	145	0.20	1.2	110	0.18	1.2	–	–	–	–	–	–	–	–	–	–	–	–
VBMT 160408E-FM2:T8430	0.8	140	0.20	1.2	75	0.18	1.2	115	0.20	1.2	–	–	–	–	–	–	–	–	–
VBMT 160408E-FM2:T9325	0.8	175	0.20	1.2	105	0.18	1.2	165	0.20	1.2	–	–	–	–	–	–	–	–	–
VBMT 160408E-FM2:T9335	0.8	150	0.20	1.2	90	0.18	1.2	–	–	–	–	–	–	–	–	–	–	–	–
VBMT 160408E-FM2:T9415	0.8	220	0.20	1.2	–	–	–	205	0.20	1.2	–	–	–	–	–	–	–	–	–
VBMT 160412E-FM2:T8430	1.2	145	0.22	1.2	80	0.20	1.2	120	0.22	1.2	–	–	–	–	–	–	–	–	–
VBMT 160412E-FM2:T9315	1.2	195	0.22	1.2	–	–	–	185	0.22	1.2	–	–	–	–	–	–	–	–	–
VBMT 160412E-FM2:T9325	1.2	175	0.22	1.2	105	0.20	1.2	165	0.22	1.2	–	–	–	–	–	–	–	–	–
VBMT 160412E-FM2:T9415	1.2	225	0.22	1.2	–	–	–	210	0.22	1.2	–	–	–	–	–	–	–	–	–
 		**FM2** talaş kırıcı sağlamdır ve Çeliklerin orta düzeyde işlenmesi için ilk tercihtir. Pozitif eğim açısı ve dengeli, ılımlı T-land özelliğine sahiptir. Dökme demirler ve şartlı olarak Paslanmaz çelikler için de uygundur.																	
VCGT 130308E-FM2:T8430	0.8	145	0.17	1.0	80	0.15	1.0	120	0.17	1.0	–	–	–	–	–	–	–	–	–
VCGT 130308E-FM2:T9325	0.8	180	0.17	1.0	105	0.15	1.0	170	0.17	1.0	–	–	–	–	–	–	–	–	–

SI



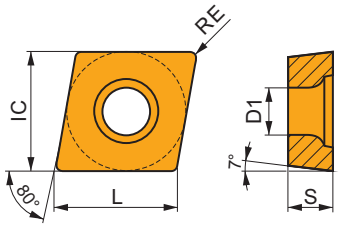


SI talaş kırıcı keskin ve Paslanmaz çeliklerin orta düzeyde işlenmesi için ilk tercihtir. T-land olmadan son derece pozitif eğim açısına sahiptir. Çelikler ve Süper alaşımlar için ve şartlı olarak Dökme demirler için de uygundur.

PRAMET

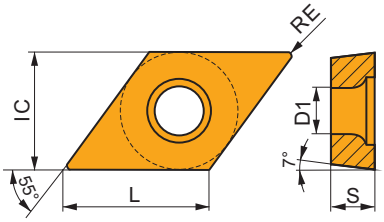
CCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0602	6.350	2.80	6.40	2.38
09T3	9.525	4.40	9.70	3.97
1204	12.700	5.50	12.90	4.76



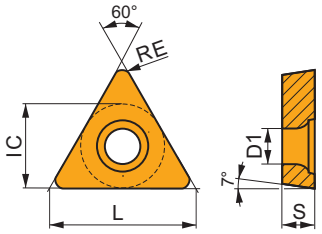
DCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
11T3	9.525	4.40	11.60	3.97

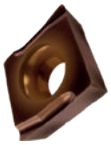
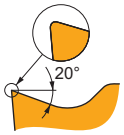
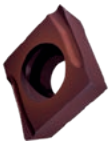
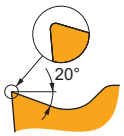


TCGT

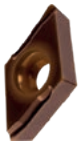
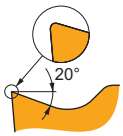
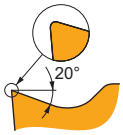
	IC (mm)	D1 (mm)	L (mm)	S (mm)
1102	6.350	2.80	11.00	2.38



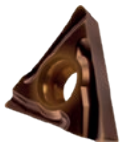
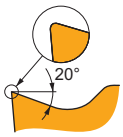
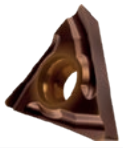
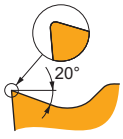
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
  																			
SI talaş kırıcı keskin ve Paslanmaz çeliklerin orta düzeyde işlenmesi için ilk tercihtir. T-land olmadan son derece pozitif eğim açısına sahiptir. Çelikler ve Süper alaşımlar için ve şartlı olarak Dökme demirler için de uygundur.																			
CCGT 060202ER-SI:T8430	0.2	260	0.10	0.8	140	0.09	0.8	215	0.10	0.8	–	–	–	55	0.08	0.6	–	–	–
CCGT 060204ER-SI:T8315	0.4	225	0.12	0.8	135	0.11	0.8	210	0.12	0.8	–	–	–	55	0.10	0.6	–	–	–
CCGT 060204ER-SI:T8430	0.4	260	0.12	0.8	140	0.11	0.8	215	0.12	0.8	–	–	–	55	0.10	0.6	–	–	–
CCGT 09T304ER-SI:T8315	0.4	205	0.17	0.8	120	0.15	0.8	190	0.17	0.8	–	–	–	50	0.15	0.6	–	–	–
CCGT 09T304ER-SI:T8430	0.4	230	0.17	0.8	125	0.15	0.8	185	0.17	0.8	–	–	–	45	0.15	0.6	–	–	–
CCGT 120408ER-SI:T8430	0.8	230	0.24	1.0	125	0.22	1.0	185	0.24	1.0	–	–	–	45	0.22	0.8	–	–	–
  																			
SI talaş kırıcı keskin ve Paslanmaz çeliklerin orta düzeyde işlenmesi için ilk tercihtir. T-land olmadan son derece pozitif eğim açısına sahiptir. Çelikler ve Süper alaşımlar için ve şartlı olarak Dökme demirler için de uygundur.																			
CCGT 060202EL-SI:T8430	0.2	260	0.10	0.8	140	0.09	0.8	215	0.10	0.8	–	–	–	55	0.08	0.6	–	–	–
CCGT 060204EL-SI:T8315	0.4	225	0.12	0.8	135	0.11	0.8	210	0.12	0.8	–	–	–	55	0.10	0.6	–	–	–
CCGT 060204EL-SI:T8415	0.4	275	0.12	0.8	140	0.11	0.8	250	0.12	0.8	–	–	–	60	0.10	0.6	–	–	–
CCGT 060204EL-SI:T8430	0.4	260	0.12	0.8	140	0.11	0.8	215	0.12	0.8	–	–	–	55	0.10	0.6	–	–	–
CCGT 09T304EL-SI:T8315	0.4	205	0.17	0.8	120	0.15	0.8	190	0.17	0.8	–	–	–	50	0.15	0.6	–	–	–
CCGT 09T304EL-SI:T8415	0.4	250	0.17	0.8	130	0.15	0.8	225	0.17	0.8	–	–	–	55	0.15	0.6	–	–	–
CCGT 09T304EL-SI:T8430	0.4	230	0.17	0.8	125	0.15	0.8	185	0.17	0.8	–	–	–	45	0.15	0.6	–	–	–
CCGT 120408EL-SI:T8430	0.8	230	0.24	1.0	125	0.22	1.0	185	0.24	1.0	–	–	–	45	0.22	0.8	–	–	–

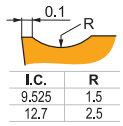
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
																				
SI talaş kırıcı keskin ve Paslanmaz çeliklerin orta düzeyde işlenmesi için ilk tercihtir. T-land olmadan son derece pozitif eğim açısına sahiptir. Çelikler ve Süper alaşımlar için ve şartlı olarak Dökme demirler için de uygundur.																				
DCGT 11T304ER-SI:T8430	●	0.4	205	0.12	0.8	110	0.11	0.8	170	0.12	0.8	–	–	–	45	0.10	0.6	–	–	–
DCGT 11T308ER-SI:T8430	●	0.8	190	0.22	1.0	105	0.20	1.0	155	0.22	1.0	–	–	–	40	0.18	0.8	–	–	–
																				
SI talaş kırıcı keskin ve Paslanmaz çeliklerin orta düzeyde işlenmesi için ilk tercihtir. T-land olmadan son derece pozitif eğim açısına sahiptir. Çelikler ve Süper alaşımlar için ve şartlı olarak Dökme demirler için de uygundur.																				
DCGT 11T304EL-SI:T8430	●	0.4	205	0.12	0.8	110	0.11	0.8	170	0.12	0.8	–	–	–	45	0.10	0.6	–	–	–
DCGT 11T308EL-SI:T8430	●	0.8	190	0.22	1.0	105	0.20	1.0	155	0.22	1.0	–	–	–	40	0.18	0.8	–	–	–

Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	Interrupted/ Continuous cut	RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
																				
SI talaş kırıcı keskin ve Paslanmaz çeliklerin orta düzeyde işlenmesi için ilk tercihtir. T-land olmadan son derece pozitif eğim açısına sahiptir. Çelikler ve Süper alaşımlar için ve şartlı olarak Dökme demirler için de uygundur.																				
TCGT 110202ER-SI:T8315	●	0.2	190	0.10	0.8	110	0.09	0.8	180	0.10	0.8	–	–	–	45	0.08	0.6	–	–	–
TCGT 110202ER-SI:T8430	●	0.2	225	0.10	0.8	120	0.09	0.8	185	0.10	0.8	–	–	–	45	0.08	0.6	–	–	–
TCGT 110204ER-SI:T8430	●	0.4	225	0.12	0.8	120	0.11	0.8	185	0.12	0.8	–	–	–	45	0.10	0.6	–	–	–
																				
SI talaş kırıcı keskin ve Paslanmaz çeliklerin orta düzeyde işlenmesi için ilk tercihtir. T-land olmadan son derece pozitif eğim açısına sahiptir. Çelikler ve Süper alaşımlar için ve şartlı olarak Dökme demirler için de uygundur.																				
TCGT 110202EL-SI:T8315	●	0.2	190	0.10	0.8	110	0.09	0.8	180	0.10	0.8	–	–	–	45	0.08	0.6	–	–	–
TCGT 110202EL-SI:T8415	●	0.2	230	0.10	0.8	120	0.09	0.8	210	0.10	0.8	–	–	–	50	0.08	0.6	–	–	–
TCGT 110202EL-SI:T8430	●	0.2	225	0.10	0.8	120	0.09	0.8	185	0.10	0.8	–	–	–	45	0.08	0.6	–	–	–
TCGT 110204EL-SI:T8315	●	0.4	195	0.12	0.8	115	0.11	0.8	185	0.12	0.8	–	–	–	45	0.10	0.6	–	–	–
TCGT 110204EL-SI:T8415	●	0.4	230	0.12	0.8	120	0.11	0.8	210	0.12	0.8	–	–	–	50	0.10	0.6	–	–	–
TCGT 110204EL-SI:T8430	●	0.4	225	0.12	0.8	120	0.11	0.8	185	0.12	0.8	–	–	–	45	0.10	0.6	–	–	–

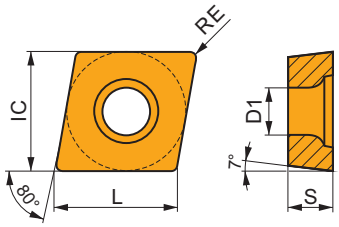
RF



RF talaş kırıcı sağlamdır ve Dökme demirlerin orta düzeyde işlenmesi için ilk tercihtir. Hafif pozitif eğim açısı ve dengeli, ılımlı T-land özelliğine sahiptir. Çelikler için ve şartlı olarak Paslanmaz çelikler ve Sert malzemeler için de uygundur.

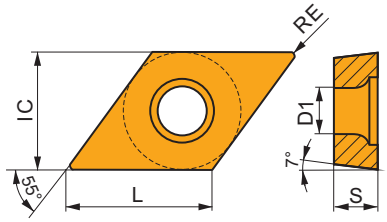
CCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0602	6.350	2.80	6.40	2.38
09T3	9.525	4.40	9.70	3.97
1204	12.700	5.50	12.90	4.76



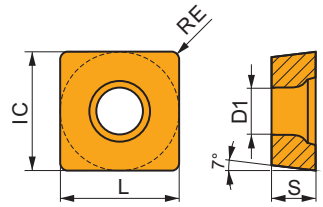
DCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
11T3	9.525	4.40	11.60	3.97



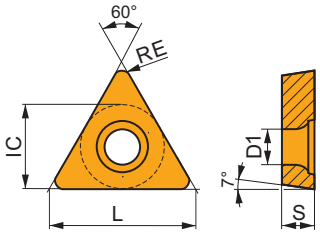
SCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
09T3	9.525	4.40	9.53	3.97
1204	12.700	5.50	12.70	4.76



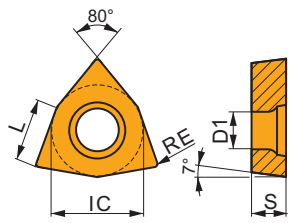
TCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
16T3	9.525	4.40	16.50	3.97

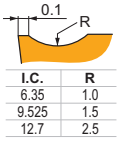
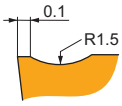
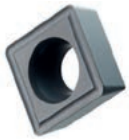
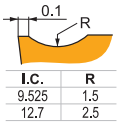
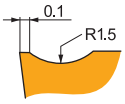
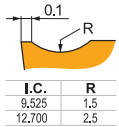


WCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
06T3	9.525	4.40	6.50	3.97
0804	12.700	5.50	8.70	4.76



Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
  I.C. / R: 6.35 / 1.0; 9.525 / 1.5; 12.7 / 2.5																			
RF talaş kırıcı sağlamdır ve Dökme demirlerin orta düzeyde işlenmesi için ilk tercihtir. Hafif pozitif eğim açısı ve dengeli, ılımlı T-land özelliğine sahiptir. Çelikler için ve şartlı olarak Paslanmaz çelikler ve Sert malzemeler için de uygundur.																			
CCMT 060202E-RF:T7335	0.2	◪ 150	0.15	1.0	◪ 115	0.14	1.0	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 060204E-RF:T5315	0.4	◪ 235	0.15	1.0	–	–	–	■ 220	0.15	1.0	–	–	–	–	–	–	◪ 45	0.11	0.3
CCMT 060204E-RF:T7335	0.4	◪ 160	0.15	1.0	◪ 120	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 060204E-RF:T9325	0.4	■ 205	0.15	1.0	◪ 120	0.15	1.0	◪ 190	0.15	1.0	–	–	–	–	–	–	–	–	–
CCMT 09T304E-RF:T7335	0.4	◪ 135	0.20	1.5	◪ 105	0.18	1.5	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 09T304E-RF:T9325	0.4	■ 175	0.20	1.5	◪ 105	0.18	1.5	◪ 165	0.20	1.5	–	–	–	–	–	–	–	–	–
CCMT 09T308E-RF:T5315	0.8	◪ 245	0.20	1.5	–	–	–	■ 230	0.20	1.5	–	–	–	–	–	–	◪ 45	0.14	0.7
CCMT 09T308E-RF:T7335	0.8	◪ 165	0.20	1.5	◪ 125	0.18	1.5	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 09T308E-RF:T9325	0.8	■ 210	0.20	1.5	◪ 125	0.18	1.5	◪ 195	0.20	1.5	–	–	–	–	–	–	–	–	–
CCMT 120408E-RF:T5315	0.8	◪ 230	0.22	2.2	–	–	–	■ 215	0.22	2.2	–	–	–	–	–	–	◪ 45	0.13	0.7
CCMT 120408E-RF:T7335	0.8	◪ 150	0.22	2.2	◪ 115	0.22	2.2	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 120408E-RF:T9325	0.8	■ 195	0.22	2.2	◪ 115	0.22	2.2	◪ 185	0.22	2.2	–	–	–	–	–	–	–	–	–
 																			
RF talaş kırıcı sağlamdır ve Dökme demirlerin orta düzeyde işlenmesi için ilk tercihtir. Hafif pozitif eğim açısı ve dengeli, ılımlı T-land özelliğine sahiptir. Çelikler için ve şartlı olarak Paslanmaz çelikler ve Sert malzemeler için de uygundur.																			
DCMT 11T304E-RF:T5315	0.4	◪ 175	0.20	0.8	–	–	–	■ 165	0.20	0.8	–	–	–	–	–	–	◪ 35	0.14	0.3
DCMT 11T304E-RF:T7335	0.4	◪ 115	0.20	0.8	◪ 85	0.18	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T304E-RF:T9325	0.4	■ 150	0.20	0.8	◪ 90	0.18	0.8	◪ 140	0.20	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T308E-RF:T5315	0.8	◪ 205	0.20	0.8	–	–	–	■ 190	0.20	0.8	–	–	–	–	–	–	◪ 40	0.10	0.7
DCMT 11T308E-RF:T7335	0.8	◪ 140	0.20	0.8	◪ 105	0.18	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T308E-RF:T9325	0.8	■ 175	0.20	0.8	◪ 105	0.18	0.8	◪ 165	0.20	0.8	–	–	–	–	–	–	–	–	–
  I.C. / R: 9.525 / 1.5; 12.7 / 2.5																			
RF talaş kırıcı sağlamdır ve Dökme demirlerin orta düzeyde işlenmesi için ilk tercihtir. Hafif pozitif eğim açısı ve dengeli, ılımlı T-land özelliğine sahiptir. Çelikler için ve şartlı olarak Paslanmaz çelikler ve Sert malzemeler için de uygundur.																			
SCMT 09T308E-RF:T5315	0.8	◪ 255	0.20	1.5	–	–	–	■ 240	0.20	1.5	–	–	–	–	–	–	◪ 50	0.10	0.7
SCMT 09T308E-RF:T9325	0.8	■ 220	0.20	1.5	◪ 130	0.18	1.5	◪ 205	0.20	1.5	–	–	–	–	–	–	–	–	–
SCMT 120408E-RF:T5315	0.8	◪ 240	0.22	2.2	–	–	–	■ 225	0.22	2.2	–	–	–	–	–	–	◪ 45	0.13	0.7
SCMT 120408E-RF:T7335	0.8	◪ 160	0.22	2.2	◪ 120	0.22	2.2	–	–	–	–	–	–	–	–	–	–	–	–
SCMT 120408E-RF:T9325	0.8	■ 205	0.22	2.2	◪ 120	0.22	2.2	◪ 190	0.22	2.2	–	–	–	–	–	–	–	–	–
 																			
RF talaş kırıcı sağlamdır ve Dökme demirlerin orta düzeyde işlenmesi için ilk tercihtir. Hafif pozitif eğim açısı ve dengeli, ılımlı T-land özelliğine sahiptir. Çelikler için ve şartlı olarak Paslanmaz çelikler ve Sert malzemeler için de uygundur.																			
TCMT 16T308E-RF:T9325	0.8	■ 175	0.20	1.5	◪ 105	0.18	1.5	◪ 165	0.20	1.5	–	–	–	–	–	–	–	–	–
  I.C. / R: 9.525 / 1.5; 12.700 / 2.5																			
RF talaş kırıcı sağlamdır ve Dökme demirlerin orta düzeyde işlenmesi için ilk tercihtir. Hafif pozitif eğim açısı ve dengeli, ılımlı T-land özelliğine sahiptir. Çelikler için ve şartlı olarak Paslanmaz çelikler ve Sert malzemeler için de uygundur.																			
WCMT 06T308E-RF:T7335	0.8	◪ 165	0.20	1.5	◪ 125	0.18	1.5	–	–	–	–	–	–	–	–	–	–	–	–
WCMT 080412E-RF:T7335	1.2	◪ 160	0.22	2.2	◪ 120	0.22	2.2	–	–	–	–	–	–	–	–	–	–	–	–

.CMW



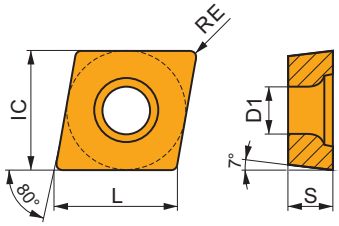


.CMW düz kesici uç, dökme demirlerin orta düzeyde işlenmesi için tasarlanmıştır. T-land olmadan nötr eğim açısına sahiptir. Sert malzemeler için de şartlara bağlı olarak uygundur.

PRAMET

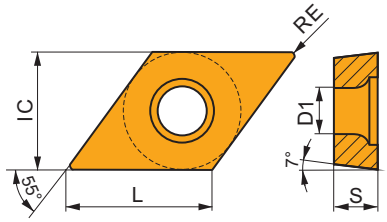
CCMW

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0602	6.350	2.80	6.40	2.38
09T3	9.525	4.40	9.70	3.97
1204	12.700	5.50	12.90	4.76



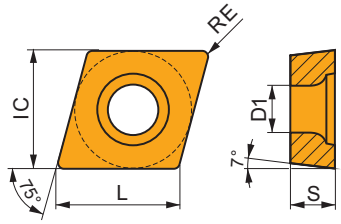
DCMW

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0702	6.350	2.80	7.80	2.38
11T3	9.525	4.40	11.60	3.97



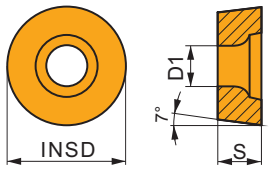
ECMW

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0602	6.350	2.80	6.50	2.38
0803	7.940	3.40	8.20	3.18



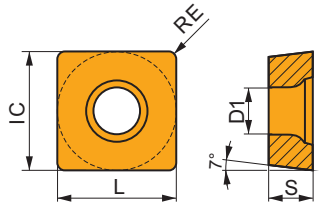
RCMW

	INSD (mm)	D1 (mm)	S (mm)
0602	6.000	2.80	2.38
0803	8.000	3.40	3.18
10T3	10.000	4.40	3.97
1204	12.000	4.40	4.76



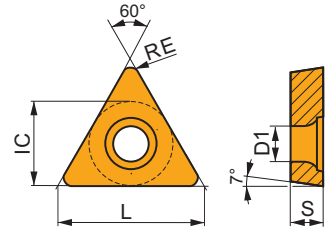
SCMW

	IC (mm)	D1 (mm)	L (mm)	S (mm)
09T3	9.525	4.40	9.53	3.97
1204	12.700	5.50	12.70	4.76



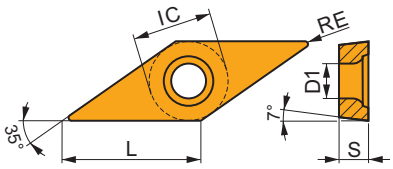
TCMW

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1102	6.350	2.80	11.00	2.38
16T3	9.525	4.40	16.50	3.97



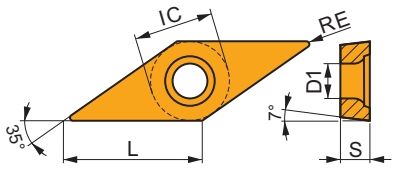
VCGW

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1303	7.940	3.40	13.80	3.18

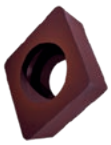
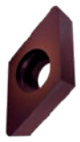


VCMW

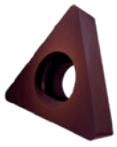
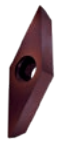
	IC (mm)	D1 (mm)	L (mm)	S (mm)
1103	6.350	2.80	11.10	3.18
1604	9.525	4.40	16.60	4.76



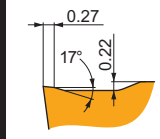
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P			M			K			N			S			H		
			vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)
																				
.CMW düz kesici uç, dökme demirlerin orta düzeyde işlenmesi için tasarlanmıştır. T-land olmadan nötr eğim açısına sahiptir. Sert malzemeler için de şartlara bağlı olarak uygundur.																				
CCMW 060202:T5305	●	0.2	–	–	–	–	–	–	230	0.08	2.0	–	–	–	–	–	–	45	0.08	0.2
CCMW 060204:T5305	●	0.4	–	–	–	–	–	–	230	0.10	2.0	–	–	–	–	–	–	45	0.10	0.3
CCMW 060204:T5315	●	0.4	–	–	–	–	–	–	195	0.10	2.0	–	–	–	–	–	–	40	0.10	0.3
CCMW 060204:T6310	●	0.4	–	–	–	–	–	–	95	0.10	2.0	–	–	–	–	–	–	20	0.10	0.3
CCMW 060204:T8415	●	0.4	–	–	–	–	–	–	145	0.10	2.0	–	–	–	–	–	–	25	0.10	0.3
CCMW 09T304:T5305	●	0.4	–	–	–	–	–	–	215	0.10	3.0	–	–	–	–	–	–	45	0.10	0.3
CCMW 09T304:T5315	●	0.4	–	–	–	–	–	–	190	0.10	3.0	–	–	–	–	–	–	40	0.10	0.3
CCMW 09T304:T6310	●	0.4	–	–	–	–	–	–	95	0.10	3.0	–	–	–	–	–	–	20	0.10	0.3
CCMW 09T304:T8415	●	0.4	–	–	–	–	–	–	135	0.10	3.0	–	–	–	–	–	–	25	0.10	0.3
CCMW 09T308:T5305	●	0.8	–	–	–	–	–	–	200	0.20	3.0	–	–	–	–	–	–	40	0.11	0.7
CCMW 09T308:T5315	⬢	0.8	–	–	–	–	–	–	180	0.20	3.0	–	–	–	–	–	–	35	0.11	0.7
CCMW 09T308:T6310	⬢	0.8	–	–	–	–	–	–	90	0.20	3.0	–	–	–	–	–	–	20	0.11	0.7
CCMW 09T308:T8415	⬢	0.8	–	–	–	–	–	–	135	0.20	3.0	–	–	–	–	–	–	25	0.11	0.7
CCMW 120404:T5305	●	0.4	–	–	–	–	–	–	210	0.10	4.0	–	–	–	–	–	–	45	0.10	0.3
CCMW 120404:T5315	●	0.4	–	–	–	–	–	–	185	0.10	4.0	–	–	–	–	–	–	35	0.10	0.3
CCMW 120408:T5305	●	0.8	–	–	–	–	–	–	195	0.20	4.0	–	–	–	–	–	–	40	0.11	0.7
CCMW 120408:T5315	⬢	0.8	–	–	–	–	–	–	175	0.20	4.0	–	–	–	–	–	–	35	0.11	0.7
																				
.CMW düz kesici uç, dökme demirlerin orta düzeyde işlenmesi için tasarlanmıştır. T-land olmadan nötr eğim açısına sahiptir. Sert malzemeler için de şartlara bağlı olarak uygundur.																				
DCMW 070202:T5305	●	0.2	–	–	–	–	–	–	200	0.08	0.8	–	–	–	–	–	–	40	0.08	0.2
DCMW 070204:T5305	●	0.4	–	–	–	–	–	–	195	0.10	0.8	–	–	–	–	–	–	40	0.10	0.3
DCMW 070204:T6310	●	0.4	–	–	–	–	–	–	85	0.10	0.8	–	–	–	–	–	–	20	0.10	0.3
DCMW 070204:T8415	●	0.4	–	–	–	–	–	–	125	0.10	0.8	–	–	–	–	–	–	20	0.10	0.3
DCMW 11T304:T5305	●	0.4	–	–	–	–	–	–	190	0.10	1.2	–	–	–	–	–	–	40	0.10	0.3
DCMW 11T304:T5315	●	0.4	–	–	–	–	–	–	165	0.10	1.2	–	–	–	–	–	–	35	0.10	0.3
DCMW 11T304:T6310	●	0.4	–	–	–	–	–	–	80	0.10	1.2	–	–	–	–	–	–	20	0.10	0.3
DCMW 11T304:T8415	●	0.4	–	–	–	–	–	–	120	0.10	1.2	–	–	–	–	–	–	20	0.10	0.3
DCMW 11T308:T5305	●	0.8	–	–	–	–	–	–	185	0.18	1.2	–	–	–	–	–	–	35	0.11	0.7
DCMW 11T308:T5315	●	0.8	–	–	–	–	–	–	160	0.18	1.2	–	–	–	–	–	–	30	0.11	0.7
DCMW 11T308:T6310	●	0.8	–	–	–	–	–	–	80	0.18	1.2	–	–	–	–	–	–	20	0.11	0.7
DCMW 11T308:T8415	●	0.8	–	–	–	–	–	–	125	0.18	1.2	–	–	–	–	–	–	20	0.11	0.7
																				
.CMW düz kesici uç, dökme demirlerin orta düzeyde işlenmesi için tasarlanmıştır. T-land olmadan nötr eğim açısına sahiptir. Sert malzemeler için de şartlara bağlı olarak uygundur.																				
ECMW 060204:H07	●	0.4	–	–	–	–	–	–	100	0.10	2.0	–	–	–	–	–	–	–	–	–
ECMW 080304:H07	●	0.4	–	–	–	–	–	–	100	0.10	2.5	–	–	–	–	–	–	–	–	–
																				
.CMW düz kesici uç, dökme demirlerin orta düzeyde işlenmesi için tasarlanmıştır. T-land olmadan nötr eğim açısına sahiptir. Sert malzemeler için de şartlara bağlı olarak uygundur.																				
RCMW 0602MO:T5305	⬢	–	–	–	–	–	–	–	280	0.25	0.6	–	–	–	–	–	–	55	0.17	0.4
RCMW 0602MO:T5315	⬢	–	–	–	–	–	–	–	250	0.25	0.6	–	–	–	–	–	–	50	0.17	0.4
RCMW 0803MO:T5305	⬢	–	–	–	–	–	–	–	255	0.30	0.8	–	–	–	–	–	–	50	0.17	0.5
RCMW 0803MO:T5315	⬢	–	–	–	–	–	–	–	230	0.30	0.8	–	–	–	–	–	–	45	0.17	0.5
RCMW 10T3MO:T5305	⬢	–	–	–	–	–	–	–	225	0.40	1.0	–	–	–	–	–	–	45	0.20	0.7
RCMW 10T3MO:T5315	⬢	–	–	–	–	–	–	–	200	0.40	1.0	–	–	–	–	–	–	40	0.20	0.7
RCMW 1204MO:T5305	⬢	–	–	–	–	–	–	–	205	0.45	1.2	–	–	–	–	–	–	40	0.20	0.8

Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

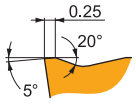
Product		RE	P			M			K			N			S			H		
		(mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)
																				
.CMW düz kesici uç, dökme demirlerin orta düzeyde işlenmesi için tasarlanmıştır. T-land olmadan nötr eğim açısına sahiptir. Sert malzemeler için de şartlara bağlı olarak uygundur.																				
SCMW 09T304:T5305	●	0.4	–	–	–	–	–	–	240	0.10	2.0	–	–	–	–	–	–	50	0.10	0.3
SCMW 09T304:T5315	●	0.4	–	–	–	–	–	–	205	0.10	2.0	–	–	–	–	–	–	40	0.10	0.3
SCMW 09T308:T5305	●	0.8	–	–	–	–	–	–	220	0.20	2.0	–	–	–	–	–	–	45	0.11	0.7
SCMW 09T308:T5315	❋	0.8	–	–	–	–	–	–	190	0.20	2.0	–	–	–	–	–	–	40	0.11	0.7
SCMW 120408:T5305	●	0.8	–	–	–	–	–	–	205	0.20	4.0	–	–	–	–	–	–	40	0.11	0.7
SCMW 120408:T5315	❋	0.8	–	–	–	–	–	–	185	0.20	4.0	–	–	–	–	–	–	35	0.11	0.7
																				
.CMW düz kesici uç, dökme demirlerin orta düzeyde işlenmesi için tasarlanmıştır. T-land olmadan nötr eğim açısına sahiptir. Sert malzemeler için de şartlara bağlı olarak uygundur.																				
TCMW 110204:T5305	●	0.4	–	–	–	–	–	–	200	0.10	1.2	–	–	–	–	–	–	40	0.10	0.3
TCMW 110204:T5315	●	0.4	–	–	–	–	–	–	180	0.10	1.2	–	–	–	–	–	–	35	0.10	0.3
TCMW 16T304:T5305	●	0.4	–	–	–	–	–	–	195	0.10	1.5	–	–	–	–	–	–	40	0.10	0.3
TCMW 16T304:T5315	●	0.4	–	–	–	–	–	–	175	0.10	1.5	–	–	–	–	–	–	35	0.10	0.3
TCMW 16T308:T5305	●	0.8	–	–	–	–	–	–	190	0.18	1.5	–	–	–	–	–	–	40	0.11	0.7
TCMW 16T308:T5315	●	0.8	–	–	–	–	–	–	165	0.18	1.5	–	–	–	–	–	–	35	0.11	0.7
TCMW 16T308:T6310	●	0.8	–	–	–	–	–	–	85	0.18	1.5	–	–	–	–	–	–	20	0.11	0.7
TCMW 16T308:T8415	❋	0.8	–	–	–	–	–	–	125	0.18	1.5	–	–	–	–	–	–	20	0.11	0.7
																				
.CMW düz kesici uç, dökme demirlerin orta düzeyde işlenmesi için tasarlanmıştır. T-land olmadan nötr eğim açısına sahiptir. Sert malzemeler için de şartlara bağlı olarak uygundur.																				
VCGW 130302:T5305	●	0.2	–	–	–	–	–	–	170	0.08	1.3	–	–	–	–	–	–	35	0.08	0.2
VCGW 130304:T5305	●	0.4	–	–	–	–	–	–	165	0.10	1.3	–	–	–	–	–	–	35	0.10	0.3
																				
.CMW düz kesici uç, dökme demirlerin orta düzeyde işlenmesi için tasarlanmıştır. T-land olmadan nötr eğim açısına sahiptir. Sert malzemeler için de şartlara bağlı olarak uygundur.																				
VCMW 110302:T5305	●	0.2	–	–	–	–	–	–	170	0.08	1.2	–	–	–	–	–	–	35	0.08	0.2
VCMW 110304:T5305	●	0.4	–	–	–	–	–	–	165	0.10	1.2	–	–	–	–	–	–	35	0.10	0.3
VCMW 110304:T6310	●	0.4	–	–	–	–	–	–	70	0.10	1.2	–	–	–	–	–	–	15	0.10	0.3
VCMW 110304:T8415	●	0.4	–	–	–	–	–	–	105	0.10	1.2	–	–	–	–	–	–	20	0.10	0.3
VCMW 160404:T5305	●	0.4	–	–	–	–	–	–	165	0.10	1.5	–	–	–	–	–	–	35	0.10	0.3
VCMW 160404:T6310	●	0.4	–	–	–	–	–	–	70	0.10	1.5	–	–	–	–	–	–	15	0.10	0.3
VCMW 160404:T8415	●	0.4	–	–	–	–	–	–	100	0.10	1.5	–	–	–	–	–	–	15	0.10	0.3
VCMW 160408:T5305	●	0.8	–	–	–	–	–	–	155	0.18	1.5	–	–	–	–	–	–	30	0.11	0.7
VCMW 160408:T5315	●	0.8	–	–	–	–	–	–	135	0.18	1.5	–	–	–	–	–	–	25	0.11	0.7
VCMW 160408:T6310	●	0.8	–	–	–	–	–	–	70	0.18	1.5	–	–	–	–	–	–	15	0.11	0.7
VCMW 160408:T8415	●	0.8	–	–	–	–	–	–	100	0.18	1.5	–	–	–	–	–	–	15	0.11	0.7

RM



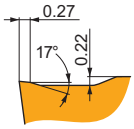
RM talaş kırıcı sağlamdır ve Çeliklerin ve Dökme demirlerin kaba işlenmesi için ilk tercihtir. Pozitif eğim açısı ve dengeli, geniş T-land özelliğine sahiptir. Paslanmaz çelikler ve şartlı olarak Süper alaşımlar ve Sert malzemeler için de uygundur.

RM3



RM3 talaş kırıcı sağlamdır ve çeliklerin ve dökme demirlerin kaba işlenmesi için tasarlanmıştır. Pozitif eğim açısı ve negatif, geniş T-land özelliğine sahiptir. Paslanmaz çelikler ve sert malzemeler için de şartlara bağlı olarak uygundur.

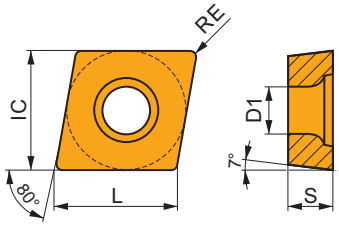
RM



RM talaş kırıcı sağlamdır ve Çeliklerin ve Dökme demirlerin kaba işlenmesi için ilk tercihtir. Pozitif eğim açısı ve dengeli, geniş T-land özelliğine sahiptir. Paslanmaz çelikler ve şartlı olarak Süper alaşımlar ve Sert malzemeler için de uygundur.

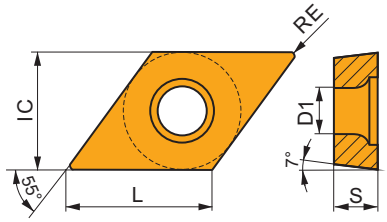
CCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
09T3	9.525	4.40	9.70	3.97
1204	12.700	5.50	12.90	4.76



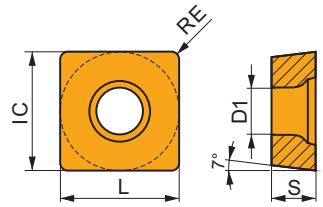
DCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
11T3	9.525	4.40	11.60	3.97
1504	12.700	5.50	15.50	4.76



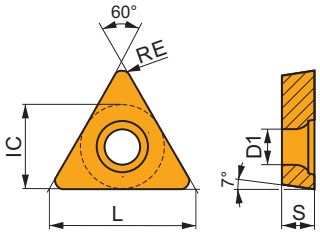
SCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
09T3	9.525	4.40	9.53	3.97
1204	12.700	5.50	12.70	4.76



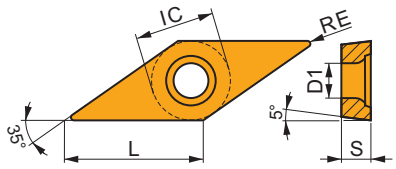
TCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
16T3	9.525	4.40	16.50	3.97

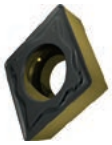
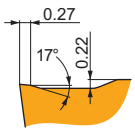
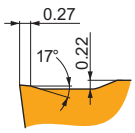


VBMT

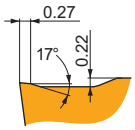
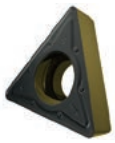
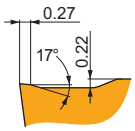
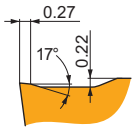
	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	4.40	16.60	4.76



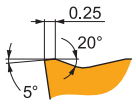
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
			**RM** talaş kırıcı sağlamdır ve Çeliklerin ve Dökme demirlerin kaba işlenmesi için ilk tercihtir. Pozitif eğim açısı ve dengeli, geniş T-land özelliğine sahiptir. Paslanmaz çelikler ve şartlı olarak Süper alaşımlar ve Sert malzemeler için de uygundur.																	
CCMT 09T304E-RM:T5305	●	0.4	260	0.25	2.2	–	–	–	245	0.25	2.2	–	–	–	–	–	–	50	0.18	0.3
CCMT 09T304E-RM:T5315	●	0.4	235	0.25	2.2	–	–	–	220	0.25	2.2	–	–	–	–	–	–	45	0.18	0.3
CCMT 09T304E-RM:T7335	●	0.4	160	0.25	2.2	120	0.23	2.2	–	–	–	–	–	–	50	0.18	1.8	–	–	–
CCMT 09T304E-RM:T8430	●	0.4	155	0.25	2.2	85	0.23	2.2	130	0.25	2.2	–	–	–	30	0.18	1.8	25	0.18	0.3
CCMT 09T304E-RM:T9325	●	0.4	195	0.25	2.2	115	0.23	2.2	185	0.25	2.2	–	–	–	40	0.18	1.8	–	–	–
CCMT 09T304E-RM:T9415	●	0.4	255	0.25	2.2	–	–	–	240	0.25	2.2	–	–	–	–	–	–	50	0.18	0.3
CCMT 09T308E-RM:T5305	●	0.8	290	0.30	2.2	–	–	–	275	0.30	2.2	–	–	–	–	–	–	55	0.15	0.7
CCMT 09T308E-RM:T5315	●	0.8	265	0.30	2.2	–	–	–	250	0.30	2.2	–	–	–	–	–	–	50	0.15	0.7
CCMT 09T308E-RM:T7335	●	0.8	175	0.30	2.2	135	0.27	2.2	–	–	–	–	–	–	55	0.24	1.8	–	–	–
CCMT 09T308E-RM:T8430	●	0.8	180	0.30	2.2	95	0.27	2.2	145	0.30	2.2	–	–	–	35	0.24	1.8	30	0.15	0.7
CCMT 09T308E-RM:T9325	●	0.8	215	0.30	2.2	125	0.27	2.2	200	0.30	2.2	–	–	–	45	0.24	1.8	–	–	–
CCMT 09T308E-RM:T9415	●	0.8	285	0.30	2.2	–	–	–	270	0.30	2.2	–	–	–	–	–	–	55	0.15	0.7
CCMT 120408E-RM:T5305	●	0.8	290	0.30	2.7	–	–	–	275	0.30	2.7	–	–	–	–	–	–	55	0.15	0.7
CCMT 120408E-RM:T5315	●	0.8	260	0.30	2.7	–	–	–	245	0.30	2.7	–	–	–	–	–	–	50	0.15	0.7
CCMT 120408E-RM:T7335	●	0.8	175	0.30	2.7	135	0.27	2.7	–	–	–	–	–	–	55	0.24	2.2	–	–	–
CCMT 120408E-RM:T8430	●	0.8	175	0.30	2.7	95	0.27	2.7	140	0.30	2.7	–	–	–	35	0.24	2.2	30	0.15	0.7
CCMT 120408E-RM:T9325	●	0.8	210	0.30	2.7	125	0.27	2.7	195	0.30	2.7	–	–	–	45	0.24	2.2	–	–	–
CCMT 120408E-RM:T9415	●	0.8	280	0.30	2.7	–	–	–	265	0.30	2.7	–	–	–	–	–	–	55	0.15	0.7
CCMT 120412E-RM:T8430	●	1.2	180	0.33	2.7	95	0.30	2.7	145	0.33	2.7	–	–	–	35	0.23	2.2	30	0.17	1.0
CCMT 120412E-RM:T9325	●	1.2	215	0.33	2.7	125	0.30	2.7	200	0.33	2.7	–	–	–	45	0.23	2.2	–	–	–
CCMT 120412E-RM:T9415	●	1.2	280	0.33	2.7	–	–	–	265	0.33	2.7	–	–	–	–	–	–	55	0.17	1.0
			**RM** talaş kırıcı sağlamdır ve Çeliklerin ve Dökme demirlerin kaba işlenmesi için ilk tercihtir. Pozitif eğim açısı ve dengeli, geniş T-land özelliğine sahiptir. Paslanmaz çelikler ve şartlı olarak Süper alaşımlar ve Sert malzemeler için de uygundur.																	
DCMT 11T304E-RM:T5305	●	0.4	250	0.20	1.0	–	–	–	235	0.20	1.0	–	–	–	–	–	–	50	0.14	0.3
DCMT 11T304E-RM:T5315	●	0.4	220	0.20	1.0	–	–	–	205	0.20	1.0	–	–	–	–	–	–	40	0.14	0.3
DCMT 11T304E-RM:T7335	●	0.4	145	0.20	1.0	110	0.18	1.0	–	–	–	–	–	–	45	0.14	0.8	–	–	–
DCMT 11T304E-RM:T8430	●	0.4	150	0.20	1.0	80	0.18	1.0	125	0.20	1.0	–	–	–	30	0.14	0.8	25	0.14	0.3
DCMT 11T304E-RM:T9325	●	0.4	185	0.20	1.0	110	0.18	1.0	175	0.20	1.0	–	–	–	40	0.14	0.8	–	–	–
DCMT 11T304E-RM:T9415	●	0.4	235	0.20	1.0	–	–	–	220	0.20	1.0	–	–	–	–	–	–	45	0.14	0.3
DCMT 11T308E-RM:T5305	●	0.8	270	0.27	0.8	–	–	–	255	0.27	0.8	–	–	–	–	–	–	50	0.14	0.7
DCMT 11T308E-RM:T5315	●	0.8	240	0.27	0.8	–	–	–	225	0.27	0.8	–	–	–	–	–	–	45	0.14	0.7
DCMT 11T308E-RM:T7335	●	0.8	165	0.27	0.8	125	0.24	0.8	–	–	–	–	–	–	50	0.19	0.6	–	–	–
DCMT 11T308E-RM:T8430	●	0.8	165	0.27	0.8	90	0.24	0.8	135	0.27	0.8	–	–	–	35	0.19	0.6	25	0.14	0.7
DCMT 11T308E-RM:T9325	●	0.8	200	0.27	0.8	120	0.24	0.8	190	0.27	0.8	–	–	–	45	0.19	0.6	–	–	–
DCMT 11T308E-RM:T9415	●	0.8	255	0.27	1.0	–	–	–	240	0.27	1.0	–	–	–	–	–	–	50	0.14	0.7
DCMT 11T312E-RM:T8430	●	1.2	170	0.27	1.2	90	0.24	1.2	135	0.27	1.2	–	–	–	35	0.19	1.2	25	0.14	0.9
DCMT 11T312E-RM:T9315	●	1.2	225	0.27	1.2	–	–	–	210	0.27	1.2	–	–	–	–	–	–	45	0.14	0.9
DCMT 11T312E-RM:T9325	●	1.2	200	0.27	1.2	120	0.24	1.2	190	0.27	1.2	–	–	–	45	0.19	1.2	–	–	–
DCMT 11T312E-RM:T9415	●	1.2	260	0.27	1.2	–	–	–	245	0.27	1.2	–	–	–	–	–	–	50	0.14	0.9
DCMT 150408E-RM:T8430	●	0.8	150	0.27	1.9	80	0.24	1.9	125	0.27	1.9	–	–	–	30	0.22	1.5	25	0.14	0.7
DCMT 150408E-RM:T9325	●	0.8	180	0.27	1.9	105	0.24	1.9	170	0.27	1.9	–	–	–	40	0.22	1.5	–	–	–
DCMT 150408E-RM:T9415	●	0.8	235	0.27	1.9	–	–	–	220	0.27	1.9	–	–	–	–	–	–	45	0.14	0.7

Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
RM talaş kırıcı sağlamdır ve Çeliklerin ve Dökme demirlerin kaba işlenmesi için ilk tercihtir. Pozitif eğim açısı ve dengeli, geniş T-land özelliğine sahiptir. Paslanmaz çelikler ve şartlı olarak Süper alaşımlar ve Sert malzemeler için de uygundur.																			
SCMT 09T308E-RM:T5315	0.8	275	0.30	2.0	–	–	–	260	0.30	2.0	–	–	–	–	–	–	55	0.15	0.7
SCMT 09T308E-RM:T7335	0.8	190	0.30	2.0	145	0.27	2.0	–	–	–	–	–	–	60	0.24	1.6	–	–	–
SCMT 09T308E-RM:T8430	0.8	190	0.30	2.0	105	0.27	2.0	155	0.30	2.0	–	–	–	40	0.24	1.6	30	0.15	0.7
SCMT 09T308E-RM:T9325	0.8	230	0.30	2.0	135	0.27	2.0	215	0.30	2.0	–	–	–	50	0.24	1.6	–	–	–
SCMT 09T308E-RM:T9415	0.8	295	0.30	2.0	–	–	–	280	0.30	2.0	–	–	–	–	–	–	55	0.15	0.7
SCMT 120408E-RM:T5305	0.8	305	0.30	2.3	–	–	–	285	0.30	2.3	–	–	–	–	–	–	60	0.15	0.7
SCMT 120408E-RM:T5315	0.8	275	0.30	2.3	–	–	–	260	0.30	2.3	–	–	–	–	–	–	55	0.15	0.7
SCMT 120408E-RM:T7335	0.8	185	0.30	2.3	140	0.27	2.3	–	–	–	–	–	–	60	0.24	1.8	–	–	–
SCMT 120408E-RM:T8430	0.8	190	0.30	2.3	105	0.27	2.3	155	0.30	2.3	–	–	–	40	0.24	1.8	30	0.15	0.7
SCMT 120408E-RM:T9325	0.8	225	0.30	2.3	135	0.27	2.3	210	0.30	2.3	–	–	–	50	0.24	1.8	–	–	–
SCMT 120408E-RM:T9415	0.8	295	0.30	2.3	–	–	–	280	0.30	2.3	–	–	–	–	–	–	55	0.15	0.7
 																			
RM talaş kırıcı sağlamdır ve Çeliklerin ve Dökme demirlerin kaba işlenmesi için ilk tercihtir. Pozitif eğim açısı ve dengeli, geniş T-land özelliğine sahiptir. Paslanmaz çelikler ve şartlı olarak Süper alaşımlar ve Sert malzemeler için de uygundur.																			
TCMT 16T308E-RM:T5305	0.8	265	0.27	1.9	–	–	–	250	0.27	1.9	–	–	–	–	–	–	50	0.14	0.7
TCMT 16T308E-RM:T5315	0.8	235	0.27	1.9	–	–	–	220	0.27	1.9	–	–	–	–	–	–	45	0.14	0.7
TCMT 16T308E-RM:T7335	0.8	155	0.27	1.9	120	0.24	1.9	–	–	–	–	–	–	50	0.19	1.5	–	–	–
TCMT 16T308E-RM:T8430	0.8	165	0.27	1.9	90	0.24	1.9	135	0.27	1.9	–	–	–	35	0.19	1.5	25	0.14	0.7
TCMT 16T308E-RM:T9325	0.8	195	0.27	1.9	115	0.24	1.9	185	0.27	1.9	–	–	–	40	0.19	1.5	–	–	–
TCMT 16T308E-RM:T9415	0.8	250	0.27	1.9	–	–	–	235	0.27	1.9	–	–	–	–	–	–	50	0.14	0.7
TCMT 16T312E-RM:T5305	1.2	280	0.27	1.9	–	–	–	265	0.27	1.9	–	–	–	–	–	–	55	0.14	0.9
TCMT 16T312E-RM:T5315	1.2	250	0.27	1.9	–	–	–	235	0.27	1.9	–	–	–	–	–	–	50	0.14	0.9
TCMT 16T312E-RM:T8430	1.2	170	0.27	1.9	90	0.24	1.9	135	0.27	1.9	–	–	–	35	0.19	1.5	25	0.14	0.9
TCMT 16T312E-RM:T9325	1.2	205	0.27	1.9	120	0.24	1.9	190	0.27	1.9	–	–	–	45	0.19	1.5	–	–	–
TCMT 16T312E-RM:T9415	1.2	265	0.27	1.9	–	–	–	250	0.27	1.9	–	–	–	–	–	–	50	0.14	0.9
 																			
RM talaş kırıcı sağlamdır ve Çeliklerin ve Dökme demirlerin kaba işlenmesi için ilk tercihtir. Pozitif eğim açısı ve dengeli, geniş T-land özelliğine sahiptir. Paslanmaz çelikler ve şartlı olarak Süper alaşımlar ve Sert malzemeler için de uygundur.																			
VBMT 160404E-RM:T5305	0.4	270	0.12	1.2	–	–	–	255	0.12	1.2	–	–	–	–	–	–	50	0.12	0.3
VBMT 160404E-RM:T5315	0.4	235	0.12	1.2	–	–	–	220	0.12	1.2	–	–	–	–	–	–	45	0.12	0.3
VBMT 160404E-RM:T7335	0.4	140	0.18	1.2	105	0.16	1.2	–	–	–	–	–	–	45	0.16	1.0	–	–	–
VBMT 160404E-RM:T8430	0.4	170	0.12	1.2	90	0.11	1.2	135	0.12	1.2	–	–	–	35	0.11	1.0	25	0.12	0.3
VBMT 160404E-RM:T9325	0.4	170	0.20	1.2	100	0.18	1.2	160	0.20	1.2	–	–	–	35	0.18	1.0	–	–	–
VBMT 160404E-RM:T9415	0.4	255	0.12	1.2	–	–	–	240	0.12	1.2	–	–	–	–	–	–	50	0.12	0.3
VBMT 160408E-RM:T5305	0.8	285	0.17	1.2	–	–	–	270	0.17	1.2	–	–	–	–	–	–	55	0.11	0.7
VBMT 160408E-RM:T5315	0.8	250	0.17	1.2	–	–	–	235	0.17	1.2	–	–	–	–	–	–	50	0.11	0.7
VBMT 160408E-RM:T7335	0.8	155	0.20	1.2	120	0.18	1.2	–	–	–	–	–	–	50	0.18	1.0	–	–	–
VBMT 160408E-RM:T8430	0.8	175	0.17	1.2	95	0.15	1.2	140	0.17	1.2	–	–	–	35	0.12	1.0	30	0.11	0.7
VBMT 160408E-RM:T9325	0.8	200	0.20	1.2	120	0.18	1.2	190	0.20	1.2	–	–	–	45	0.18	1.0	–	–	–
VBMT 160408E-RM:T9415	0.8	270	0.17	1.2	–	–	–	255	0.17	1.2	–	–	–	–	–	–	50	0.12	0.7
VBMT 160412E-RM:T7335	1.2	150	0.27	1.2	115	0.24	1.2	–	–	–	–	–	–	45	0.19	1.0	–	–	–
VBMT 160412E-RM:T8430	1.2	155	0.27	1.2	85	0.24	1.2	130	0.27	1.2	–	–	–	30	0.19	1.0	25	0.14	0.9
VBMT 160412E-RM:T9325	1.2	185	0.27	1.2	110	0.24	1.2	175	0.27	1.2	–	–	–	40	0.19	1.0	–	–	–
VBMT 160412E-RM:T9415	1.2	240	0.27	1.2	–	–	–	225	0.27	1.2	–	–	–	–	–	–	45	0.14	0.9

RM3

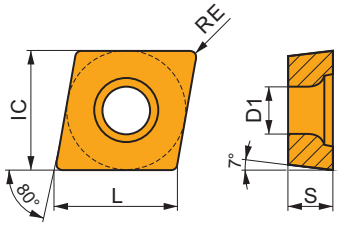


RM3 talaş kırıcı sağlamdır ve çeliklerin ve dökme demirlerin kaba işlenmesi için tasarlanmıştır. Pozitif eğim açısı ve negatif, geniş T-land özelliğine sahiptir. Paslanmaz çelikler ve sert malzemeler için de şartlara bağlı olarak uygundur.

PRAMET

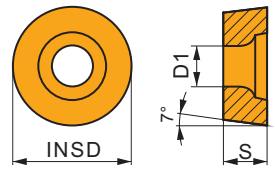
CCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.50	12.90	4.76



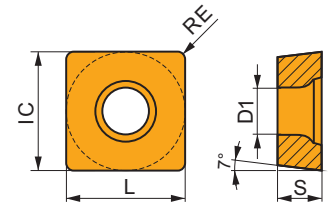
RCMT

	INSD (mm)	D1 (mm)	S (mm)
0803	8.000	3.40	3.18
1204	12.000	4.40	4.76
1606	16.000	5.50	6.35



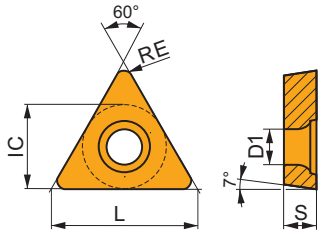
SCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.50	12.70	4.76

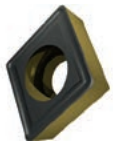
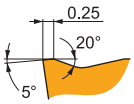
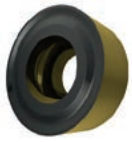
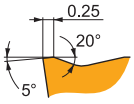
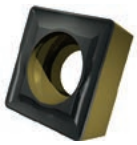
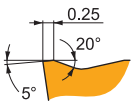
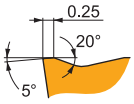


TCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
16T3	9.525	4.40	16.50	3.97

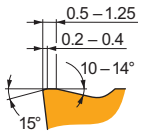


Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
RM3 talaş kırıcı sağlamdır ve çeliklerin ve dökme demirlerin kaba işlenmesi için tasarlanmıştır. Pozitif eğim açısı ve negatif, geniş T-land özelliğine sahiptir. Paslanmaz çelikler ve sert malzemeler için de şartlara bağlı olarak uygundur.																			
CCMT 120404E-RM3:T9325	0.4	165	0.25	2.5	95	0.25	2.5	155	0.25	2.5	–	–	–	–	–	–	–	–	–
CCMT 120404E-RM3:T9415	0.4	215	0.25	2.5	–	–	–	200	0.25	2.5	–	–	–	–	–	–	40	0.13	0.3
CCMT 120408E-RM3:T6310	0.8	145	0.27	2.5	100	0.27	2.5	115	0.27	2.5	–	–	–	–	–	–	25	0.14	0.7
CCMT 120408E-RM3:T9325	0.8	195	0.27	2.5	115	0.27	2.5	185	0.27	2.5	–	–	–	–	–	–	–	–	–
CCMT 120408E-RM3:T9415	0.8	250	0.27	2.5	–	–	–	235	0.27	2.5	–	–	–	–	–	–	50	0.14	0.7
CCMT 120412E-RM3:T9415	1.2	255	0.30	2.5	–	–	–	240	0.30	2.5	–	–	–	–	–	–	50	0.15	1.0
 																			
RM3 talaş kırıcı sağlamdır ve çeliklerin ve dökme demirlerin kaba işlenmesi için tasarlanmıştır. Pozitif eğim açısı ve negatif, geniş T-land özelliğine sahiptir. Paslanmaz çelikler ve sert malzemeler için de şartlara bağlı olarak uygundur.																			
RCMT 0803M0E-RM3:T9415	–	275	0.50	1.3	–	–	–	260	0.50	1.3	–	–	–	–	–	–	55	0.25	0.5
RCMT 1204M0E-RM3:H07	–	–	–	–	65	0.54	1.8	105	0.60	1.8	–	–	–	–	–	–	–	–	–
RCMT 1204M0E-RM3:T7325	–	165	0.60	1.8	125	0.54	1.8	–	–	–	–	–	–	–	–	–	–	–	–
RCMT 1204M0E-RM3:T8430	–	150	0.60	1.8	80	0.54	1.8	125	0.60	1.8	–	–	–	–	–	–	25	0.30	0.8
RCMT 1204M0E-RM3:T9415	–	255	0.60	1.8	–	–	–	240	0.60	1.8	–	–	–	–	–	–	50	0.30	0.8
RCMT 1606M0E-RM3:T7325	–	160	0.65	2.0	120	0.59	2.0	–	–	–	–	–	–	–	–	–	–	–	–
RCMT 1606M0E-RM3:T8430	–	145	0.65	2.0	80	0.59	2.0	120	0.65	2.0	–	–	–	–	–	–	25	0.33	1.1
RCMT 1606M0E-RM3:T9415	–	245	0.65	2.0	–	–	–	230	0.65	2.0	–	–	–	–	–	–	45	0.33	1.1
 																			
RM3 talaş kırıcı sağlamdır ve çeliklerin ve dökme demirlerin kaba işlenmesi için tasarlanmıştır. Pozitif eğim açısı ve negatif, geniş T-land özelliğine sahiptir. Paslanmaz çelikler ve sert malzemeler için de şartlara bağlı olarak uygundur.																			
SCMT 120408E-RM3:T8430	0.8	170	0.27	2.3	90	0.27	2.3	135	0.27	2.3	–	–	–	–	–	–	25	0.14	0.7
SCMT 120408E-RM3:T9325	0.8	205	0.27	2.3	120	0.27	2.3	190	0.27	2.3	–	–	–	–	–	–	–	–	–
SCMT 120408E-RM3:T9335	0.8	175	0.27	2.3	105	0.27	2.3	–	–	–	–	–	–	–	–	–	–	–	–
SCMT 120408E-RM3:T9415	0.8	265	0.27	2.3	–	–	–	250	0.27	2.3	–	–	–	–	–	–	50	0.14	0.7
SCMT 120412E-RM3:T9325	1.2	205	0.30	2.3	120	0.27	2.3	190	0.30	2.3	–	–	–	–	–	–	–	–	–
 																			
RM3 talaş kırıcı sağlamdır ve çeliklerin ve dökme demirlerin kaba işlenmesi için tasarlanmıştır. Pozitif eğim açısı ve negatif, geniş T-land özelliğine sahiptir. Paslanmaz çelikler ve sert malzemeler için de şartlara bağlı olarak uygundur.																			
TCMT 16T304E-RM3:T6310	0.4	115	0.20	2.0	80	0.20	2.0	90	0.20	2.0	–	–	–	–	–	–	20	0.14	0.3
TCMT 16T304E-RM3:T8415	0.4	150	0.20	2.0	75	0.20	2.0	135	0.20	2.0	–	–	–	–	–	–	25	0.14	0.3
TCMT 16T304E-RM3:T8430	0.4	130	0.20	2.0	70	0.20	2.0	105	0.20	2.0	–	–	–	–	–	–	20	0.14	0.3
TCMT 16T304E-RM3:T9325	0.4	145	0.25	2.0	85	0.25	2.0	135	0.25	2.0	–	–	–	–	–	–	–	–	–
TCMT 16T304E-RM3:T9335	0.4	125	0.25	2.0	75	0.25	2.0	–	–	–	–	–	–	–	–	–	–	–	–
TCMT 16T304E-RM3:T9415	0.4	205	0.20	2.0	–	–	–	190	0.20	2.0	–	–	–	–	–	–	40	0.14	0.3
TCMT 16T308E-RM3:T6310	0.8	125	0.27	2.0	90	0.27	2.0	100	0.27	2.0	–	–	–	–	–	–	25	0.14	0.7
TCMT 16T308E-RM3:T8415	0.8	160	0.27	2.0	85	0.27	2.0	145	0.27	2.0	–	–	–	–	–	–	25	0.14	0.7
TCMT 16T308E-RM3:T8430	0.8	135	0.27	2.0	75	0.27	2.0	110	0.27	2.0	–	–	–	–	–	–	20	0.14	0.7
TCMT 16T308E-RM3:T9325	0.8	170	0.27	2.0	100	0.27	2.0	160	0.27	2.0	–	–	–	–	–	–	–	–	–
TCMT 16T308E-RM3:T9335	0.8	145	0.27	2.0	85	0.27	2.0	–	–	–	–	–	–	–	–	–	–	–	–
TCMT 16T308E-RM3:T9415	0.8	220	0.27	2.0	–	–	–	205	0.27	2.0	–	–	–	–	–	–	40	0.14	0.7

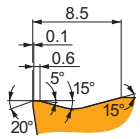
AĞIR KABA İŞLEME - REHBER

OR



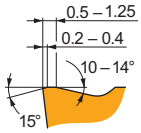
OR talaş kırıcı sağlamdır ve Paslanmaz çeliklerin ağır kaba işlenmesi için ilk tercihtir. Pozitif eğim açısı ve negatif/kararlı, ekstra geniş çift T-land özelliğine sahiptir. Ayrıca Çelikler, Dökme demirler ve şartlı olarak Süper alaşımlar için de uygundur.

DR4



DR4 talaş kırıcı sağlamdır ve Çeliklerin ağır kaba işlenmesi için ilk tercihtir. Pozitif eğim açısı ve negatif/kararlı, ekstra geniş çift T-land özelliğine sahiptir. Dökme demirler ve şartlı olarak Paslanmaz çelikler için de uygundur.

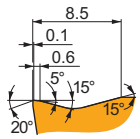
OR



OR talaş kırıcı sağlamdır ve Paslanmaz çeliklerin ağır kaba işlenmesi için ilk tercihtir. Pozitif eğim açısı ve negatif/kararlı, ekstra geniş çift T-land özelliğine sahiptir. Ayrıca Çelikler, Dökme demirler ve şartlı olarak Süper alaşımlar için de uygundur.

PRAMET

DR4

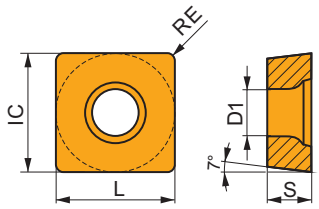


DR4 talaş kırıcı sağlamdır ve Çeliklerin ağır kaba işlenmesi için ilk tercihtir. Pozitif eğim açısı ve negatif/kararlı, ekstra geniş çift T-land özelliğine sahiptir. Dökme demirler ve şartlı olarak Paslanmaz çelikler için de uygundur.

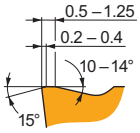
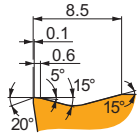
PRAMET

SCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
2509	25.400	8.70	25.40	9.53
3809	38.100	8.70	38.10	9.53



Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

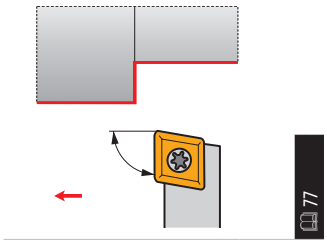
Product		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
OR talaş kırıcı sağlamdır ve Paslanmaz çeliklerin ağır kaba işlenmesi için ilk tercihtir. Pozitif eğim açısı ve negatif/kararlı, ekstra geniş çift T-land özelliğine sahiptir. Ayrıca Çelikler, Dökme demirler ve şartlı olarak Süper alaşımlar için de uygundur.																				
SCMT 250924E-OR:T9226		2.4	80	1.00	10.0	45	0.90	10.0	75	1.00	10.0	–	–	–	15	0.70	8.0	–	–	–
SCMT 250924E-OR:T9325		2.4	90	1.00	10.0	50	0.90	10.0	85	1.00	10.0	–	–	–	20	0.70	8.0	–	–	–
SCMT 250924E-OR:T9335		2.4	70	1.00	10.0	40	0.90	10.0	–	–	–	–	–	–	15	0.70	8.0	–	–	–
SCMT 380932E-OR:6635		3.2	60	1.20	18.0	35	1.08	18.0	–	–	–	–	–	–	15	1.08	9.9	–	–	–
SCMT 380932E-OR:T9315		3.2	85	1.20	18.0	–	–	–	80	1.20	18.0	–	–	–	–	–	–	–	–	–
SCMT 380932E-OR:T9325		3.2	80	1.20	18.0	45	1.08	18.0	75	1.20	18.0	–	–	–	15	1.08	9.9	–	–	–
SCMT 380932E-OR:T9335		3.2	60	1.20	18.0	35	1.08	18.0	–	–	–	–	–	–	10	1.08	9.9	–	–	–
																				
DR4 talaş kırıcı sağlamdır ve Çeliklerin ağır kaba işlenmesi için ilk tercihtir. Pozitif eğim açısı ve negatif/kararlı, ekstra geniş çift T-land özelliğine sahiptir. Dökme demirler ve şartlı olarak Paslanmaz çelikler için de uygundur.																				
SCMT 380932E-DR4:T9335		3.2	50	1.33	16.0	30	1.20	16.0	–	–	–	–	–	–	–	–	–	–	–	–

CC

ISO TORNALAMA - DIŞ - REHBER

SCAC(RL) EXT 90°

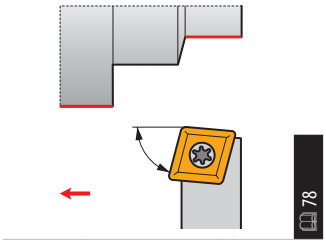
CC..



77

SCBC(RL) EXT 75°

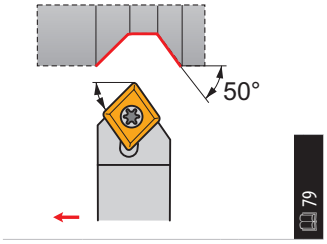
CC..



78

SCDCR EXT 45°

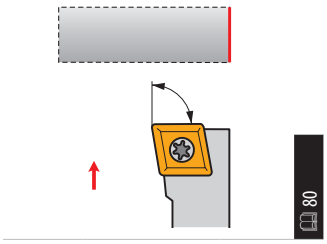
CC..



79

SCFC(RL) EXT 90°

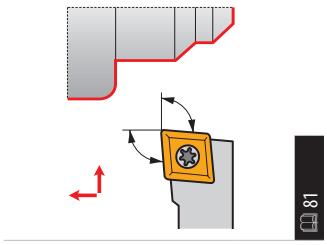
CC..



80

SCLC(RL) EXT 95°

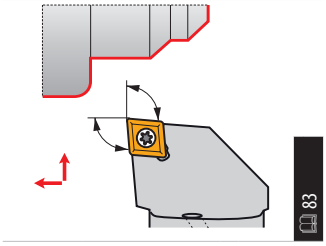
CC..



81

C.-SCLC(RL) EXT 95°

CC..



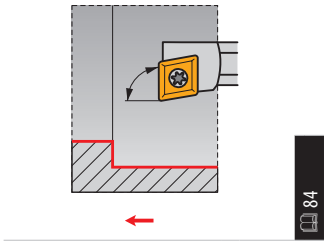
83

CC

ISO TORNALAMA - İÇ - REHBER

SCFC(RL) INT 90°

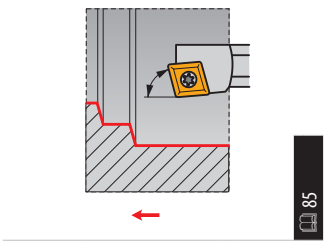
CC..



84

SCKC(RL) INT 75°

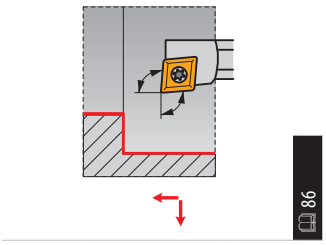
CC..



85

SCLC(RL) INT 45°

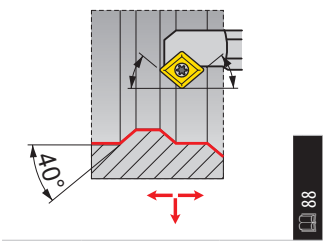
CC..



86

SCXC(RL) INT 90°

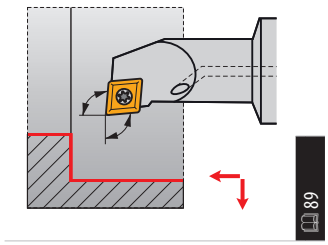
CC..



88

C.-SCLC(RL) INT 95°

CC..



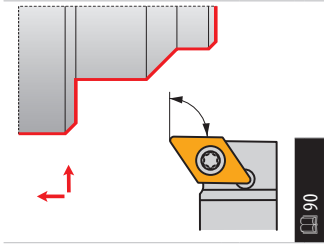
89

DC

ISO TORNALAMA - DIŞ - REHBER

SDFC(RL) EXT 91°

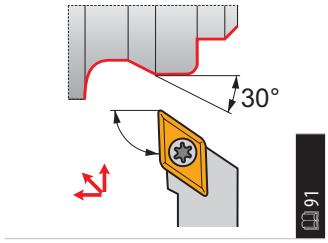
DC..



90

SDJC(RL) EXT 93°

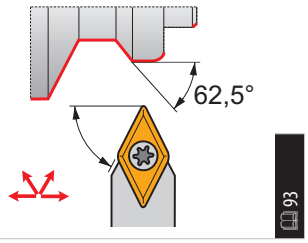
DC..



91

SDNCN EXT 62°30´

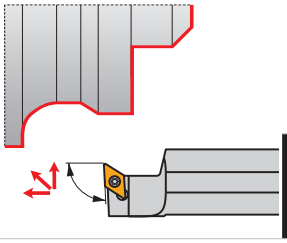
DC..



93

SDUCL EXT 93°

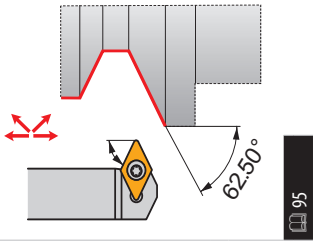
DC..



94

SDXC(RL) EXT 62°30´

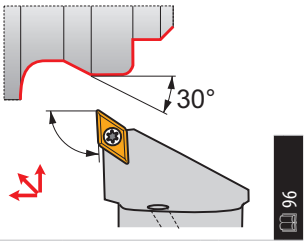
DC..



95

C.-SDJC(RL) EXT 93°

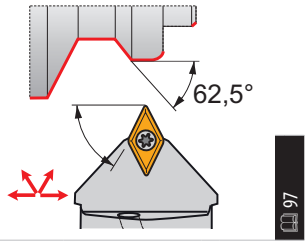
DC..



96

C.-SDNCN EXT 62°30´

DC..



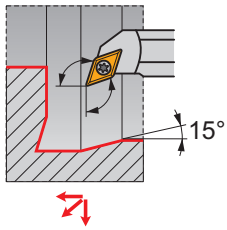
97

DC

ISO TORNALAMA - İÇ - REHBER

SDQC(RL) INT 95°

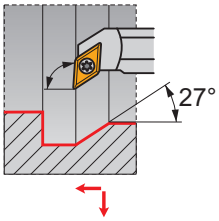
DC..



98

SDUC(RL) INT 93°

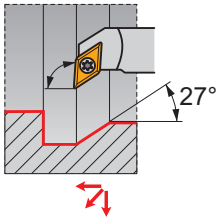
DC..



99

SDUC(RL)-E INT 62°30´

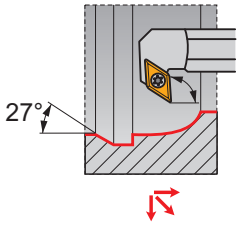
DC..



100

SDZC(RL) INT 90°

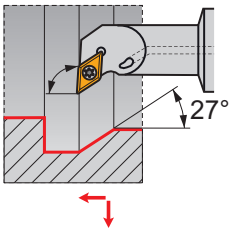
DC..



101

C.-SDUC(RL) INT 93°

DC..



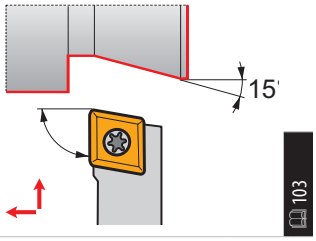
102

EC

ISO TORNALAMA - DIŞ - REHBER

SEGC(RL) EXT 90°

EC..



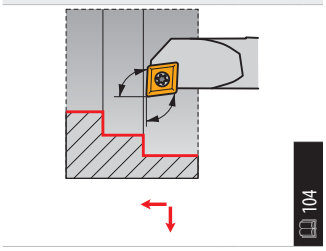
103

EC

ISO TORNALAMA - İÇ - REHBER

SEUC(RL) INT 93°

EC..



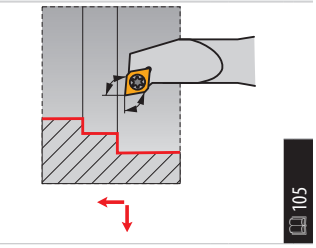
104

EP

ISO TORNALAMA - İÇ - REHBER

SELP(RL) INT 95°

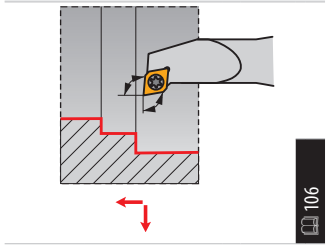
EP..



105

SELP(RL)-E INT 95°

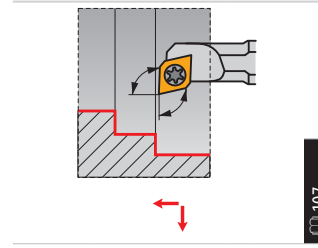
EP..



106

SEUP(RL) INT 93°

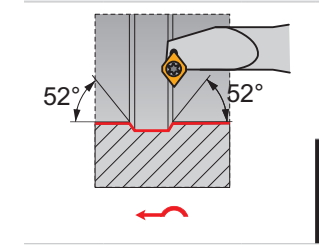
EP..



107

SEXP(RL) INT 52°30´

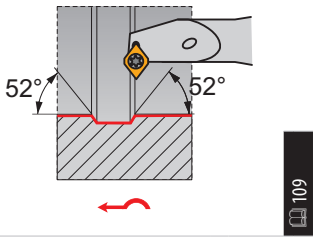
EP..



108

SEXP(RL)-E INT 52°30´

EP..



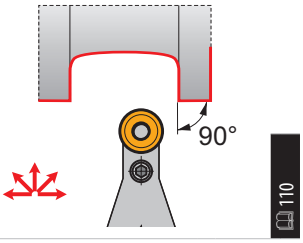
109

RC

ISO TORNALAMA - DIŞ - REHBER

PRDCN EXT

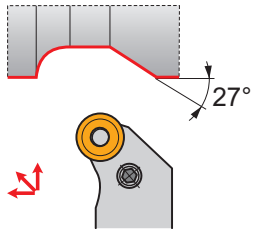
RC..



110

PRSC(RL) EXT

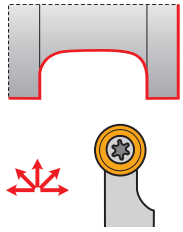
RC..



111

SRDC(RL) EXT

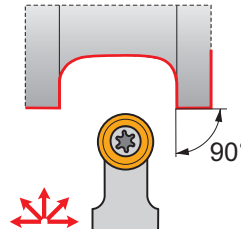
RC..



112

SRDCN EXT

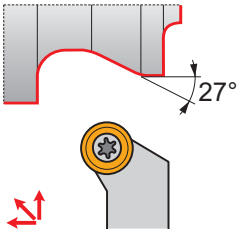
RC..



113

SRCS(RL) EXT

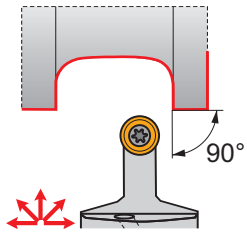
RC..



114

C.-SRDCN EXT

RC..



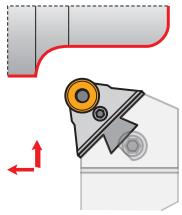
116

RC

ISO TORNALAMA - AĞIR KABA - REHBER

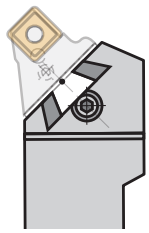
KHP-RSCR/L

RC..



117

DKH(RL)



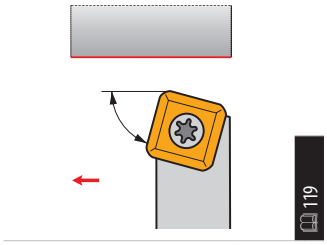
118

SC

ISO TORNALAMA - DIŞ - REHBER

SSBC(RL) EXT 75°

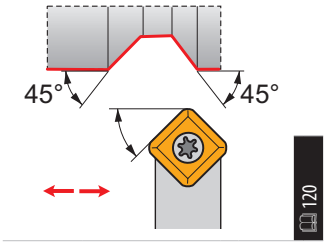
SC..



119

SSDCN EXT 45°

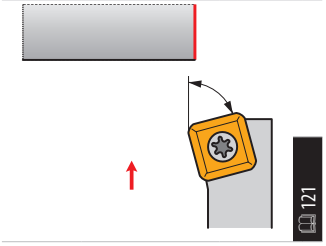
SC..



120

SSKC(RL) EXT 75°

SC..



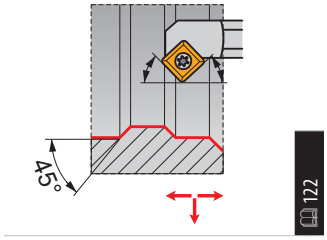
121

SC

ISO TORNALAMA - İÇ - REHBER

SSSC(RL) INT 45°

SC..



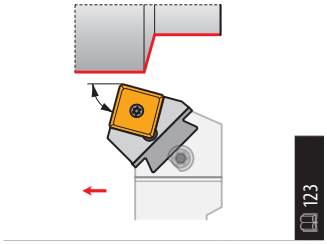
122

SC

ISO TORNALAMA - AĞIR KABA - REHBER

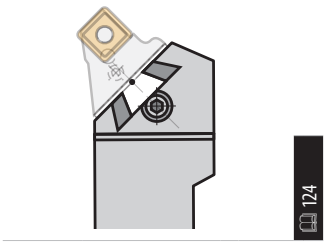
KHS-SBCR 75°

SC..



123

DKH(RL)



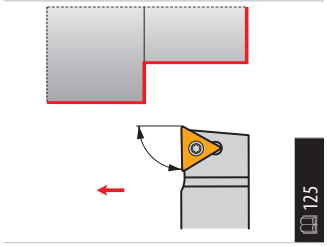
124

TC

ISO TORNALAMA - DIŞ - REHBER

STAC(RL) EXT 90°

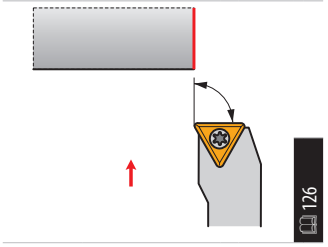
TC..



125

STFC(RL) EXT 90°

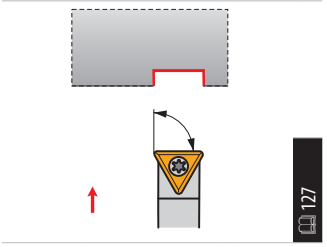
TC..



126

STFC(RL)-A EXT 90°

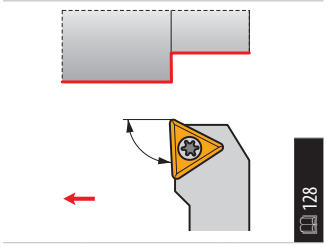
TC..



127

STJC(RL) EXT 93°

TC..



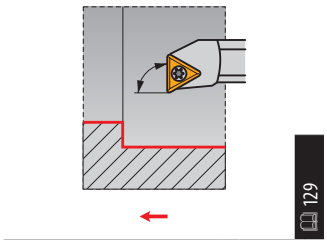
128

TC

ISO TORNALAMA - İÇ - REHBER

STFC(RL) INT 90°

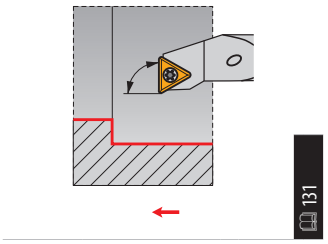
TC..



129

STFC(RL)-E INT 90°

TC..



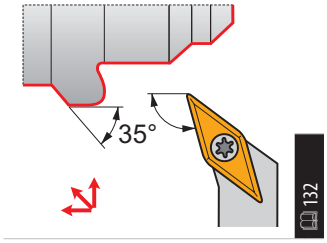
131

VB

ISO TORNALAMA - DIŞ - REHBER

SVHB(C)(RL) EXT 107°30´

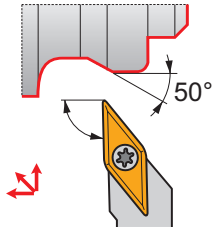
VB, VC..



132

SVJB(C)(RL) EXT 93°

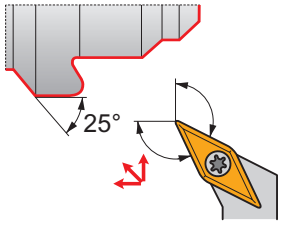
VB, VC..



133

SVPB(C)(RL) EXT 117°30´

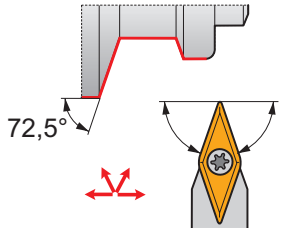
VB, VC..



135

SVVB(C)N EXT 72°30´

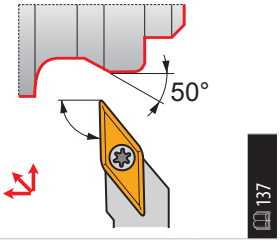
VB, VC..



136

SVXB(C)(RL) EXT 98°

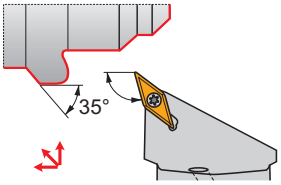
VB, VC..



137

C.-SVHB(RL) EXT 107°30´

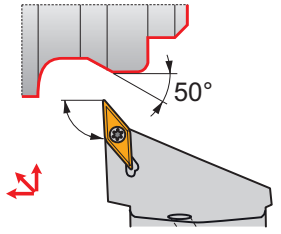
VB, VC..



138

C.-SVJB(RL) EXT 93°

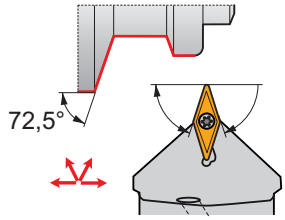
VB, VC..



139

C.-SVVBN EXT 72°30´

VB, VC..



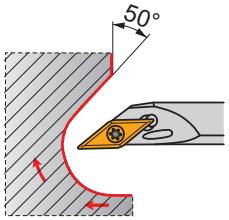
140

VB

ISO TORNALAMA - İÇ - REHBER

SVJB(RL) INT 93°

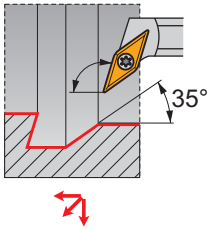
VB, VC..



141

SVQB(C)(RL) INT 107°30´

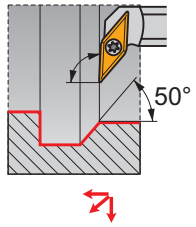
VB, VC..



142

SVUB(C)(RL) INT 93°

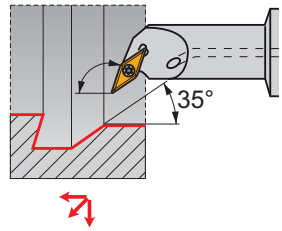
VB, VC..



143

C.-SVQB(C)(RL) INT 108°

VB, VC..



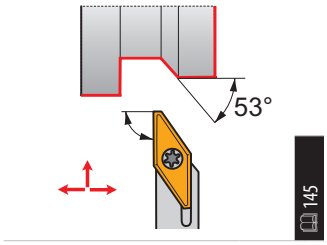
144

VC

ISO TORNALAMA - DIŞ - REHBER

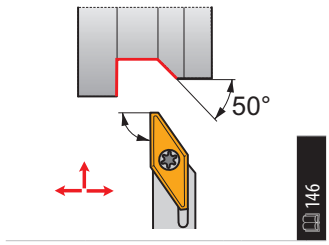
SVAC(RL)-DC EXT 90°

VC..



SVJC(RL)-DC EXT 93°

VC..

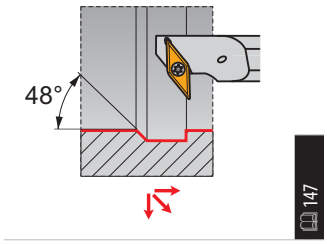


VC

ISO TORNALAMA - İÇ - REHBER

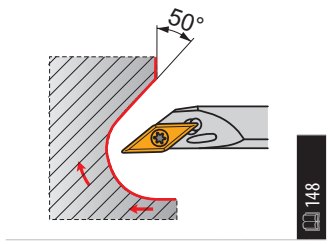
SVLC(RL) INT 95°

VC..



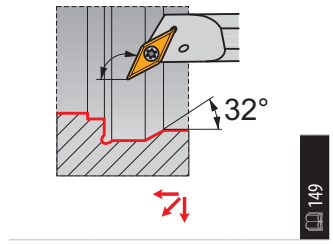
SVJB(RL) INT 93°

VB, VC..



SVXC(RL)-E INT 113°

VC..

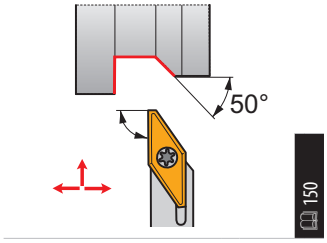


WC

ISO TORNALAMA - DIŞ - REHBER

SWLC(RL) EXT 95°

WC..

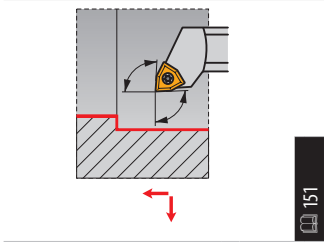


WC

ISO TORNALAMA - İÇ - REHBER

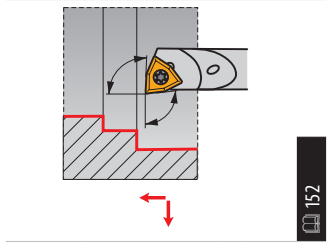
SWLC(RL) INT 95°

WC..



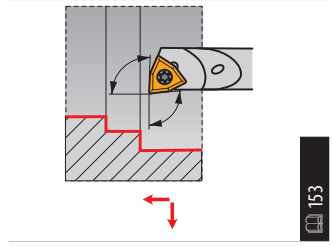
SWUC(RL) INT 93°

WC..



SWUC(RL)-E INT 93°

WC..



SCAC(RL) EXT

P M K N S H

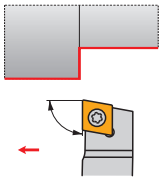
PRAMET

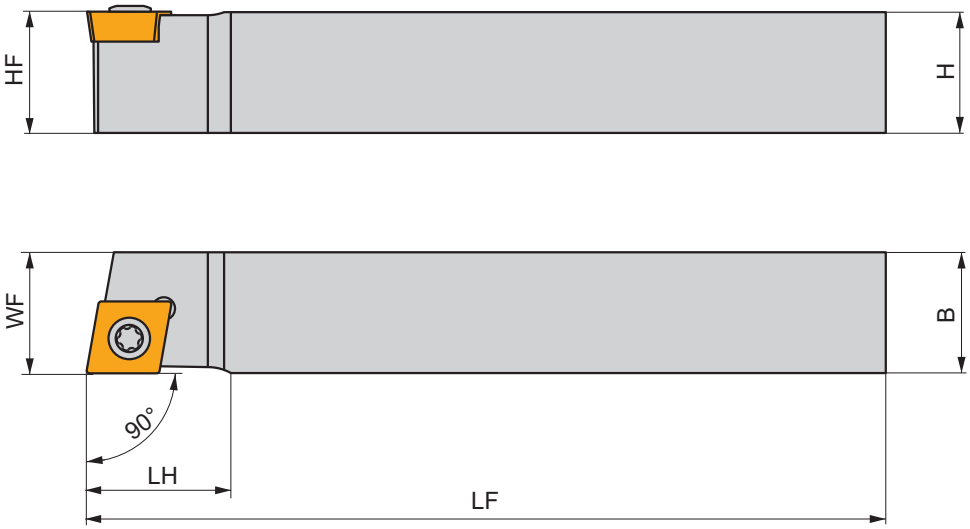
S

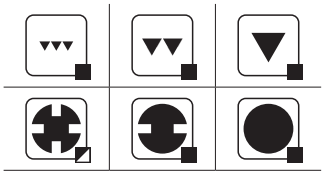


CC Kesici Uç için Vida Sıkmalı 90° Açılı Dış Kater

Vida tipi pozitif CC 06 veya 09 uç için 90° açılı Sağ/Sol yönlü Dış Kater. Dış çap boyuna, konik ve pah tornalama için uygundur. 08 × 08 ile 16 × 16 mm arası şaft boyutları ile sunulmuştur, bazıları kayar otomat tezgahlarında kullanılabilir. Gövde uzun takım ömrü için işlem görmüştür.









	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	SCACR 0808 D 06	8	8	8	8.5	60	–	0	0	0.04	GI045	S07
	SCACR 1010 E 06	10	10	10	10.5	70	–	0	0	0.08	GI045	S07
	SCACR 1212 F 09	12	12	12	12.5	80	–	0	0	0.11	GI041	S04
	SCACR 1212 K 09-S	12	12	12	12	125	19.0	0	0	0.14	GI041	S04
	SCACR 1616 H 09	16	16	16	16.5	100	–	0	0	0.22	GI041	S04
	SCACR 1616 K 09-S	16	16	16	16	125	19.0	0	0	0.24	GI041	S04
L	SCACL 0808 D 06	8	8	8	8.5	60	–	0	0	0.05	GI045	S07
	SCACL 1010 E 06	10	10	10	10.5	70	–	0	0	0.06	GI045	S07
	SCACL 1212 F 09	12	12	12	12.5	80	–	0	0	0.12	GI041	S04
	SCACL 1212 K 09-S	12	12	12	12	125	19.0	0	0	0.14	GI041	S04
	SCACL 1616 H 09	16	16	16	16.5	100	–	0	0	0.22	GI041	S04
	SCACL 1616 K 09-S	16	16	16	16	125	19.0	0	0	0.24	GI041	S04

GI041	CC.. 09T3..
GI045	CC.. 0602..

		Nm			
S04	US 3510-T15P	3.0	M 3.5	10.6	FLAG T15P
S07	US 2506-T07P	0.9	M 2.5	6.3	FLAG T07P

SCBC(RL) EXT

P M K N S H

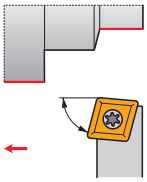
PRAMET

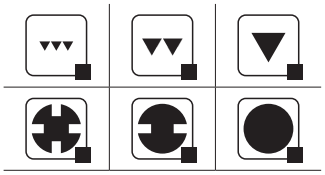
S

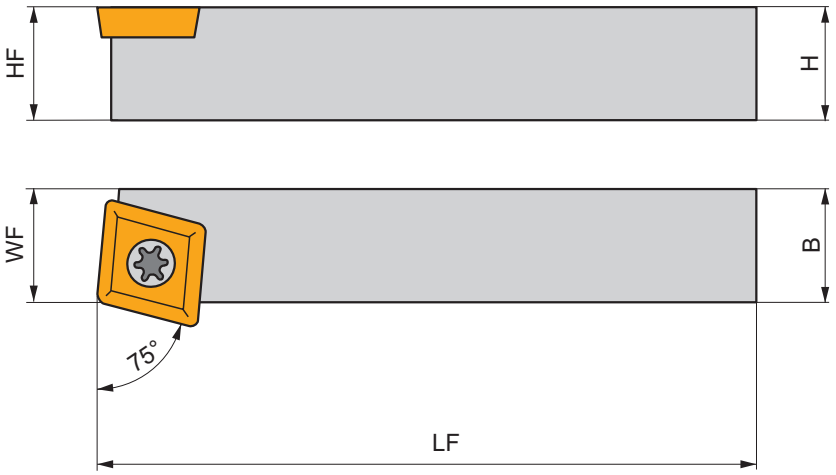


CC.. Uç için Vida Sıkmalı 75° Açılı Dış Kater

Vida sıkmalı Sağ/Sol 75° dış kater. Pozitif CC.. 09 veya 12 uçlarla çap ve pah tornalama için uygundur. 12x12-25x25mm şaft ölçülerinde bulunur. Gövde uzun takım ömrü için işlem görmüştür.













	Product	H	B	HF	WF	LF	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	SCBCR 1212 F 09	12	12	12	11	80	0	0	0.10	GI041	S08
	SCBCR 1616 H 09	16	16	16	13	100	0	0	0.20	GI041	S08
	SCBCR 2020 K 12-M-A	20	20	20	17	125	0	0	0.45	GI011	SC20
	SCBCR 2525 M 12-M-A	25	25	25	22	150	0	0	0.61	GI011	SC20
L	SCBCL 1212 F 09	12	12	12	11	80	0	0	0.10	GI041	S08
	SCBCL 1616 H 09	16	16	16	13	100	0	0	0.22	GI041	S08
	SCBCL 2020 K 12-M-A	20	20	20	17	125	0	0	0.43	GI011	SC20
	SCBCL 2525 M 12-M-A	25	25	25	22	150	0	0	0.75	GI011	SC20

GI011	CC.. 1204..
GI041	CC.. 09T3..

		Nm						
SC20	US 5012-T15P	5.0	M 5	12.2	SCN 120304	MS 5008	FLAG T15P	HXK 5
S08	US 3510-T15P	3.0	M 3.5	10.6	–	–	FLAG T15P	–

SCDCR EXT

P M K N S H

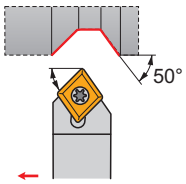
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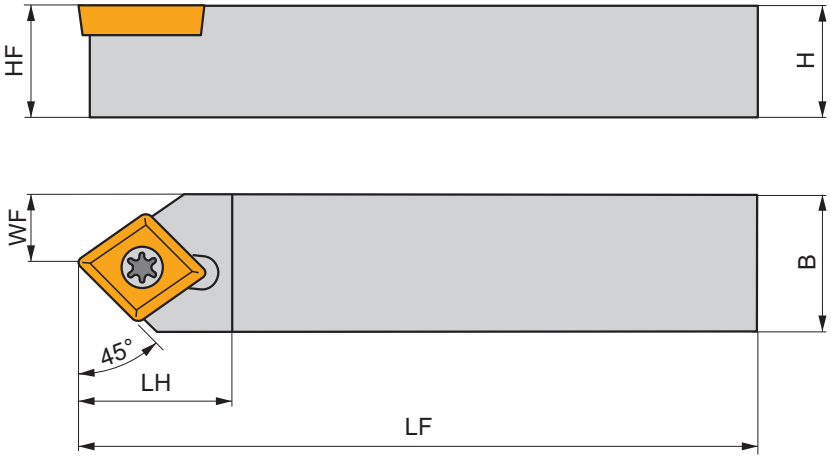
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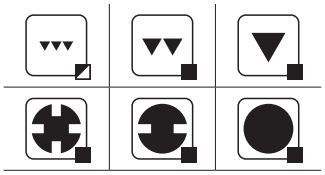


CC.. Uç için Vida Sıkmalı 45° Açılı Dış Kater

Vida sıkmalı nötr dış kater. Pozitif CC.. 06 uçlarla çap, kopya, konik ve pah tornalama için uygundur. Sadece 10mm mevcuttur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	SCDCR 1010 E 06	10	10	10	5.11	70	11.0	0	0	0.06	GI045	SC21

GI045	CC.. 0602..

SC21	5513 020-03	0.8 Nm	M 2.5	6.5	PT-8001

SCFC(RL) EXT

P M K N S H

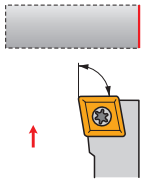
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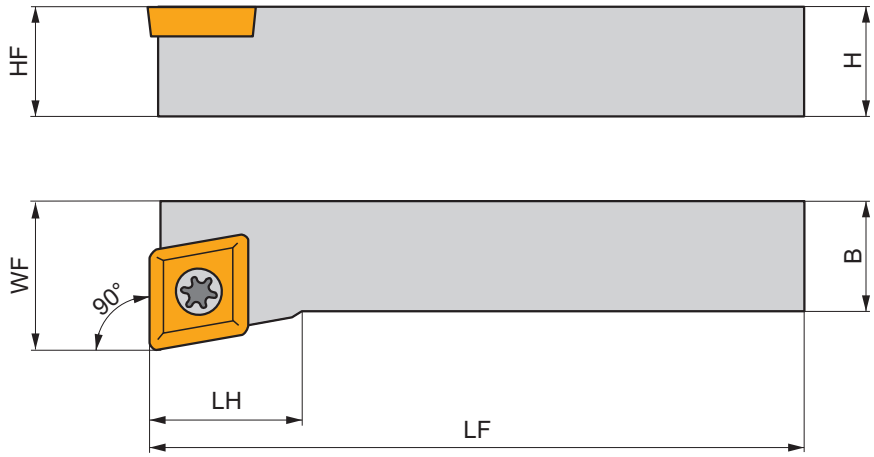
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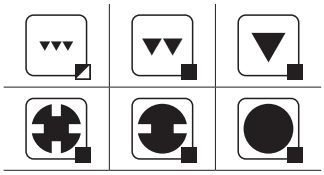


CC.. Uç için Vida Sıkmalı 90° Açılı Dış Kater

Vida sıkmalı Sağ/Sol 90° dış kater. Pozitif CC.. 06 veya 09 uçlarla çap, alın, konik ve pah tornalama için uygundur. 08x08-16x16mm şaft ölçülerinde bulunur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	SCFCR 0808 D 06	8	8	8	10	60	8.0	0	0	0.04	GI045	S07
	SCFCR 1010 E 06	10	10	10	12	70	8.0	0	0	0.07	GI045	S07
	SCFCR 1212 F 09	12	12	12	16	80	16.0	0	0	0.12	GI041	S04
	SCFCR 1616 H 09	16	16	16	20	100	16.0	0	0	0.22	GI041	S04
L	SCFCL 1010 E 06	10	10	10	12	70	8.0	0	0	0.06	GI045	S07
	SCFCL 1212 F 09	12	12	12	16	80	16.0	0	0	0.10	GI041	S04
	SCFCL 1616 H 09	16	16	16	20	100	16.0	0	0	0.22	GI041	S04

GI041	CC.. 09T3..
GI045	CC.. 0602..

		Nm			
S04	US 3510-T15P	3.0	M 3.5	10.6	FLAG T15P
S07	US 2506-T07P	0.9	M 2.5	6.3	FLAG T07P

SCLC(RL) EXT

P M K N S H

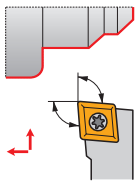
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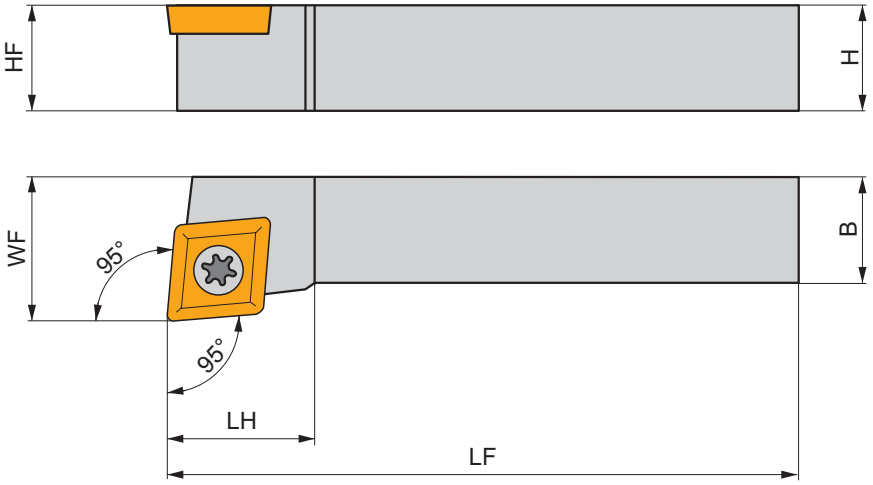
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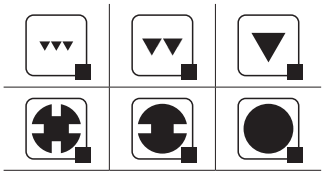


CC Uç için Vida Sıkmalı 95° Açılı Dış Kater

Vida tipi pozitif CC 06, 08, 09 veya 12 uç için 95° açılı Sağ/Sol yönlü dış kater. Dış boyuna kenar, konik ve pah tornalama için uygundur. 08 × 08 ile 25 × 25 mm arası şaft boyutları ile sunulmuştur, bazıları kayar otomat tezgahlarında kullanılabilir. Gövde uzun takım ömrü için işlem görmüştür.









	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	SCLCR 0808 D 06	8	8	8	10	60	8.0	0	0	0.05	GI045	S01
	SCLCR 1010 E 06	10	10	10	12	70	8.0	0	0	0.09	GI045	S01
	SCLCR 1010 E 08	10	10	10	12	70	13.2	0	0	0.03	GI232	SC22
	SCLCR 1212 F 08	12	12	12	16	80	13.4	0	0	0.01	GI232	SC22
	SCLCR 1212 F 09	12	12	12	16	80	16.0	0	0	0.12	GI041	S08
	SCLCR 1212 K 09-S	12	12	12	12	125	21.3	0	0	0.13	GI041	S08
	SCLCR 1616 H 08	16	16	16	20	100	15.2	0	0	0.22	GI232	SC22
	SCLCR 1616 H 09	16	16	16	20	100	16.0	0	0	0.22	GI041	S08
	SCLCR 1616 K 09-S	16	16	16	16	125	21.3	0	0	0.24	GI041	S08
	SCLCR 2020 K 12-M-A	20	20	20	25	125	20.0	0	0	0.43	GI011	SC20
	SCLCR 2525 M 12-M-A	20	25	20	32	150	20.0	0	0	0.77	GI011	SC20
L	SCLCL 0808 D 06	8	8	8	10	60	8.0	0	0	0.06	GI045	S01
	SCLCL 1010 E 06	10	10	10	12	70	8.0	0	0	0.06	GI045	S01
	SCLCL 1212 F 08	12	12	12	16	80	13.4	0	0	0.03	GI232	SC22
	SCLCL 1212 F 09	12	12	12	16	80	16.0	0	0	0.10	GI041	S08
	SCLCL 1212 K 09-S	12	12	12	12	125	21.3	0	0	0.13	GI041	S08
	SCLCL 1616 H 08	16	16	16	20	100	15.2	0	0	0.23	GI232	SC22
	SCLCL 1616 H 09	16	16	16	20	100	16.0	0	0	0.22	GI041	S08
	SCLCL 1616 K 09-S	16	16	16	16	125	21.3	0	0	0.24	GI041	S08
	SCLCL 2020 K 12-M-A	20	20	20	25	125	20.0	0	0	0.40	GI011	SC20
	SCLCL 2525 M 12-M-A	25	25	25	32	150	20.0	0	0	0.77	GI011	SC20

GI011	CC.. 1204..
GI041	CC.. 09T3..
GI045	CC.. 0602..

GI232	CC.. 0803..

		Nm						
SC20	US 5012-T15P	5.0	M 5	12.2	SCN 120304	MS 5008	FLAG T15P	HXK 5
SC22	5513 020-04	1.5	M 3	7.2	–	–	PT-8003	–
S01	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–
S08	US 3510-T15P	3.0	M 3.5	10.6	–	–	FLAG T15P	–

C.-SCLC(RL) EXT

P M K N S H

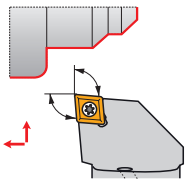
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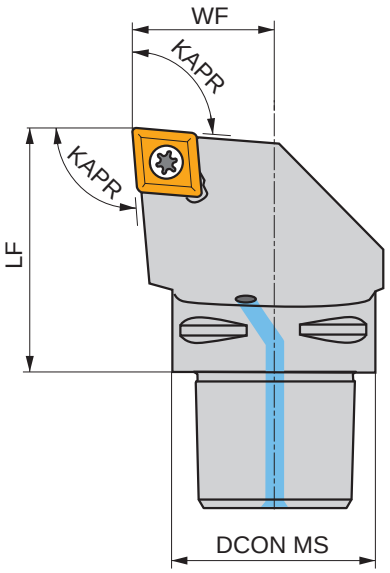
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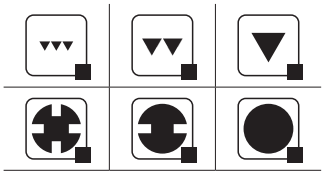


CC.. Uç için Vida Sıkmalı, 95° Açılı Hızlı Değiştirme Dış Takımı

Vida sıkmalı Sağ/Sol, içten su vermeli 95° dış kater. Pozitif DC.. 07, 11 veya 15 uçlarla çap, kopya, konik, kopya ve pah tornalama için uygundur. PSC C3-C5 ölçülerinde bulunur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	DCON MS (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg		
R	C3-SCLCR-22040-09	32	22	40	95	0	0	✓	0.21	GI041	C-SC09S
	C4-SCLCR-27050-09	40	27	50	95	0	0	✓	0.39	GI041	C-SC09S
	C4-SCLCR-27050-12	40	27	50	95	0	0	✓	0.40	GI011	C-SC12-1
	C5-SCLCR-35060-12	50	35	60	95	0	0	✓	0.72	GI011	C-SC12-2
L	C3-SCLCL-22040-09	32	22	40	95	0	0	✓	0.21	GI041	C-SC09S
	C4-SCLCL-27050-09	40	27	50	95	0	0	✓	0.39	GI041	C-SC09S
	C5-SCLCL-35060-12	50	35	60	95	0	0	✓	0.72	GI011	C-SC12-2

GI011	CC.. 1204..
GI041	CC.. 09T3..

		Nm						
C-SC09S	US 2001-T15P	3.0	M 3.5	12.1	SCS 232-01	MS 9001	FLAG T15P/3,5	CN 034-01
C-SC12-1	US 2018-T15P	3.0	M 4	14	SCS 232-02	MS 9003	FLAG T15P/4	CN 034-01
C-SC12-2	US 2018-T15P	3.0	M 4	14	SCS 232-02	MS 9003	FLAG T15P/4	CN 034-02

SCFC(RL) INT

P M K N S H

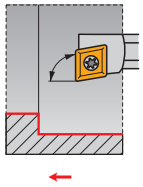
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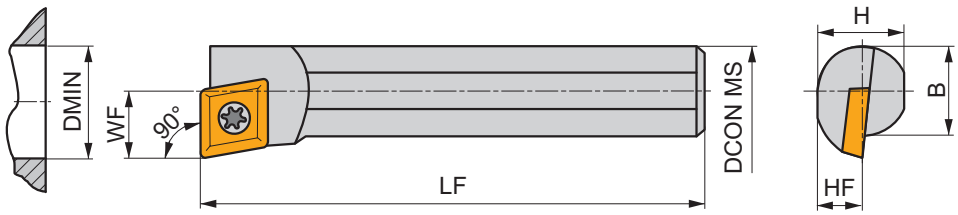
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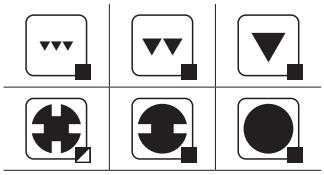


CC.. Uç için Vida Sıkmalı 90° Açılı Delik Kateri

Vida sıkmalı Sağ/Sol 90° delik kateri. Pozitif CC.. 06 uçlarla Kenar ve pah tornalama ile iç konik ve çap tornalama için uygundur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)	kg		
R	S10H-SCFCR 06	10	13	7	9	9.5	100	-10	0	0.08	GI045	S06
	S12K-SCFCR 06	12	16	9	11	11.5	125	-7	0	0.11	GI045	S06
L	S10H-SCFCL 06	10	13	7	9	9.5	100	-10	0	0.08	GI045	S06
	S12K-SCFCL 06	12	16	9	11	11.5	125	-7	0	0.13	GI045	S06

GI045	CC.. 0602..

S06	US 2505-T07P	0.9	M 2.5	5.2	FLAG T07P

SCKC(RL) INT

P M K N S H

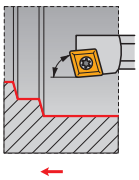
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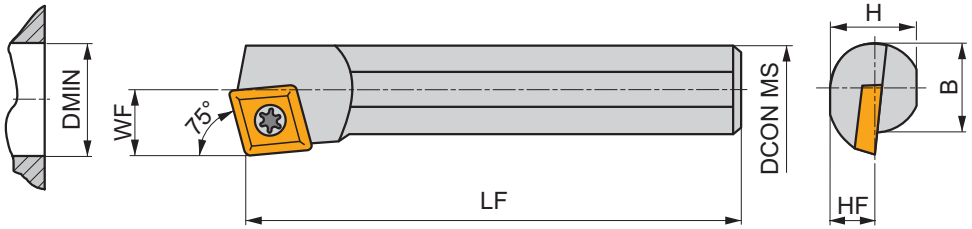
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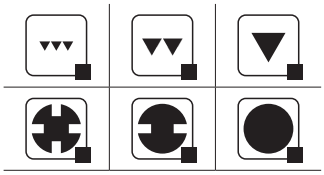


CC.. Uç için Vida Sıkmalı 75° Açılı Delik Kateri

Vida sıkmalı Sağ/Sol 75° delik kateri. Pozitif CC.. uçlarla kenar ve pah tornalama ile iç konik ve çap tornalama için uygundur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)	kg		
R	S08F-SCKCR 06	8	11	6	7.2	7.6	80	-12	0	0.03	GI045	S02
	S12K-SCKCR 06	12	16	9	11	11.5	125	-8	0	0.11	GI045	S02
	S16M-SCKCR 09-A	16	20	11	14.5	15	150	-8	0	0.25	GI041	S05
	S20S-SCKCR 09	20	25	13	18.5	18.5	250	-5	0	0.60	GI041	S08
	S25T-SCKCR 09	25	32	17	23	23	300	-3	0	1.15	GI041	S08
	S32U-SCKCR 12-A	32	40	22	30	30	350	-10	0	2.10	GI011	SC20
L	S20S-SCKCL 09	20	25	13	18.5	18.5	250	-5	0	0.60	GI041	S08

GI011	CC.. 1204..
GI041	CC.. 09T3..
GI045	CC.. 0602..

		Nm						
SC20	US 5012-T15P	5.0	M 5	12.2	SCN 120304	MS 5008	FLAG T15P	HXK 5
S02	US 2505-T07P	0.9	M 2.5	5.2	–	–	FLAG T07P	–
S05	US 4008-T15P	3.5	M 4	8	–	–	FLAG T15P	–
S08	US 3510-T15P	3.0	M 3.5	10.6	–	–	FLAG T15P	–

SCLC(RL) INT

P M K N S H

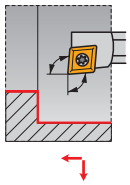
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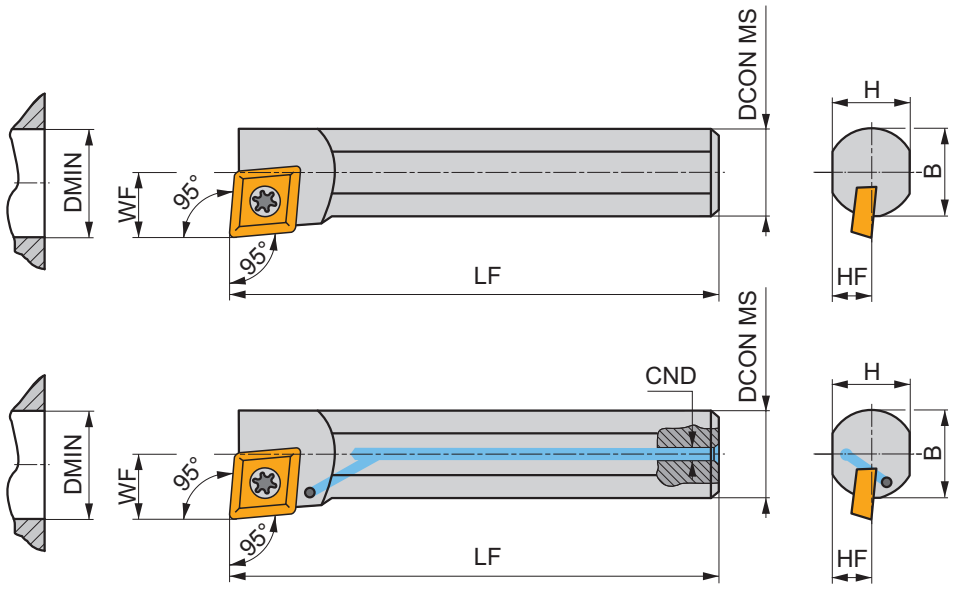
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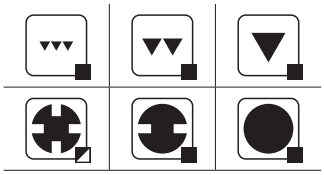


CC.. Uç için Vida Sıkmalı 95° Açılı Delik Kateri

Vidalı sıkmalı tip CC.. uçlar için 95° kesme açılı ,iç çap Sağ/Sol delik işleme barası, içten soğutmalı . Kenar ve pah tornalama ile iç konik ve çap tornalama için. Gövde uzun takım ömrü için işlem görmüştür.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	CND (mm)	LAMS (°)	GAMO (°)		kg		
R	A08H-SCLCR 06	8	11	6	7.2	7.6	100	3.5	-13	0	✓	0.03	GI045	S02
	S08F-SCLCR 06	8	11	6	7.2	7.6	80	–	-13	0	–	0.05	GI045	S02
	A10H-SCLCR 06	10	13	7	9	–	100	4	-10	0	✓	0.07	GI045	S02
	S10H-SCLCR 06	10	13	7	9	9.5	100	–	-10	0	–	0.07	GI045	S02
	A12K-SCLCR 06	12	16	9	11	–	125	5	-8	0	✓	0.09	GI045	S01
	S12K-SCLCR 06	12	16	9	11	11.5	125	–	-8	0	–	0.12	GI045	S01
	S16M-SCLCR 06	16	20	11	14.5	15	150	–	-8	0	–	0.25	GI045	S01
	A10K-SCLCR 08	10	12	6	9	9.5	125	4	-14	0	✓	0.09	GI232	SC22
	A12M-SCLCR 08	12	16	9	11	11.5	150	5	-5	0	✓	0.14	GI232	SC22
	A16R-SCLCR 08	16	20	11	14	15	200	6	-8	0	✓	0.28	GI232	SC22
	A16M-SCLCR 09-A	16	20	11	14.5	–	150	6	-8	0	✓	0.22	GI041	S05
	S16M-SCLCR 09-A	16	20	11	14.5	15	150	–	-8	0	–	0.25	GI041	S05
	A20Q-SCLCR 09	20	25	13	18	–	180	8	-5	0	✓	0.37	GI041	S08
	S20S-SCLCR 09	20	25	13	18	18.5	250	–	-5	0	–	0.59	GI041	S08
	A25R-SCLCR 09	25	32	17	23	23	200	8	-3	0	✓	0.60	GI041	S08
	S25T-SCLCR 09	25	32	17	23	23	300	–	-3	0	–	1.08	GI041	S08
	A32S-SCLCR 12-A	32	40	22	30	30	250	8	-10	0	✓	1.35	GI011	SC20
	S32U-SCLCR 12-A	32	40	22	30	30	350	–	-10	0	–	2.10	GI011	SC20
L	A08H-SCLCL 06	8	11	6	7.2	7.6	100	–	-13	0	✓	0.05	GI045	S02
	S08F-SCLCL 06	8	11	6	7.2	7.6	80	–	-13	0	–	0.05	GI045	S02
	A10H-SCLCL 06	10	13	7	9	–	100	4	-10	0	✓	0.06	GI045	S02
	S10H-SCLCL 06	10	13	7	9	9.5	100	–	-10	0	–	0.06	GI045	S02
	A12K-SCLCL 06	12	16	9	11	–	125	5	-8	0	✓	0.10	GI045	S01
	S12K-SCLCL 06	12	16	9	11	11.5	125	–	-8	0	–	0.11	GI045	S01
	S16M-SCLCL 06	16	20	11	14.5	15	150	–	-8	0	–	0.24	GI045	S01
	A10K-SCLCL 08	10	12	6	9	9.5	125	4	-14	0	✓	0.00	GI232	SC22
	A12M-SCLCL 08	12	16	9	11	11.5	150	5	-5	0	✓	0.14	GI232	SC22

	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	CND (mm)	LAMS (°)	GAMO (°)		kg		
L	**A16R-SCLCL 08**	16	20	11	14	15	200	6	-8	0	✓	0.30	GI232	SC22
	A16M-SCLCL 09-A	16	20	11	14.5	–	150	6	-8	0	✓	0.22	GI041	S05
	S16M-SCLCL 09-A	16	20	11	14.5	15	150	–	-8	0	–	0.24	GI041	S05
	A20Q-SCLCL 09	20	25	13	18	–	180	8	-5	0	✓	0.37	GI041	S08
	S20S-SCLCL 09	20	25	13	18	18.5	250	–	-5	0	–	0.60	GI041	S08
	A25R-SCLCL 09	25	32	17	23	23	200	8	-3	0	✓	0.67	GI041	S08
	S25T-SCLCL 09	25	32	17	23	23	300	–	-3	0	–	1.08	GI041	S08
	A32S-SCLCL 12-A	32	40	22	30	30	250	8	-10	0	✓	1.35	GI011	SC20
	S32U-SCLCL 12-A	32	40	22	30	30	350	–	-10	0	–	2.00	GI011	SC20

GI011	CC.. 1204..
GI041	CC.. 09T3..
GI045	CC.. 0602..
GI232	CC.. 0803..

		Nm						
SC20	US 5012-T15P	5.0	M 5	12.2	SCN 120304	MS 5008	FLAG T15P	HXK 5
SC22	5513 020-04	1.5	M 3	7.2	–	–	PT-8003	–
S01	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–
S02	US 2505-T07P	0.9	M 2.5	5.2	–	–	FLAG T07P	–
S05	US 4008-T15P	3.5	M 4	8	–	–	FLAG T15P	–
S08	US 3510-T15P	3.0	M 3.5	10.6	–	–	FLAG T15P	–

SCXC(RL) INT

P M K N S H

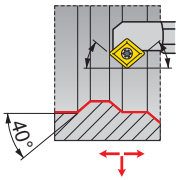
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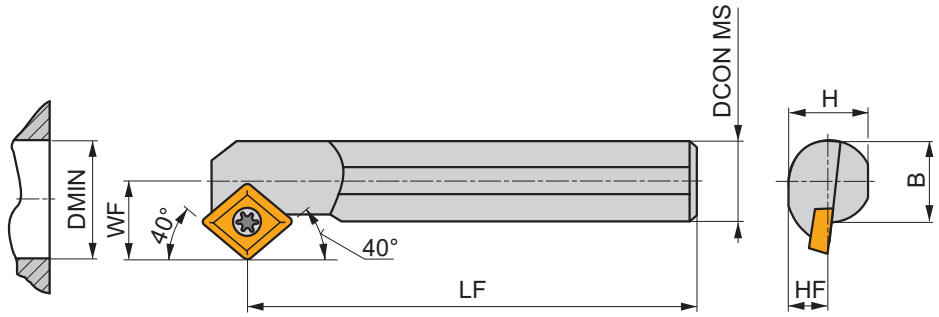
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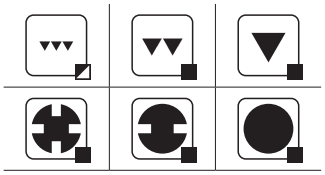


CC.. Uç için Vida Sıkmalı 40° Açılı Delik Kateri

Vida sıkmalı Sağ/Sol 40° delik kateri. Pozitif CC.. uçlarla kenar ve pah tornalama ile iç konik ve çap tornalama için uygundur.Gövde uzun takım ömrü için işlem görmüştür.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)	kg		
R	**S10H-SCXCR 06**	10	13	7	9	9.5	100	-10	0	0.06	GI045	S06
	S12K-SCXCR 06	12	16	9	11	11.5	125	-8	0	0.11	GI045	S06
	S16Q-SCXCR 06	16	20	11	14.5	15	180	-7	0	0.29	GI045	S07
L	**S10H-SCXCL 06**	10	13	7	9	9.5	100	-10	0	0.06	GI045	S06
	S12K-SCXCL 06	12	16	9	11	11.5	125	-8	0	0.11	GI045	S06
	S16Q-SCXCL 06	16	20	11	14.5	15	180	-7	0	0.30	GI045	S07

GI045	CC.. 0602..

		Nm			
S06	US 2505-T07P	0.9	M 2.5	5.2	FLAG T07P
S07	US 2506-T07P	0.9	M 2.5	6.3	FLAG T07P

C.-SCLC(RL) INT

P M K N S H

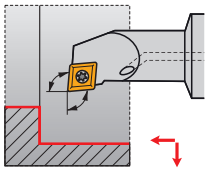
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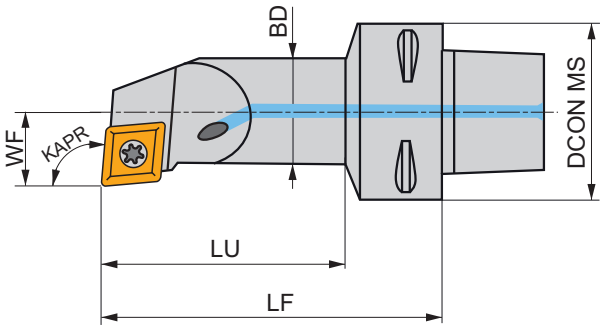
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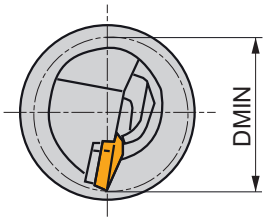


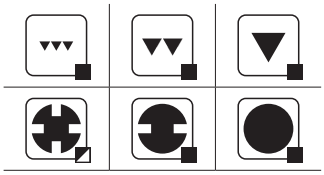
CC.. Uç için Vida Sıkmalı 95° Açılı PSC Hızlı Değiştirme Delik Takımı

Vida sıkmalı tip CC.. uçlar için 95° kesme açılı, içten soğutmalı, içten soğutmalı, İçten Sağ/Sol yönlü takım. Çok çeşitli iç tornalama uygulamaları için uygundur. Uzunluk seçenekleriyle Çokgen Saplı Kaplin.Gövde uzun takım ömrü için işlem görmüştür.











	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	LF (mm)	LU (mm)	BD (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg		
R	C3-SCLCR-11065-09	32	20	11	65	48	16	95	-8.4	0	✓	0.21	GI041	SC09M
	C3-SCLCR-13075-09	32	25	13	75	58	20	95	-5.8	0	✓	0.26	GI041	SC09M
	C4-SCLCR-11070-09	40	20	11	70	47	16	95	-8.4	0	✓	0.36	GI041	SC09M
	C4-SCLCR-13080-09	40	25	13	80	57	20	95	-5.8	0	✓	0.41	GI041	SC09M
	C4-SCLCR-17090-09	40	32	17	90	68	25	95	-3.4	0	✓	0.50	GI041	SC09M
	C5-SCLCR-11070-09	50	20	11	70	46	16	95	-8.4	0	✓	0.55	GI041	SC09M
	C5-SCLCR-13080-09	50	25	13	80	56	20	95	-5.8	0	✓	0.60	GI041	SC09M
L	C4-SCLCL-11070-09	40	20	11	70	47	16	95	-8.4	0	✓	0.36	GI041	SC09M
	C4-SCLCL-13080-09	40	25	13	80	57	20	95	-5.8	0	✓	0.41	GI041	SC09M
	C5-SCLCL-11070-09	50	20	11	70	46	16	95	-8.4	0	✓	0.55	GI041	SC09M
	C5-SCLCL-13080-09	50	25	13	80	56	20	95	-5.8	0	✓	0.60	GI041	SC09M

GI041	CC.. 09T3..

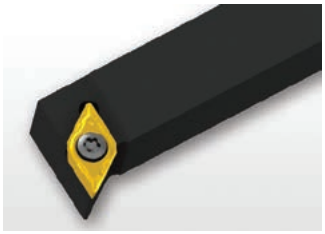
		Nm			
SC09M	US 2009-T15P	3.0	M 3.5	8.1	FLAG T15P/3,5

SDFC(RL) EXT

P M K N S H

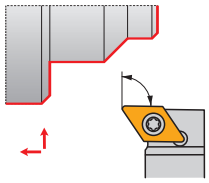
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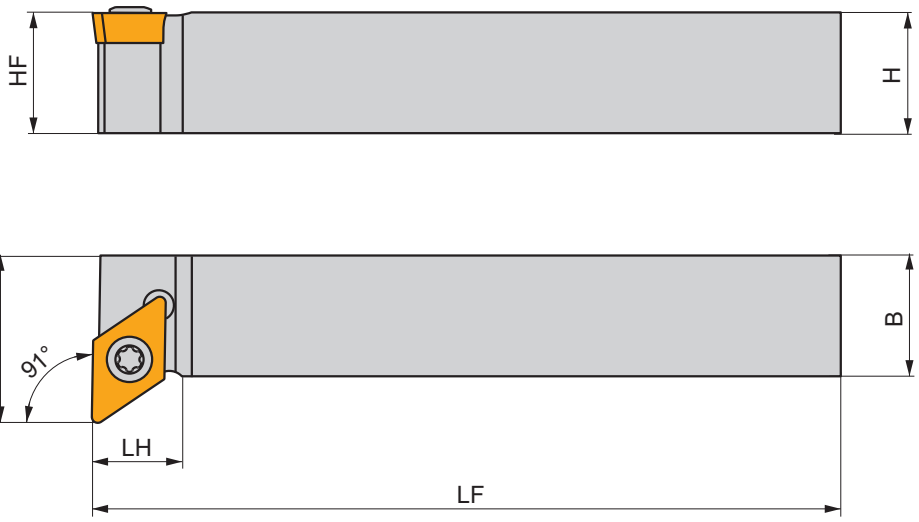
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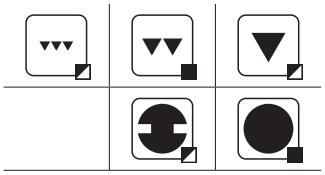


DC Uç için Vida Sıkmalı 91° Açılı Dış Kater

Vida tipi pozitif DC 07 ve 11 uç için 91° açılı Sağ/Sol yönlü dış kater. Dış boyuna kenar, kopya, alın, konik ve pah tornalama için uygundur. 12 × 12 ile 16 × 16 mm arası şaft boyutları ile sunulmuştur ve kayar otomat tezgahlarında kullanılabilir. Gövde uzun takım ömrü için işlem görmüştür.









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	SDFCR 1212 K 07-S	12	12	12	16	125	8.8	0	0	0.14	GI052	S01
	SDFCR 1616 K 11-S	16	16	16	22	125	11.9	0	0	0.25	GI012	S08
L	SDFCL 1212 K 07-S	12	12	12	16	125	8.8	0	0	0.14	GI052	S01
	SDFCL 1616 K 11-S	16	16	16	22	125	11.9	0	0	0.25	GI012	S08

GI012	DC.. 11T3..
GI052	DC.. 0702..

		Nm			
S01	US 2506-T07P	0.9	M 2.5	6.3	FLAG T07P
S08	US 3510-T15P	3.0	M 3.5	10.6	FLAG T15P

SDJC(RL) EXT

P M K N S H

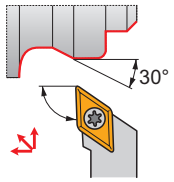
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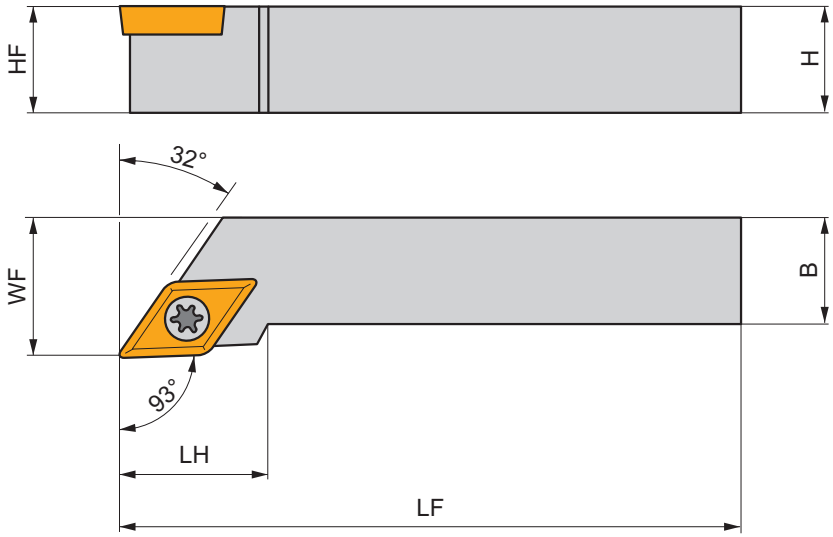
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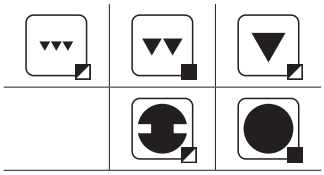


DC Uç için Vida Sıkmalı 93° Açılı Dış Kater

Vida tipi pozitif DC 07, 11 ve 15 uç için 93° açılı Sağ/Sol yönlü dış kater. Dış boyuna kenar, kopya, konik ve pah tornalama için uygundur. 08 × 08 ile 25 × 25 mm arası şaft boyutları ile sunulmuştur, bazıları kayar otomat tezgahlarında kullanılabilir. Gövde uzun takım ömrü için işlem görmüştür.









	Product	H	B	HF	WF	LF	LH	LAMS	GAMO			
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)	kg		
R	SDJCR 0808 D 07	8	8	8	10	60	14.0	0	0	0.05	GI052	S01
	SDJCR 1010 E 07	10	10	10	12	70	14.0	0	0	0.06	GI052	S01
	SDJCR 1212 F 07	12	12	12	16	80	14.0	0	0	0.11	GI052	S01
	SDJCR 1212 F 11	12	12	12	16	80	20.0	0	0	0.10	GI012	S08
	SDJCR 1212 K 07-S	12	12	12	12	125	18.2	0	0	0.13	GI052	S01
	SDJCR 1212 K 11-S	12	12	12	12	125	22.6	0	0	0.13	GI012	S08
	SDJCR 1616 H 11	16	16	16	20	100	20.0	0	0	0.22	GI012	S08
	SDJCR 1616 K 11-S	16	16	16	16	125	22.6	0	0	0.23	GI012	S08
	SDJCR 2020 K 11-M-A	20	20	20	25	125	20.0	0	0	0.40	GI012	SD10
	SDJCR 2525 M 11-M-A	25	25	25	32	150	20.0	0	0	0.74	GI012	SD10
	SDJCR 2525 M 15	25	25	25	32	150	28.0	0	0	0.74	GI243	SD11
L	SDJCL 0808 D 07	8	8	8	10	60	14.0	0	0	0.04	GI052	S01
	SDJCL 1010 E 07	10	10	10	12	70	14.0	0	0	0.07	GI052	S01
	SDJCL 1212 F 07	12	12	12	16	80	14.0	0	0	0.11	GI052	S01
	SDJCL 1212 F 11	12	12	12	16	80	20.0	0	0	0.11	GI012	S08
	SDJCL 1212 K 07-S	12	12	12	12	125	18.2	0	0	0.13	GI052	S01
	SDJCL 1212 K 11-S	12	12	12	12	125	22.6	0	0	0.13	GI012	S08
	SDJCL 1616 H 11	16	16	16	20	100	20.0	0	0	0.20	GI012	S08
	SDJCL 1616 K 11-S	16	16	16	16	125	22.6	0	0	0.23	GI012	S08
	SDJCL 2020 K 11-M-A	20	20	20	25	125	20.0	0	0	0.41	GI012	SD10
	SDJCL 2525 M 11-M-A	25	25	25	32	150	20.0	0	0	0.74	GI012	SD10
	SDJCL 2525 M 15	25	25	25	32	150	28.0	0	0	0.07	GI243	SD11

GI012	DC.. 11T3..
GI052	DC.. 0702..
GI243	DC.. 1504..

		Nm						
SD10	US 3510-T15P	3.0	M 3.5	10.6	SDN 110304	MS 3510	FLAG T15P	HXK 3.5
SD11	US 64518-T15P	5.0	M 4.5	18	SDN 150304	MS 4512	FLAG T15P	HXK 5
S01	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–
S08	US 3510-T15P	3.0	M 3.5	10.6	–	–	FLAG T15P	–

SDNCN EXT

P M K N S H

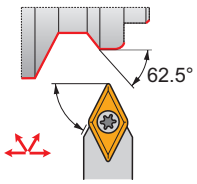
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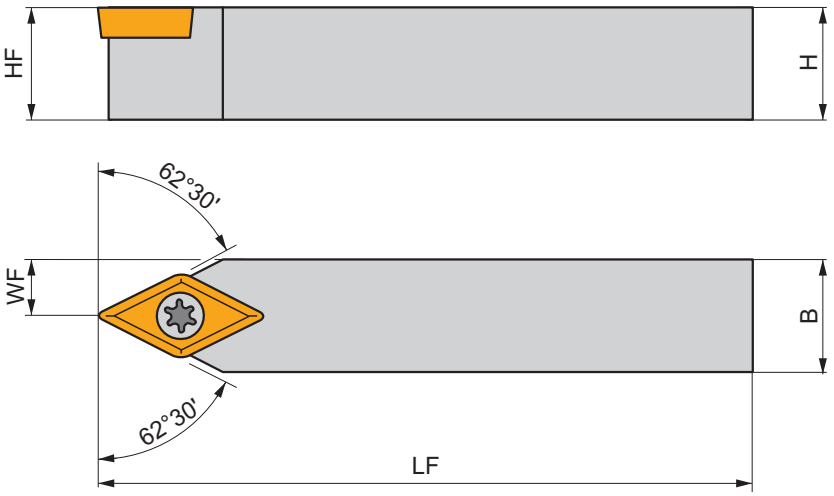
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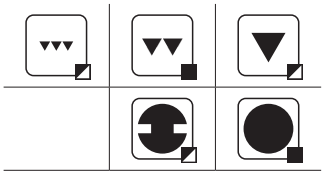


DC Uç için Vida Sıkmalı 62,5° Açılı Dış Kater

Vida sıkmalı nötr dış kater. Pozitif DC.. 07 veya 11 uçlarla çap, kopya, konik ve pah tornalama için uygundur. 08x08-25x25mm mevcuttur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LAMS (°)	GAMO (°)	kg		
N	**SDNCN 0808 D 07**	8	8	8	4	60	0	0	0.05	GI052	S01
	SDNCN 1010 E 07	10	10	10	5	70	0	0	0.07	GI052	S01
	SDNCN 1212 F 07	12	12	12	6	80	0	0	0.11	GI052	S01
	SDNCN 1212 F 11	12	12	12	6	80	0	0	0.11	GI012	S08
	SDNCN 1616 H 11	16	16	16	8	100	0	0	0.20	GI012	S08
	SDNCN 2020 K 11-M-A	20	20	20	10	125	0	0	0.35	GI012	SD10
	SDNCN 2525 M 11-M-A	25	25	25	12.5	150	0	0	0.70	GI012	SD10

GI012	DC.. 11T3..
GI052	DC.. 0702..

		Nm						
SD10	US 3510-T15P	3.0	M 3.5	10.6	SDN 110304	MS 3510	FLAG T15P	HXK 3.5
S01	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–
S08	US 3510-T15P	3.0	M 3.5	10.6	–	–	FLAG T15P	–

SDUCL EXT

P M K N S H

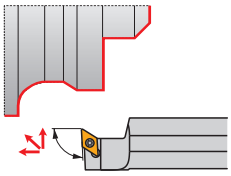
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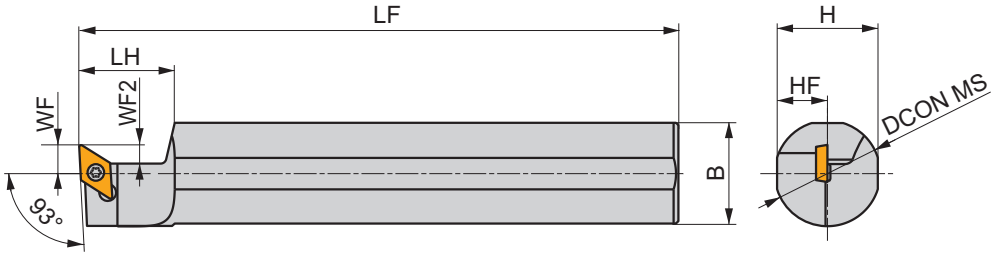
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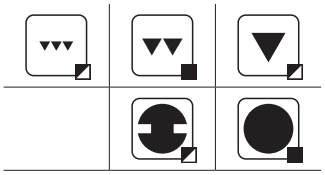


DC Uç için Vida Sıkmalı 93° Açılı Dış Kater

Vida tipi pozitif DC 07 uç için 93° açılı Sağ/Sol yönlü dış kater. Dış boyuna kenar, kopya, alın, konik ve pah tornalama için uygundur. 12 × 12 ile 16 × 16 mm arası şaft boyutları ile sunulmuştur ve kayar otomat tezgahlarında kullanılabilir. Gövde uzun takım ömrü için işlem görmüştür.









	Product	DCON MS (mm)	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	WF2 (mm)	LAMS (°)	GAMO (°)	kg		
L	**S20K-SDUCL07-S**	20	19	19	9.5	6	125	18.0	4	0	0	0.23	GI052	S01
	S22K-SDUCL07-S	22	21	21	10.5	6	125	18.0	4	0	0	0.27	GI052	S01

GI052	DC.. 0702..

S01	US 2506-T07P	0.9 Nm	M 2.5	6.3	FLAG T07P

SDXC(RL) EXT

P M K N S H

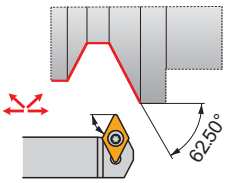
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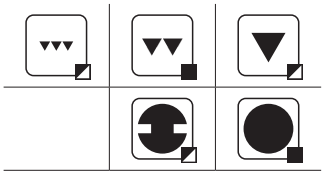
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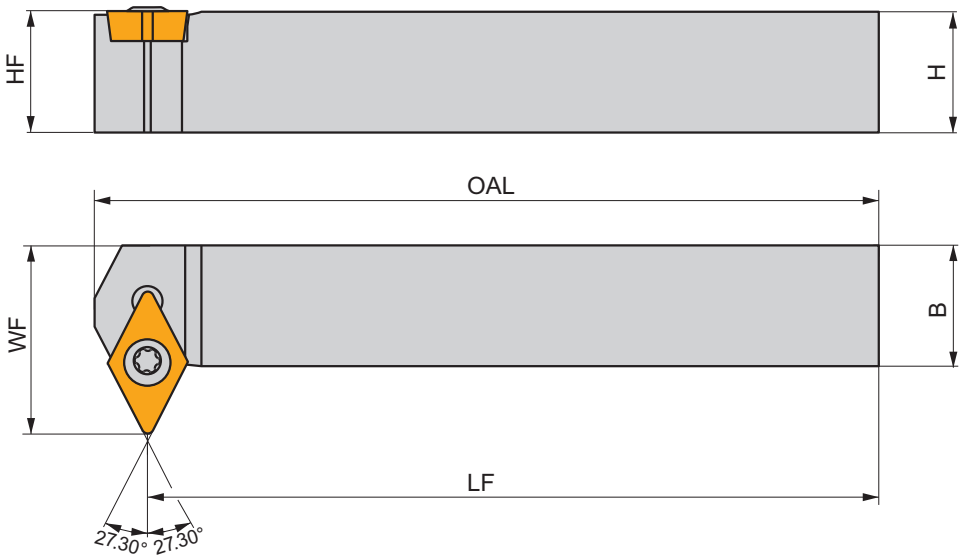


DC.. Uçlar için 62,5° Kesme Açılı Dış Vida Sıkmalı Kater

Vida tipi pozitif DC 07 ve 11 uçlar için 62,5° açılı Sağ/Sol yönlü dış kater. Dış boyuna kenar, kopya, konik ve pah tornalama için uygundur. 12 × 12 ile 16 × 16 mm arası şaft boyutları ile sunulmuştur ve kayar otomat tezgahlarında kullanılabilir. Gövde uzun takım ömrü için işlem görmüştür.









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	OAL (mm)	LAMS (°)	GAMO (°)	kg		
R	SDXCR 1212 K 07-S	12	12	12	18	125	130	0	0	0.15	GI052	S01
	SDXCR 1616 K 11-S	16	16	16	25	125	132	0	0	0.26	GI012	S08
L	SDXCL 1212 K 07-S	12	12	12	18	125	130	0	0	0.15	GI052	S01
	SDXCL 1616 K 11-S	16	16	16	25	125	132	0	0	0.26	GI012	S08

GI012	DC.. 11T3..
GI052	DC.. 0702..

		Nm			
S01	US 2506-T07P	0.9	M 2.5	6.3	FLAG T07P
S08	US 3510-T15P	3.0	M 3.5	10.6	FLAG T15P

C.-SDJC(RL) EXT

P M K N S H

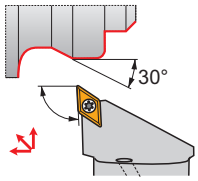
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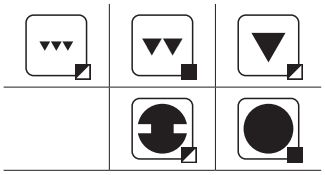
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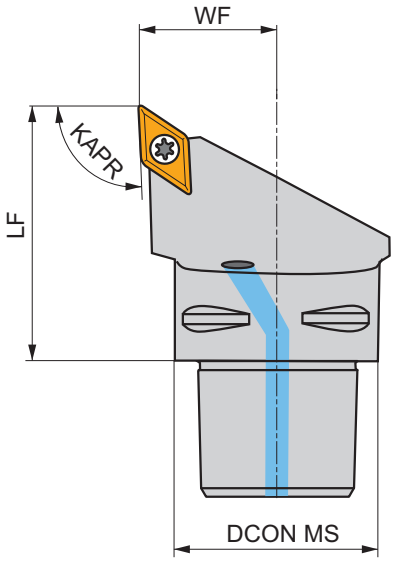


DC.. Uç için Vida Sıkmalı, 93° Açılı Hızlı Değiştirme Dış Takımı

Vida sıkmalı Sağ/Sol, içten su vermeli 93° dış kater. Pozitif DC.. 07, 11 veya 15 uçlarla çap, kopya, konik, kopya ve pah tornalama için uygundur. PSC C3-C5 ölçülerinde bulunur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	DCON MS (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg		
R	**C3-SDJCR-22040-11**	32	22	40	93	0	0	✓	0.20	GI012	C-SD11V-1
	C4-SDJCR-27050-11	40	27	50	93	0	0	✓	0.38	GI012	C-SD11V-1
	C5-SDJCR-35060-11	50	35	60	93	0	0	✓	0.69	GI012	C-SD11V-2
L	**C3-SDJCL-22040-11**	32	22	40	93	0	0	✓	0.20	GI012	C-SD11V-1
	C4-SDJCL-27050-11	40	27	50	93	0	0	✓	0.38	GI012	C-SD11V-1
	C5-SDJCL-35060-11	50	35	60	93	0	0	✓	0.70	GI012	C-SD11V-2

GI012	DC.. 11T3..

		Nm						
C-SD11V-1	US 2001-T15P	3.0	M 3.5	12.1	SDS 263-01	MS 9001	FLAG T15P/3,5	CN 034-01
C-SD11V-2	US 2001-T15P	3.0	M 3.5	12.1	SDS 263-01	MS 9001	FLAG T15P/3,5	CN 034-02

C.-SDNCN EXT

P M K N S H

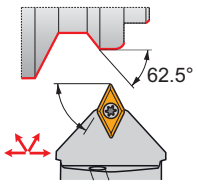
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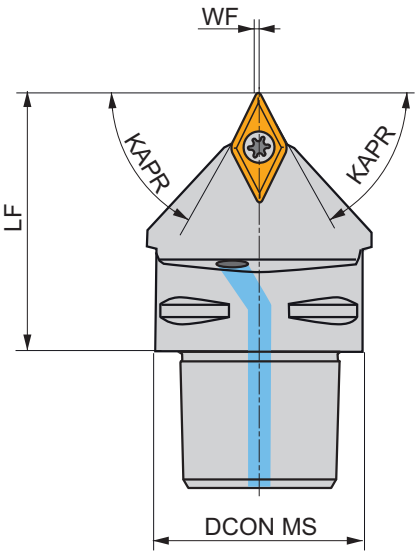
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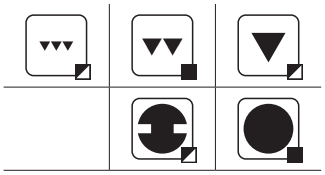


DC.. Uç için Vida Sıkmalı, 62.5° Açılı Hızlı Değiştirme Dış Takımı

Vida sıkmalı Sağ/Sol, içten su vermeli 62.5° dış kater. Pozitif DC.. 11 uçlarla çap,konik, kopya ve pah tornalama için uygundur. PSC C4 ve C5 ölçülerinde bulunur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	DCON MS (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg		
N	**C4-SDNCN-00050-11**	40	0.5	50	62.5	0	0	✓	0.35	GI012	C-SD11V-1
	C5-SDNCN-00060-11	50	0.5	60	62.5	0	0	✓	0.62	GI012	C-SD11V-2

GI012	DC.. 11T3..

		Nm						
C-SD11V-1	US 2001-T15P	3.0	M 3.5	12.1	SDS 263-01	MS 9001	FLAG T15P/3,5	CN 034-01
C-SD11V-2	US 2001-T15P	3.0	M 3.5	12.1	SDS 263-01	MS 9001	FLAG T15P/3,5	CN 034-02

SDQC(RL) INT

P M K N S H

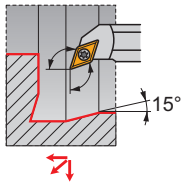
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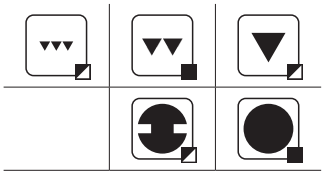
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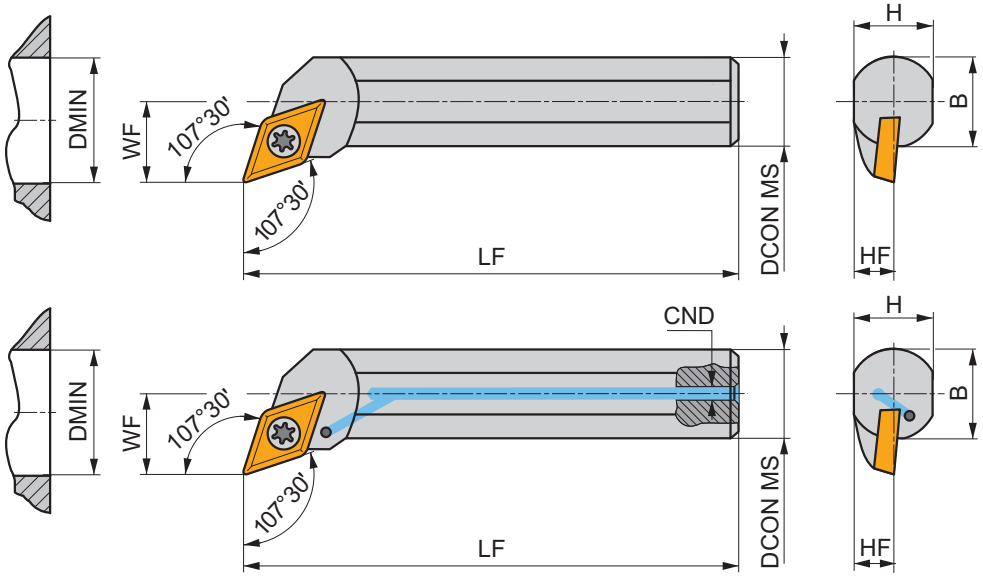


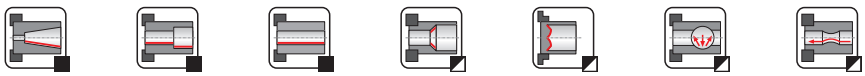
DC.. Uç için Vida Sıkmalı 107.5° Açılı Delik Kateri

Vida sıkmalı Sağ/Sol 107.5° delik kateri. Pozitif DC.. uçlarla kenar ve pah tornalama ile iç konik ve çap tornalama için uygundur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	CND (mm)	LAMS (°)	GAMO (°)		kg		
R	A10H-SDQCR 07	10	13	7	9	–	100	4	-10	0	✓	0.07	GI052	S02
	A12K-SDQCR 07	12	16	9	11	–	125	5	-7	0	✓	0.10	GI052	S02
	A16M-SDQCR 07	16	20	11	14.5	–	150	6	-7	0	✓	0.22	GI052	S01
	A20Q-SDQCR 11	20	25	13	18	–	180	8	-5	0	✓	0.36	GI012	S08
	S20S-SDQCR 11	20	25	13	18	18.5	250	–	-5	0	–	0.60	GI012	S08
	A25R-SDQCR 11	25	32	17	23	23	200	8	-3	0	✓	0.65	GI012	S08
	S25T-SDQCR 11	25	32	17	23	23	300	–	-3	0	–	1.08	GI012	S08
	A32S-SDQCR 11-A	32	40	22	30	30	250	8	-10	0	✓	1.25	GI012	SD10
	S32U-SDQCR 11-A	32	40	22	30	30	350	–	-10	0	–	2.10	GI012	SD10
L	A10H-SDQCL 07	10	13	7	9	–	100	4	-10	0	✓	0.06	GI052	S02
	A12K-SDQCL 07	12	16	9	11	–	125	5	-7	0	✓	0.11	GI052	S02
	A16M-SDQCL 07	16	20	11	14.5	–	150	6	-7	0	✓	0.22	GI052	S01
	A20Q-SDQCL 11	20	25	13	18	–	180	8	-5	0	✓	0.37	GI012	S08
	S20S-SDQCL 11	20	25	13	18	18.5	250	–	-5	0	–	0.63	GI012	S08
	A25R-SDQCL 11	25	32	17	23	23	200	8	-3	0	✓	0.64	GI012	S08
	S25T-SDQCL 11	25	32	17	23	23	300	–	-3	0	–	1.15	GI012	S08
	A32S-SDQCL 11-A	32	40	22	30	30	250	8	-10	0	✓	1.32	GI012	SD10
	S32U-SDQCL 11-A	32	40	22	30	30	350	–	-10	0	–	2.08	GI012	SD10

GI012	DC.. 11T3..
GI052	DC.. 0702..

		Nm						
SD10	US 3510-T15P	3.0	M 3.5	10.6	SDN 110304	MS 3510	FLAG T15P	HXK 3.5
S01	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–
S02	US 2505-T07P	0.9	M 2.5	5.2	–	–	FLAG T07P	–
S08	US 3510-T15P	3.0	M 3.5	10.6	–	–	FLAG T15P	–

SDUC(RL) INT

P M K N S H

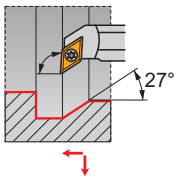
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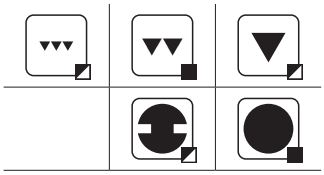
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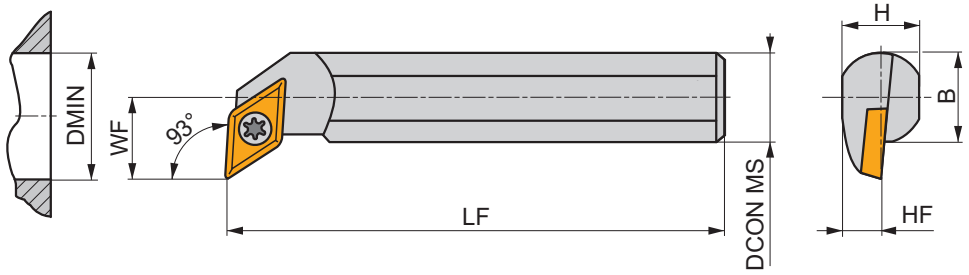


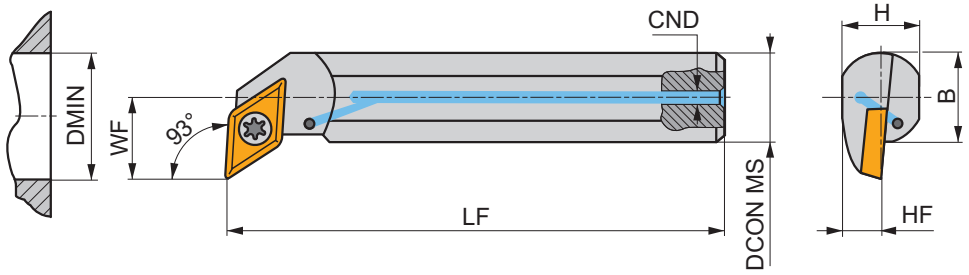
DC.. Uç için Vida Sıkmalı 93° Açılı Delik Kateri

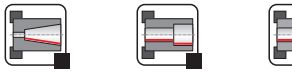
Vida sıkmalı Sağ/Sol 93° içten su vermeli delik kateri. Pozitif DC.. uçlarla mKenar ve pah tornalama ile iç konik ve çap tornalama için uygundur. Ø10-32mm şaft ölçülerinde bulunur. Gövde uzun takım ömrü için işlem görmüştür.











	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	CND (mm)	LAMS (°)	GAMO (°)		kg		
R	A10H-SDUCR 07	10	13	7	9	–	100	4	-10	0	✓	0.07	GI052	S02
	A12K-SDUCR 07	12	16	9	11	–	125	5	-7	0	✓	0.12	GI052	S02
	A16M-SDUCR 07	16	20	11	14.5	–	150	6	-7	0	✓	0.22	GI052	S01
	A20Q-SDUCR 11	20	25	13	18	–	180	8	-3	0	✓	0.37	GI012	S08
	S20S-SDUCR 11	20	25	13	18	18.5	250	–	-5	0	–	0.60	GI012	S08
	A25R-SDUCR 11	25	32	17	23	23	200	8	-3	0	✓	0.60	GI012	S08
	S25T-SDUCR 11	25	32	17	23	23	300	–	-3	0	–	1.09	GI012	S08
	A32S-SDUCR 11-A	32	40	22	30	30	250	8	-10	0	✓	1.30	GI012	SD10
	S32U-SDUCR 11-A	32	40	22	30	30	350	–	-10	0	–	2.10	GI012	SD10
L	A10H-SDUCL 07	10	13	7	9	–	100	4	-10	0	✓	0.07	GI052	S02
	A12K-SDUCL 07	12	16	9	11	–	125	5	-7	0	✓	0.11	GI052	S02
	A16M-SDUCL 07	16	20	11	14.5	–	150	6	-7	0	✓	0.22	GI052	S01
	A20Q-SDUCL 11	20	25	13	18	–	180	8	-3	0	✓	0.37	GI012	S08
	S20S-SDUCL 11	20	25	13	18	18.5	250	–	-5	0	–	0.60	GI012	S08
	A25R-SDUCL 11	25	32	17	23	23	200	8	-3	0	✓	0.66	GI012	S08
	S25T-SDUCL 11	25	32	17	23	23	300	–	-3	0	–	1.09	GI012	S08
	A32S-SDUCL 11-A	32	40	22	30	30	250	8	-10	0	✓	0.00	GI012	SD10
	S32U-SDUCL 11-A	32	40	22	30	30	350	–	-10	0	–	2.09	GI012	SD10

GI012	DC.. 11T3..
GI052	DC.. 0702..

		Nm						
SD10	US 3510-T15P	3.0	M 3.5	10.6	SDN 110304	MS 3510	FLAG T15P	HXK 3.5
S01	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–
S02	US 2505-T07P	0.9	M 2.5	5.2	–	–	FLAG T07P	–
S08	US 3510-T15P	3.0	M 3.5	10.6	–	–	FLAG T15P	–

SDUC(RL)-E INT

P M K N S H

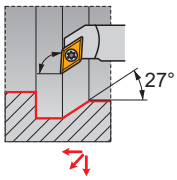
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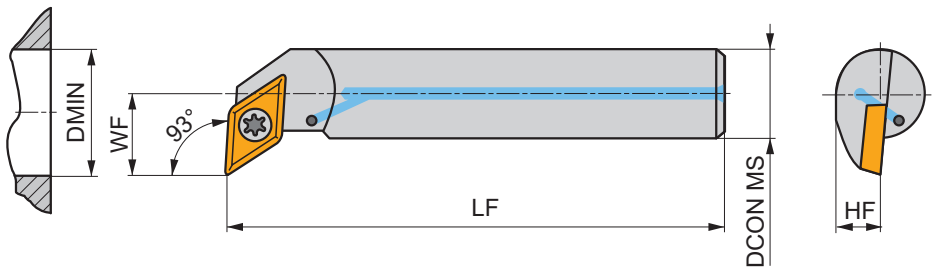
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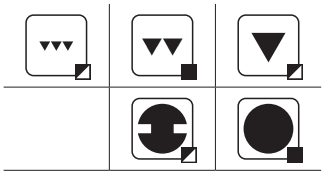


DC.. Uç için Vida Sıkmalı 93° Açılı Karbür Delik Kateri

Vida sıkmalı tip pozitif DC.. uçlar için 93° kesme açılı ,içten karbür delik işleme barası, içten soğutmalı. Kenar, konik, kopyalama ve pah tornalama ile iç boyuna tornalama için. Takım kullanma mesafesi için >3xD.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	HF (mm)	LF (mm)	LAMS (°)	GAMO (°)		kg		
R	E10M-SDUCR 07-ER	10	15	9	5.6	150	-5	0	✓	0.14	GI052	SD21
	E12Q-SDUCR 07-ER	12	18	11	6.5	150	-5	0	✓	0.26	GI052	SD21
	E16R-SDUCR 07-ER	16	22	13	8.5	150	-5	0	✓	0.49	GI052	SD21
L	E10M-SDUCL 07-ER	10	15	9	5.6	150	-5	0	✓	0.15	GI052	SD21
	E12Q-SDUCL 07-ER	12	18	11	6.5	150	-5	0	✓	0.26	GI052	SD21
	E16R-SDUCL 07-ER	16	22	13	8.5	150	-5	0	✓	0.50	GI052	SD21

GI052	DC.. 0702..

		Nm			
SD21	5513 020-03	0.8	M 2.5	6.5	PT-8001

SDZC(RL) INT

P M K N S H

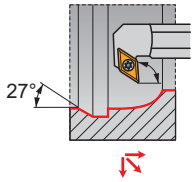
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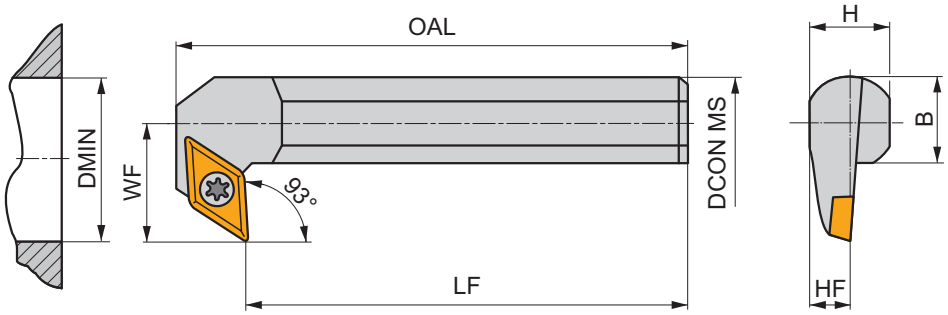
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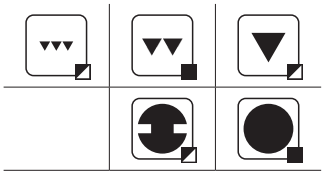


DC.. Uç için Vida Sıkmalı 93° Açılı Delik Kateri

Vida sıkmalı Sağ/Sol 93° delik kateri. Pozitif DC.. uçlarla minimum Kenar ve pah tornalama ile iç konik ve çap tornalama ,ters ve kopya için uygundur. Ø10-12mm şaft ölçülerinde bulunur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	OAL (mm)	LAMS (°)	GAMO (°)	kg		
R	S16M-SDZCR 07-93	16	27	17	14.5	15	150	163	-4	0	0.26	GI052	S01
	S20Q-SDZCR 11-93	20	35	22	18	18.5	180	198	-5	0	0.49	GI012	S08
	S25R-SDZCR 11-93	25	42	27	23	23	200	218	-3	0	0.79	GI012	S08
	S32S-SDZCR 11-93-A	32	53	35	30	30	250	268	-6	0	1.62	GI012	SD10
	S40T-SDZCR 11-93-A	40	65	43	38	38	300	322	-5	0	3.00	GI012	SD10
L	S16M-SDZCL 07-93	16	27	17	14.5	15	150	163	-4	0	0.27	GI052	S01
	S20Q-SDZCL 11-93	20	35	22	18	18.5	180	198	-5	0	0.48	GI012	S08
	S25R-SDZCL 11-93	25	42	27	23	23	200	218	-3	0	0.80	GI012	S08
	S32S-SDZCL 11-93-A	32	53	35	30	30	250	268	-6	0	1.60	GI012	SD10
	S40T-SDZCL 11-93-A	40	65	43	38	38	300	322	-5	0	3.00	GI012	SD10

GI012	DC.. 11T3..
GI052	DC.. 0702..

		Nm						
SD10	US 3510-T15P	3.0	M 3.5	10.6	SDN 110304	MS 3510	FLAG T15P	HXK 3.5
S01	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–
S08	US 3510-T15P	3.0	M 3.5	10.6	–	–	FLAG T15P	–

C.-SDUC(RL) INT

P M K N S H

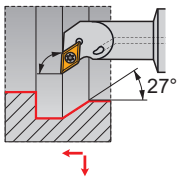
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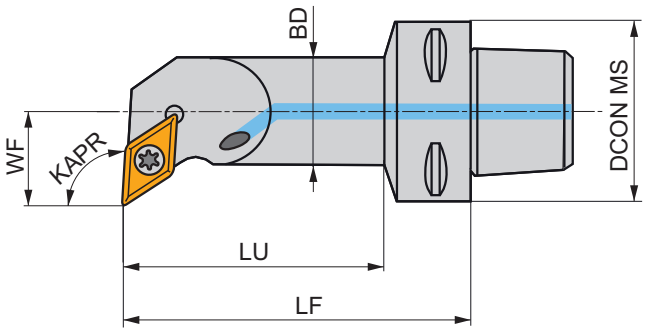
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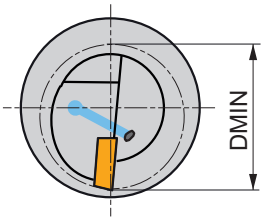


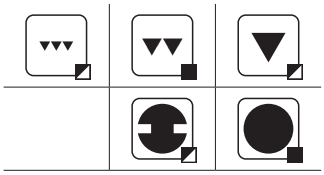
DC.. Uç için Vida Sıkmalı 93° Açılı PSC Hızlı Değiştirme Delik Takımı

Vida sıkmalı Sağ/Sol 93° içten su vermeli delik kateri. Pozitif DC.. uçlarla minimum ve birçok çeşit tornalama için uygundur. Çokgen şaft çeşitli boy ölçülerinde bulunur. Gövde uzun takım ömrü için işlem görmüştür.











	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	LF (mm)	LU (mm)	BD (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg		
R	C3-SDUCR-11065-07	50	20	11	65	48	16	93	-4.3	0	✓	0.20	GI052	SV11
	C4-SDUCR-11070-07	40	20	11	70	47	16	93	-4.3	0	✓	0.35	GI052	SV11
	C4-SDUCR-13080-11	40	25	13	80	57	20	93	-5.8	0	✓	0.41	GI012	SC09M
	C4-SDUCR-17090-11	40	32	17	90	68	25	93	-3.4	0	✓	0.49	GI012	SV16
	C5-SDUCR-13080-11	50	25	13	80	56	20	93	-5.8	0	✓	0.60	GI012	SC09M
	C5-SDUCR-17090-11	50	32	17	90	67	25	93	-3.4	0	✓	0.68	GI012	SV16
L	C4-SDUCL-11070-07	40	20	11	70	47	16	93	-4.3	0	✓	0.35	GI052	SV11
	C4-SDUCL-13080-11	40	25	13	80	57	20	93	-5.8	0	✓	0.41	GI012	SC09M
	C4-SDUCL-17090-11	40	32	17	90	68	25	93	-3.4	0	✓	0.49	GI012	SV16
	C5-SDUCL-13080-11	50	25	13	80	56	20	93	-5.8	0	✓	0.60	GI012	SC09M

GI012	DC.. 11T3..
GI052	DC.. 0702..

		Nm				
SC09M	US 2009-T15P	3.0	M 3.5	8.1	FLAG T15P/3,5	–
SV11	US 2003-T07P	0.8	M 2.5	6.5	–	FLAG T07P
SV16	US 2010-T15P	3.0	M 3.5	10.1	–	FLAG T15P/3,5

SEGC(RL) EXT

P M K N S H

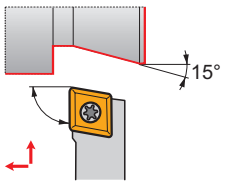
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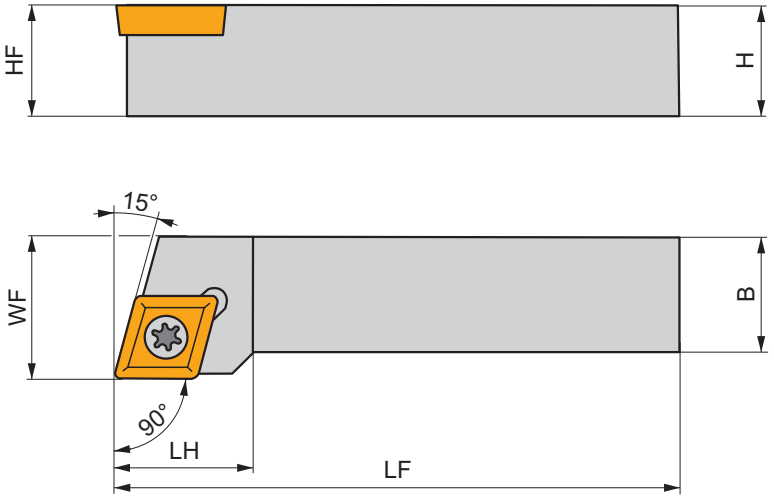
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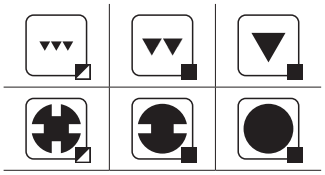


EC.. Uç için Vida Sıkmalı 90° Açılı Dış Kater

Vida sıkmalı Sağ/Sol 90° dış kater. Pozitif EC.. 08 uçlarla çap, konik ve pah tornalama için uygundur. 12x12 ve 16x16mm şaft ölçülerinde bulunur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	SEGCR 1212 N 08	12	12	12	16	160	12.0	0	0	0.15	GI210	SE08
	SEGCR 1616 H 08	16	16	16	20	100	12.0	0	0	0.22	GI210	SE08
L	SEGCL 1212 N 08	12	12	12	16	160	12.0	0	0	0.22	GI210	SE08
	SEGCL 1616 H 08	16	16	16	20	100	12.0	0	0	2.14	GI210	SE08

GI210	EC.. 0803..

SE08	416.1-832	3.6	M 3	8.5	PT-8002

SEUC(RL) INT

P M K N S H

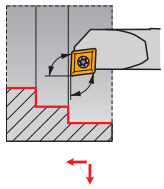
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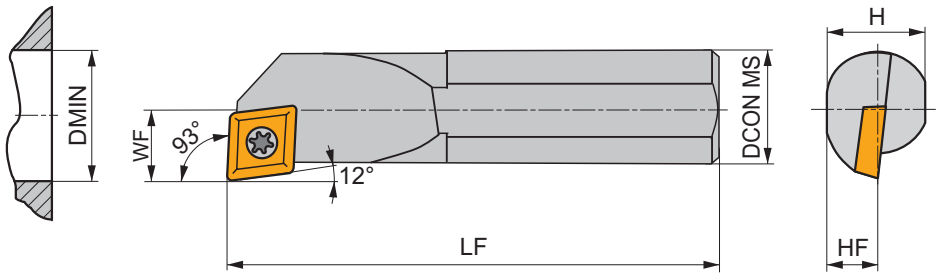
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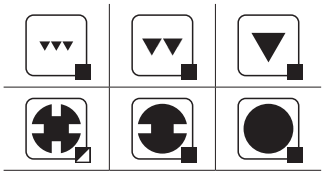


EC.. Uç için Vida Sıkmalı 93° Açılı Delik Kateri

Vida sıkmalı Sağ/Sol 93° delik kateri. Pozitif EC.. uçlarla Kenar ve pah tornalama ile iç konik ve çap tornalama için uygundur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	HF (mm)	LF (mm)	LAMS (°)	GAMO (°)	kg		
R	S08K-SEUCR 06	8	11	7	7	3.5	125	-5	0	0.06	GI213	SE23
	S10M-SEUCR 06	10	13	8	9	4.5	150	-5	0	0.10	GI213	SE23
	S12M-SEUCR 08	12	15	9	11	5.5	150	-5	0	0.14	GI210	SE24
	S16R-SEUCR 08	16	20	11	15	7.5	200	-5	0	0.32	GI210	SE24
	S20S-SEUCR 08	20	25	13	18	9	250	-5	0	0.58	GI210	SE24
	S25T-SEUCR 08	25	32	17	23	11.5	300	-4	0	1.06	GI210	SE24
L	S08K-SEUCL 06	8	11	7	7	3.5	125	-5	0	0.06	GI213	SE23
	S10M-SEUCL 06	10	13	8	9	4.5	150	-5	0	0.10	GI213	SE23
	S12M-SEUCL 08	12	15	9	11	5.5	150	-5	0	0.14	GI210	SE24
	S16R-SEUCL 08	16	20	11	15	7.5	200	-5	0	0.32	GI210	SE24
	S20S-SEUCL 08	20	25	13	18	9	250	-5	0	0.58	GI210	SE24

GI210	EC.. 0803..
GI213	EC.. 0602..

		Nm			
SE23	5513 020-03	0.8	M 2.5	6.5	PT-8001
SE24	416.1-832	3.6	M 3	8.5	PT-8003

SELP(RL) INT

P M K N S H

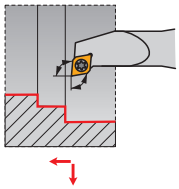
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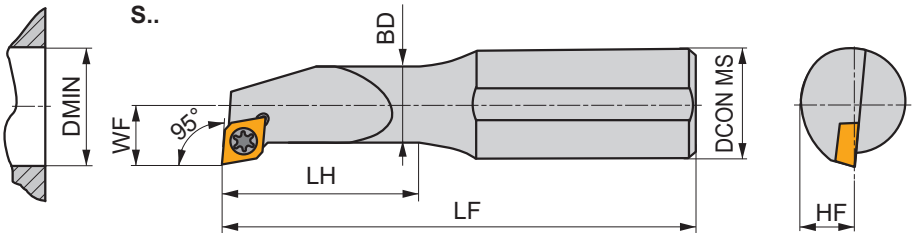
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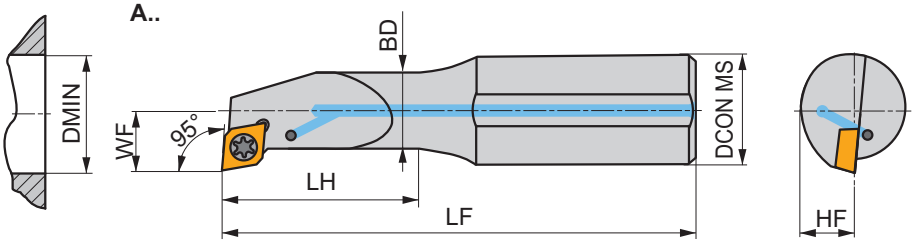


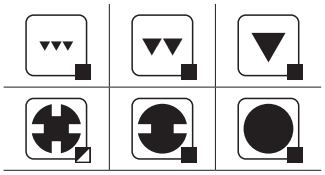
EP.. Uç için Vida Sıkmalı 95° Açılı Delik Kateri

Vidalı sıkmalı tip EP.. uçlar için 95° kesme açılı ,iç çap Sağ/Sol delik işleme barası, içten soğutmalı . Kenar ve pah tornalama ile iç konik ve çap tornalama için. Gövde uzun takım ömrü için işlem görmüştür.











	Product	DCON MS (mm)	DMIN (mm)	BD (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)		kg		
R	S0608H-SELPR 05	8	8	6	4.5	100	20.0	-10	0	–	0.04	GI212	SE21
	S0810J-SELPR 05	10	11	8	6	110	26.0	-5	0	–	0.06	GI212	SE22
	S1012K-SELPR 05	12	13	10	7	125	32.0	-5	0	–	0.11	GI212	SE22
	A1216M-SELPR 05	16	16	12	9	150	40.0	-2	0	✓	0.18	GI212	SE22
	S1216M-SELPR 05	16	16	12	9	150	40.0	-2	0	–	0.21	GI212	SE22
L	S0608H-SELPL 05	8	8	6	4.5	100	20.0	-10	0	–	0.04	GI212	SE21
	S0810J-SELPL 05	10	11	8	6	110	26.0	-5	0	–	0.06	GI212	SE22
	S1012K-SELPL 05	12	13	10	7	125	32.0	-5	0	–	0.11	GI212	SE22
	S1216M-SELPL 05	16	16	12	9	150	40.0	-2	0	–	0.21	GI212	SE22

GI212	EP.. 0502..

		Nm			
SE21	28992	0.8	M 2.2	4.2	MA2-8304
SE22	28588	0.8	M 2.2	5.6	MA2-8304

SELP(RL)-E INT

P M K N S H

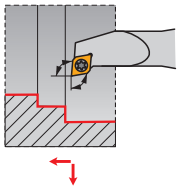
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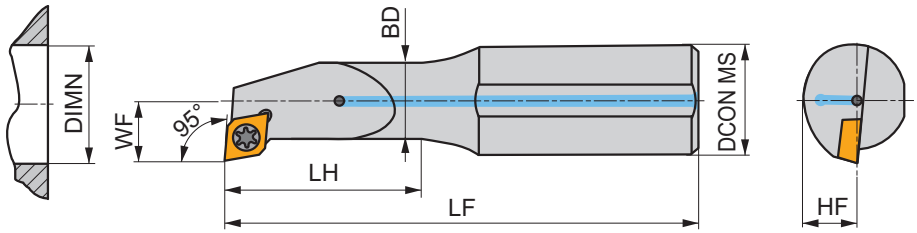
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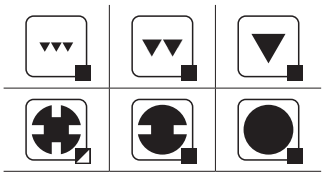


EP.. Uç için Vida Sıkmalı 95° Açılı Karbür Delik Kateri

Vida sıkmalı tip EP.. uçlar için 95° kesme açılı, içten soğutmalı, İçten Sağ/Sol karbür delik işleme barası. Kenar ve pah tornalama ile iç konik ve boyuna tornalama için uygundur. Takım kullanma mesafesi için >3xD.









	Product	DCON MS (mm)	DMIN (mm)	BD (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)		kg		
R	**E0608H-SELPR 05**	8	8	6	4.5	100	28.0	-10	0	✓	0.06	GI212	SE22
	E0810J-SELPR 05	10	11	8	6	110	36.0	-5	0	✓	0.10	GI212	SE22
	E1012K-SELPR 05	12	13	10	7	125	44.0	-5	0	✓	0.17	GI212	SE22
L	**E0608H-SELPL 05**	8	8	6	4.5	100	28.0	-10	0	✓	0.06	GI212	SE22
	E0810J-SELPL 05	10	11	8	6	110	36.0	-5	0	✓	0.10	GI212	SE22
	E1216M-SELPL 05	16	16	12	9	150	55.0	-2	0	✓	0.33	GI212	SE22

GI212	EP.. 0502..

SE22	28588	0.8 Nm	M 2.2	5.6	MA2-8304

SEUP(RL) INT

P M K N S H

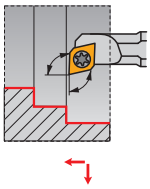
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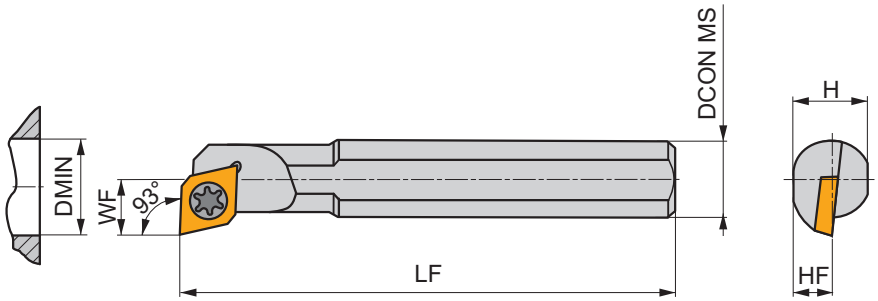
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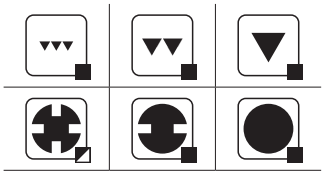


EP.. Uç için Vida Sıkmalı 93° Açılı Delik Kateri

Vida sıkmalı Sağ/Sol 93° delik kateri. Pozitif EP..uçlarlaKenar ve pah tornalama ile iç konik ve çap tornalama için uygundur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	HF (mm)	LF (mm)	LAMS (°)	GAMO (°)	kg		
R	S06H-SEUPR 05	6	8.3	5	5.4	2.7	100	-7	0	0.04	GI212	SE21
L	S06H-SEUPL 05	6	8.3	5	5.4	2.7	100	-7	0	0.05	GI212	SE21

GI212	EP.. 0502..

SE21	28992	0.8 Nm	M 2.2	4.2	MA2-8304

SEXP(RL) INT

P M K N S H

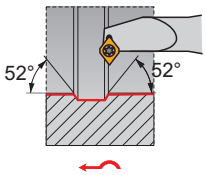
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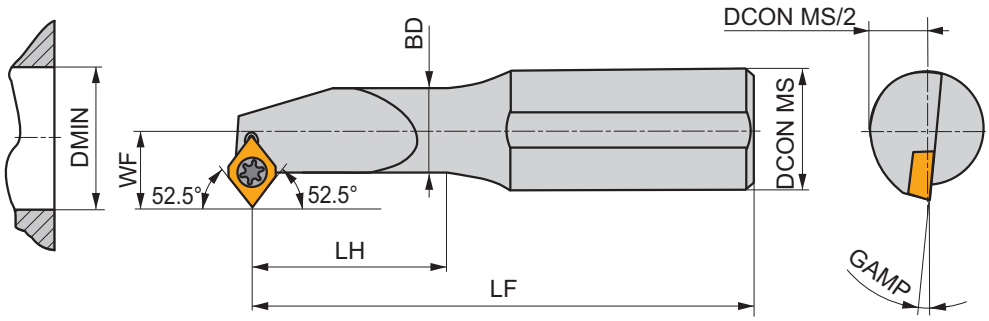
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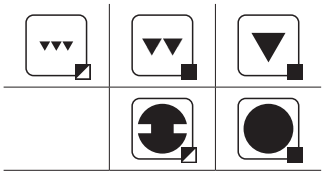


EP.. Uç için Vida Sıkmalı 52.5° Açılı Delik Kateri

Vida sıkmalı Sağ/Sol 52.5° delik kateri. Pozitif EP.. uçlarla Kenar ve pah tornalama ile iç konik ve ters çap tornalama için uygundur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	DCON MS (mm)	DMIN (mm)	BD (mm)	WF (mm)	LF (mm)	LH (mm)	GAMP (°)	kg		
R	S0608H-SEXPR 05	8	9.5	6	5.5	100	20.0	-7	0.04	GI212	SE21
	S0810J-SEXPR 05	10	11	8	6	110	26.0	-5	0.06	GI212	SE22
	S1012K-SEXPR 05	12	13	10	7	125	32.0	-5	0.11	GI212	SE22
	S1216M-SEXPR 05	16	16	12	9	150	40.0	-2	0.21	GI212	SE22
L	S0608H-SEXPL 05	8	9.5	6	5.5	100	20.0	-7	0.04	GI212	SE21
	S0810J-SEXPL 05	10	11	8	6	110	26.0	-5	0.06	GI212	SE22
	S1012K-SEXPL 05	12	13	10	7	125	32.0	-5	0.11	GI212	SE22
	S1216M-SEXPL 05	16	16	12	9	150	40.0	-2	0.21	GI212	SE22

GI212	EP.. 0502..

		Nm			
SE21	28992	0.8	M 2.2	4.2	MA2-8304
SE22	28588	0.8	M 2.2	5.6	MA2-8304

SEXP(RL)-E INT

P M K N S H

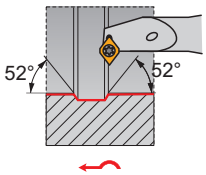
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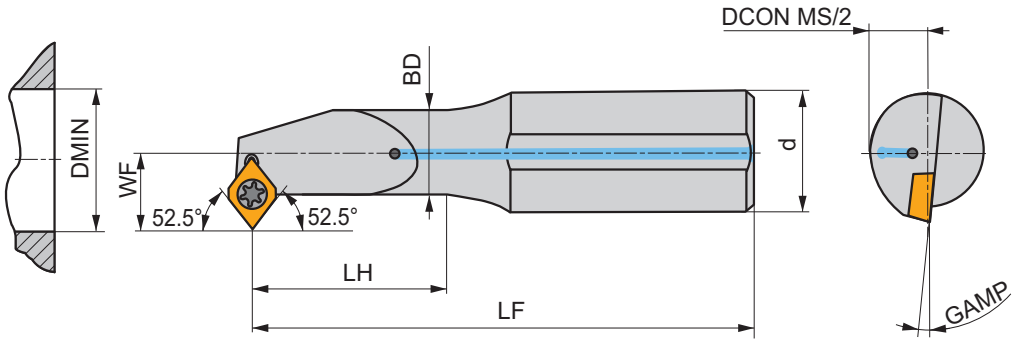
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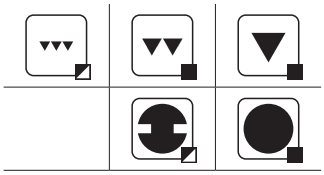


EP.. Uç için Vida Sıkmalı 52.5° Açılı Karbür Delik Kateri

İçten sağ/sol karbür delik işleme barası, içten soğutmalı, vida sıkmalı tip EP.. uçlar için 52,5° kesme açısı. İç arka pah, konik, çok yönlü, pahlı ve omuzsuz çap tornalama için.Tutucu İşleme Derinliği > 3xD.









	Product	DCON MS (mm)	DMIN (mm)	BD (mm)	WF (mm)	LF (mm)	LH (mm)	GAMP (°)		kg		
R	**E0608H-SEXPR 05**	8	9.5	6	5.5	100	28.0	-7	✓	0.07	GI212	SE21
	E0810J-SEXPR 05	10	11	8	6	110	36.0	-5	✓	0.10	GI212	SE22
	E1012K-SEXPR 05	12	13	10	7	125	44.0	-5	✓	0.16	GI212	SE22
	E1216M-SEXPR 05	16	16	12	9	150	55.0	-2	✓	0.32	GI212	SE22
L	**E0608H-SEXPL 05**	8	9.5	6	5.5	100	28.0	-7	✓	0.06	GI212	SE21

GI212	EP.. 0502..

		Nm			
SE21	28992	0.8	M 2.2	4.2	MA2-8304
SE22	28588	0.8	M 2.2	5.6	MA2-8304

PRDCN EXT

P M K N S H

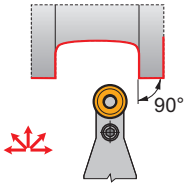
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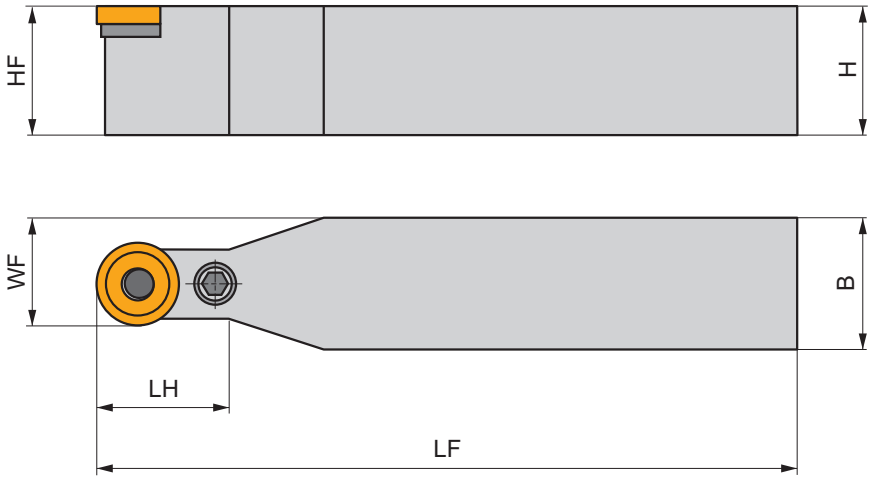
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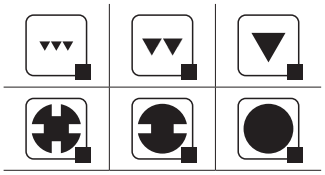


RC.. UÇ için Kollu Kilitleme Dış Kater

Kollu kilitli nötr dış kater. RC.. 16-32 uçlarla çap, 90°'ye kadar kopya, konik ve pah tornalama için uygundur. 32x25'ten 50x50mm'ye kadar mevcuttur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
N	**PRDCN 3225 P 16**	32	25	32	20.5	170	34.0	0	0	0.80	GI090	PR01
	PRDCN 3232 P 20	32	32	32	26	170	42.0	0	0	1.16	GI069	PR03
	PRDCN 4040 S 20	40	40	40	30	250	40.0	0	0	2.82	GI069	PR03
	PRDCN 4040 S 25	40	40	40	32.5	250	40.0	0	0	2.75	GI122	PR02
	PRDCN 5050 V 32	50	50	50	41	400	52.0	0	0	7.30	GI096	PR04

GI069	RCMX 2006M0
GI090	RCMX 1606M0
GI096	RCMX 3209M0
GI122	RCMX 2507M0

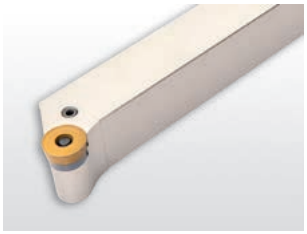
				Nm					
PR01	PRS 816	CL 116	CS 706	2.0	M 6x1	20.7	TR 16	MT 05	HXK 2.5
PR02	PRS 825	CL 125	CS 710	3.5	M 10x1	30.4	TR 19	MT 06	HXK 4
PR03	PRS 820	CL 120	CS 708	3.0	M 8x1	23.5	TR 15	MT 07	HXK 3
PR04	PRS 832	CL 132	CS 612	4.0	M 12x1	36	TR 25	MT 08	HXK 5

PRSC(RL) EXT

P M K N S H

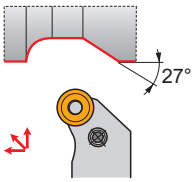
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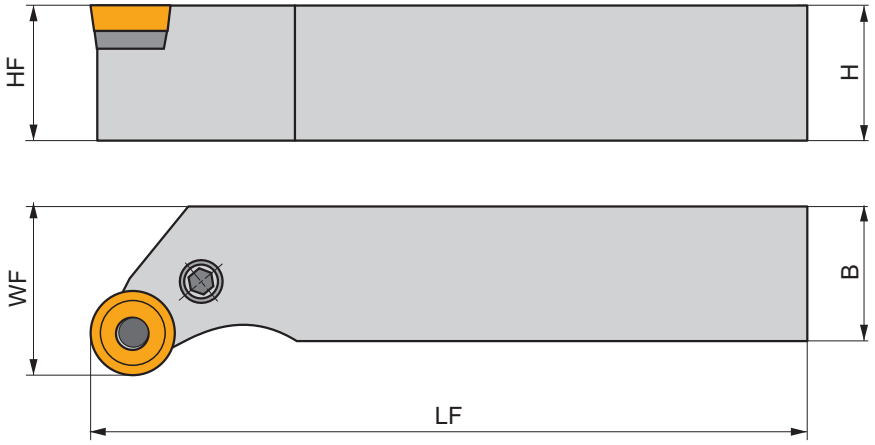
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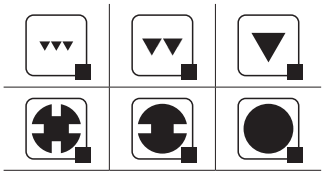


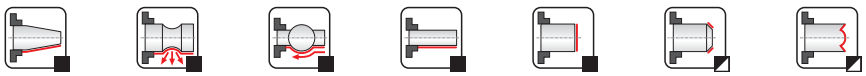
Yuvarlak RC.. Uçları için Levyeli Kilitli Takım Tutucu

Levyeli, Sağ/Sol dış kater. Pozitif RC.. 16 - 25 uçlarla çap, 27°'ye kadar kopya, konik ve pah tornalamak için uygundur. 32x25 - 40x40 kadar mevcuttur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LAMS (°)	GAMO (°)	kg		
R	PRSCR 3225 P 16	32	25	32	32	170	0	0	1.05	GI090	PR01
	PRSCR 3232 P 20	32	32	32	40	170	0	0	1.29	GI069	PR03
	PRSCR 4040 S 16	40	40	40	50	250	0	0	3.00	GI090	PR01
	PRSCR 4040 S 25	40	40	40	50	250	0	0	3.04	GI122	PR02
L	PRSCL 3225 P 16	32	25	32	32	170	0	0	0.90	GI090	PR01
	PRSCL 4040 S 16	40	40	40	50	250	0	0	2.38	GI090	PR01
	PRSCL 3232 P 20	32	32	32	40	170	0	0	1.32	GI069	PR03
	PRSCL 4040 S 25	40	40	40	50	250	0	0	3.06	GI122	PR02

GI069	RCMX 2006M0
GI090	RCMX 1606M0
GI122	RCMX 2507M0

				Nm					
PR01	PRS 816	CL 116	CS 706	2.0	M 6x1	20.7	TR 16	MT 05	HXK 2.5
PR02	PRS 825	CL 125	CS 710	3.5	M 10x1	30.4	TR 19	MT 06	HXK 4
PR03	PRS 820	CL 120	CS 708	3.0	M 8x1	23.5	TR 15	MT 07	HXK 3

SRDC(RL) EXT

P M K N S H

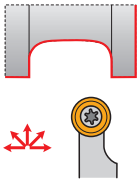
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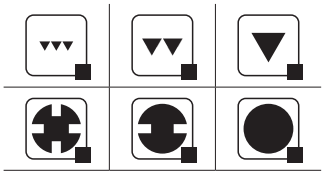
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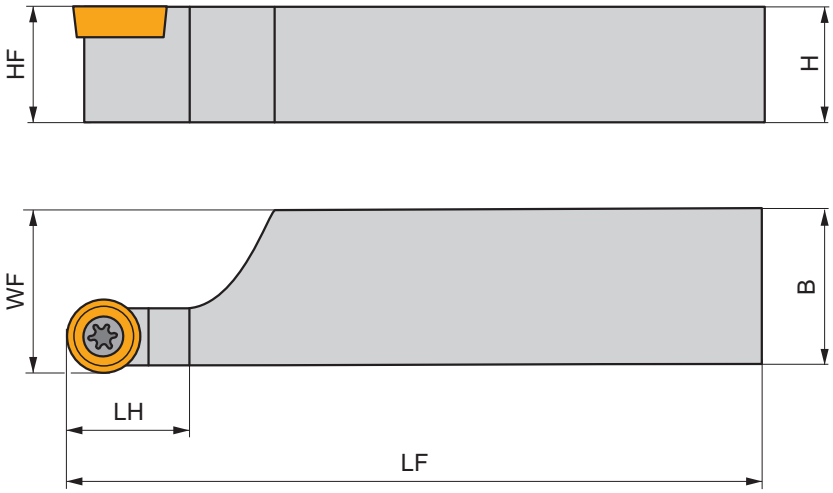


Yuvarlak RC.. Uçları için Levyeli Kilitli Takım Tutucu

Vida sıkmalı Sağ/Sol dış kater. Pozitif RC.. 08 uçlarla alın, çap, konik ve pah tornalama için uygundur. 20x20-32x25mm şaft ölçülerinde bulunur. Gövde uzun takım ömrü için işlem görmüştür.














	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	**SRDCR 2020 K 08-A**	20	20	20	20.5	125	20.0	0	0	0.36	GI051	SR21
	SRDCR 2525 M 08-A	25	25	25	25.5	150	20.0	0	0	0.66	GI051	SR21
	SRDCR 3225 P 08-A	32	25	32	25.5	170	20.0	0	0	0.95	GI051	SR21
L	**SRDCL 2020 K 08-A**	20	20	20	20.5	125	20.0	0	0	0.37	GI051	SR21
	SRDCL 2525 M 08-A	25	25	25	25.5	150	20.0	0	0	0.66	GI051	SR21
	SRDCL 3225 P 08-A	32	25	32	25.5	170	20.0	0	0	0.96	GI051	SR21

GI051	RC.. 0803M0

		Nm			
SR21	5513 020-04	1.5	M 3	7.2	PT-8002

SRDCN EXT

P M K N S H

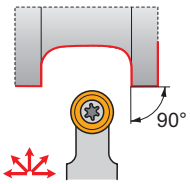
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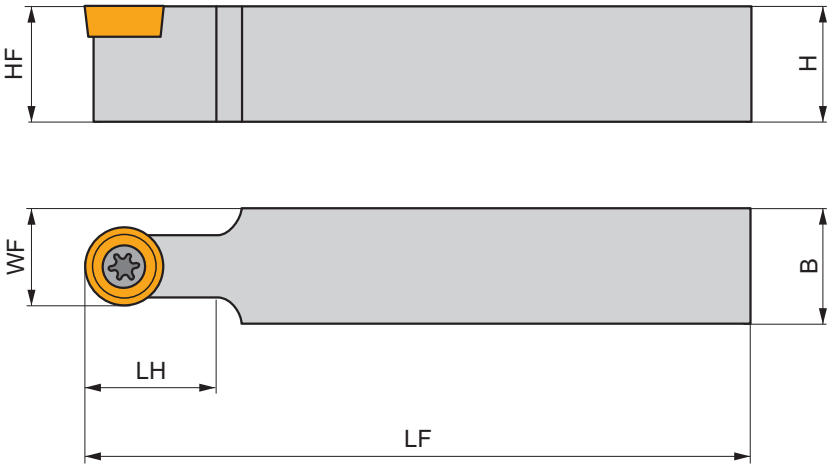
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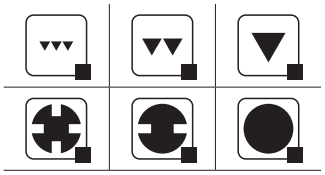


Yuvarlak RC.. Uçları için Levyeli Kilitli Takım Tutucu

Vida sıkmalı nötr dış kater. Pozitif RC.. 06-16 uçlarla çap, alın, kopya, konik ve pah tornalama için uygundur. 12x12-32x25mm mevcuttur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
N	**SRDCN 1212 F 06**	12	12	12	9	80	12.0	0	0	0.10	GI054	S01
	SRDCN 1616 H 06	16	16	16	11	100	12.0	0	0	0.20	GI054	S01
	SRDCN 2020 K 08	20	20	20	14	125	20.0	0	0	0.37	GI051	S03
	SRDCN 2020 K 1003-M-A	20	20	20	15	125	25.0	0	0	0.38	GI064	SR10
	SRDCN 2020 K 10-M-A	20	20	20	15	125	25.0	0	0	0.37	GI013	SR10
	SRDCN 2525 M 10-M-A	25	25	25	17.5	150	25.0	0	0	0.67	GI013	SR10
	SRDCN 2525 M 12-M-A	25	25	25	18.5	150	30.0	0	0	0.08	GI014	SR12
	SRDCN 3225 P 10-M	32	25	32	17.5	170	25.0	0	0	0.90	GI013	SR10
	SRDCN 3225 P 12-M	32	25	32	18.5	170	30.0	0	0	0.90	GI014	SR12
	SRDCN 3225 P 16-M	32	25	32	20.5	170	32.0	0	0	1.00	GI161	SR16

GI013	RC.. 10T3M0
GI014	RC.. 1204M0
GI051	RC.. 0803M0
GI054	RC.. 0602M0
GI064	RC.. 1003M0
GI161	RC.. 1606M0

		Nm						
S01	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–
S03	US 3007-T09P	2.0	M 3	7.3	–	–	FLAG T09P	–
SR10	US 3510-T15P	3.0	M 3.5	10.6	SRN 100300	MS 3510	FLAG T15P	HXK 3.5
SR12	US 3510-T15P	3.0	M 3.5	10.6	SRN 120300	MS 3510	FLAG T15P	HXK 3.5
SR16	US 5018-T20P	5.0	M 5	18.2	SRN 16T3M0	MS 5015	FLAG T20P	HXK 5

SRSC(RL) EXT

P M K N S H

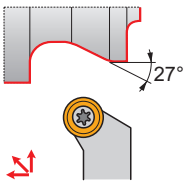
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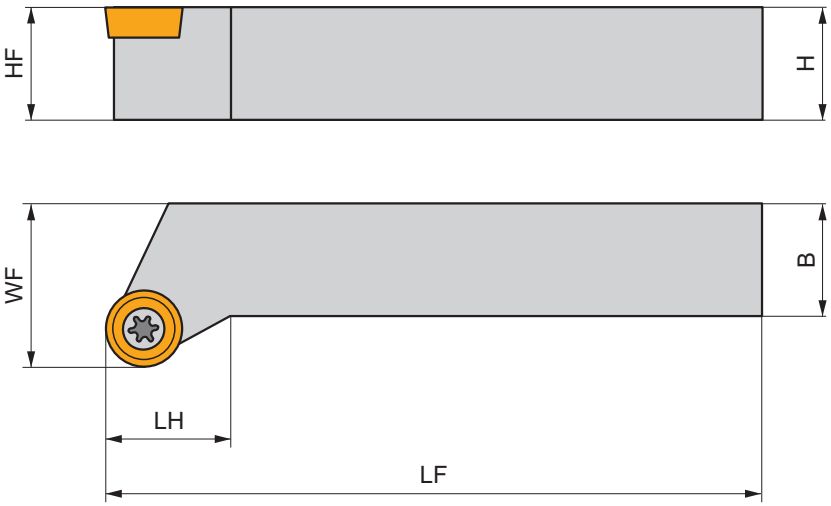
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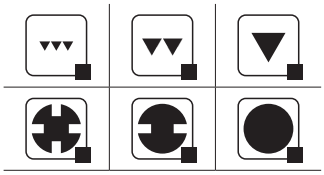


Yuvarlak RC.. Uçları için Levyeli Kilitli Takım Tutucu

Vida sıkmalı Sağ/Sol dış kater. Pozitif RC.. 06-16 uçlarla alın, çap, kopya, konik ve pah tornalama için uygundur. 12x12-32x25mm şaft ölçülerinde bulunur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	SRSCR 1212 F 06	12	12	12	16	80	12.0	0	0	0.09	GI054	S01
	SRSCR 1616 H 06	16	16	16	20	100	12.0	0	0	0.21	GI054	S01
	SRSCR 2020 K 08	20	20	20	25	125	20.0	0	0	0.40	GI051	S03
	SRSCR 2020 K 10-M-A	20	20	20	25	125	20.0	0	0	0.41	GI013	SR10
	SRSCR 2525 M 10-M-A	25	25	25	32	150	20.0	0	0	0.75	GI013	SR10
	SRSCR 3225 P 10-M	32	25	32	32	170	20.0	0	0	1.06	GI013	SR10
	SRSCR 2525 M 12-M-A	25	25	25	32	150	20.0	0	0	0.75	GI014	SR12
	SRSCR 3225 P 16-M	32	25	32	32	170	20.0	0	0	1.08	GI161	SR16
L	SRSCL 1212 F 06	12	12	12	16	80	12.0	0	0	0.10	GI054	S01
	SRSCL 1616 H 06	16	16	16	20	100	12.0	0	0	0.22	GI054	S01
	SRSCL 2020 K 08	20	20	20	25	125	20.0	0	0	0.45	GI051	S03
	SRSCL 2020 K 10-M-A	20	20	20	25	125	20.0	0	0	0.42	GI013	SR10
	SRSCL 2525 M 10-M-A	25	25	25	32	150	20.0	0	0	0.74	GI013	SR10
	SRSCL 3225 P 10-M	32	25	32	32	170	20.0	0	0	1.06	GI013	SR10
	SRSCL 2525 M 12-M-A	25	25	25	32	150	20.0	0	0	0.75	GI014	SR12
	SRSCL 3225 P 16-M	32	25	32	32	170	20.0	0	0	1.08	GI161	SR16

GI013	RC.. 10T3M0
GI014	RC.. 1204M0
GI051	RC.. 0803M0
GI054	RC.. 0602M0
GI161	RC.. 1606M0

		Nm						
S01	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–
S03	US 3007-T09P	2.0	M 3	7.3	–	–	FLAG T09P	–
SR10	US 3510-T15P	3.0	M 3.5	10.6	SRN 100300	MS 3510	FLAG T15P	HXK 3.5
SR12	US 3510-T15P	3.0	M 3.5	10.6	SRN 120300	MS 3510	FLAG T15P	HXK 3.5
SR16	US 5018-T20P	5.0	M 5	18.2	SRN 16T3M0	MS 5015	FLAG T20P	HXK 5

C.-SRDCN EXT

P M K N S H

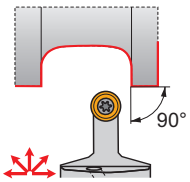
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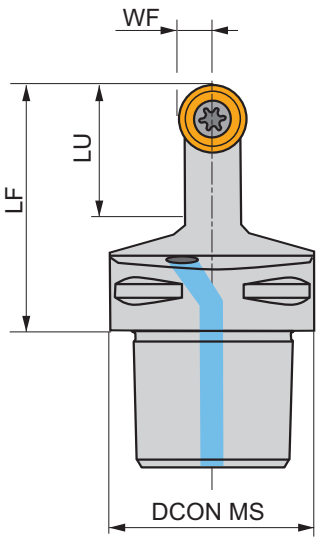
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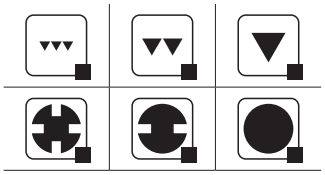


Vida Sıkmalı RC.. Uç için PSC Hızlı Değiştirme Dış Kateri

Vida sıkmalı, içten su vermeli nötr dış kater. Pozitif RC.. 10 veya 12 uçlarla çap, kopya, konik ve pah tornalamak için uygundur. C4'ten C6'ya kadar PSC şaftlı mevcuttur. Tutucu uzun takım ömrü için işlem görmüştür.







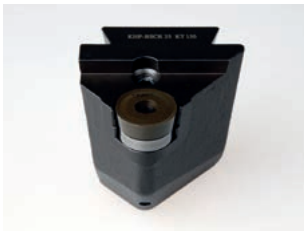


	Product	DCON MS (mm)	WF (mm)	LF (mm)	LU (mm)	LAMS (°)	GAMO (°)		kg		
N	**C4-SRDCN-00050-12A**	40	6	50	28	0	0	✓	0.32	GI014	C-SR12V-1
	C5-SRDCN-00060-10A	50	5	60	25	0	0	✓	0.56	GI013	C-SR10V
	C5-SRDCN-00060-12A	50	6	60	28	0	0	✓	0.56	GI014	C-SR12V-2

GI013	RC.. 10T3M0
GI014	RC.. 1204M0

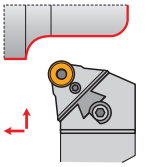
		Nm						
C-SR10V	US 2010-T15P	3.0	M 3.5	10.1	SRS 110-01	MS 9001	FLAG T15P/3,5	CN 034-02
C-SR12V-1	US 2001-T15P	3.0	M 3.5	12.1	SRS 110-02	MS 9001	FLAG T15P/3,5	CN 034-01
C-SR12V-2	US 2001-T15P	3.0	M 3.5	12.1	SRS 110-02	MS 9001	FLAG T15P/3,5	CN 034-02

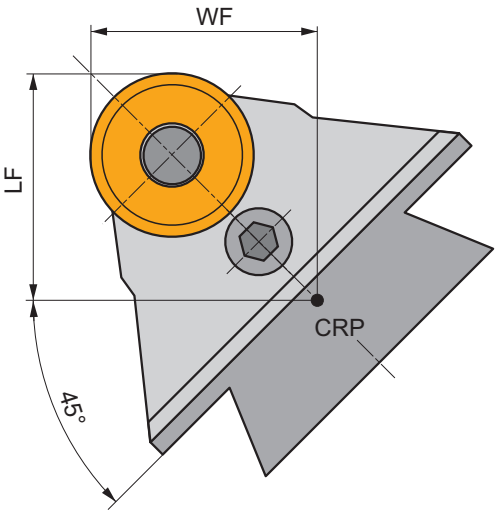
KHP-RSC(RL)

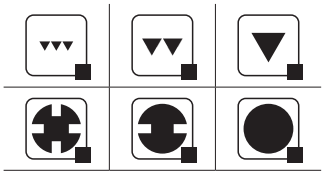


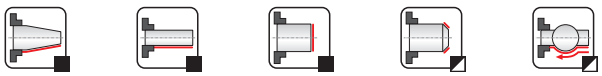
Modüler KHP Levyeli Torna Kartuşu, RC.. Uç için

DKH takım tutucu şaft için kırlangıç bağlantılı Sağ/Sol levyeli kartuş. Pozitif RC.. 20-32 uçlarla çap, alın, konik ve pah tornalamak için uygundur. Tutucu uzun takım ömrü için işlem görmüştür.









	Product	WF (mm)	LF (mm)	LAMS (°)	GAMO (°)	kg		
R	**KHP-RSCR 20**	35	45	0	0	1.25	GI069	PRP90
	KHP-RSCL 20	35	45	0	0	1.30	GI069	PRP90

GI069	RCMX 2006M0

PRP90	RCU 200400	CL 120	US 36	6.0 Nm	M 8x1	26	NT 07	MT 07	HXK 4

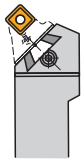
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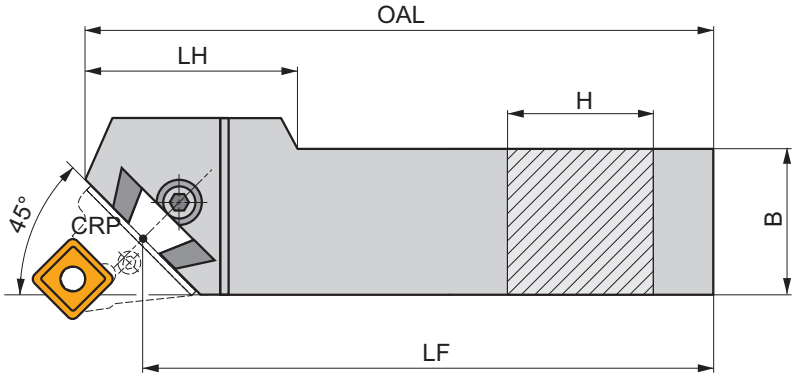
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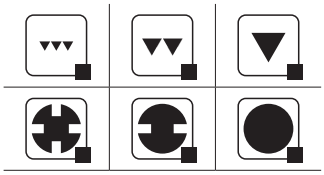


KHP/KHS Ağır Tornalama Kartuşları için Dış Kater Şaftı

KHP/KHS kartuşlar için kırlangıçlı Sağ/Sol takım şaftı. Ağır tornalama için uygundur. 40x50'den 60x80mm'ye kadar mevcut. Gövde uzun takım ömrü için işlem görmüştür.







	Product	H (mm)	B (mm)	LF (mm)	OAL (mm)	LH (mm)	kg		
R	**DKHR 4050 V**	40	50	400	425	100.0	7.10	GI098	DKH10
	DKHR 5060 W	50	60	450	475	110.0	11.30	GI098	DKH10
	DKHR 6080 W-A	60	80	450	485	90.0	19.65	GI098	DKH10
L	**DKHL 4050 V**	40	50	400	425	100.0	7.10	GI098	DKH10
	DKHL 5060 W	50	60	450	475	110.0	11.30	GI098	DKH10
	DKHL 6080 W-A	60	80	450	485	90.0	19.28	GI098	DKH10

GI098	KHP	KHS

DKH10	SR 14	HXK 10

SSBC(RL) EXT

P M K N S H

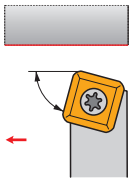
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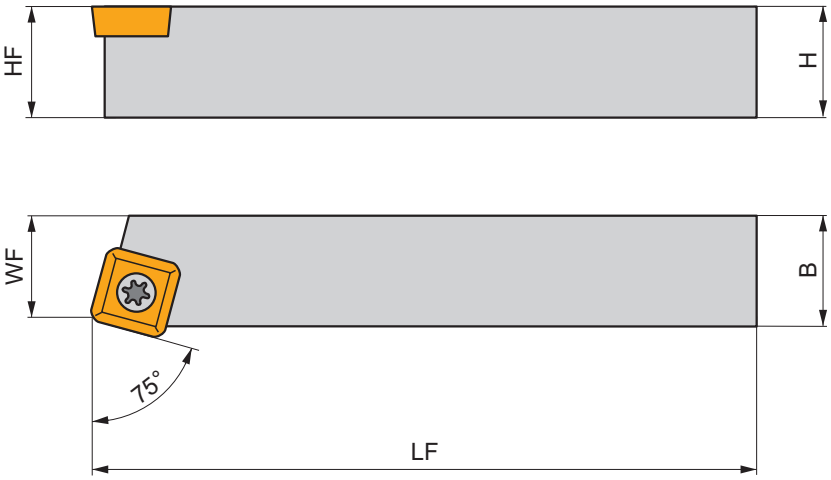
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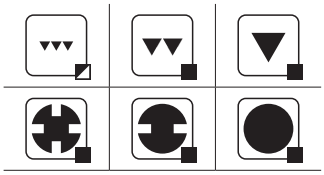


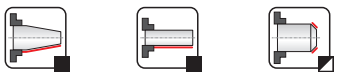
SC.. Uç için Vida Sıkmalı 75° Açılı Dış Kater

Vida sıkmalı Sağ/Sol dış kater. Pozitif SC.. 0938 uçlarla çap, konik ve pah tornalama için uygundur. 12x12-60x60mm şaft ölçülerinde bulunur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	H	B	HF	WF	LF	LAMS	GAMO			
		(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)	kg		
R	SSBCR 1212 F 09	12	12	12	11	80	0	0	0.10	GI053	S08
	SSBCR 1616 H 09	16	16	16	13	100	0	0	0.20	GI053	S08
	SSBCR 2020 K 12-M-A	20	20	20	17	125	0	0	0.40	GI015	SS20
	SSBCR 2525 M 12-M-A	25	25	25	22	150	0	0	0.76	GI015	SS20
	SSBCR 4040 S 25	40	40	40	35	250	0	0	3.01	GI131	SS25
	SSBCR 5050 T 25	50	50	50	43	300	0	0	5.65	GI131	SS25
	SSBCR 5050 T 38-A	50	50	50	43	300	0	0	4.84	GI164	SS38A
	SSBCR 6060 V 38-A	60	60	60	53	400	0	0	11.10	GI164	SS38A
L	SSBCL 1212 F 09	12	12	12	11	80	0	0	0.10	GI053	S08
	SSBCL 1616 H 09	16	16	16	13	100	0	0	0.22	GI053	S08
	SSBCL 2020 K 12-M-A	20	20	20	17	125	0	0	0.40	GI015	SS20
	SSBCL 2525 M 12-M-A	25	25	25	22	150	0	0	0.70	GI015	SS20
	SSBCL 4040 S 25	40	40	40	35	250	0	0	3.01	GI131	SS25
	SSBCL 5050 T 25	50	50	50	43	300	0	0	5.65	GI131	SS25
	SSBCL 5050 T 38-A	50	50	50	43	300	0	0	5.78	GI164	SS38A
	SSBCL 6060 V 38-A	60	60	60	53	400	0	0	11.16	GI164	SS38A

GI015	SC.. 1204..
GI053	SC.. 09T3..
GI131	SC.. 2509..
GI164	SC.. 3809..

		Nm							
S08	US 3510-T15P	3.0	M 3.5	10.6	–	–	FLAG T15P	–	–
SS20	US 5012-T15P	5.0	M 5	12.2	SSN 120304	MS 5008	FLAG T15P	HXK 5	–
SS25	US 8025-T30P	13.0	M 8	24.2	SSN 250620	MS 8020	–	HXK 5	SDR T30P
SS38A	US 8025-T30P	13.0	M 8	24.2	SSN 380920	MS 8020	–	HXK 5	SDR T30P

SSDCN EXT

P M K N S H

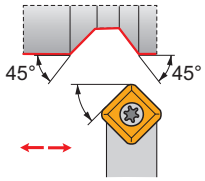
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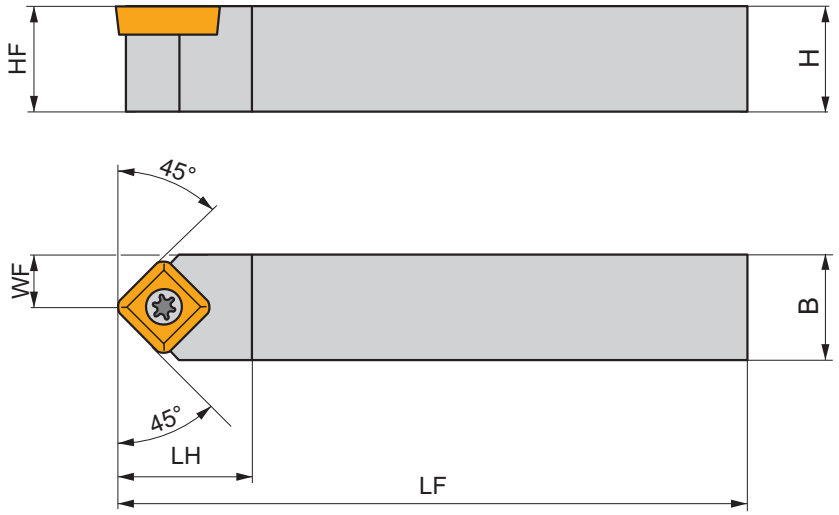
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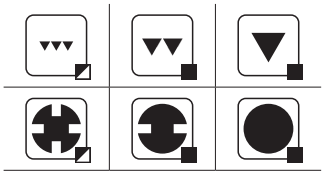


SC.. Uç için Vida Sıkmalı 45° Açılı Dış Kater

Vida sıkmalı nötr dış kater. Pozitif SC.. 09 ve 12 uçlarla çap, kopya, konik ve pah tornalama için uygundur. 12x12-25x25mm mevcuttur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
N	SSDCN 1212 F 09	12	12	12	6	80	–	0	0	0.11	GI053	S08
	SSDCN 1616 H 09	16	16	16	8	100	–	0	0	0.20	GI053	S08
	SSDCN 2020 K 12-M-A	20	20	20	10	125	–	0	0	0.41	GI015	SS20
	SSDCN 2525 M 12-M-A	25	25	25	12.5	150	–	0	0	0.74	GI015	SS20

GI015	SC.. 1204..
GI053	SC.. 09T3..

		Nm						
S08	US 3510-T15P	3.0	M 3.5	10.6	–	–	FLAG T15P	–
SS20	US 5012-T15P	5.0	M 5	12.2	SSN 120304	MS 5008	FLAG T15P	HXK 5

SSKC(RL) EXT

P M K N S H

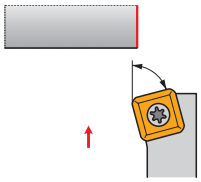
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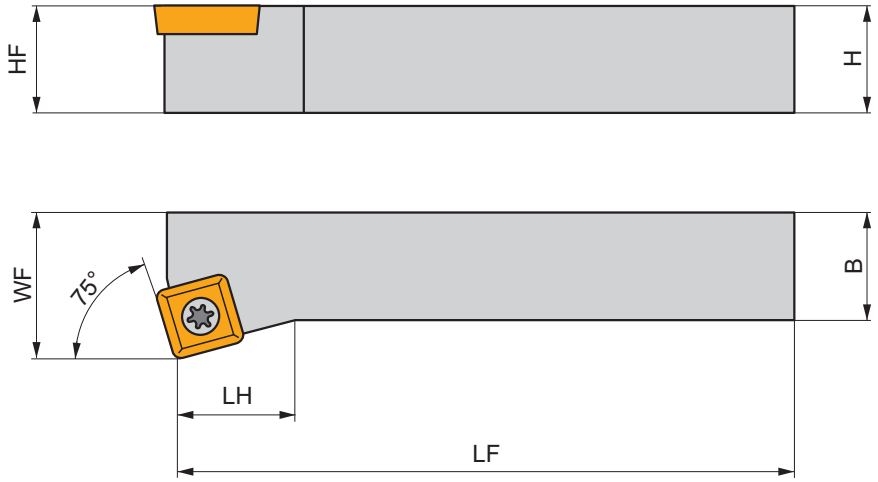
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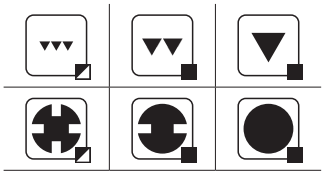


SC.. Uç için Vida Sıkmalı 75° (Alın) Açılı Dış Kater

Vida sıkmalı Sağ/Sol dış kater. Pozitif SC.. 09 ve 12 uçlarla alın ve pah tornalama için uygundur. 12x12-25x25mm şaft ölçülerinde bulunur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	**SSKCR 1212 F 09**	12	12	12	16	80	32.0	0	0	0.10	GI053	S08
	SSKCR 1616 H 09	16	16	16	20	100	32.0	0	0	0.25	GI053	S08
	SSKCR 2020 K 12-M-A	20	20	20	25	125	36.0	0	0	0.75	GI015	SS20
	SSKCR 2525 M 12-M-A	25	25	25	32	150	36.0	0	0	0.75	GI015	SS20

GI015	SC.. 1204..
GI053	SC.. 09T3..

		Nm						
S08	US 3510-T15P	3.0	M 3.5	10.6	–	–	FLAG T15P	–
SS20	US 5012-T15P	5.0	M 5	12.2	SSN 120304	MS 5008	FLAG T15P	HXK 5

SSSC(RL) INT

P M K N S H

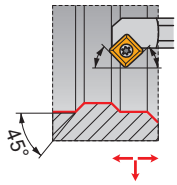
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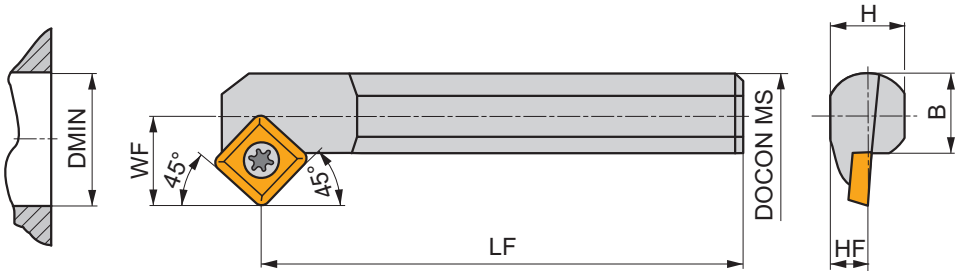
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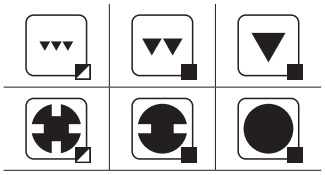


SC.. Uç için Vida Sıkmalı 45° Açılı Delik Kateri

Vida sıkmalı Sağ/Sol 45° delik kateri. Pozitif SC.. uçlarla kenar ve pah tornalama ile iç konik ve çap tornalama için uygundur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)	kg		
R	S20S-SSSCR 09	20	25	13	18	18.5	250	-5	0	0.61	GI053	S04
	S25T-SSSCR 09	25	32	17	23	23	300	-3	0	1.10	GI053	S04
L	S20S-SSSCL 09	20	25	13	18	18.5	250	-5	0	0.05	GI053	S04
	S25T-SSSCL 09	25	32	17	23	23	300	-3	0	1.10	GI053	S04

GI053	SC.. 09T3..

S04	US 3510-T15P	3.0	M 3.5	10.6	FLAG T15P

KHS-SBC(RL)

P M K

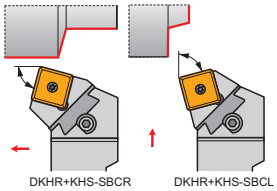
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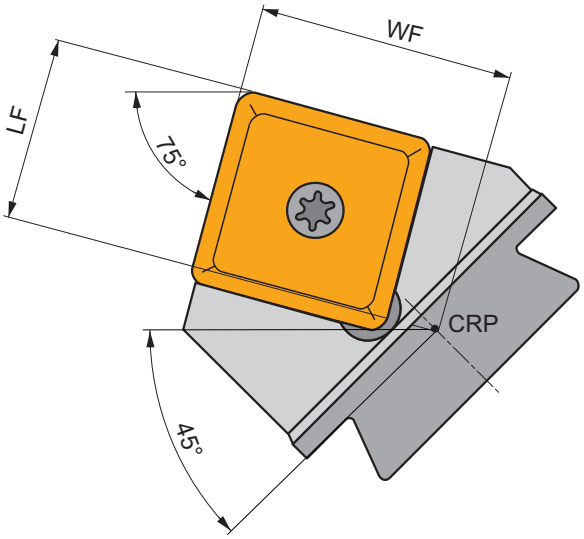
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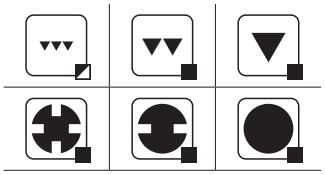


Modüler KHS Vida Sıkmalı Torna Kartuşu, 75° Kesme Açılı, SC.. Uç için

DKH takım tutucu şaft için kırlangıç bağlantılı, 75° açılı Sağ/Sol vida sıkmalı kartuş. Pozitif SC.. 25 veya 38 uçlarla çap, alın, konik ve pah tornalamak için uygundur. Tutucu uzun takım ömrü için işlem görmüştür.









	Product	WF (mm)	LF (mm)	LAMS (°)	GAMO (°)	kg		
R	KHS-SBCR 25	47	36	0	0	1.50	GI131	SS26
	KHS-SBCR 38-A	47	36	0	0	1.47	GI164	SS38
L	KHS-SBCL 25	47	36	0	0	1.45	GI131	SS26
	KHS-SBCL 38-A	47	36	0	0	1.48	GI164	SS38

GI131	SC.. 2509..
GI164	SC.. 3809..

		Nm						
SS26	US 8025-T30P	13.0	M 8	24.2	SSN 250620	MS 8020	SDR T30P	HXK 5
SS38	US 8025-T30P	13.0	M 8	24.2	SSN 380620	MS 8020	SDR T30P	HXK 5

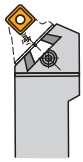
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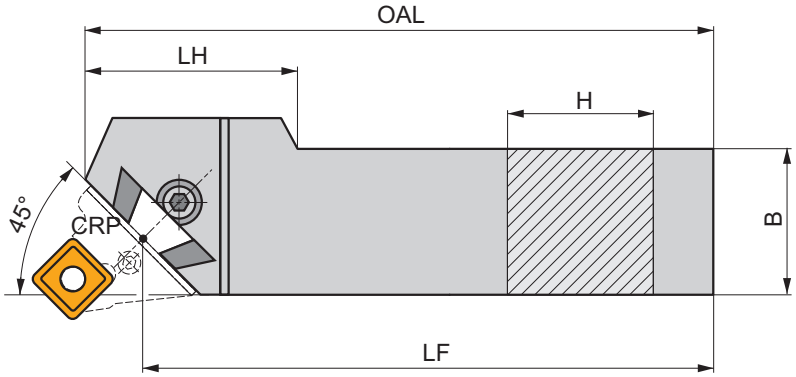
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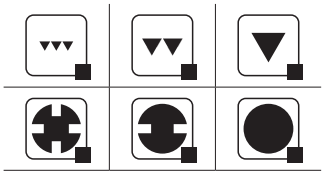


KHP/KHS Ağır Tornalama Kartuşları için Dış Kater Şaftı

KHP/KHS kartuşlar için kırlangıçlı Sağ/Sol takım şaftı. Ağır tornalama için uygundur. 40x50'den 60x80mm'ye kadar mevcut. Gövde uzun takım ömrü için işlem görmüştür.







	Product	H (mm)	B (mm)	LF (mm)	OAL (mm)	LH (mm)	kg		
R	**DKHR 4050 V**	40	50	400	425	100.0	7.10	GI098	DKH10
	DKHR 5060 W	50	60	450	475	110.0	11.30	GI098	DKH10
	DKHR 6080 W-A	60	80	450	485	90.0	19.65	GI098	DKH10
L	**DKHL 4050 V**	40	50	400	425	100.0	7.10	GI098	DKH10
	DKHL 5060 W	50	60	450	475	110.0	11.30	GI098	DKH10
	DKHL 6080 W-A	60	80	450	485	90.0	19.28	GI098	DKH10

GI098	KHP	KHS

DKH10	SR 14	HXK 10

STAC(RL) EXT

P M K N S H

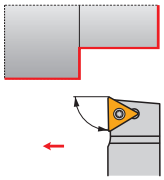
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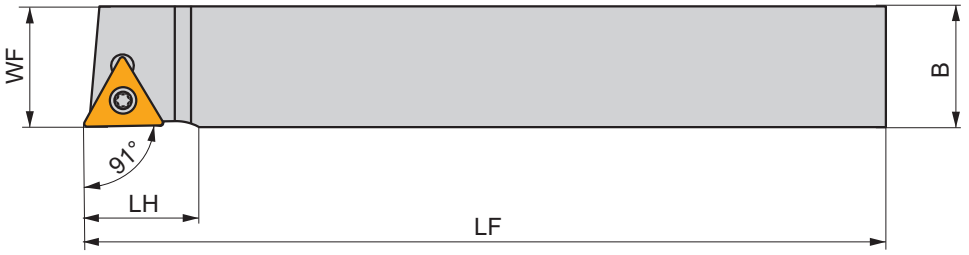


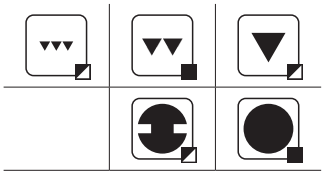
TC Uç için Vida Sıkmalı 91° Açılı Dış Kater

Vida tipi pozitif TC 11 ve 16 uçlar için Sağ/Sol yönlü dış kater. Dış boyuna kenar, konik ve pah tornalama için uygundur. 12 × 12 ile 16 × 16 mm arası şaft boyutları ile sunulmuştur ve kayar otomat tezgahlarında kullanılabilir. Gövde uzun takım ömrü için işlem görmüştür.











	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	STACR 1212 K 11-S	12	12	12	12	125	15.2	0	0	0.14	GI056	S01
	STACR 1616 K 11-S	16	16	16	16	125	15.2	0	0	0.25	GI056	S01
L	STACL 1212 K 11-S	12	12	12	12	125	15.2	0	0	0.14	GI056	S01
	STACL 1616 K 11-S	16	16	16	16	125	15.2	0	0	0.25	GI056	S01

GI056	TC.. 1102..

		Nm			
S01	US 2506-T07P	0.9	M 2.5	6.3	FLAG T07P

STFC(RL) EXT

P M K N S H

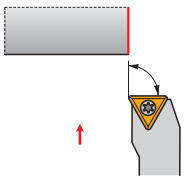
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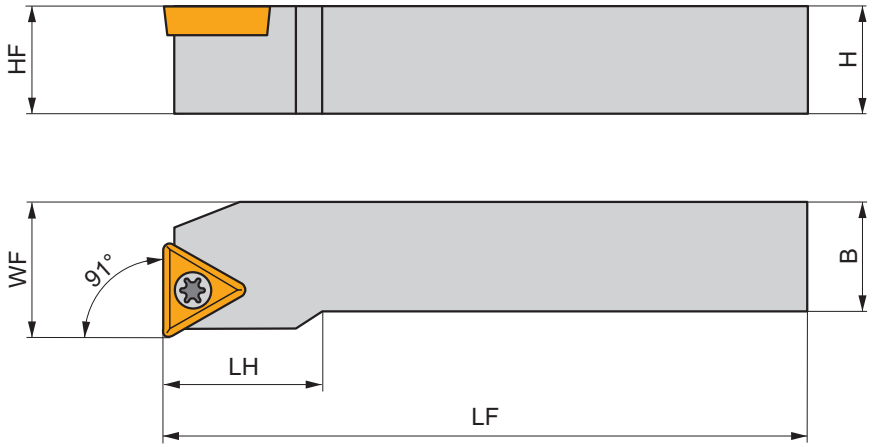
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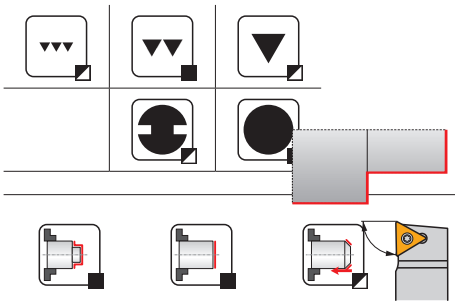


TC.. Uç için Vida Sıkmalı 91° (Alın) Açılı Dış Kater

Vida sıkmalı Sağ/Sol 91° dış kater. Pozitif TC.. 11-16 uçlarla alın ve pah tornalama için uygundur. 16x16-25x25mm şaft ölçülerinde bulunur. Gövde uzun takım ömrü için işlem görmüştür.







	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	STFCR 1616 H 11	16	16	16	20	100	18.0	0	0	0.20	GI056	S01
	STFCR 2020 K 16-M-A	20	20	20	25	125	25.0	0	0	0.40	GI016	ST10
	STFCR 2525 M 16-M-A	25	25	25	32	150	25.0	0	0	0.75	GI016	ST10
L	STFCL 1616 H 11	16	16	16	20	100	18.0	0	0	0.22	GI056	S01
	STFCL 2020 K 16-M-A	20	20	20	25	125	25.0	0	0	0.40	GI016	ST10
	STFCL 2525 M 16-M-A	25	25	25	32	150	25.0	0	0	0.75	GI016	ST10

GI016	TC.. 16T3..
GI056	TC.. 1102..

		Nm						
S01	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–
ST10	US 3510-T15P	3.0	M 3.5	10.6	STN 160308	MS 3510	FLAG T15P	HXK 3.5

STFC(RL)-A EXT

P M K N S H

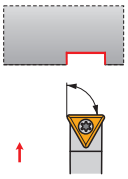
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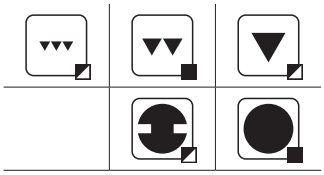
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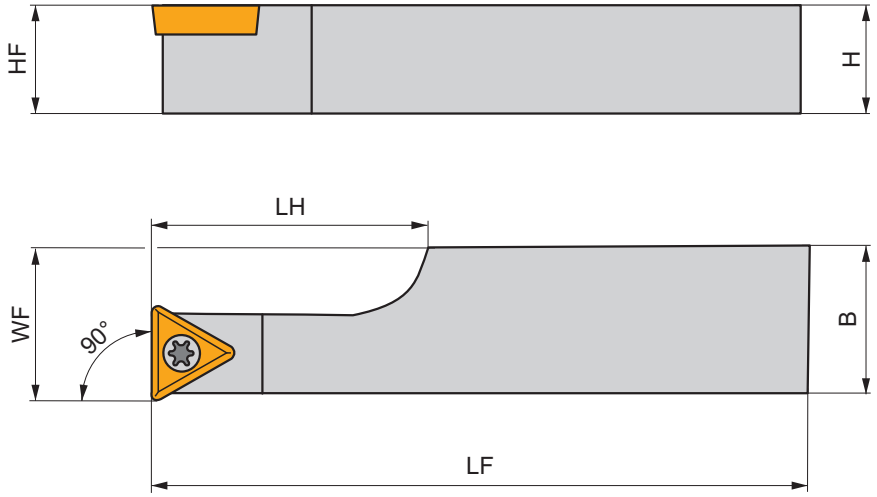


TC.. Uç için Vida Sıkmalı 90° (Alın) Açılı Dış Kater

Vida sıkmalı Sağ/Sol dış kater. Pozitif TC.. 11 uçlarla alın ve pah tornalama için uygundur. 20x20mm şaft ölçülerinde bulunur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	STFCR 2020 K 11-A	20	20	20	25	125	21.3	0	0	0.37	GI056	ST21
L	STFCL 2020 K 11-A	20	20	20	25	125	21.3	0	0	0.36	GI056	ST21

GI056	TC.. 1102..

ST21	5513 020-03	0.8 Nm	M 2.5	6.5	PT-8001

STJC(RL) EXT

P M K N S H

PRAMET

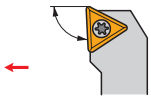
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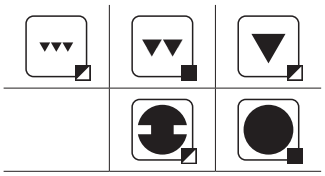


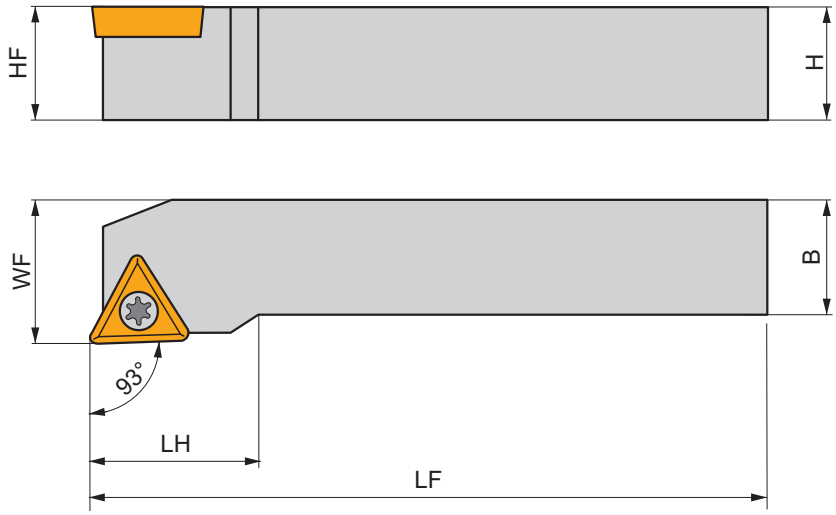
TC.. Uç için Vida Sıkmalı 93° Açılı Dış Kater

Vida sıkmalı Sağ/Sol dış kater. Pozitif TC.. 11-16 uçlarla çap, konik ve pah tornalama için uygundur. 16x16-25x25mm şaft ölçülerinde bulunur. Gövde uzun takım ömrü için işlem görmüştür.











	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	STJCR 1616 H 11	16	16	16	20	100	18.0	0	0	0.22	GI056	S01
	STJCR 2020 K 16-M-A	20	20	20	25	125	25.0	0	0	0.43	GI016	ST10
	STJCR 2525 M 16-M-A	25	25	25	32	150	25.0	0	0	0.76	GI016	ST10
L	STJCL 1616 H 11	16	16	16	20	100	18.0	0	0	0.22	GI056	S01
	STJCL 2020 K 16-M-A	20	20	20	25	125	25.0	0	0	0.43	GI016	ST10
	STJCL 2525 M 16-M-A	25	25	25	32	150	25.0	0	0	0.75	GI016	ST10

GI016	TC.. 16T3..
GI056	TC.. 1102..

		Nm						
S01	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–
ST10	US 3510-T15P	3.0	M 3.5	10.6	STN 160308	MS 3510	FLAG T15P	HXK 3.5

STFC(RL) INT

P M K N S H

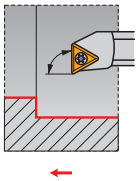
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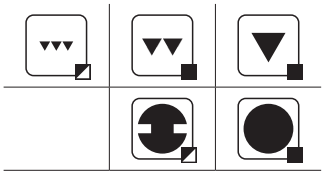
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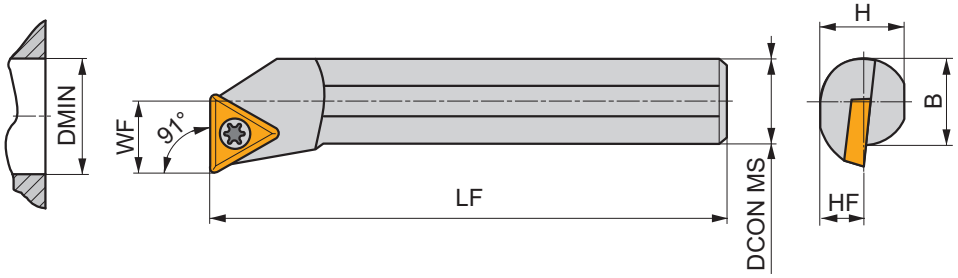


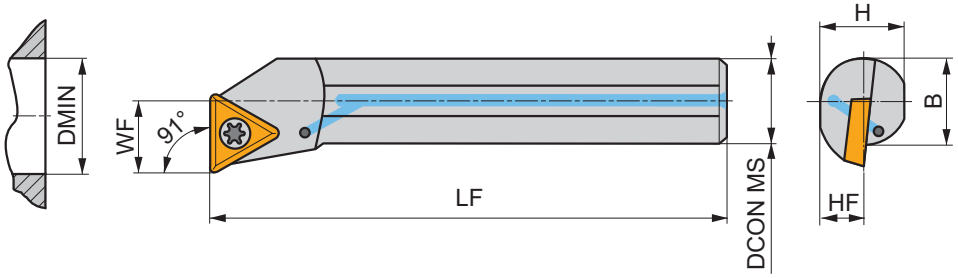
TC.. Uç için Vida Sıkmalı 91° Açılı Delik Kateri

Vida sıkmalı Sağ/Sol 91° içten su vermeli delik kateri. Pozitif TC.. uçlarla Kenar ve pah tornalama ile iç konik ve çap tornalama için uygundur.Gövde uzun takım ömrü için işlem görmüştür.











	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)		kg		
R	A06F-STFCR 06	6	8.5	4.5	5	–	80	-12	0	✓	0.02	GI217	ST12
	A08H-STFCR 06	8	11	5.9	7	–	100	-10	0	✓	0.05	GI217	ST13
	A10K-STFCR 09	10	13	7	9	–	125	-9	0	✓	0.06	GI218	ST14
	A12M-STFCR 09	12	16	9	11	–	150	-6.5	0	✓	0.12	GI218	ST14
	S10H-STFCR 11	10	13	7	9	9.5	100	-10	0	–	0.08	GI056	S02
	A12M-STFCR 11	12	16	9	11	11.5	150	-10	0	✓	0.14	GI056	S01
	S12K-STFCR 11	12	16	9	11	11.5	125	-7	0	–	0.13	GI056	S01
	A16R-STFCR 11	16	20	11	14.5	15	200	-7	0	✓	0.30	GI056	S01
	S16M-STFCR 11	16	20	11	14.5	15	150	-7	0	–	0.24	GI056	S01
	A20S-STFCR 11	20	25	13	18	18.5	250	-7	0	✓	0.53	GI056	S01
	S20Q-STFCR 11	20	25	13	18	18.5	180	-7	0	–	0.40	GI056	S01
	A25R-STFCR 16	25	32	17	23	23	200	-3	0	✓	0.66	GI016	S08
	S25T-STFCR 16	25	32	17	23	23	300	-3	0	–	1.08	GI016	S08
	A32S-STFCR 16	32	40	22	30	30	250	-10	0	✓	1.35	GI016	ST10
	S32U-STFCR 16-A	32	40	22	30	30	350	-10	0	–	2.10	GI016	ST10
L	A06F-STFCL 06	6	8.5	4.5	5	–	80	-12	0	✓	0.03	GI217	ST12
	A08H-STFCL 06	8	11	5.9	7	–	100	-10	0	✓	0.05	GI217	ST13
	A10K-STFCL 09	10	13	7	9	–	125	-9	0	✓	0.06	GI218	ST14
	A12M-STFCL 09	12	16	9	11	–	150	-6.5	0	✓	0.03	GI218	ST14
	S10H-STFCL 11	10	13	7	9	9.5	100	-10	0	–	0.06	GI056	S02
	A12M-STFCL 11	12	16	9	11	11.5	150	-10	0	✓	0.12	GI056	S01
	S12K-STFCL 11	12	16	9	11	11.5	125	-7	0	–	0.12	GI056	S01
	A16R-STFCL 11	16	20	11	14.5	15	200	-7	0	✓	0.00	GI056	S01
	S16M-STFCL 11	16	20	11	14.5	15	150	-7	0	–	0.24	GI056	S01
	A20S-STFCL 11	20	25	13	18	18.5	250	-7	0	✓	0.00	GI056	S01
	S20Q-STFCL 11	20	25	13	18	18.5	180	-7	0	–	0.42	GI056	S01
	A25R-STFCL 16	25	32	17	23	23	200	-3	0	✓	0.00	GI016	S08

	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)		kg		
L	**S25T-STFCL 16**	25	32	17	23	23	300	-3	0	–	1.08	GI016	S08
	A32S-STFCL 16	32	40	22	30	30	250	-10	0	✓	1.36	GI016	ST10
	S32U-STFCL 16-A	32	40	22	30	30	350	-10	0	–	2.06	GI016	ST10

GI016	TC.. 16T3..
GI056	TC.. 1102..
GI217	TC.. 06T1..
GI218	TC.. 0902..

		Nm							
S01	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–	–
S02	US 2505-T07P	0.9	M 2.5	5.2	–	–	FLAG T07P	–	–
S08	US 3510-T15P	3.0	M 3.5	10.6	–	–	FLAG T15P	–	–
ST10	US 3510-T15P	3.0	M 3.5	10.6	STN 160308	MS 3510	FLAG T15P	HXK 3.5	–
ST12	5513 020-28	0.6	M 2	4.2	–	–	–	–	PT-8000
ST13	5513 020-27	0.6	M 2	4.9	–	–	–	–	PT-8000
ST14	5513 020-05	0.8	M 2.2	6.4	–	–	–	–	PT-8001

STFC(RL)-E INT

P M K N S H

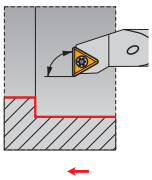
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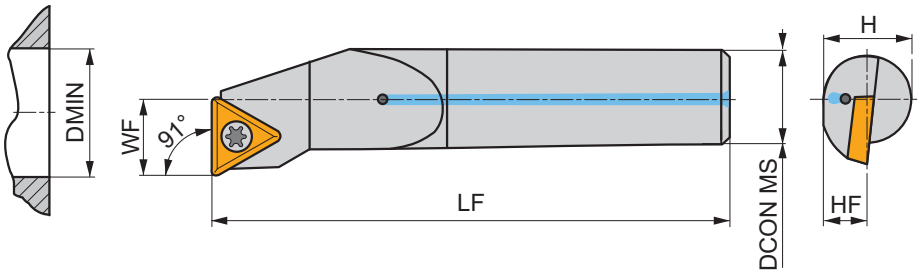
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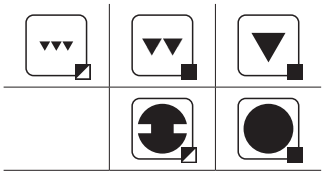


TC.. Uç için Vida Sıkmalı 91° Açılı Karbür Delik Kateri

Vidalı sıkmalı tip TC.. uçlar için 91° kesme açılı, içten soğutmalı, İçten Sağ/Sol karbür delik işleme barası. Kenar ve pah tornalama ile iç konik ve çap tornalama için. Takım kullanma mesafesi için >3xD.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	HF (mm)	LF (mm)	LAMS (°)	GAMO (°)		kg		
R	E06H-STFCR 06-R	6	8.5	4.5	6	3	100	-10	0	✓	0.05	GI217	ST22
	E08K-STFCR 06-R	8	11	5.9	8	4	125	-10	0	✓	0.09	GI217	ST23
	E10M-STFCR 09-R	10	13	7	10	5	150	-8	0	✓	0.15	GI218	ST24
	E12Q-STFCR 09-R	12	16	9	12	6	180	-6	0	✓	0.26	GI218	ST24
	E16R-STFCR 11-R	16	20	11	16	8	200	-5	0	✓	0.48	GI056	ST21
L	E06H-STFCL 06-R	6	8.5	4.5	6	3	100	-10	0	✓	0.05	GI217	ST22
	E08K-STFCL 06-R	8	11	5.9	8	4	125	-10	0	✓	0.09	GI217	ST23
	E10M-STFCL 09-R	10	13	7	10	5	150	-8	0	✓	0.15	GI218	ST24
	E12Q-STFCL 09-R	12	16	9	12	6	180	-6	0	✓	0.26	GI218	ST24
	E16R-STFCL 11-R	16	20	11	16	8	200	-5	0	✓	0.48	GI056	ST21

GI056	TC.. 1102..
GI217	TC.. 06T1..
GI218	TC.. 0902..

		Nm			
ST21	5513 020-03	0.8	M 2.5	6.5	PT-8001
ST22	5513 020-28	0.6	M 2	4.2	PT-8000
ST23	5513 020-27	0.6	M 2	4.9	PT-8000
ST24	5513 020-05	0.8	M 2.2	6.4	PT-8001

SVHB(C)(RL) EXT

P M K N S H

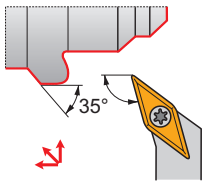
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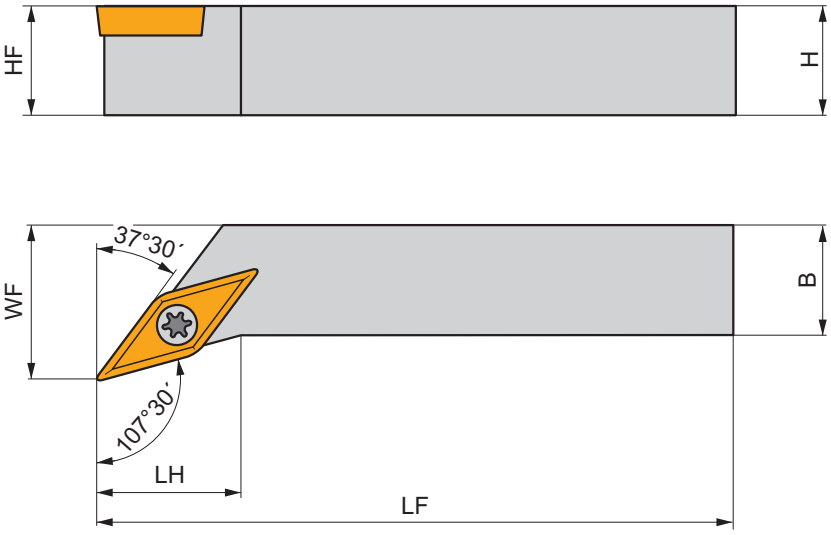
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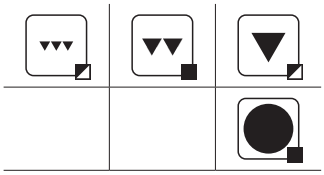


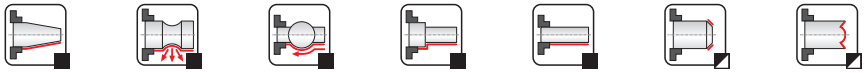
VB/VC.. Uç için Vida Sıkmalı 107.5° Açılı Dış Kater

Vida sıkmalı Sağ/Sol dış kater. Pozitif VB/VC.. 11 veya 16 uçlarla çap, alın,konik, 25°'ye kadar kopya ve pah tornalama için uygundur. 16x16-25x25mm şaft ölçülerinde bulunur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	SVHBR 1616 H 11	16	16	16	20	100	14.0	0	0	0.20	GI194	S01
	SVHCR 2020 K 16-M-A	20	20	20	25	125	20.0	0	0	0.39	GI017	SV10
	SVHCR 2525 M 16-M-A	25	25	25	32	150	20.0	0	0	0.71	GI017	SV10
L	SVHBL 1616 H 11	16	16	16	20	100	14.0	0	0	0.19	GI194	S01
	SVHCL 2020 K 16-M-A	20	20	20	25	125	20.0	0	0	0.40	GI017	SV10
	SVHCL 2525 M 16-M-A	25	25	25	32	150	20.0	0	0	0.07	GI017	SV10

GI017	VB.. 1604..	VC.. 1604..
GI194	VB.. 1103..	VC.. 1103..

		Nm						
S01	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–
SV10	US 3512-T15P	3.0	M 3.5	12.6	SVN 160304	MS 3510	FLAG T15P	HXK 3.5

SVJB(C)(RL) EXT

P M K N S H

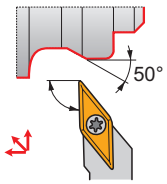
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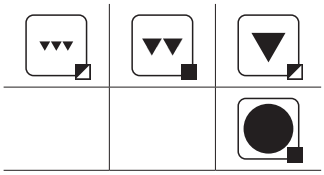
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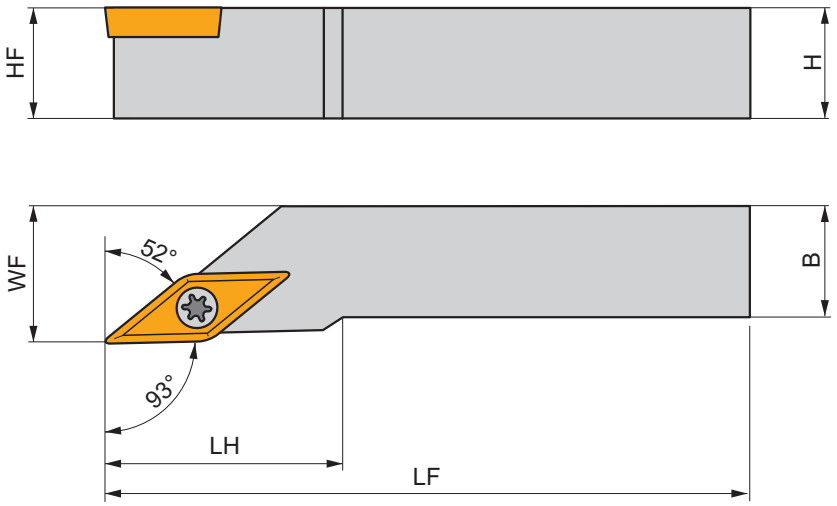


VB/VC Uçlar için Vida Sıkmalı 93° Açılı Dış Kater

Vida tipi pozitif VB 11 veya 16 ve VC 11 ile 16 arası uçlar için Sağ/Sol yönlü dış kater. Maks. 50° boyuna dış kenar, konik, pah ve kopya tornalama için uygundur. 12 × 12 ile 32 × 25 mm arası şaft boyutları ile sunulmuştur, bazıları kayar otomat tezgahlarında kullanılabilir. Gövde uzun takım ömrü için işlem görmüştür.














	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	**SVJBR 1212 F 11**	12	12	12	16	80	20.0	0	0	0.09	GI194	S01
	SVJBR 1212 K 11-S	12	12	12	12	125	25.6	0	0	0.13	GI194	S01
	SVJBR 1616 H 11	16	16	16	20	100	20.0	0	0	0.20	GI194	S01
	SVJBR 1616 K 11-S	16	16	16	16	125	25.6	0	0	0.22	GI194	S01
	SVJCR 1212 N 13	12	12	12	16	160	27.0	0	0	0.19	GI211	SV21
	SVJCR 1616 H 13	16	16	16	20	100	30.0	0	0	0.20	GI211	SV21
	SVJCR 2020 K 13	20	20	20	25	125	30.0	0	0	0.37	GI211	SV22
	SVJCR 2020 K 16-M-A	20	20	20	25	125	28.0	0	0	0.35	GI017	SV10
	SVJCR 2525 M 13	25	25	25	32	150	30.0	0	0	0.67	GI211	SV22
	SVJCR 2525 M 16-M-A	25	25	25	32	150	32.0	0	0	0.66	GI017	SV10
	SVJCR 3225 P 16-M-A	32	25	32	32	170	32.0	0	0	0.99	GI017	SV10
L	**SVJBL 1212 F 11**	12	12	12	16	80	20.0	0	0	0.09	GI194	S01
	SVJBL 1212 K 11-S	12	12	12	12	125	25.6	0	0	0.13	GI194	S01
	SVJBL 1616 H 11	16	16	16	20	100	20.0	0	0	0.19	GI194	S01
	SVJBL 1616 K 11-S	16	16	16	16	125	25.6	0	0	0.22	GI194	S01
	SVJCL 1212 N 13	12	12	12	16	160	27.0	0	0	0.19	GI211	SV21
	SVJCL 1616 H 13	16	16	16	20	100	30.0	0	0	0.20	GI211	SV21
	SVJCL 2020 K 13	20	20	20	25	125	30.0	0	0	0.37	GI211	SV22
	SVJCL 2020 K 16-M-A	20	20	20	25	125	28.0	0	0	0.38	GI017	SV10
	SVJCL 2525 M 13	25	25	25	32	150	30.0	0	0	0.67	GI211	SV22
	SVJCL 2525 M 16-M-A	25	25	25	32	150	32.0	0	0	0.68	GI017	SV10
	SVJCL 3225 P 16-M-A	32	25	32	32	170	32.0	0	0	0.99	GI017	SV10

GI017	VB.. 1604..	VC.. 1604..
GI194	VB.. 1103..	VC.. 1103..
GI211	–	VC.. 1303..

		Nm						
S01	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–
SV10	US 3512-T15P	3.0	M 3.5	12.6	SVN 160304	MS 3510	FLAG T15P	HXK 3.5
SV21	5513 020-24	1.5	M 3	8.5	–	–	PT-8002	–
SV22	DVF 0573	1.5	M 3	10.3	DAP 0331	DVT 0332	PT-8002	174.1-870

SVPB(C)(RL) EXT

P M K N S H

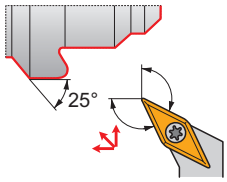
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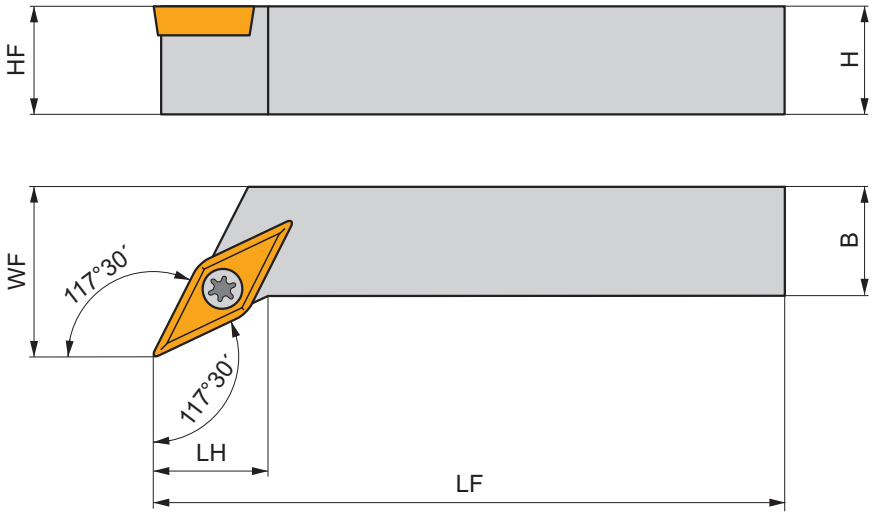
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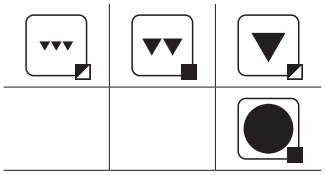


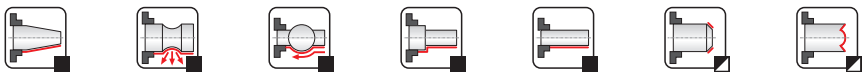
VB/VC.. Uç için Vida Sıkmalı 117.5° Açılı Dış Kater

Vida sıkmalı Sağ/Sol dış kater. Pozitif VB/VC.. 11 veya 16 uçlarla çap, alın,konik, 25°'ye kadar kopya ve pah tornalama için uygundur. 16x16-32x25mm şaft ölçülerinde bulunur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	SVPBR 1616 H 11	16	16	16	20	100	12.0	0	0	0.20	GI194	S01
	SVPBR 2020 K 11	20	20	20	25	125	12.0	0	0	0.40	GI194	S01
	SVPCR 2020 K 16-M-A	20	20	20	25	125	20.0	0	0	0.40	GI017	SV10
	SVPCR 2525 M 16-M-A	25	25	25	32	150	25.0	0	0	0.73	GI017	SV10
	SVPCR 3225 P 16-M-A	32	25	32	32	170	25.0	0	0	1.03	GI017	SV10
L	SVPBL 1616 H 11	16	16	16	20	100	12.0	0	0	0.20	GI194	S01
	SVPBL 2020 K 11	20	20	20	25	125	12.0	0	0	0.39	GI194	S01
	SVPCL 2020 K 16-M-A	20	20	20	25	125	20.0	0	0	0.40	GI017	SV10
	SVPCL 2525 M 16-M-A	25	25	25	32	150	25.0	0	0	0.70	GI017	SV10
	SVPCL 3225 P 16-M-A	32	25	32	32	170	25.0	0	0	1.10	GI017	SV10

GI017	VB.. 1604..	VC.. 1604..
GI194	VB.. 1103..	VC.. 1103..

		Nm						
S01	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–
SV10	US 3512-T15P	3.0	M 3.5	12.6	SVN 160304	MS 3510	FLAG T15P	HXK 3.5

SVVB(C)N EXT

P M K N S H

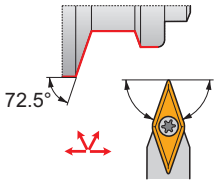
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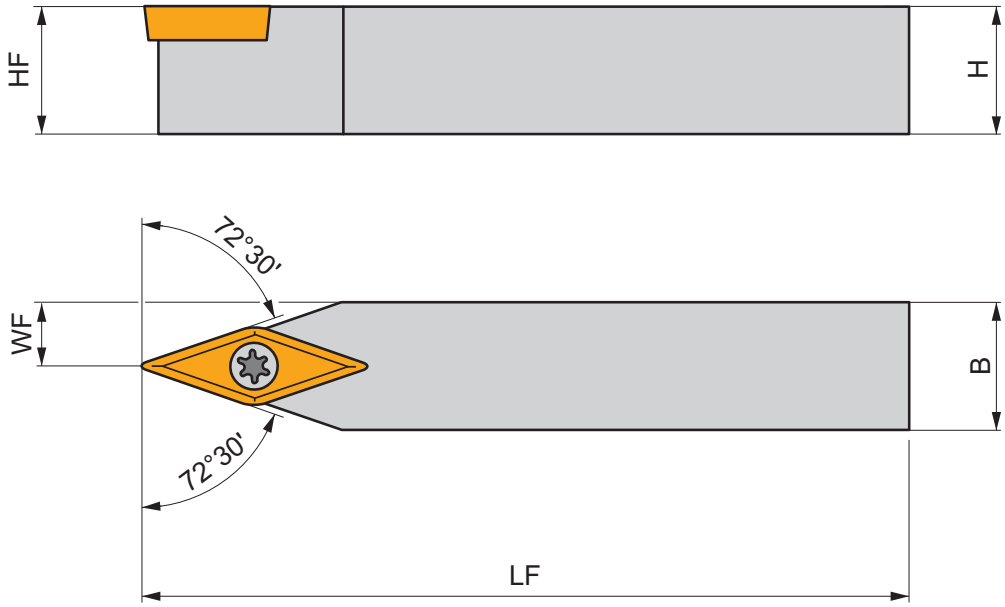
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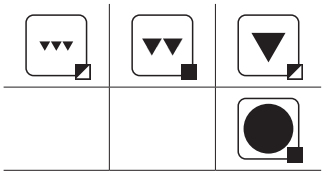


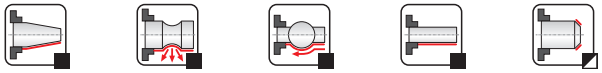
VB/VC.. Uç için Vida Sıkmalı 72.5° Açılı Dış Kater

Vida sıkmalı nötr dış kater. Pozitif VB/VC.. 11 ve 16 uçlarla çap, 72.5°'ye kadar kopya, konik ve pah tornalama için uygundur. 12x12-32x25mm mevcuttur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
N	SVVBN 1212 F 11	12	12	12	6	80	–	0	0	0.10	GI194	S01
	SVVBN 1616 H 11	16	16	16	8	100	–	0	0	0.20	GI194	S01
	SVVBN 2020 K 11	20	20	20	10	125	–	0	0	0.36	GI194	S01
	SVVCN 1212 N 13	12	12	12	6	160	–	0	0	0.19	GI211	SV21
	SVVCN 1616 H 13	16	16	16	8	100	–	0	0	0.20	GI211	SV21
	SVVCN 2020 K 13	20	20	20	10	125	–	0	0	0.36	GI211	SV22
	SVVCN 2525 M 13	25	25	25	12.5	150	–	0	0	0.66	GI211	SV22
	SVVCN 2020 K 16-M-A	20	20	20	10	125	–	0	0	0.34	GI017	SV10
	SVVCN 2525 M 16-M-A	25	25	25	12.5	150	–	0	0	0.67	GI017	SV10
	SVVCN 3225 P 16-M-A	32	25	32	12.5	170	–	0	0	0.97	GI017	SV10

GI017	VB.. 1604..	VC.. 1604..
GI194	VB.. 1103..	VC.. 1103..
GI211	–	VC.. 1303..

		Nm						
S01	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–
SV10	US 3512-T15P	3.0	M 3.5	12.6	SVN 160304	MS 3510	FLAG T15P	HXK 3.5
SV21	5513 020-24	1.5	M 3	8.5	–	–	PT-8002	–
SV22	DVF 0573	1.5	M 3	10.3	DAP 0331	DVT 0332	PT-8002	174.1-870

SVXB(C)(RL) EXT

P M K N S H

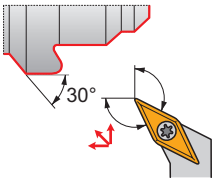
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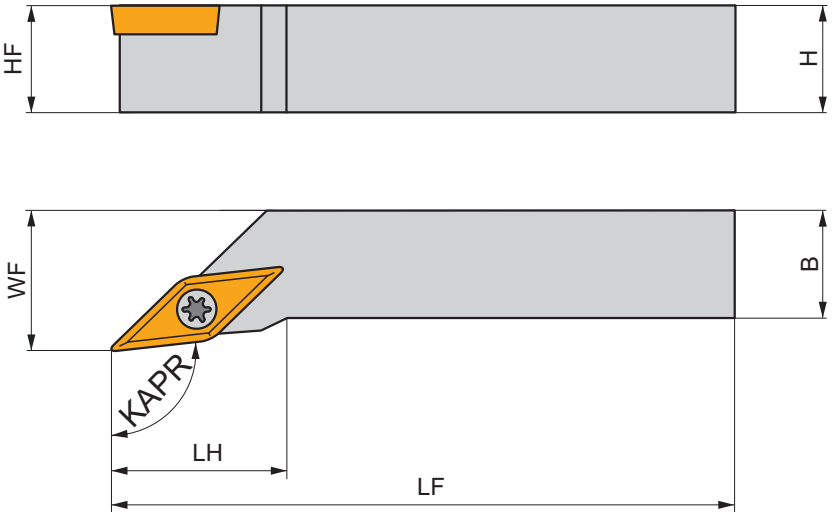
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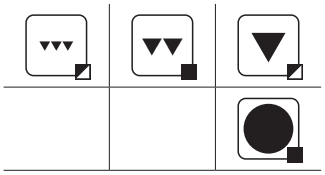


VB/VC.. Uç için Vida Sıkmalı 98/113° Açılı Dış Kater

Vida sıkmalı Sağ/Sol dış kater. Pozitif VB/VC.. 11 veya 16 uçlarla çap, konik, 30°'ye kadar kopya ve pah tornalama için uygundur. 12x12-32x25mm şaft ölçülerinde bulunur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	KAPR (°)	LAMS (°)	GAMO (°)	kg		
R	SVXBR 1212 F 11	12	12	12	16	80	20.0	98	0	0	0.09	GI194	S01
	SVXBR 1616 H 11	16	16	16	20	100	14.0	98	0	0	0.19	GI194	S01
	SVXCR 2020 K 13	20	20	20	25	125	12.0	113	0	0	0.41	GI211	SV22
	SVXCR 2020 K 16-M-A	20	20	20	25	125	28.0	98	0	0	0.38	GI017	SV10
	SVXCR 2525 M 16-M-A	25	25	25	32	150	32.0	98	0	0	0.68	GI017	SV10
	SVXCR 3225 P 16-M-A	32	25	32	32	170	32.0	98	0	0	1.00	GI017	SV10
L	SVXBL 1212 F 11	12	12	12	16	80	20.0	98	0	0	0.09	GI194	S01
	SVXBL 1616 H 11	16	16	16	20	100	14.0	98	0	0	0.19	GI194	S01
	SVXCL 2020 K 13	20	20	20	25	125	12.0	113	0	0	0.38	GI211	SV22
	SVXCL 2020 K 16-M-A	20	20	20	25	125	28.0	98	0	0	0.38	GI017	SV10
	SVXCL 2525 M 16-M-A	25	25	25	32	150	32.0	98	0	0	0.69	GI017	SV10
	SVXCL 3225 P 16-M-A	32	25	32	32	170	32.0	98	0	0	0.99	GI017	SV10

GI017	VB.. 1604..	VC.. 1604..
GI194	VB.. 1103..	VC.. 1103..
GI211	–	VC.. 1303..

		Nm						
S01	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–
SV10	US 3512-T15P	3.0	M 3.5	12.6	SVN 160304	MS 3510	FLAG T15P	HXK 3.5
SV22	DVF 0573	1.5	M 3	10.3	DAP 0331	DVT 0332	PT-8002	174.1-870

C.-SVHB(RL) EXT

P M K N S H

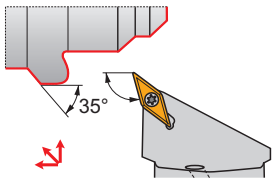
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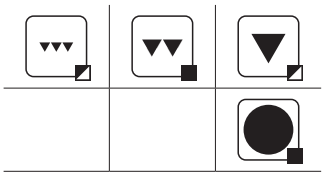
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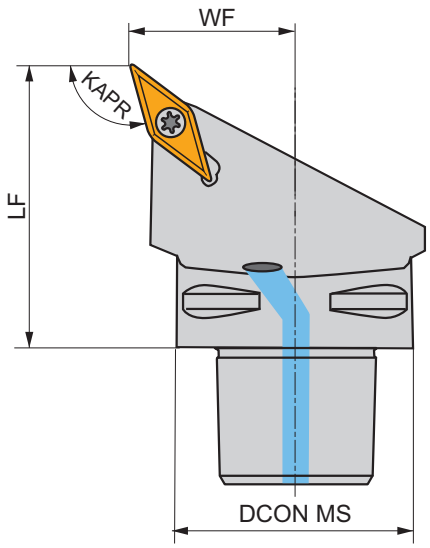


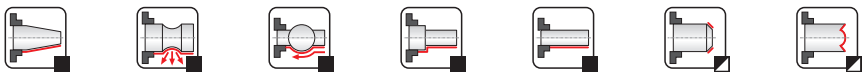
VB/VC.. Uç için Vida Sıkmalı, 107.5° Açılı Hızlı Değiştirme Dış Takımı

Vida sıkmalı Sağ/Sol, içten su vermeli dış kater. Pozitif VB/VC.. 16 uçlarla çap,konik, 35°'ye kadar kopya ve pah tornalama için uygundur. PSC C4-C6 ölçülerinde bulunur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	DCON MS (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg		
R	**C4-SVHBR-27050-16**	40	27	50	107.5	0	0	✓	0.35	GI017	C-SV16S-1
	C5-SVHBR-35060-16	50	35	60	107.5	0	0	✓	0.64	GI017	C-SV16S-2
	C6-SVHBR-45065-16	63	45	65	107.5	0	0	✓	1.13	GI017	C-SV16S-2
L	**C4-SVHBL-27050-16**	40	27	50	107.5	0	0	✓	0.35	GI017	C-SV16S-1
	C5-SVHBL-35060-16	50	35	60	107.5	0	0	✓	0.64	GI017	C-SV16S-2
	C6-SVHBL-45065-16	63	45	65	107.5	0	0	✓	1.12	GI017	C-SV16S-2

GI017	VB.. 1604..	VC.. 1604..

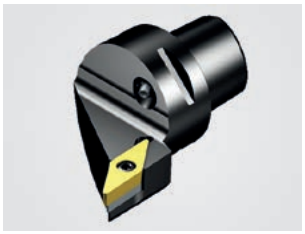
		Nm						
C-SV16S-1	US 2001-T15P	3.0	M 3.5	12.1	SVS 270-01	MS 9001	FLAG T15P/3,5	CN 034-01
C-SV16S-2	US 2001-T15P	3.0	M 3.5	12.1	SVS 270-01	MS 9001	FLAG T15P/3,5	CN 034-02

C.-SVJB(RL) EXT

P M K N S H

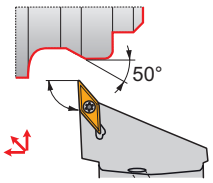
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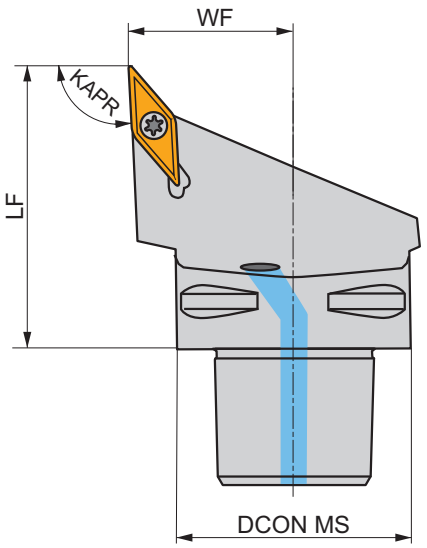
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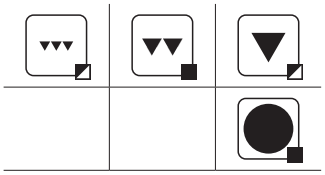


VB/VC.. Uç için Vida Sıkmalı, 93° Açılı Hızlı Değiştirme Dış Takımı

Vida sıkmalı Sağ/Sol, içten su vermeli dış kater. Pozitif VB/VC.. 11 veya 16 uçlarla çap, konik, 50°'ye kadar kopya ve pah tornalama için uygundur. PSC C3-C6 ölçülerinde bulunur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	DCON MS (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg		
R	C3-SVJBR-22040-11-B1	32	22	40	93	0	0	✓	0.17	GI194	C-SV11
	C4-SVJBR-27050-11-B1	40	27	50	93	0	0	✓	0.34	GI194	C-SV11
	C4-SVJBR-27050-16	40	27	50	93	0	0	✓	0.35	GI017	C-SV16S-1
	C5-SVJBR-35060-16	50	35	60	93	0	0	✓	0.63	GI017	C-SV16S-2
	C6-SVJBR-45065-16	63	45	65	93	0	0	✓	1.11	GI017	C-SV16S-2
L	C4-SVJBL-27050-16	40	27	50	93	0	0	✓	0.34	GI017	C-SV16S-1
	C5-SVJBL-35060-16	50	35	60	93	0	0	✓	0.64	GI017	C-SV16S-2
	C6-SVJBL-45065-16	63	45	65	93	0	0	✓	1.11	GI017	C-SV16S-2

GI017	VB.. 1604..	VC.. 1604..
GI194	VB.. 1103..	VC.. 1103..

		Nm						
C-SV11	US 2003-T07P	0.8	M 2.5	6.5	–	–	FLAG T07P	CN 034-01
C-SV16S-1	US 2001-T15P	3.0	M 3.5	12.1	SVS 270-01	MS 9001	FLAG T15P/3,5	CN 034-01
C-SV16S-2	US 2001-T15P	3.0	M 3.5	12.1	SVS 270-01	MS 9001	FLAG T15P/3,5	CN 034-02

C.-SVVBN EXT

P M K N S H

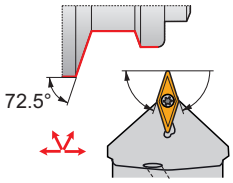
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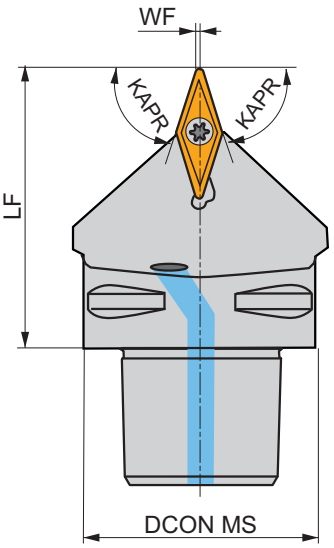
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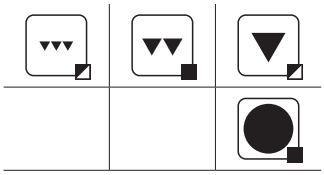


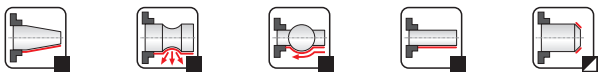
Vida Sıkmalı VB/VC.. Uç için PSC Hızlı Değiştirme 72.5° Dış Kateri

Vida sıkmalı, içten su vermeli nötr dış kater. Pozitif VB/VC.. 16 uçlarla çap, 72.5°'ye kadar kopya, konik ve pah tornalamak için uygundur. C4'ten C6'ya kadar PSC şaftlı mevcuttur. Tutucu uzun takım ömrü için işlem görmüştür.









	Product	DCON MS (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg		
N	**C4-SVVBN-00050-16**	40	0.6	50	72.5	0	0	✓	0.32	GI017	C-SV16S-1
	C5-SVVBN-00060-16	50	0.6	60	72.5	0	0	✓	0.56	GI017	C-SV16S-2
	C6-SVVBN-00065-16	63	0.6	65	72.5	0	0	✓	0.99	GI017	C-SV16S-2

GI017	VB.. 1604..	VC.. 1604..

		Nm						
C-SV16S-1	US 2001-T15P	3.0	M 3.5	12.1	SVS 270-01	MS 9001	FLAG T15P/3,5	CN 034-01
C-SV16S-2	US 2001-T15P	3.0	M 3.5	12.1	SVS 270-01	MS 9001	FLAG T15P/3,5	CN 034-02

SVJB(RL) INT

P M K N S H

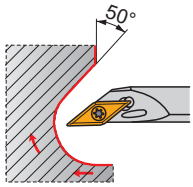
PRAMET

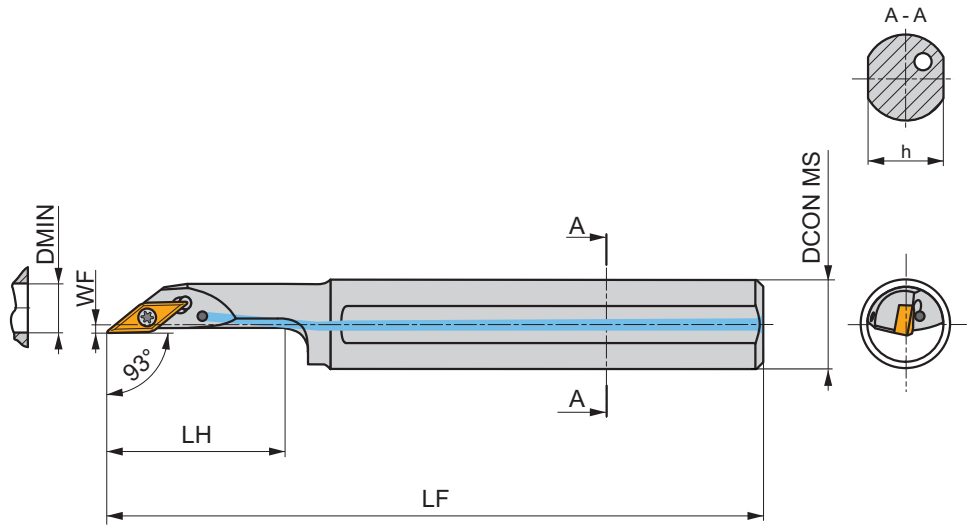
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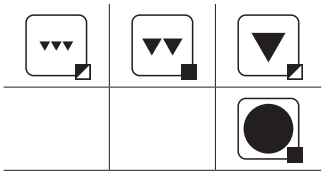


VB/VC.. Uç için Vida Sıkmalı 93° Açılı Delik Kateri

Vida sıkmalı Sağ/Sol 93° içten su vermeli delik kateri. Pozitif VB/VC.. uçlarla , ve 50°'ye kadar kopya tornalama için uygundur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)		kg		
R	**A20R-SVJBR 11**	20	25	2	18	200	40.0	-5	-5	✓	0.40	GI194	S07
	A25S-SVJBR 11	25	32	3.5	23	250	50.0	-5	-5	✓	0.81	GI194	S07
L	**A20R-SVJBL 11**	20	25	2	18	200	40.0	-5	-5	✓	0.41	GI194	S07
	A25S-SVJBL 11	25	32	3.5	23	250	50.0	-5	-5	✓	0.81	GI194	S07

GI194	VB.. 1103..	VC.. 1103..

S07	US 2506-T07P	0.9	M 2.5	6.3	FLAG T07P

SVQB(C)(RL) INT

P M K N S H

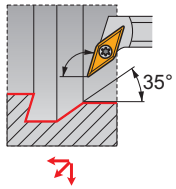
PRAMET

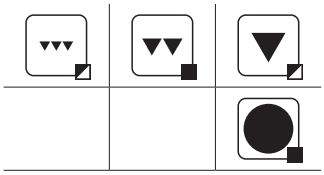
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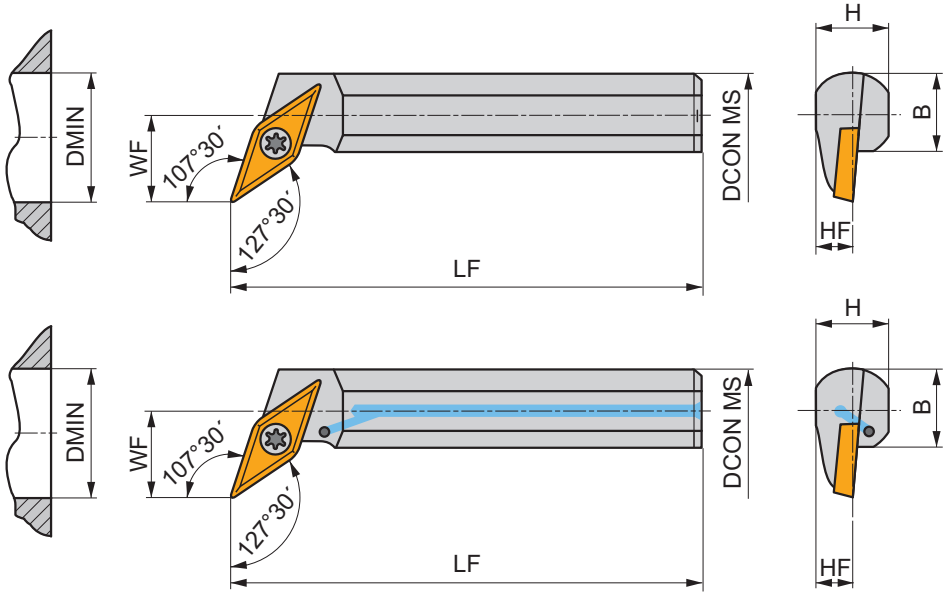


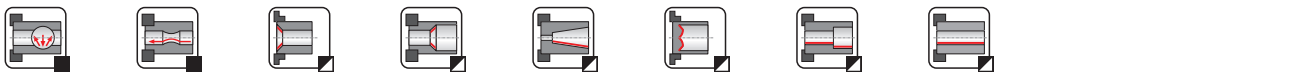
VB/VC.. Uç için Vida Sıkmalı 107.5° Açılı Delik Kateri

Vida sıkmalı Sağ/Sol 107.5° içten su vermeli delik kateri. Pozitif VB/VC.. uçlarla birçok uygulama için uygundur. Ø16-40mm şaft ölçülerinde bulunur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)		kg		
R	A16R-SVQBR 11	16	20	11	14.5	15	200	-5	0	✓	0.33	GI194	S01
	A20S-SVQBR 11	20	25	13	18	18.5	250	-4	0	✓	0.57	GI194	S01
	A16R-SVQCR 13	16	21	11	15	15	200	-6	0	✓	0.29	GI211	SV21
	A20S-SVQCR 13	20	25	13	18	18.5	250	-4	0	✓	0.12	GI211	SV21
	S25T-SVQCR 16	25	32	17	23	23	300	-7	0	–	1.08	GI017	S08
	S32U-SVQCR 16	32	40	22	30	30	350	-5	0	–	2.07	GI017	S08
	S40V-SVQCR 16-A	40	50	27	38	38	400	-5	0	–	3.80	GI017	SV10
L	A16R-SVQBL 11	16	20	11	14.5	15	200	-5	0	✓	0.32	GI194	S01
	A20S-SVQBL 11	20	25	13	18	18.5	250	-4	0	✓	0.57	GI194	S01
	A16R-SVQCL 13	16	21	11	15	15	200	-6	0	✓	0.29	GI211	SV21
	A20S-SVQCL 13	20	25	13	18	18.5	250	-4	0	✓	0.54	GI211	SV21
	S25T-SVQCL 16	25	32	17	23	23	300	-7	0	–	1.08	GI017	S08
	S32U-SVQCL 16	32	40	22	30	30	350	-5	0	–	2.07	GI017	S08
	S40V-SVQCL 16-A	40	50	27	38	38	400	-5	0	–	4.10	GI017	SV10

GI017	VB.. 1604..	VC.. 1604..
GI194	VB.. 1103..	VC.. 1103..
GI211	–	VC.. 1303..

		Nm						
S01	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–
S08	US 3510-T15P	3.0	M 3.5	10.6	–	–	FLAG T15P	–
SV10	US 3512-T15P	3.0	M 3.5	12.6	SVN 160304	MS 3510	FLAG T15P	HXK 3.5
SV21	5513 020-24	1.5	M 3	8.5	–	–	PT-8002	–

SVUB(C)(RL) INT

P M K N S H

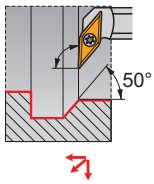
PRAMET

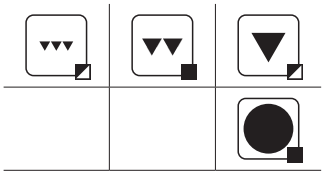
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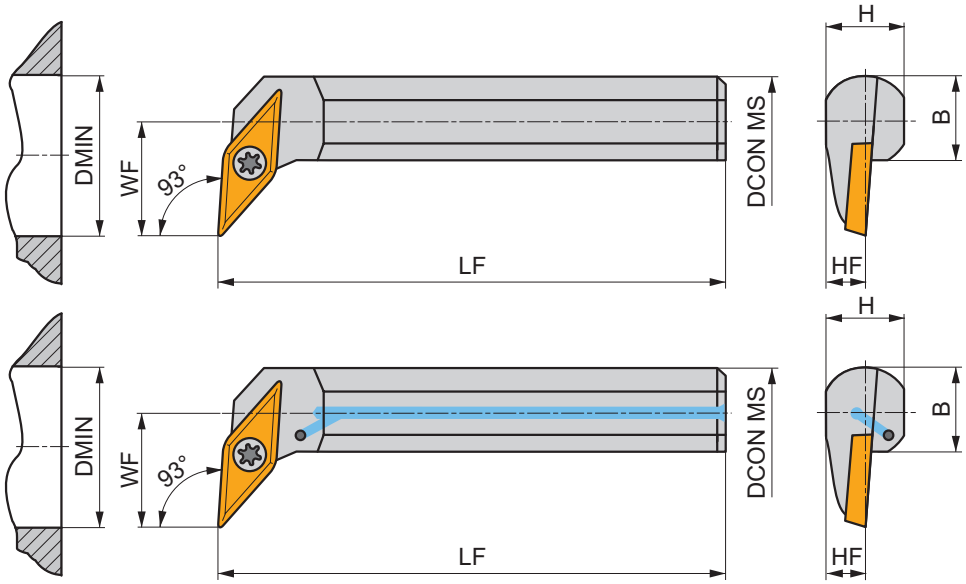


VB/VC.. Uç için Vida Sıkmalı 93° Açılı Delik Kateri

Vida sıkmalı Sağ/Sol 93° içten su vermeli delik kateri. Pozitif VB/VC.. uçlarla , ve 50°'ye kadar kopya tornalama için uygundur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)		kg		
R	**A16R-SVUBR 11**	16	20	11	14.5	15	200	-5	0	✓	0.32	GI194	S01
	A20S-SVUBR 11	20	25	13	18	18.8	250	-4	0	✓	0.57	GI194	S01
	A20S-SVUCR 13	20	25	13	19	18.5	250	-4	2	✓	0.54	GI211	SV21
	A25T-SVUCR 13	25	32	17	24	23	300	-2	2	✓	0.96	GI211	SV22
	A32T-SVUCR 13	32	40	22	30	30	300	-1	2	✓	1.66	GI211	SV22
	S25T-SVUCR 16	25	32	17	23	23	300	-7	0	–	1.08	GI017	S08
	S32U-SVUCR 16	32	40	22	30	30	350	-5	0	–	2.10	GI017	S08
	S40V-SVUCR 16-A	40	50	27	38	38	400	-5	0	–	4.10	GI017	SV10
L	**A16R-SVUBL 11**	16	20	11	14.5	15	200	-5	0	✓	0.32	GI194	S01
	A20S-SVUBL 11	20	25	13	18	18.5	250	-4	0	✓	0.57	GI194	S01
	A20S-SVUCL 13	20	25	13	19	18.5	250	-4	2	✓	0.32	GI211	SV21
	A25T-SVUCL 13	25	32	17	24	23	300	-2	2	✓	0.96	GI211	SV22
	A32T-SVUCL 13	32	40	22	30	30	300	-1	2	✓	1.66	GI211	SV22
	S25T-SVUCL 16	25	32	17	23	23	300	-7	0	–	1.09	GI017	S08
	S32U-SVUCL 16	32	40	22	30	30	350	-5	0	–	2.10	GI017	S08
	S40V-SVUCL 16-A	40	50	27	38	38	400	-5	0	–	4.10	GI017	SV10

GI017	VB.. 1604..	VC.. 1604..
GI194	VB.. 1103..	VC.. 1103..
GI211	–	VC.. 1303..

		Nm						
S01	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–
S08	US 3510-T15P	3.0	M 3.5	10.6	–	–	FLAG T15P	–
SV10	US 3512-T15P	3.0	M 3.5	12.6	SVN 160304	MS 3510	FLAG T15P	HXK 3.5
SV21	5513 020-24	1.5	M 3	8.5	–	–	PT-8002	–
SV22	DVF 0573	1.5	M 3	10.3	DAP 0331	DVT 0332	PT-8002	174.1-870

C.-SVQB(RL) INT

P M K N S H

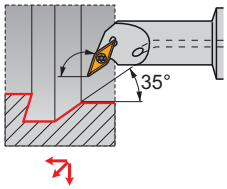
PRAMET

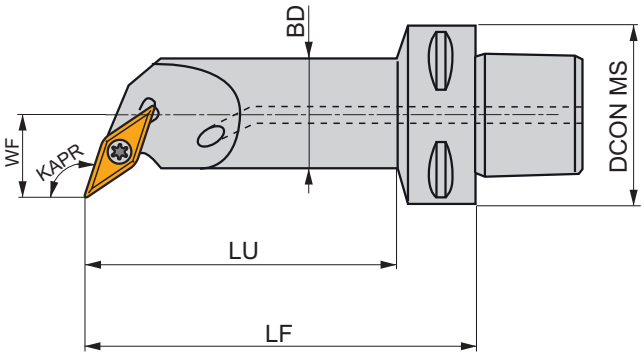
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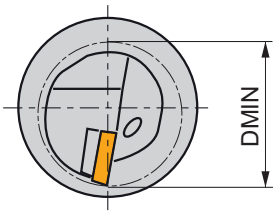


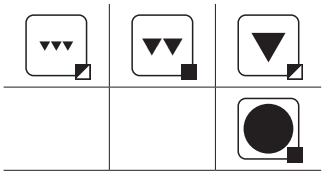
VB/VC.. Uç için Vida Sıkmalı 107.5° Açılı PSC Hızlı Değiştirme Delik Takımı

Vida sıkmalı Sağ/Sol 107.5° içten su vermeli delik kateri. Pozitif VB/VC.. uçlarla birçok uygulama için uygundur.Çokgen Şaft çeşitli boy ölçülerinde bulunur. Gövde uzun takım ömrü için işlem görmüştür.











	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	LF (mm)	LU (mm)	BD (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg		
R	C4-SVQBR-18090-16	40	33	18	90	68	25	107.5	-7.2	0	✓	0.48	GI017	SV16
	C5-SVQBR-18090-16	50	33	18	90	67	25	107.5	-7.2	0	✓	0.67	GI017	SV16
L	C4-SVQBL-18090-16	40	33	18	90	68	25	107.5	-7.2	0	✓	0.48	GI017	SV16
	C5-SVQBL-18090-16	50	33	18	90	67	25	107.5	-7.2	0	✓	0.68	GI017	SV16

GI017	VB.. 1604..	VC.. 1604..

SV16	US 2010-T15P	3.0 Nm	M 3.5	10.1	FLAG T15P/3,5

SVAC(RL)-DC EXT

P M K N S H

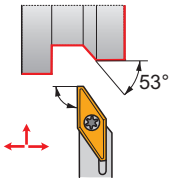
PRAMET

S

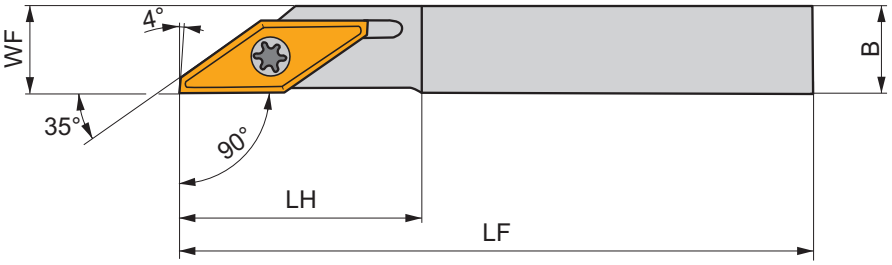


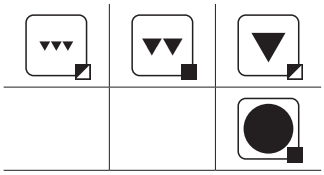
VCGX13 Uç için Vida Sıkmalı 90° Açılı Dış Kater

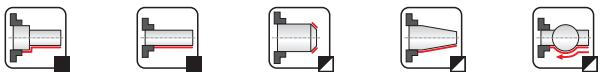
Vida sıkmalı Sağ/Sol dış kayar otomat kateri. Pozitif VCGX uçlarla çap, alın, konik, 53°'ye kadar kopya ve pah tornalama için uygundur. 10x10-25x25mm şaft ölçülerinde bulunur. Gövde uzun takım ömrü için işlem görmüştür.











	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	SVACR 1010 L 13-DC	10	10	10	10	140	25.0	0	0	0.12	GI222	SV20
	SVACR 1212 L 13-DC	12	12	12	12	140	25.0	0	0	0.17	GI222	SV20
	SVACR 1616 M 13-DC	16	16	16	16	150	25.0	0	0	0.29	GI222	SV20
	SVACR 2020 M 13-DC	20	20	20	20	150	25.0	0	0	0.46	GI222	SV20
L	SVACL 1212 L 13-DC	12	12	12	12	140	25.0	0	0	0.19	GI222	SV20
	SVACL 1616 M 13-DC	16	16	16	16	150	25.0	0	0	0.29	GI222	SV20
	SVACL 2020 M 13-DC	20	20	20	20	150	25.0	0	0	0.43	GI222	SV20
	SVACL 2525 M 13-DC	25	25	25	25	150	25.0	0	0	0.67	GI222	SV20

GI222	VCGX 1303..

		Nm			
SV20	5513 020-24	1.5	M 3	8.5	PT-8002

SVJC(RL)-DC EXT

P M K N S H

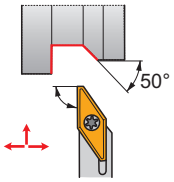
PRAMET

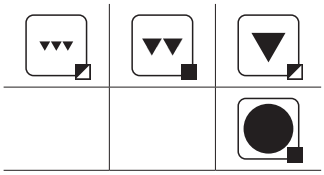
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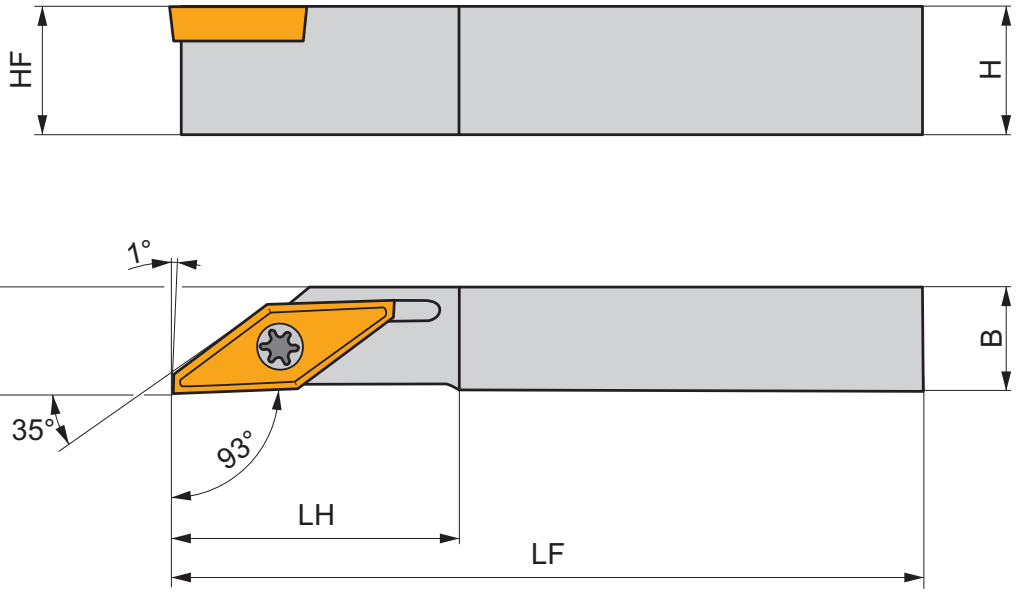


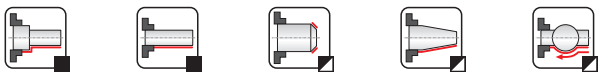
VCGX13 Uç için Vida Sıkmalı 93° Açılı Dış Kater

Vida sıkmalı Sağ/Sol dış kayar otomat kateri. Pozitif VCGX uçlarla çap, alın, konik, 50°'ye kadar kopya ve pah tornalama için uygundur. 10x10-25x25mm şaft ölçülerinde bulunur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	SVJCR 1212 L 13-DC	12	12	12	–	140	25.0	0	0	0.17	GI222	SV20
	SVJCR 1616 M 13-DC	16	16	16	–	150	25.0	0	0	0.29	GI222	SV20
	SVJCR 2020 M 13-DC	20	20	20	–	150	25.0	0	0	0.45	GI222	SV20
	SVJCR 2525 M 13-DC	25	25	25	–	150	25.0	0	0	0.68	GI222	SV20
L	SVJCL 1212 L 13-DC	12	12	12	–	140	25.0	0	0	0.17	GI222	SV20
	SVJCL 1616 M 13-DC	16	16	16	–	150	25.0	0	0	0.30	GI222	SV20
	SVJCL 2020 M 13-DC	20	20	20	–	150	25.0	0	0	0.47	GI222	SV20
	SVJCL 2525 M 13-DC	25	25	25	–	150	25.0	0	0	0.69	GI222	SV20

GI222	VCGX 1303..

		Nm			
SV20	5513 020-24	1.5	M 3	8.5	PT-8002

SVLC(RL) INT

P M K N S H

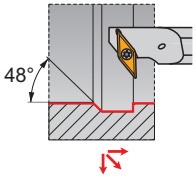
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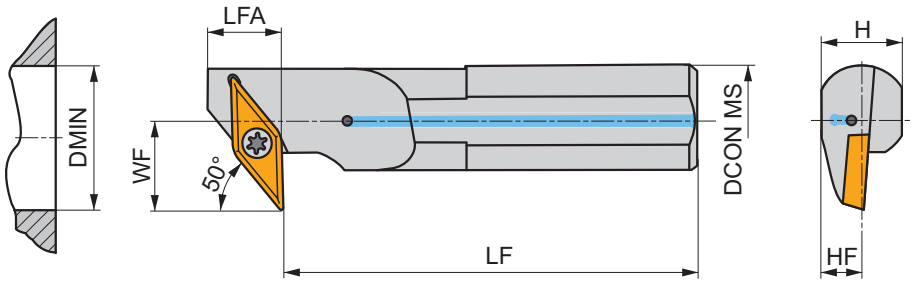
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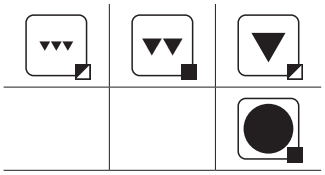


VC.. Uç için Vida Sıkmalı 50° Açılı Delik Kateri

Vida sıkmalı Sağ/Sol 50° içten su vermeli delik kateri. Pozitif VC..uçlarla 48°'ye kadar kopya tornalama için uygundur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	LF (mm)	HF (mm)	LFA (mm)	LAMS (°)	GAMO (°)		kg		
R	**A20S-SVLCR 13-X**	20	27	15	18	250	9	15	-4	-2	✓	0.57	GI211	SV21
	A25T-SVLCR 13-X	25	35	20	24	300	12	18	-2	-2	✓	1.01	GI211	SV22
	A32T-SVLCR 13-X	32	43	25	30	300	15	18	-1	-2	✓	1.75	GI211	SV22
L	**A20S-SVLCL 13-X**	20	27	15	18	250	9	15	-4	-2	✓	0.57	GI211	SV21
	A25T-SVLCL 13-X	25	35	20	24	300	12	18	-2	-2	✓	0.05	GI211	SV22
	A32T-SVLCL 13-X	32	43	25	30	300	15	18	-1	-2	✓	1.75	GI211	SV22

GI211	VC.. 1303..

		Nm						
SV21	5513 020-24	1.5	M 3	8.5	–	–	PT-8002	–
SV22	DVF 0573	1.5	M 3	10.3	DAP 0331	DVT 0332	PT-8002	174.1-870

SVXC(RL) INT

P M K N S H

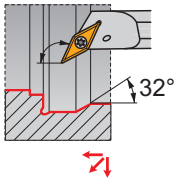
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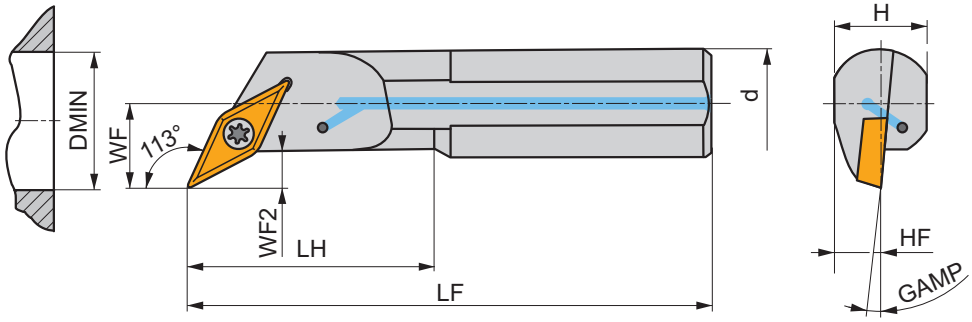
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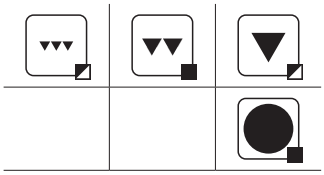


VC.. Uç için Vida Sıkmalı 113° Açılı Delik Kateri

Vida sıkmalı Sağ/Sol 113° içten su vermeli delik kateri. Pozitif VC..uçlarla 32°'ye kadar kopya tornalama için uygundur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	LF (mm)	HF (mm)	LH (mm)	WF2 (mm)	GAMP (°)		kg		
R	**A10H-SVXCR 07**	10	12.5	7	9	100	4.5	22.0	3	-10	✓	0.06	GI234	SV23
	A12K-SVXCR 07	12	15.5	9	11	125	5.5	28.0	3	-8	✓	0.11	GI234	SV23
	A16M-SVXCR 07	16	17.5	11	15	150	7.5	36.0	3	-6	✓	0.19	GI234	SV23
L	**A10H-SVXCL 07**	10	12.5	7	9	100	4.5	22.0	3	-10	✓	0.06	GI234	SV23
	A12K-SVXCL 07	12	15.5	9	11	125	5.5	28.0	3	-8	✓	0.11	GI234	SV23
	A16M-SVXCL 07	16	17.5	11	15	150	7.5	36.0	3	-6	✓	0.20	GI234	SV23

GI234	VC.. 0702..

SV23	DVF 3584	0.6 Nm	M 2	5.5	DMD 1650

SVXC(RL)-E INT

P M K N S H

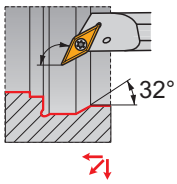
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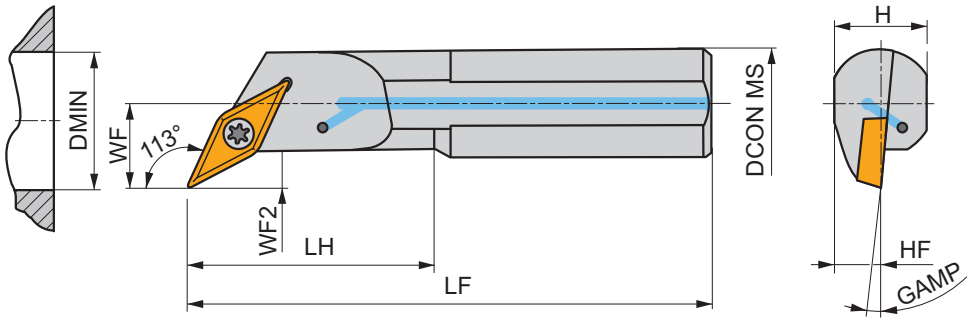
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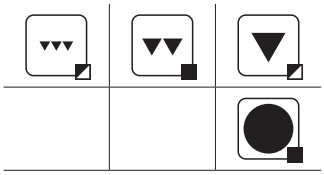


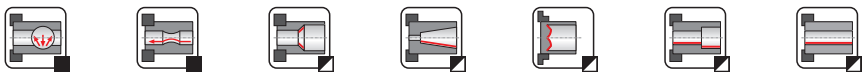
VC.. Uç için Vida Sıkmalı 113° Açılı Karbür Delik Kateri

Vida sıkmalı tip VC.. uçlar için 113° kesme açılı, içten soğutmalı, İçten Sağ/Sol karbür delik işleme barası. Çok çeşitli iç çap tornalama işlemleri ve 32° altında kopyalama için uygundur. Takım kullanma mesafesi için >3xD.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	HF (mm)	LF (mm)	LH (mm)	WF2 (mm)	GAMP (°)		kg		
R	**E10H-SVXCR 07**	10	12.5	7	9	4.5	100	22.0	3	-10	✓	0.10	GI234	SV23
	E12K-SVXCR 07	12	15.5	9	11	5.5	125	28.0	3	-8	✓	0.18	GI234	SV23
	E16M-SVXCR 07	16	17.5	11	15	7.5	150	36.0	3	-6	✓	0.33	GI234	SV23
L	**E10H-SVXCL 07**	10	12.5	7	9	4.5	100	22.0	3	-10	✓	0.10	GI234	SV23
	E16M-SVXCL 07	16	17.5	11	15	7.5	150	36.0	3	-6	✓	0.33	GI234	SV23

GI234	VC.. 0702..

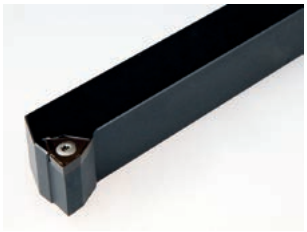
SV23	DVF 3584	0.6 Nm	M 2	5.5	DMD 1650

SWLC(RL) EXT

P M K N S H

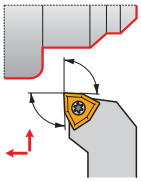
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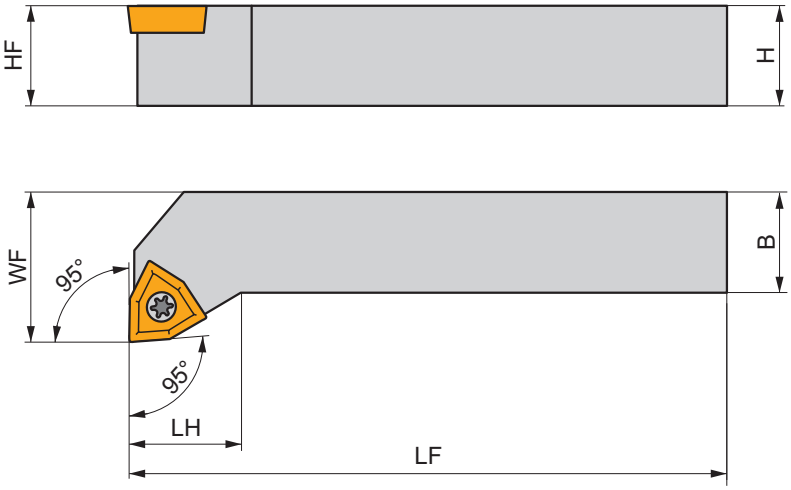
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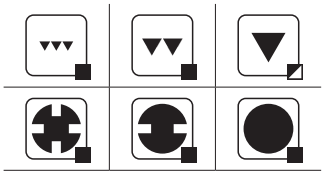


WC.. Uç için Vida Sıkmalı 95° Açılı Dış Kater

Vida sıkmalı Sağ/Sol dış kater. Pozitif WC.. 06 veya 08 uçlarla alın, çap, konik ve pah tornalama için uygundur. 16x16-25x25mm şaft ölçülerinde bulunur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	SWLCR 1616 H 06	16	16	16	20	100	15.0	0	0	0.23	GI055	S04
	SWLCR 2020 K 06	20	20	20	25	125	15.0	0	0	0.42	GI055	S04
	SWLCR 2525 M 08	25	25	25	32	150	20.0	0	0	0.76	GI049	S09
L	SWLCL 1616 H 06	16	16	16	20	100	15.0	0	0	0.23	GI055	S04
	SWLCL 2020 K 06	20	20	20	25	125	15.0	0	0	0.40	GI055	S04
	SWLCL 2525 M 08	25	25	25	32	150	20.0	0	0	0.75	GI049	S09

GI049	WC.. 0804..
GI055	WC.. 06T3..

		Nm			
S04	US 3510-T15P	3.0	M 3.5	10.6	FLAG T15P
S09	US 4512-T15P	5.0	M 4.5	12.2	FLAG T15P

SWLC(RL) INT

P M K N S H

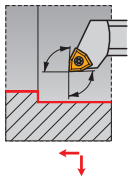
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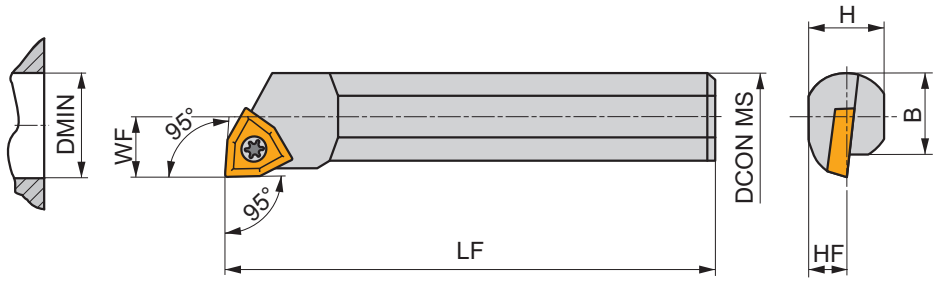
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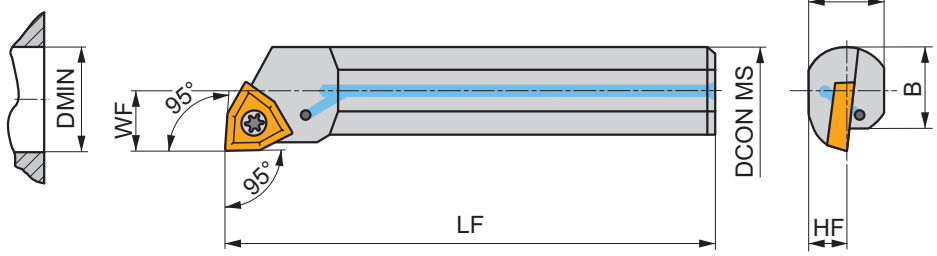


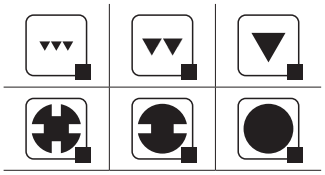
WC.. Uç için Vida Sıkmalı 95° Açılı Delik Kateri

Vidalı sıkmalı tip WC.. uçlar için 95° kesme açılı ,iç çap Sağ/Sol delik işleme barası, içten soğutmalı . Kenar ve pah tornalama ile iç konik ve çap tornalama için. Gövde uzun takım ömrü için işlem görmüştür.











	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)		kg		
R	A20Q-SWLCR 06	20	25	13	18	18.5	180	-7	0	✓	0.37	GI055	S04
	S20S-SWLCR 06	20	25	13	18	18.5	250	-7	0	–	0.60	GI055	S04
	S25T-SWLCR 06	25	32	17	23	23	300	-7	0	–	1.12	GI055	S04
	A25R-SWLCR 08	25	32	17	23	23	200	-7	0	✓	0.70	GI049	S04
	A32S-SWLCR 08	32	40	22	30	30	250	-5	0	✓	1.32	GI049	S09
	S32U-SWLCR 08	32	40	22	30	30	350	-5	0	–	2.05	GI049	S09
L	A20Q-SWLCL 06	20	25	13	18	18.5	180	-7	0	✓	0.00	GI055	S04
	S20S-SWLCL 06	20	25	13	18	18.5	250	-7	0	–	0.60	GI055	S04
	A25R-SWLCL 06	25	32	17	23	23	200	-7	0	✓	0.66	GI055	S04

GI049	WC.. 0804..
GI055	WC.. 06T3..

		Nm			
S04	US 3510-T15P	3.0	M 3.5	10.6	FLAG T15P
S09	US 4512-T15P	5.0	M 4.5	12.2	FLAG T15P

SWUC(RL) INT

P M K N S H

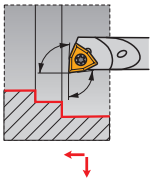
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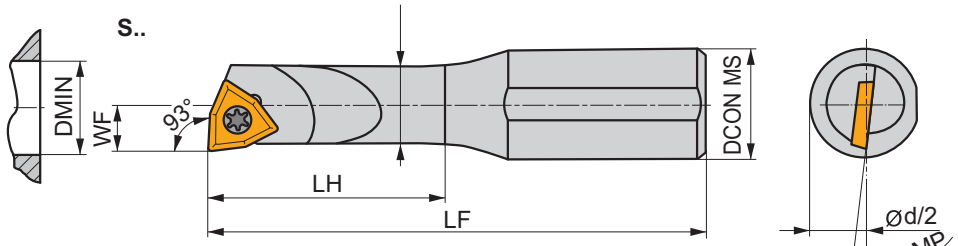
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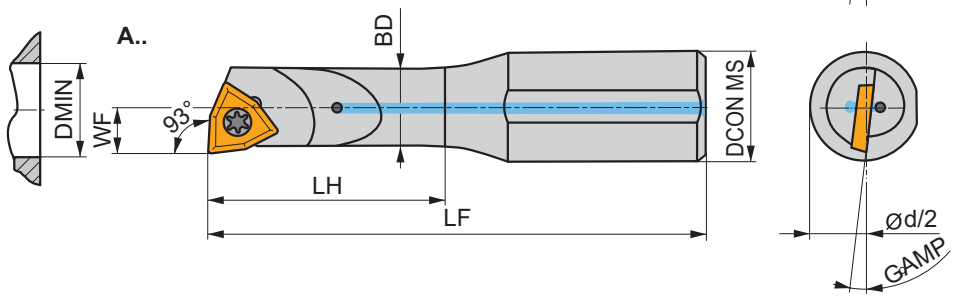


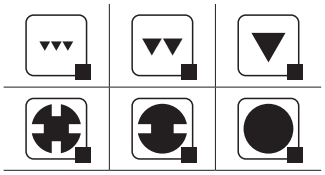
WC.. Uç için Vida Sıkmalı 93° Açılı Delik Kateri

Vida sıkmalı Sağ/Sol 93° içten su vermeli delik kateri. Pozitif WC..uçlarla Kenar ve pah tornalama ile iç konik ve çap tornalama için uygundur. Gövde uzun takım ömrü için işlem görmüştür.











	Product	DCON MS (mm)	DMIN (mm)	BD (mm)	WF (mm)	LF (mm)	LH (mm)	GAMP (°)		kg		
R	A0508H-SWUCR 02	8	5.8	5	2.9	100	18.0	-17	✓	0.04	GI221	SW21
	S0508H-SWUCR 02	8	5.8	5	2.9	100	18.0	-17	–	0.03	GI221	SW21
	A0608H-SWUCR 02	8	7.8	6	3.9	100	24.0	-12	✓	0.04	GI221	SW21
	S0608H-SWUCR 02	8	7.8	6	3.9	100	24.0	-12	–	0.04	GI221	SW21
L	A0508H-SWUCL 02	8	5.8	5	2.9	100	18.0	-17	✓	0.04	GI221	SW21
	S0508H-SWUCL 02	8	5.8	5	2.9	100	18.0	-17	–	0.04	GI221	SW21
	A0608H-SWUCL 02	8	7.8	6	3.9	100	24.0	-12	✓	0.04	GI221	SW21
	S0608H-SWUCL 02	8	7.8	6	3.9	100	24.0	-12	–	0.04	GI221	SW21

GI221	WC.. 0201..

SW21	T20.037	0.6 Nm	M 2	3.7	DMD 1650

SWUC(RL)-E INT

P M K N S H

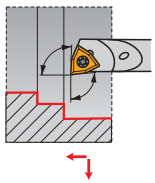
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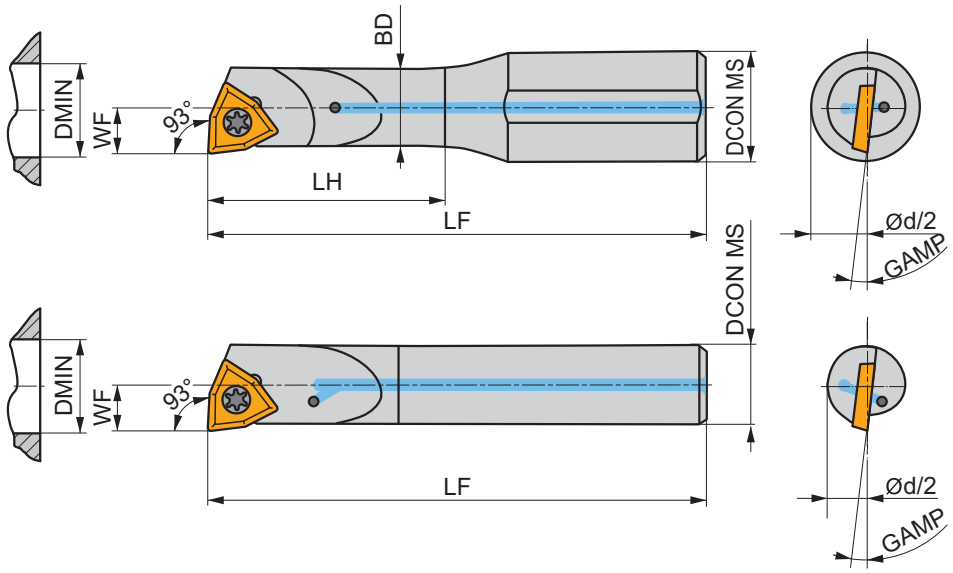
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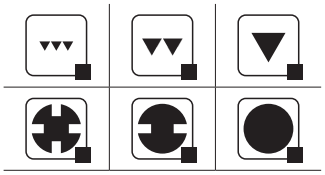


WC.. Uç için Vida Sıkmalı 93° Açılı Karbür Delik Kateri

Vida sıkmalı tip WC.. uçlar için 93° kesme açılı, içten soğutmalı, İçten Sağ/Sol karbür delik işleme barası. Kenar ve pah tornalama ile iç konik ve boyuna tornalama için uygundur. Takım kullanma mesafesi için >3xD.







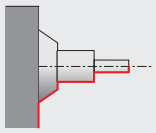


	Product	DCON MS (mm)	DMIN (mm)	BD (mm)	WF (mm)	LF (mm)	LH (mm)	GAMP (°)		kg		
R	E0508H-SWUCR 02	8	5.8	5	2.9	100	24.0	-17	✓	0.06	GI221	SW21
	E05F-SWUCR 02	5	5.8	–	2.9	85	–	-17	✓	0.03	GI221	SW21
	E0608H-SWUCR 02	8	7.8	6	3.9	100	32.0	-12	✓	0.06	GI221	SW21
	E06G-SWUCR 02	6	7.8	–	3.9	95	–	-12	✓	0.04	GI221	SW21
L	E0508H-SWUCL 02	8	5.8	5	2.9	100	24.0	-17	✓	0.06	GI221	SW21
	E05F-SWUCL 02	5	5.8	–	2.9	85	–	-17	✓	0.03	GI221	SW21
	E0608H-SWUCL 02	8	7.8	6	3.9	100	32.0	-12	✓	0.06	GI221	SW21
	E06G-SWUCL 02	6	7.8	–	3.9	95	–	-12	✓	0.04	GI221	SW21

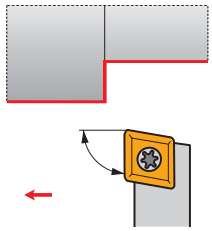
GI221	WC.. 0201..

SW21	T20.037	0.6	M 2	3.7	DMD 1650

ISO TORNALAMA - DIŞ
UZUN VE STABİL OLMAYAN PARÇALAR (Pozitif uçlar)

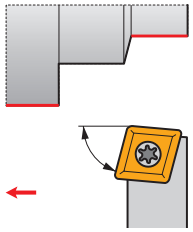


SCAC(RL) EXT 90°
CC..



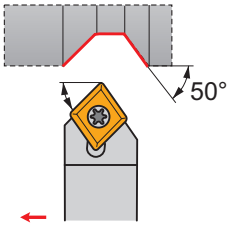
77

SCBC(RL) EXT 75°
CC..



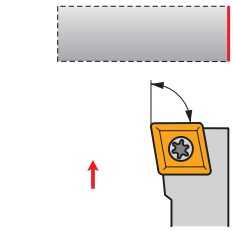
78

SCDCR EXT 45°
CC..



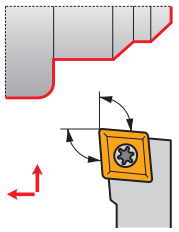
79

SCFC(RL) EXT 90°
CC..



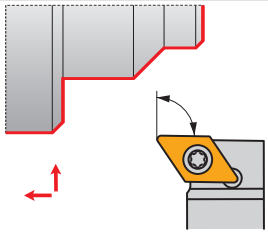
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SCLC(RL) EXT 95°
CC..



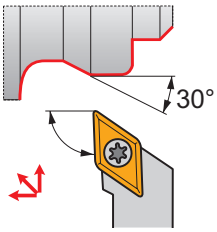
81

SDFC(RL) EXT 91°
DC..



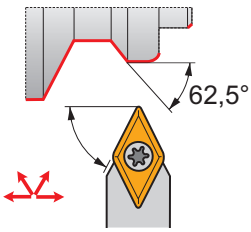
90

SDJC(RL) EXT 93°
DC..



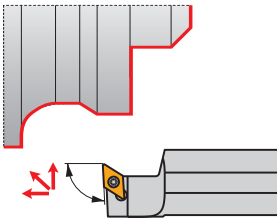
91

SDNCN EXT 62°30´
DC..



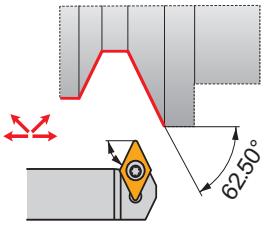
93

SDUCL EXT 93°
DC..



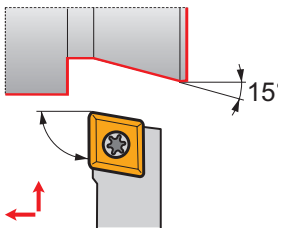
94

SDXC(RL) EXT 62°30´
DC..



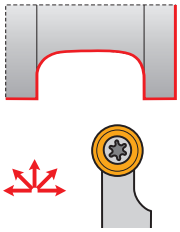
95

SEGC(RL) EXT 90°
EC..



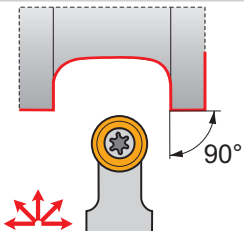
103

SRDC(RL) EXT
RC..



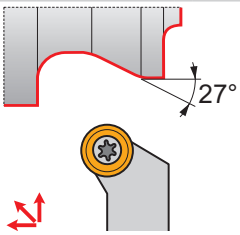
112

SRDCN EXT
RC..



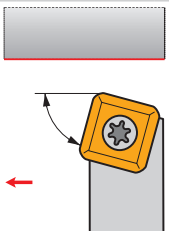
113

SRSC (RL) EXT
RC..



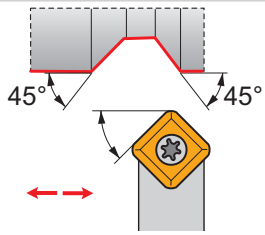
114

SSBC(RL) EXT 75°
SC..



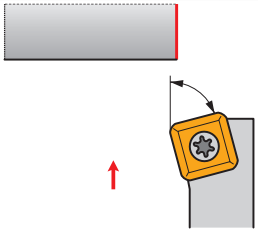
119

SSDCN EXT 45°
SC..



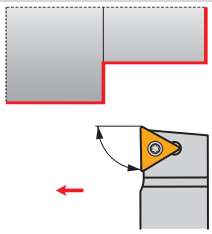
120

SSKC(RL) EXT 75°
SC..



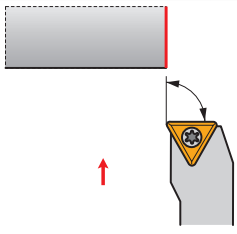
121

STAC(RL) EXT 90°
TC..



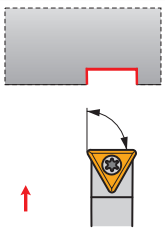
125

STFC(RL) EXT 90°
TC..



126

STFC(RL)-A EXT 90°
TC..



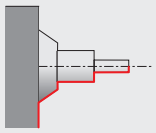
127

S SIKMA TIPI

TAKIMLAR - REHBER

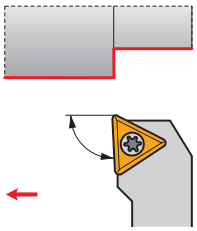
ISO TORNALAMA - DIŞ

UZUN VE STABİL OLMAYAN PARÇALAR (Pozitif uçlar)



STJC(RL) EXT 93°

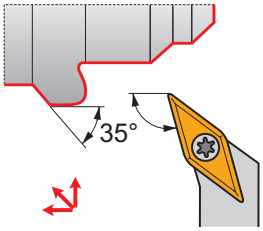
TC..



128

SVHB(C)(RL) EXT 107°30´

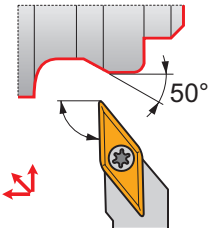
VB, VC..



132

SVJB(C)(RL) EXT 93°

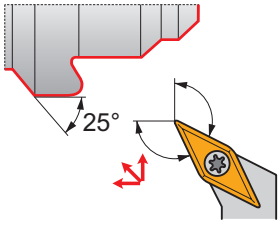
VB, VC..



133

SVPB(C)(RL) EXT 117°30´

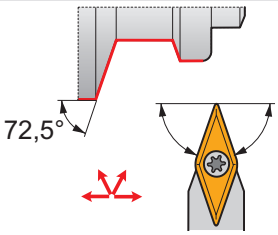
VB, VC..



135

SVVB(C)N EXT 72°30´

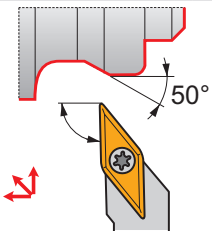
VB, VC..



136

SVXB(C)(RL) EXT 98°

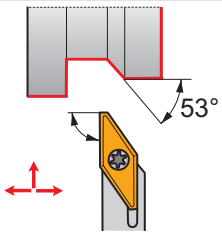
VB, VC..



137

SVAC(RL)-DC EXT 90°

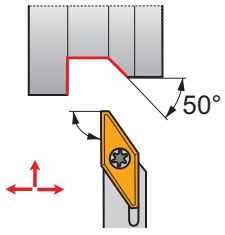
VC..



145

SVJC(RL)-DC EXT 93°

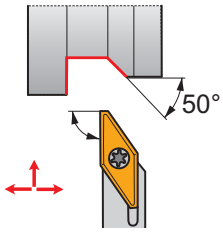
VC..



146

SWLC(RL) EXT 95°

WC..



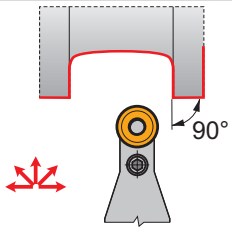
150

P SIKMA TIPI

TAKIMLAR - REHBER

PRDCN EXT

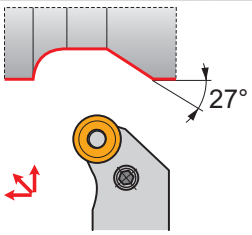
RC..



110

PRSC(RL) EXT

RC..



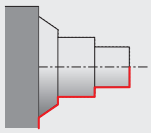
111

KHP / DKH SIKMA TIPI

TAKIMLAR - REHBER

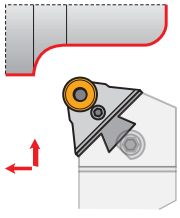
ISO TORNALAMA - AĞIR KABA - DIŞ

KAFA (KH)



KHP-RSCR/L

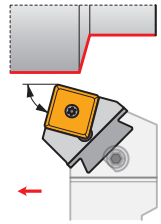
RC..



117

KHS-SBCR 75°

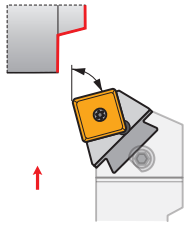
SC..



123

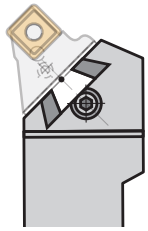
KHS-SBCL 75°

SC..



123

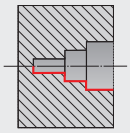
DKH(RL)



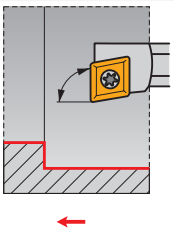
118, 124

ISO TORNALAMA - İÇ

UZUN VE STABİL OLMAYAN PARÇALAR (Pozitif uçlar)

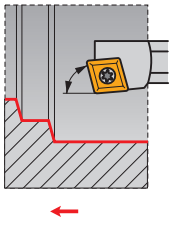


SCFC(RL) INT 90°
CC..



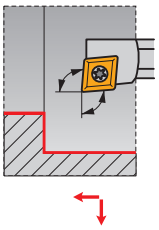
84

SCKC(RL) INT 75°
CC..



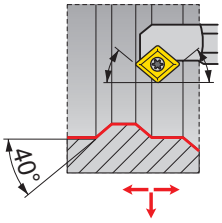
85

SCLC(RL) INT 45°
CC..



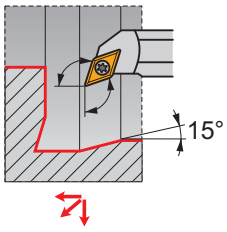
86

SCXC(RL) INT 90°
CC..



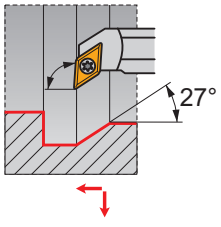
88

SDQC(RL) INT 95°
DC..



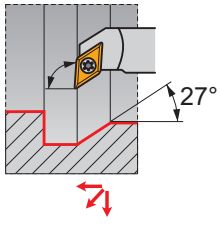
98

SDUC(RL) INT 93°
DC..



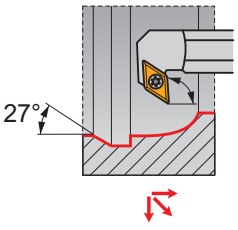
99

SDUC(RL)-E INT 62°30´
DC..



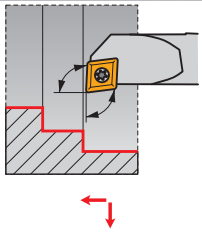
100

SDZC(RL) INT 90°
DC..



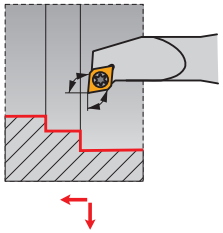
101

SEUC(RL) INT 93°
EC..



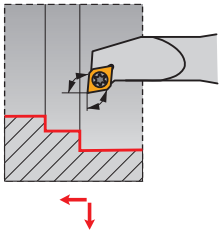
104

SELP(RL) INT 95°
EP..



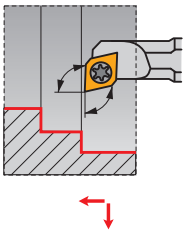
105

SELP(RL)-E INT 95°
EP..



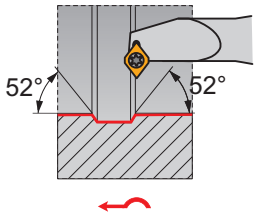
106

SEUP(RL) INT 93°
EP..



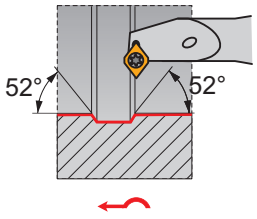
107

SEXP(RL) INT 52°30´
EP..



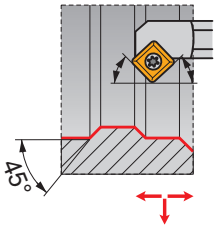
108

SEXP(RL)-E INT 52°30´
EP..



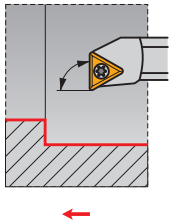
109

SSSC(RL) INT 45°
SC..



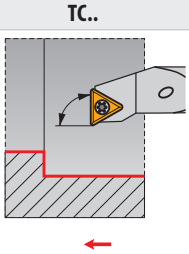
122

STFC(RL) INT 90°
TC..



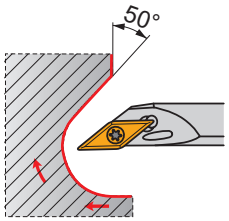
129

STFC(RL)-E INT 90°
TC..



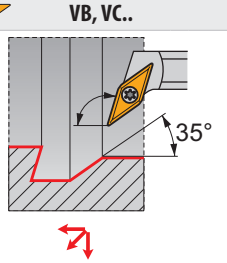
131

SVJB(RL) INT 93°
VB, VC..



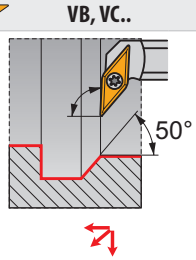
141

SVQB(C)(RL) INT 107°30´
VB, VC..



142

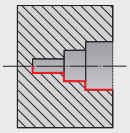
SVUB(C)(RL) INT 93°
VB, VC..



143

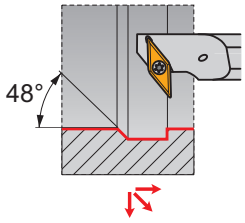
ISO TORNALAMA - İÇ

UZUN VE STABİL OLMAYAN PARÇALAR (Pozitif uçlar)



SVLC(RL) INT 95°

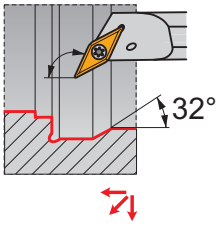
VC..



147

SVXC(RL) INT 113°

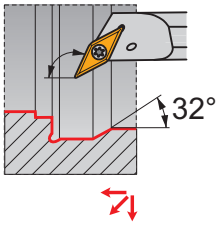
VC..



148

SVXC(RL)-E INT 113°

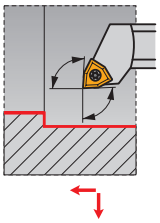
VC..



149

SWLC(RL) INT 95°

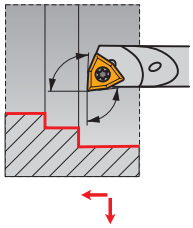
WC..



151

SWUC(RL) INT 93°

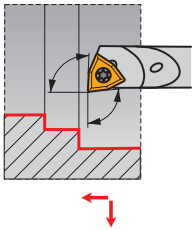
WC..



152

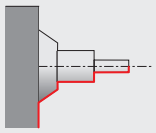
SWUC(RL)-E INT 93°

WC..

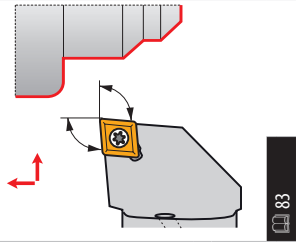


153

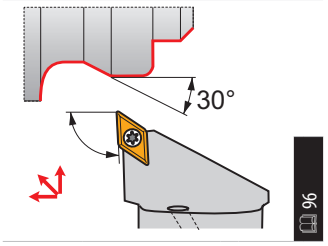
ISO TORNALAMA - DIŞ PSC
UZUN VE STABİL OLMAYAN PARÇALAR (Pozitif uçlar)



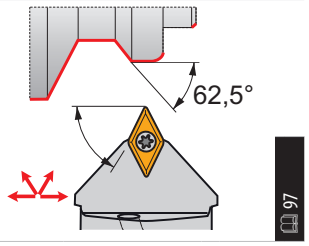
C.-SCLC(RL) EXT 95°
CC..



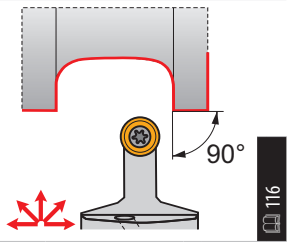
C.-SDJC(RL) EXT 93°
DC..



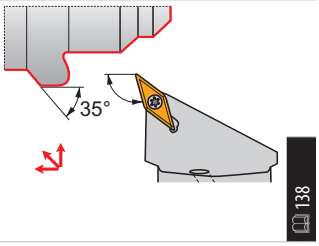
C.-SDNCN EXT 62°30´
DC..



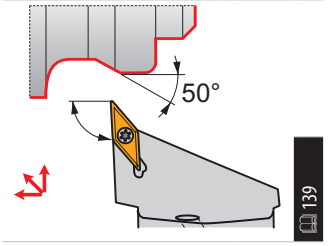
C.-SRDCN EXT
RC..



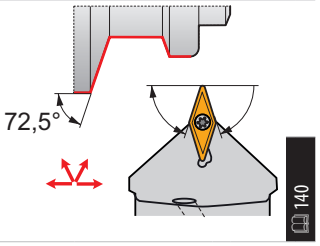
C.-SVHB(RL) EXT 107°30´
VB, VC..



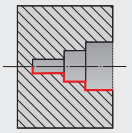
C.-SVJB(RL) EXT 93°
VB, VC..



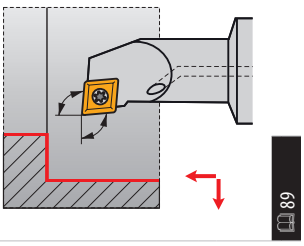
C.-SVVBN EXT 72°30´
VB, VC..



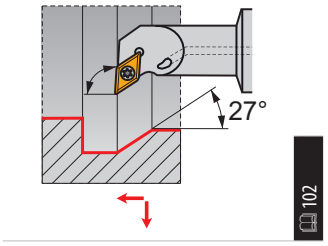
ISO TORNALAMA - İÇ PSC
UZUN VE STABİL OLMAYAN PARÇALAR (Pozitif uçlar)



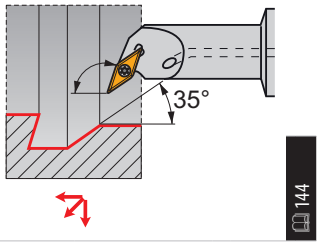
C.-SCLC(RL) INT 95°
CC..



C.-SDUC(RL) INT 93°
DC..



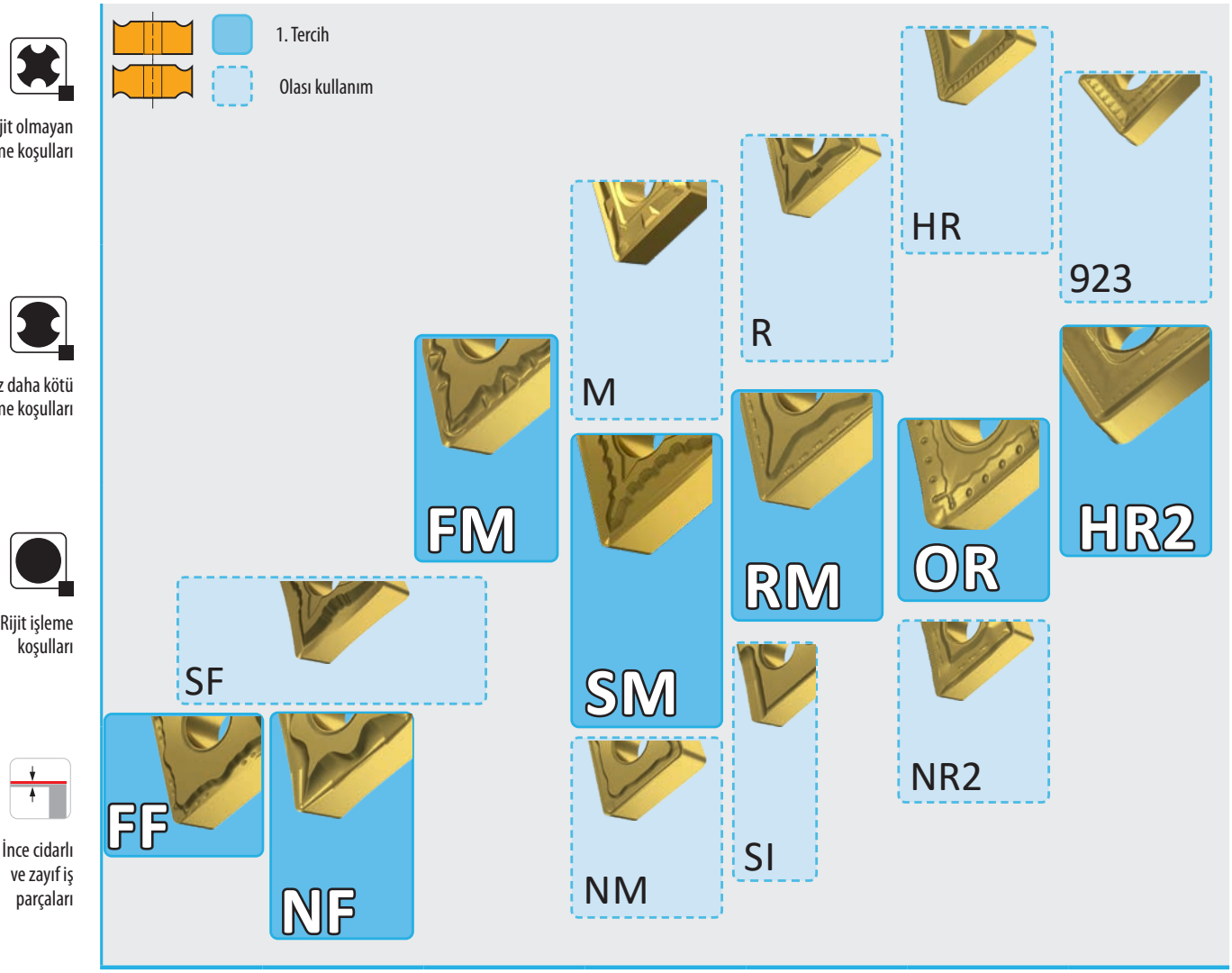
C.-SVQB(C)(RL) INT 108°
VB, VC..



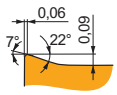
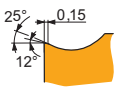
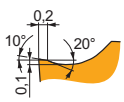
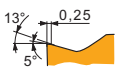
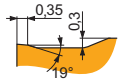
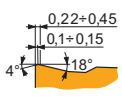


NEGATİF KESİCİ UÇLAR

P



	FF	F	M	R	HR
f	0.05 – 0.2 mm/dev	0.05 – 0.2 mm/dev	0.2 – 0.4 mm/dev	0.4 – 1.0 mm/dev	> 1.0 mm/dev
a_p	0.05 – 2 mm	0.05 – 2 mm	2 – 4 mm	4 – 10 mm	> 10 mm

FF		İnce ve finiş işleme, paslanmaz çelik ve çelik, potansiyel olarak dökme demirler ve sürekli kesim için tasarlanmış yüksek düzeyde pozitif geometri
NF		İnce finiş ve orta işleme, paslanmaz çelikler, çelik, potansiyel olarak dökme demir, demir içermeyen malzemeler ve süper alaşımlar, sürekli kesimler için yüksek düzeyde pozitif tasarım
FM		Finiş işlemeden yarı kaba işlemeye, çelik ve dökme demirler, potansiyel olarak süper alaşımlar, sürekli ve orta derecede darbeli kesimler için tasarlanmış pozitif geometri
SM		Orta işleme, paslanmaz çelikler, süper alaşımlar, çelikler ve dökme demirler, potansiyel olarak demir içermeyen ve sert malzemeler ve ince duvarları, sürekli ve darbeli kesimlerle işlemek için tasarlanmış pozitif geometri
RM		Yarı kaba ve kaba işleme, çelikler, paslanmaz çelikler ve dökme demirler, potansiyel olarak süper alaşımlar, sürekli ve darbeli kesimler için tasarlanmıştır
OR		Finiş işlemeden ağır kaba işlemeye, çelikler ve dökme demirler, potansiyel olarak paslanmaz çelik ve süper alaşımlar, sürekli ve darbeli kesimler için tasarlanmıştır

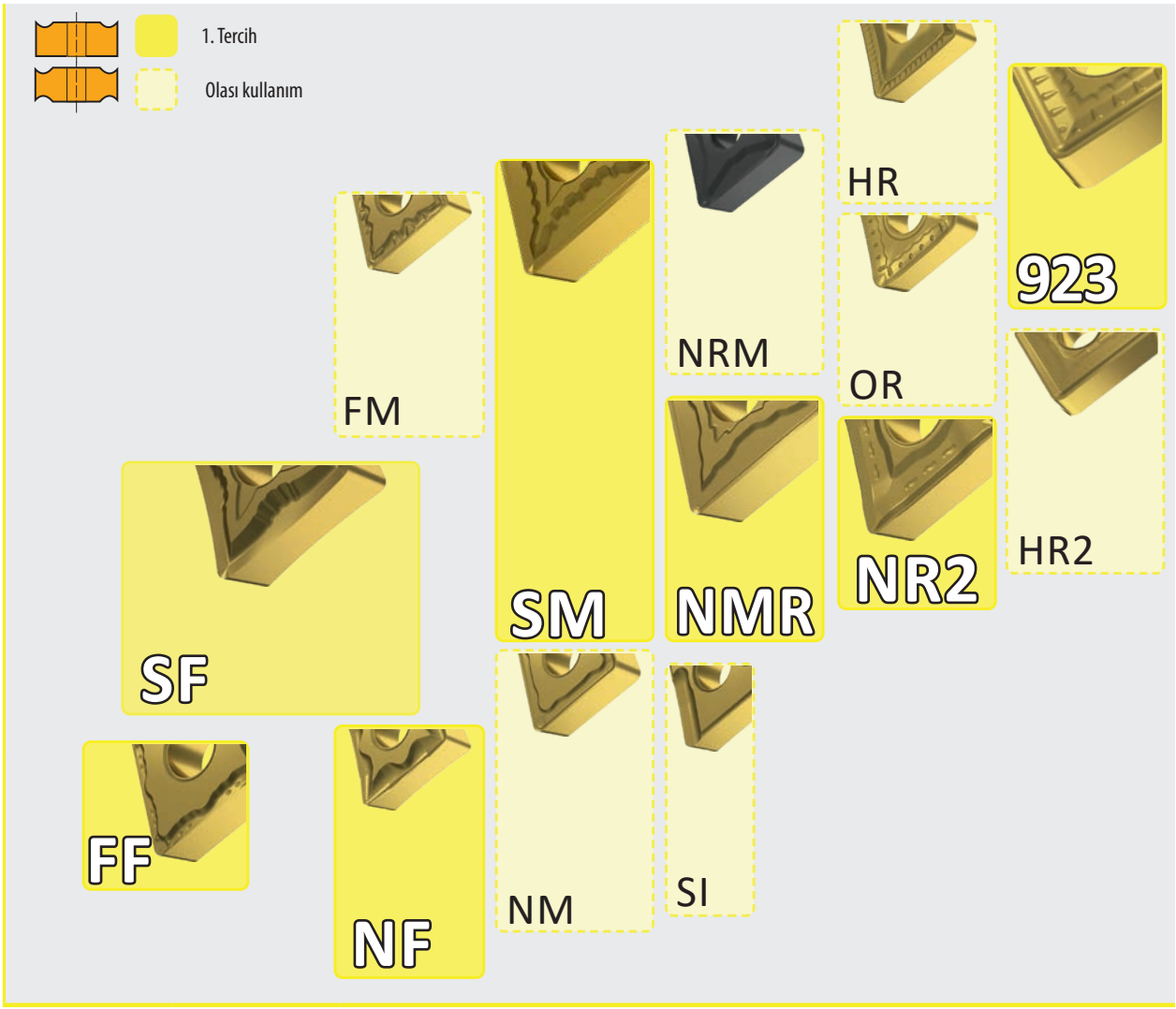
M

Rijit olmayan işleme koşulları

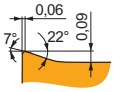
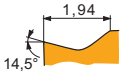
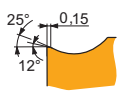
Biraz daha kötü işleme koşulları

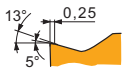
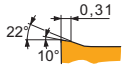
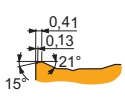
Rijit işleme koşulları

İnce cidarlı ve zayıf iş parçaları



	FF	F	M	R	HR
f	0.05 – 0.2 mm/dev	0.05 – 0.2 mm/dev	0.2 – 0.4 mm/dev	0.4 – 1.0 mm/dev	> 1.0 mm/dev
a_p	0.05 – 2 mm	0.05 – 2 mm	2 – 4 mm	4 – 10 mm	> 10 mm

FF		İnce ve finiş işleme, paslanmaz çelik ve çelik, potansiyel olarak dökme demirler ve sürekli kesim için tasarlanmış yüksek düzeyde pozitif geometri
SF		İnce finiş işleme, çelikler, paslanmaz çelikler, dökme demirler, süper alaşımlar ve sert malzemeler, potansiyel olarak demir içermeyen malzemeler ve ince duvarların sürekli kesimli işlenmesi için tasarlanmış çok yönlü pozitif geometri
NF		İnce finiş ve orta işleme, paslanmaz çelikler, çelik, potansiyel olarak dökme demir, demir içermeyen malzemeler ve süper alaşımlar, sürekli kesimler için yüksek düzeyde pozitif tasarım

SM		Orta işleme, paslanmaz çelikler, süper alaşımlar, çelikler ve dökme demirler, potansiyel olarak demir içermeyen ve sert malzemeler ve ince duvarları, sürekli ve darbeli kesimlerle işlemek için tasarlanmış pozitif geometri
NMR		Orta işlemeden kaba işlemeye, paslanmaz çeliklerin ve ayrıca yumuşak çelikler ve süper alaşımlarda sürekli kesimler için pozitif tasarım
NR2		Finiş işlemeden kaba işlemeye, paslanmaz çelikler ve çelikler, potansiyel olarak dökme demirler ve süper alaşımlar, sürekli ve darbeli kesimler için tasarlanmıştır

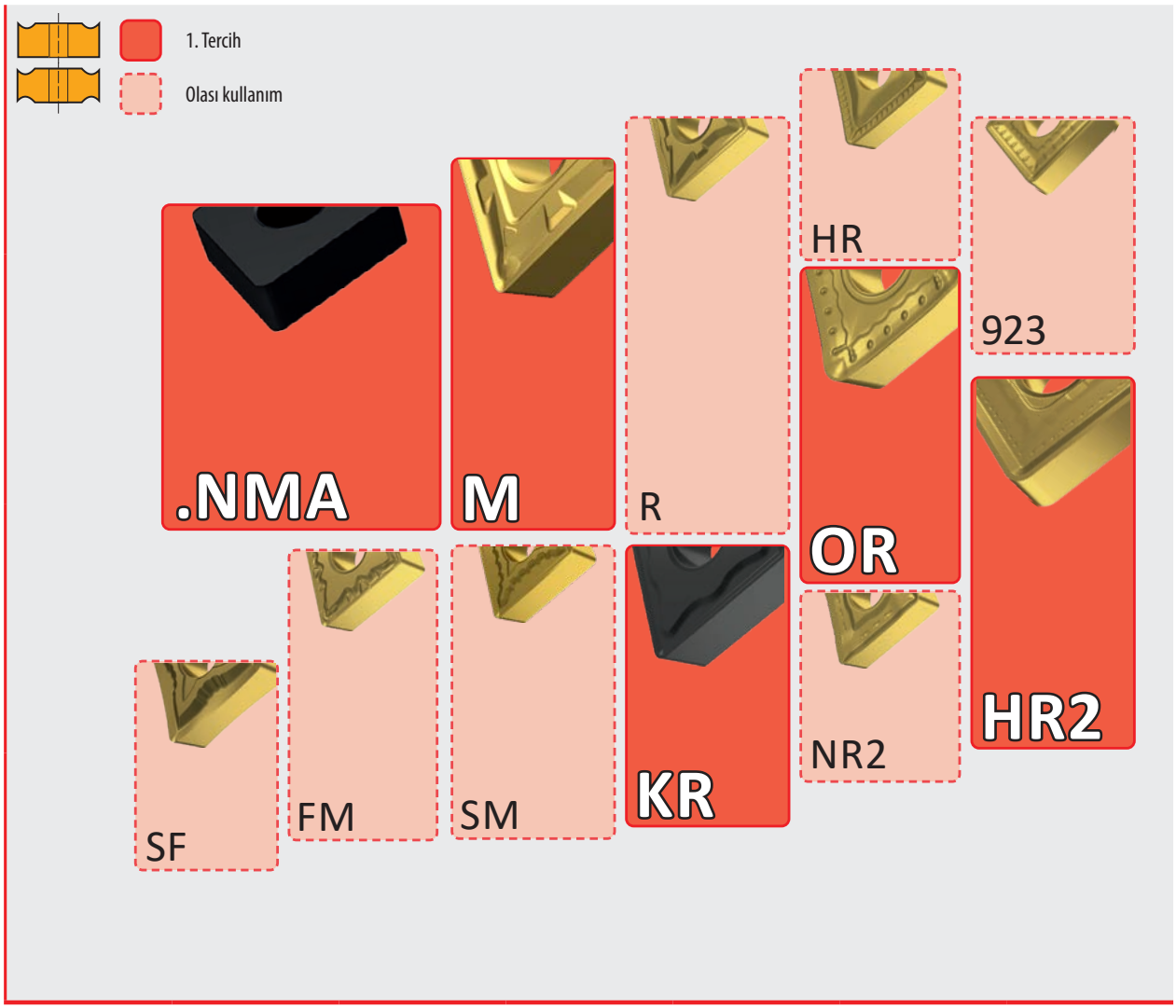
K

Rijit olmayan işleme koşulları

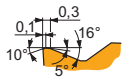
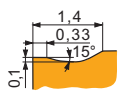
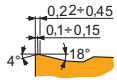
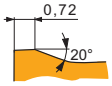
Biraz daha kötü işleme koşulları

Rijit işleme koşulları

İnce cidarlı ve zayıf iş parçaları



	FF	F	M	R	HR
f	0.05 – 0.2 mm/dev	0.05 – 0.2 mm/dev	0.2 – 0.4 mm/dev	0.4 – 1.0 mm/dev	> 1.0 mm/dev
a_p	0.05 – 2 mm	0.05 – 2 mm	2 – 4 mm	4 – 10 mm	> 10 mm

.NMA		İnce finiş işlemeden yarı kaba işlemeye, dökme demirler, potansiyel olarak sert malzemeler, sürekli ve hafif darbeli kesimler için tasarlanmıştır
M		Finiş ve yarı kaba işleme, dökme demirler, potansiyel olarak çelikler ve sert malzemeler, sürekli ve darbeli kesimler için tasarlanmıştır
KR		Yarı kaba ve kaba işleme, dökme demirler, potansiyel olarak çelik ve sert malzemeler, sürekli ve darbeli kesimler için tasarlanmıştır
OR		Finiş işlemeden ağır kaba işlemeye, çelikler ve dökme demirler, potansiyel olarak paslanmaz çelik ve süper alaşımlar, sürekli ve darbeli kesimler için tasarlanmıştır
HR2		Yüksek ilerlemeli olarak kaba ve ağır kaba işleme, çelikler ve dökme demirler, potansiyel olarak paslanmaz çelikler, sürekli ve darbeli kesimler için tasarlanmıştır

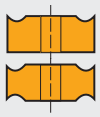
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Rijit olmayan işleme koşulları

Biraz daha kötü işleme koşulları

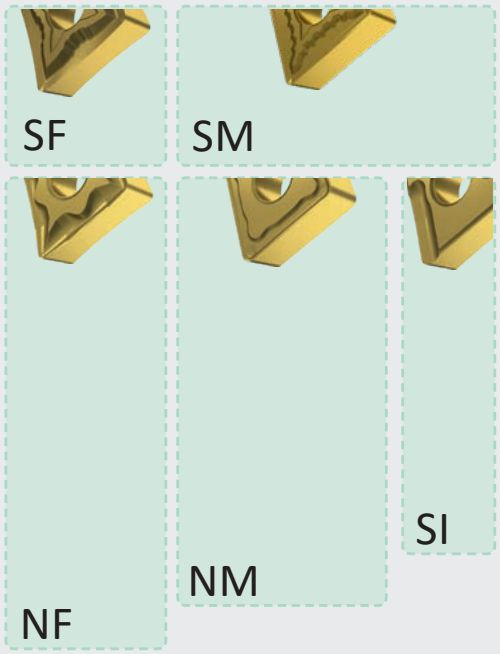
Rijit işleme koşulları

İnce cidarlı ve zayıf iş parçaları

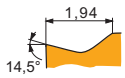
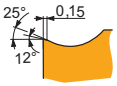
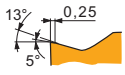


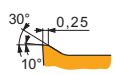
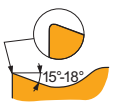
1. Tercih

Olası kullanım



	FF	F	M	R	HR
f	0.05 – 0.2 mm/dev	0.05 – 0.2 mm/dev	0.2 – 0.4 mm/dev	0.4 – 1.0 mm/dev	> 1.0 mm/dev
a_p	0.05 – 2 mm	0.05 – 2 mm	2 – 4 mm	4 – 10 mm	> 10 mm

SF		İnce finiş işleme, çelikler, paslanmaz çelikler, dökme demirler, süper alaşımlar ve sert malzemeler, potansiyel olarak demir içermeyen malzemeler ve ince duvarların sürekli kesimli işlenmesi için tasarlanmış çok yönlü pozitif geometri
NF		İnce finiş ve orta işleme, paslanmaz çelikler, çelik, potansiyel olarak dökme demir, demir içermeyen malzemeler ve süper alaşımlar, sürekli kesimler için yüksek düzeyde pozitif tasarım
SM		Orta işleme, paslanmaz çelikler, süper alaşımlar, çelikler ve dökme demirler, potansiyel olarak demir içermeyen ve sert malzemeler ve ince duvarları, sürekli ve darbeli kesimlerle işlemek için tasarlanmış pozitif geometri

NM		İnce finiş, orta ve kaba işleme, paslanmaz çelikler, çelikler, potansiyel olarak demir içermeyen malzemeler ve süper alaşımlar, sürekli kesimler için yüksek düzeyde pozitif tasarım
SI		İnce finiş işlemeden yarı kaba işlemeye, çelikler, paslanmaz çelikler ve dökme demirler ve potansiyel olarak demir içermeyen malzemeler, sürekli kesimler için pozitif geometri

S

Rijit olmayan işleme koşulları

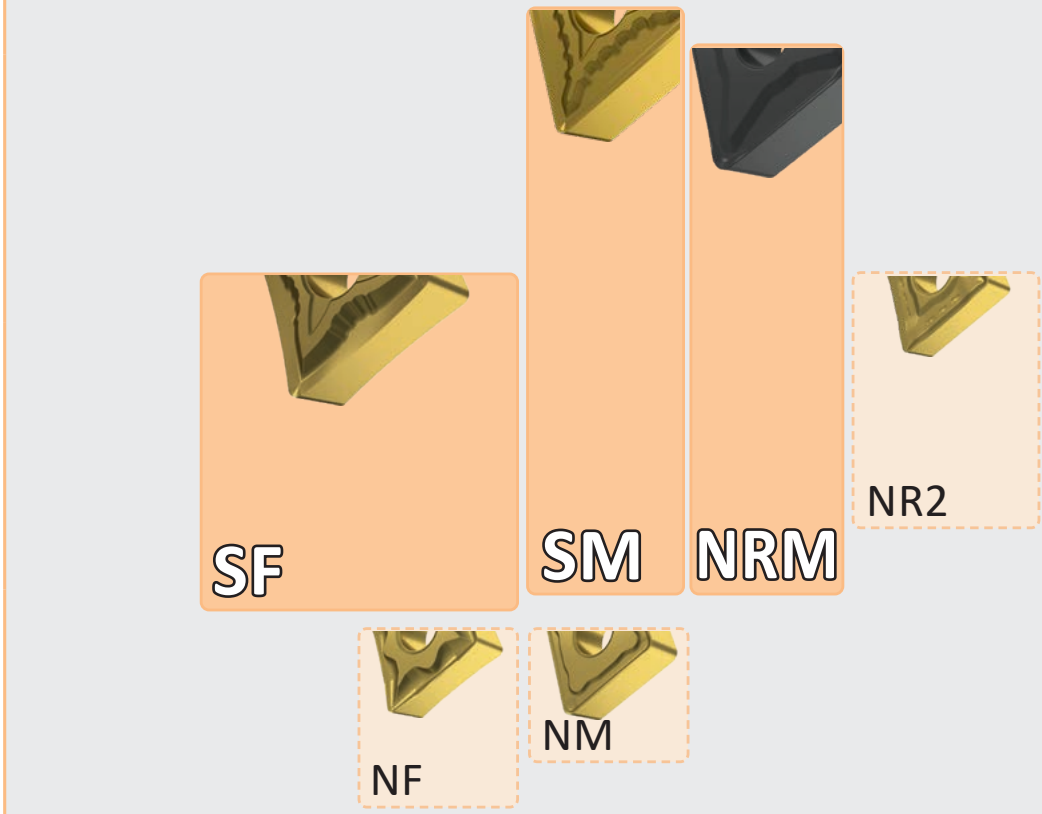
Biraz daha kötü işleme koşulları

Rijit işleme koşulları

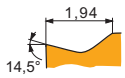
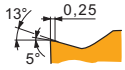
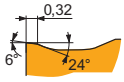
İnce cidarlı ve zayıf iş parçaları

1. Tercih

Olası kullanım



	FF	F	M	R	HR
f ⇨	0.05 – 0.2 mm/dev	0.05 – 0.2 mm/dev	0.2 – 0.4 mm/dev	0.4 – 1.0 mm/dev	> 1.0 mm/dev
a_p	0.05 – 2 mm	0.05 – 2 mm	2 – 4 mm	4 – 10 mm	> 10 mm

SF		İnce finiş işleme, çelikler, paslanmaz çelikler, dökme demirler, süper alaşımlar ve sert malzemeler, potansiyel olarak demir içermeyen malzemeler ve ince duvarların sürekli kesimli işlenmesi için tasarlanmış çok yönlü pozitif geometri
SM		Orta işleme, paslanmaz çelikler, süper alaşımlar, çelikler ve dökme demirler, potansiyel olarak demir içermeyen ve sert malzemeler ve ince duvarları, sürekli ve darbeli kesimlerle işlemek için tasarlanmış pozitif geometri
NRM		Yarı kaba ve kaba işleme, paslanmaz çelik, yumuşak çelikler ve süper alaşımlar, sürekli kesimler için pozitif tasarım

H

1. Tercih

Olası kullanım

Rijit olmayan işleme koşulları

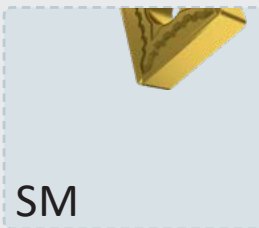
Biraz daha kötü işleme koşulları

Rijit işleme koşulları

İnce cidarlı ve zayıf iş parçaları

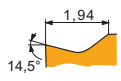
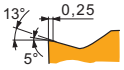

.NMA

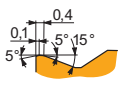

R


SM


SF

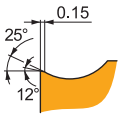
	FF	F	M	R	HR
f	0.05 – 0.2 mm/dev	0.05 – 0.2 mm/dev	0.2 – 0.4 mm/dev	0.4 – 1.0 mm/dev	> 1.0 mm/dev
a_p	0.05 – 2 mm	0.05 – 2 mm	2 – 4 mm	4 – 10 mm	> 10 mm

SF		İnce finiş işleme, çelikler, paslanmaz çelikler, dökme demirler, süper alaşımlar ve sert malzemeler, potansiyel olarak demir içermeyen malzemeler ve ince duvarların sürekli kesimli işlenmesi için tasarlanmış çok yönlü pozitif geometri
SM		Orta işleme, paslanmaz çelikler, süper alaşımlar, çelikler ve dökme demirler, potansiyel olarak demir içermeyen ve sert malzemeler ve ince duvarları, sürekli ve darbeli kesimlerle işlemek için tasarlanmış pozitif geometri
.NMA		İnce finiş işlemeden yarı kaba işlemeye, dökme demirler, potansiyel olarak sert malzemeler, sürekli ve hafif darbeli kesimler için tasarlanmıştır

R		Yarı kaba ve kaba işleme, dökme demirler, potansiyel olarak çelik ve sert malzemeler, sürekli ve darbeli kesimler için tasarlanmıştır

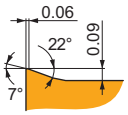
İNCE FİNİŞ - REHBER

NF



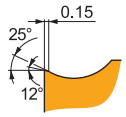
NF talaş kırıcı keskindir ve Çeliklerin, Paslanmaz çeliklerin ince finisajı için ilk tercihtir. Son derece pozitif eğim açısı ve son derece pozitif, dar T-land özelliğine sahiptir. Ayrıca Dökme demirler ve Demir dışı alaşımlar ve Süper alaşımlar için de şartlı olarak uygundur.

FF



FF talaş kırıcı keskindir ve çeliklerin, paslanmaz çeliklerin ince finisajı için tasarlanmıştır. Pozitif eğim açısı ve pozitif, ince T-land özelliğine sahiptir. Dökme demirler için de şartlara bağlı olarak uygundur.

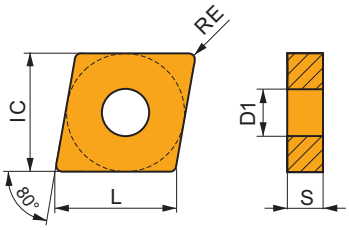
NF



NF talaş kırıcı keskindir ve Çeliklerin, Paslanmaz çeliklerin ince finisajı için ilk tercihtir. Son derece pozitif eğim açısı ve son derece pozitif, dar T-land özelliğine sahiptir. Ayrıca Dökme demirler ve Demir dışı alaşımlar ve Süper alaşımlar için de şartlı olarak uygundur.

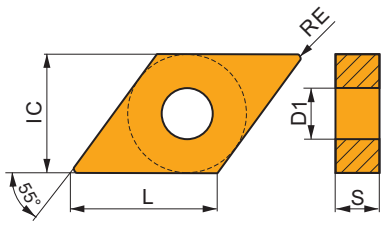
CNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0903	9.525	3.81	9.70	3.18
1204	12.700	5.16	12.90	4.76



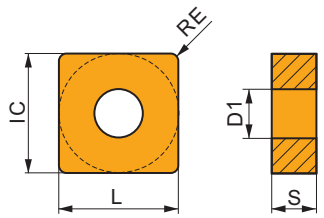
DNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1104	9.525	3.81	11.60	4.76
1504	12.700	5.16	15.50	4.76
1506	12.700	5.16	15.50	6.35



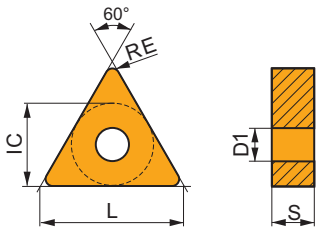
SNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76



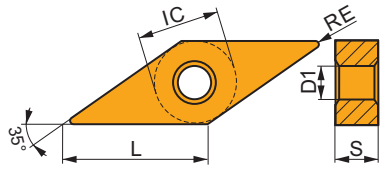
TNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76



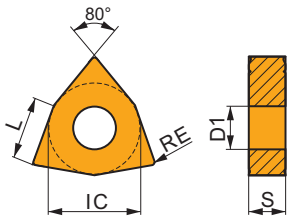
VNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.60	4.76

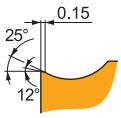
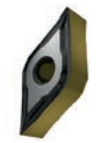
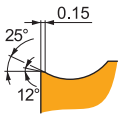


WNMG

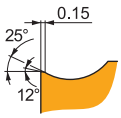
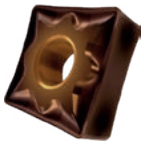
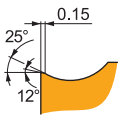
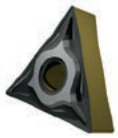
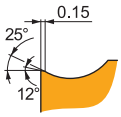
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0604	9.525	3.81	6.50	4.76
0804	12.700	5.16	8.70	4.76



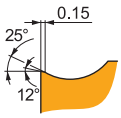
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
NF talaş kırıcı keskindir ve Çeliklerin, Paslanmaz çeliklerin ince finisajı için ilk tercihtir. Son derece pozitif eğim açısı ve son derece pozitif, dar T-land özelliğine sahiptir. Ayrıca Dökme demirler ve Demir dışı alaşımlar ve Süper alaşımlar için de şartlı olarak uygundur.																			
CNMG 090304E-NF:T6310	0.4	190	0.17	0.8	135	0.15	0.8	150	0.17	0.8	570	0.20	0.8	55	0.12	0.6	–	–	–
CNMG 090304E-NF:T7335	0.4	210	0.18	0.8	160	0.16	0.8	–	–	–	–	–	–	65	0.16	0.6	–	–	–
CNMG 090304E-NF:T8430	0.4	225	0.17	0.8	120	0.15	0.8	185	0.17	0.8	615	0.20	0.8	45	0.12	0.6	–	–	–
CNMG 090304E-NF:T9325	0.4	265	0.18	0.8	155	0.16	0.8	250	0.18	0.8	–	–	–	55	0.16	0.6	–	–	–
CNMG 090308E-NF:T8430	0.8	245	0.19	1.0	135	0.17	1.0	200	0.19	1.0	675	0.23	1.0	50	0.15	0.8	–	–	–
CNMG 090308E-NF:T9325	0.8	300	0.19	1.0	180	0.17	1.0	285	0.19	1.0	–	–	–	65	0.15	0.8	–	–	–
CNMG 120404E-NF:HF7	0.4	–	–	–	95	0.15	1.7	155	0.17	1.7	495	0.20	1.7	–	–	–	–	–	–
CNMG 120404E-NF:T6310	0.4	180	0.17	1.7	125	0.15	1.7	145	0.17	1.7	540	0.20	1.7	50	0.14	1.4	–	–	–
CNMG 120404E-NF:T7325	0.4	200	0.18	1.7	155	0.16	1.7	–	–	–	–	–	–	65	0.16	1.4	–	–	–
CNMG 120404E-NF:T7335	0.4	195	0.18	1.7	150	0.16	1.7	–	–	–	–	–	–	60	0.16	1.4	–	–	–
CNMG 120404E-NF:T8315	0.4	185	0.17	1.7	110	0.15	1.7	175	0.17	1.7	555	0.20	1.7	45	0.14	1.4	–	–	–
CNMG 120404E-NF:T8430	0.4	200	0.17	1.7	110	0.15	1.7	165	0.17	1.7	555	0.20	1.7	40	0.14	1.4	–	–	–
CNMG 120404E-NF:T9325	0.4	250	0.18	1.7	150	0.16	1.7	235	0.18	1.7	–	–	–	55	0.16	1.4	–	–	–
CNMG 120404E-NF:T9415	0.4	315	0.17	1.7	–	–	–	295	0.17	1.7	–	–	–	–	–	–	–	–	–
CNMG 120408E-NF:HF7	0.8	–	–	–	110	0.17	1.7	180	0.19	1.7	570	0.23	1.7	–	–	–	–	–	–
CNMG 120408E-NF:T6310	0.8	200	0.19	1.7	140	0.17	1.7	160	0.19	1.7	600	0.23	1.7	60	0.15	1.4	–	–	–
CNMG 120408E-NF:T7325	0.8	235	0.19	1.7	180	0.17	1.7	–	–	–	–	–	–	75	0.15	1.4	–	–	–
CNMG 120408E-NF:T7335	0.8	225	0.19	1.7	175	0.17	1.7	–	–	–	–	–	–	70	0.15	1.4	–	–	–
CNMG 120408E-NF:T8315	0.8	215	0.19	1.7	125	0.17	1.7	200	0.19	1.7	645	0.23	1.7	50	0.15	1.4	–	–	–
CNMG 120408E-NF:T8430	0.8	235	0.19	1.7	125	0.17	1.7	190	0.19	1.7	645	0.23	1.7	50	0.15	1.4	–	–	–
CNMG 120408E-NF:T9325	0.8	285	0.19	1.7	170	0.17	1.7	270	0.19	1.7	–	–	–	60	0.15	1.4	–	–	–
CNMG 120408E-NF:T9415	0.8	360	0.19	1.7	–	–	–	340	0.19	1.7	–	–	–	–	–	–	–	–	–
CNMG 120412E-NF:T6310	1.2	185	0.30	2.1	130	0.27	2.1	145	0.30	2.1	555	0.36	2.1	55	0.21	1.7	–	–	–
CNMG 120412E-NF:T7325	1.2	205	0.30	2.1	155	0.27	2.1	–	–	–	–	–	–	65	0.21	1.7	–	–	–
CNMG 120412E-NF:T7335	1.2	200	0.30	2.1	155	0.27	2.1	–	–	–	–	–	–	65	0.21	1.7	–	–	–
CNMG 120412E-NF:T8430	1.2	200	0.30	2.1	110	0.27	2.1	165	0.30	2.1	555	0.36	2.1	40	0.21	1.7	–	–	–
CNMG 120412E-NF:T9415	1.2	315	0.30	2.1	–	–	–	295	0.30	2.1	–	–	–	–	–	–	–	–	–
 																			
NF talaş kırıcı keskindir ve Çeliklerin, Paslanmaz çeliklerin ince finisajı için ilk tercihtir. Son derece pozitif eğim açısı ve son derece pozitif, dar T-land özelliğine sahiptir. Ayrıca Dökme demirler ve Demir dışı alaşımlar ve Süper alaşımlar için de şartlı olarak uygundur.																			
DNMG 110404E-NF:T6310	0.4	155	0.15	0.8	110	0.14	0.8	125	0.15	0.8	465	0.18	0.8	45	0.12	0.6	–	–	–
DNMG 110404E-NF:T7325	0.4	170	0.18	0.8	130	0.16	0.8	–	–	–	–	–	–	55	0.16	0.6	–	–	–
DNMG 110404E-NF:T7335	0.4	165	0.18	0.8	125	0.16	0.8	–	–	–	–	–	–	50	0.16	0.6	–	–	–
DNMG 110404E-NF:T8430	0.4	190	0.15	0.8	105	0.14	0.8	155	0.15	0.8	525	0.18	0.8	40	0.12	0.6	–	–	–
DNMG 110404E-NF:T9325	0.4	210	0.18	0.8	125	0.16	0.8	195	0.18	0.8	–	–	–	45	0.16	0.6	–	–	–
DNMG 110408E-NF:T6310	0.8	175	0.17	1.0	125	0.15	1.0	140	0.17	1.0	525	0.20	1.0	50	0.14	0.8	–	–	–
DNMG 110408E-NF:T7325	0.8	200	0.18	1.0	155	0.16	1.0	–	–	–	–	–	–	65	0.16	0.8	–	–	–
DNMG 110408E-NF:T7335	0.8	195	0.18	1.0	150	0.16	1.0	–	–	–	–	–	–	60	0.16	0.8	–	–	–
DNMG 110408E-NF:T8430	0.8	205	0.17	1.0	110	0.15	1.0	170	0.17	1.0	570	0.20	1.0	45	0.14	0.8	–	–	–
DNMG 110408E-NF:T9325	0.8	250	0.18	1.0	150	0.16	1.0	235	0.18	1.0	–	–	–	55	0.16	0.8	–	–	–
DNMG 110408E-NF:T9415	0.8	315	0.17	1.0	–	–	–	295	0.17	1.0	–	–	–	–	–	–	–	–	–
DNMG 150404E-NF:T6310	0.4	140	0.17	1.7	100	0.15	1.7	110	0.17	1.7	420	0.20	1.7	40	0.15	1.4	–	–	–
DNMG 150404E-NF:T7325	0.4	160	0.18	1.7	120	0.16	1.7	–	–	–	–	–	–	50	0.16	1.4	–	–	–
DNMG 150404E-NF:T7335	0.4	155	0.18	1.7	120	0.16	1.7	–	–	–	–	–	–	50	0.16	1.4	–	–	–
DNMG 150404E-NF:T8430	0.4	165	0.17	1.7	90	0.15	1.7	135	0.17	1.7	450	0.20	1.7	35	0.15	1.4	–	–	–
DNMG 150404E-NF:T9325	0.4	200	0.18	1.7	120	0.16	1.7	190	0.18	1.7	–	–	–	45	0.16	1.4	–	–	–
DNMG 150404E-NF:T9415	0.4	260	0.15	1.7	–	–	–	245	0.15	1.7	–	–	–	–	–	–	–	–	–
DNMG 150408E-NF:T6310	0.8	165	0.18	1.7	115	0.16	1.7	130	0.18	1.7	495	0.22	1.7	45	0.16	1.4	–	–	–
DNMG 150408E-NF:T7325	0.8	190	0.18	1.7	145	0.16	1.7	–	–	–	–	–	–	60	0.16	1.4	–	–	–
DNMG 150408E-NF:T7335	0.8	185	0.18	1.7	140	0.16	1.7	–	–	–	–	–	–	60	0.16	1.4	–	–	–
DNMG 150408E-NF:T8430	0.8	190	0.18	1.7	105	0.16	1.7	155	0.18	1.7	525	0.22	1.7	40	0.16	1.4	–	–	–
DNMG 150408E-NF:T9325	0.8	235	0.18	1.7	140	0.16	1.7	220	0.18	1.7	–	–	–	50	0.16	1.4	–	–	–
DNMG 150408E-NF:T9415	0.8	300	0.17	1.7	–	–	–	285	0.17	1.7	–	–	–	–	–	–	–	–	–

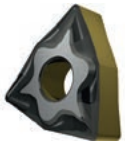
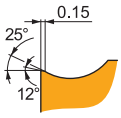
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
NF talaş kırıcı keskindir ve Çeliklerin, Paslanmaz çeliklerin ince finisajı için ilk tercihtir. Son derece pozitif eğim açısı ve son derece pozitif, dar T-land özelliğine sahiptir. Ayrıca Dökme demirler ve Demir dışı alaşımlar ve Süper alaşımlar için de şartlı olarak uygundur.																			
DNMG 150604E-NF:HF7	0.4	–	–	–	80	0.14	1.9	130	0.15	1.9	420	0.18	1.9	–	–	–	–	–	–
DNMG 150604E-NF:T6310	0.4	140	0.17	1.9	100	0.15	1.9	110	0.17	1.9	420	0.20	1.9	40	0.15	1.5	–	–	–
DNMG 150604E-NF:T7325	0.4	155	0.18	1.9	120	0.16	1.9	–	–	–	–	–	–	50	0.16	1.5	–	–	–
DNMG 150604E-NF:T7335	0.4	150	0.18	1.9	115	0.16	1.9	–	–	–	–	–	–	45	0.16	1.5	–	–	–
DNMG 150604E-NF:T8315	0.4	145	0.17	1.9	85	0.15	1.9	135	0.17	1.9	435	0.20	1.9	35	0.15	1.5	–	–	–
DNMG 150604E-NF:T8430	0.4	165	0.17	1.9	90	0.15	1.9	135	0.17	1.9	450	0.20	1.9	35	0.15	1.5	–	–	–
DNMG 150604E-NF:T9325	0.4	195	0.18	1.9	115	0.16	1.9	185	0.18	1.9	–	–	–	40	0.16	1.5	–	–	–
DNMG 150604E-NF:T9415	0.4	260	0.15	1.9	–	–	–	245	0.15	1.9	–	–	–	–	–	–	–	–	–
DNMG 150608E-NF:HF7	0.8	–	–	–	90	0.15	1.9	145	0.17	1.9	465	0.20	1.9	–	–	–	–	–	–
DNMG 150608E-NF:T6310	0.8	165	0.18	1.9	115	0.16	1.9	130	0.18	1.9	495	0.22	1.9	45	0.16	1.5	–	–	–
DNMG 150608E-NF:T7325	0.8	185	0.18	1.9	140	0.16	1.9	–	–	–	–	–	–	60	0.16	1.5	–	–	–
DNMG 150608E-NF:T7335	0.8	180	0.18	1.9	140	0.16	1.9	–	–	–	–	–	–	55	0.16	1.5	–	–	–
DNMG 150608E-NF:T8315	0.8	175	0.18	1.9	105	0.16	1.9	165	0.18	1.9	525	0.22	1.9	40	0.16	1.5	–	–	–
DNMG 150608E-NF:T8430	0.8	190	0.18	1.9	105	0.16	1.9	155	0.18	1.9	525	0.22	1.9	40	0.16	1.5	–	–	–
DNMG 150608E-NF:T9325	0.8	230	0.18	1.9	135	0.16	1.9	215	0.18	1.9	–	–	–	50	0.16	1.5	–	–	–
DNMG 150608E-NF:T9415	0.8	295	0.17	1.9	–	–	–	280	0.17	1.9	–	–	–	–	–	–	–	–	–
DNMG 150612E-NF:T6310	1.2	150	0.30	1.5	105	0.27	1.5	120	0.30	1.5	450	0.36	1.5	45	0.21	1.2	–	–	–
DNMG 150612E-NF:T8430	1.2	165	0.30	1.5	90	0.27	1.5	135	0.30	1.5	450	0.36	1.5	35	0.21	1.2	–	–	–
 																			
NF talaş kırıcı keskindir ve Çeliklerin, Paslanmaz çeliklerin ince finisajı için ilk tercihtir. Son derece pozitif eğim açısı ve son derece pozitif, dar T-land özelliğine sahiptir. Ayrıca Dökme demirler ve Demir dışı alaşımlar ve Süper alaşımlar için de şartlı olarak uygundur.																			
SNMG 120404E-NF:T6310	0.4	185	0.17	1.7	130	0.15	1.7	145	0.17	1.7	555	0.20	1.7	55	0.14	1.4	–	–	–
SNMG 120404E-NF:T7335	0.4	205	0.18	1.7	155	0.16	1.7	–	–	–	–	–	–	65	0.16	1.4	–	–	–
SNMG 120404E-NF:T8430	0.4	210	0.17	1.7	115	0.15	1.7	175	0.17	1.7	585	0.20	1.7	45	0.14	1.4	–	–	–
SNMG 120404E-NF:T9325	0.4	260	0.18	1.7	155	0.16	1.7	245	0.18	1.7	–	–	–	55	0.16	1.4	–	–	–
SNMG 120408E-NF:HF7	0.8	–	–	–	120	0.17	1.7	190	0.19	1.7	600	0.23	1.7	–	–	–	–	–	–
SNMG 120408E-NF:T6310	0.8	210	0.19	1.7	150	0.17	1.7	165	0.19	1.7	630	0.23	1.7	60	0.15	1.4	–	–	–
SNMG 120408E-NF:T7325	0.8	245	0.19	1.7	190	0.17	1.7	–	–	–	–	–	–	75	0.15	1.4	–	–	–
SNMG 120408E-NF:T7335	0.8	240	0.19	1.7	185	0.17	1.7	–	–	–	–	–	–	75	0.15	1.4	–	–	–
SNMG 120408E-NF:T8315	0.8	230	0.19	1.7	135	0.17	1.7	215	0.19	1.7	690	0.23	1.7	55	0.15	1.4	–	–	–
SNMG 120408E-NF:T8430	0.8	250	0.19	1.7	135	0.17	1.7	205	0.19	1.7	690	0.23	1.7	50	0.15	1.4	–	–	–
SNMG 120408E-NF:T9325	0.8	300	0.19	1.7	180	0.17	1.7	285	0.19	1.7	–	–	–	65	0.15	1.4	–	–	–
 																			
NF talaş kırıcı keskindir ve Çeliklerin, Paslanmaz çeliklerin ince finisajı için ilk tercihtir. Son derece pozitif eğim açısı ve son derece pozitif, dar T-land özelliğine sahiptir. Ayrıca Dökme demirler ve Demir dışı alaşımlar ve Süper alaşımlar için de şartlı olarak uygundur.																			
TNMG 160404E-NF:HF7	0.4	–	–	–	90	0.14	1.4	140	0.15	1.4	450	0.18	1.4	–	–	–	–	–	–
TNMG 160404E-NF:T6310	0.4	150	0.17	1.4	105	0.15	1.4	120	0.17	1.4	450	0.20	1.4	45	0.15	1.1	–	–	–
TNMG 160404E-NF:T7325	0.4	170	0.18	1.4	130	0.16	1.4	–	–	–	–	–	–	55	0.16	1.1	–	–	–
TNMG 160404E-NF:T7335	0.4	165	0.18	1.4	125	0.16	1.4	–	–	–	–	–	–	50	0.16	1.1	–	–	–
TNMG 160404E-NF:T8315	0.4	160	0.17	1.4	95	0.15	1.4	150	0.17	1.4	480	0.20	1.4	40	0.15	1.1	–	–	–
TNMG 160404E-NF:T8430	0.4	175	0.17	1.4	95	0.15	1.4	140	0.17	1.4	480	0.20	1.4	35	0.15	1.1	–	–	–
TNMG 160404E-NF:T9325	0.4	215	0.18	1.4	125	0.16	1.4	200	0.18	1.4	–	–	–	45	0.16	1.1	–	–	–
TNMG 160404E-NF:T9415	0.4	285	0.15	1.4	–	–	–	270	0.15	1.4	–	–	–	–	–	–	–	–	–
TNMG 160408E-NF:HF7	0.8	–	–	–	100	0.15	1.4	160	0.17	1.4	510	0.20	1.4	–	–	–	–	–	–
TNMG 160408E-NF:T6310	0.8	180	0.18	1.4	125	0.16	1.4	145	0.18	1.4	540	0.22	1.4	50	0.16	1.1	–	–	–
TNMG 160408E-NF:T7325	0.8	200	0.18	1.4	155	0.16	1.4	–	–	–	–	–	–	65	0.16	1.1	–	–	–
TNMG 160408E-NF:T7335	0.8	195	0.18	1.4	150	0.16	1.4	–	–	–	–	–	–	60	0.16	1.1	–	–	–
TNMG 160408E-NF:T8315	0.8	190	0.18	1.4	110	0.16	1.4	180	0.18	1.4	570	0.22	1.4	45	0.16	1.1	–	–	–
TNMG 160408E-NF:T8430	0.8	205	0.18	1.4	110	0.16	1.4	170	0.18	1.4	570	0.22	1.4	45	0.16	1.1	–	–	–
TNMG 160408E-NF:T9325	0.8	255	0.18	1.4	150	0.16	1.4	240	0.18	1.4	–	–	–	55	0.16	1.1	–	–	–

Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
																				

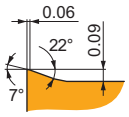
NF talaş kırıcı keskindir ve Çeliklerin, Paslanmaz çeliklerin ince finisajı için ilk tercihtir. Son derece pozitif eğim açısı ve son derece pozitif, dar T-land özelliğine sahiptir. Ayrıca Dökme demirler ve Demir dışı alaşımlar ve Süper alaşımlar için de şartlı olarak uygundur.

VNMG 160404E-NF:T6310	●	0.4	■	140	0.12	1.2	■	100	0.11	1.2	◪	110	0.12	1.2	◪	420	0.14	1.2	◪	40	0.11	1.0	–	–	–
VNMG 160404E-NF:T7325	●	0.4	◪	140	0.18	1.2	■	105	0.16	1.2		–	–	–		–	–	–	◪	45	0.16	1.0	–	–	–
VNMG 160404E-NF:T7335	●	0.4	◪	140	0.18	1.2	■	105	0.16	1.2		–	–	–		–	–	–	◪	45	0.16	1.0	–	–	–
VNMG 160404E-NF:T8315	●	0.4	◪	150	0.12	1.2	■	90	0.11	1.2	◪	140	0.12	1.2	◪	450	0.14	1.2	◪	35	0.11	1.0	–	–	–
VNMG 160404E-NF:T8430	●	0.4	■	175	0.12	1.2	■	95	0.11	1.2	◪	140	0.12	1.2	◪	480	0.14	1.2	◪	35	0.11	1.0	–	–	–
VNMG 160404E-NF:T9325	●	0.4	■	180	0.18	1.2	■	105	0.16	1.2	◪	170	0.18	1.2		–	–	–	◪	40	0.16	1.0	–	–	–
VNMG 160404E-NF:T9415	●	0.4	■	255	0.12	1.2		–	–	–	◪	240	0.12	1.2		–	–	–		–	–	–	–	–	–
VNMG 160408E-NF:T6310	●	0.8	■	145	0.17	1.4	■	100	0.15	1.4	◪	115	0.17	1.4	◪	435	0.20	1.4	◪	40	0.14	1.1	–	–	–
VNMG 160408E-NF:T7325	●	0.8	◪	165	0.18	1.4	■	125	0.16	1.4		–	–	–		–	–	–	◪	50	0.16	1.1	–	–	–
VNMG 160408E-NF:T7335	●	0.8	◪	160	0.18	1.4	■	120	0.16	1.4		–	–	–		–	–	–	◪	50	0.16	1.1	–	–	–
VNMG 160408E-NF:T8315	●	0.8	◪	160	0.17	1.4	■	95	0.15	1.4	◪	150	0.17	1.4	◪	480	0.20	1.4	◪	40	0.14	1.1	–	–	–
VNMG 160408E-NF:T8430	●	0.8	■	175	0.17	1.4	■	95	0.15	1.4	◪	140	0.17	1.4	◪	480	0.20	1.4	◪	35	0.14	1.1	–	–	–
VNMG 160408E-NF:T9325	●	0.8	■	210	0.18	1.4	■	125	0.16	1.4	◪	195	0.18	1.4		–	–	–	◪	45	0.16	1.1	–	–	–
VNMG 160408E-NF:T9415	●	0.8	■	270	0.17	1.4		–	–	–	◪	255	0.17	1.4		–	–	–		–	–	–	–	–	–
																				

NF talaş kırıcı keskindir ve Çeliklerin, Paslanmaz çeliklerin ince finisajı için ilk tercihtir. Son derece pozitif eğim açısı ve son derece pozitif, dar T-land özelliğine sahiptir. Ayrıca Dökme demirler ve Demir dışı alaşımlar ve Süper alaşımlar için de şartlı olarak uygundur.

WNMG 060404E-NF:T6310	●	0.4	■	190	0.17	0.8	■	135	0.15	0.8	◪	150	0.17	0.8	◪	570	0.20	0.8	◪	55	0.12	0.6	–	–	–
WNMG 060404E-NF:T7325	●	0.4	◪	215	0.18	0.8	■	165	0.16	0.8		–	–	–		–	–	–	◪	65	0.16	0.6	–	–	–
WNMG 060404E-NF:T7335	●	0.4	◪	210	0.18	0.8	■	160	0.16	0.8		–	–	–		–	–	–	◪	65	0.16	0.6	–	–	–
WNMG 060404E-NF:T8315	●	0.4	◪	200	0.17	0.8	■	120	0.15	0.8	◪	190	0.17	0.8	◪	600	0.20	0.8	◪	50	0.12	0.6	–	–	–
WNMG 060404E-NF:T8430	●	0.4	■	225	0.17	0.8	■	120	0.15	0.8	◪	185	0.17	0.8	◪	615	0.20	0.8	◪	45	0.12	0.6	–	–	–
WNMG 060404E-NF:T9325	●	0.4	■	265	0.18	0.8	■	155	0.16	0.8	◪	250	0.18	0.8		–	–	–	◪	55	0.16	0.6	–	–	–
WNMG 060404E-NF:T9415	●	0.4	■	340	0.17	0.8		–	–	–	◪	320	0.17	0.8		–	–	–		–	–	–	–	–	–
WNMG 060408E-NF:T6310	⬌	0.8	■	215	0.19	1.0	■	150	0.17	1.0	◪	170	0.19	1.0	◪	645	0.23	1.0	◪	60	0.15	0.8	–	–	–
WNMG 060408E-NF:T7325	⬌	0.8	◪	245	0.19	1.0	■	190	0.17	1.0		–	–	–		–	–	–	◪	75	0.15	0.8	–	–	–
WNMG 060408E-NF:T8430	⬌	0.8	■	245	0.19	1.0	■	135	0.17	1.0	◪	200	0.19	1.0	◪	675	0.23	1.0	◪	50	0.15	0.8	–	–	–
WNMG 060408E-NF:T9325	⬌	0.8	■	300	0.19	1.0	■	180	0.17	1.0	◪	285	0.19	1.0		–	–	–	◪	65	0.15	0.8	–	–	–
WNMG 060408E-NF:T9415	●	0.8	■	380	0.19	1.0		–	–	–	◪	360	0.19	1.0		–	–	–		–	–	–	–	–	–
WNMG 080404E-NF:HF7	●	0.4		–	–	–	◪	95	0.15	1.7	◪	155	0.17	1.7	◪	495	0.20	1.7		–	–	–	–	–	–
WNMG 080404E-NF:T6310	●	0.4	■	180	0.17	1.7	■	125	0.15	1.7	◪	145	0.17	1.7	◪	540	0.20	1.7	◪	50	0.14	1.4	–	–	–
WNMG 080404E-NF:T7325	●	0.4	◪	200	0.18	1.7	■	155	0.16	1.7		–	–	–		–	–	–	◪	65	0.16	1.4	–	–	–
WNMG 080404E-NF:T7335	●	0.4	◪	195	0.18	1.7	■	150	0.16	1.7		–	–	–		–	–	–	◪	60	0.16	1.4	–	–	–
WNMG 080404E-NF:T8315	●	0.4	◪	185	0.17	1.7	■	110	0.15	1.7	◪	175	0.17	1.7	◪	555	0.20	1.7	◪	45	0.14	1.4	–	–	–
WNMG 080404E-NF:T8430	●	0.4	■	200	0.17	1.7	■	110	0.15	1.7	◪	165	0.17	1.7	◪	555	0.20	1.7	◪	40	0.14	1.4	–	–	–
WNMG 080404E-NF:T9325	●	0.4	■	250	0.18	1.7	■	150	0.16	1.7	◪	235	0.18	1.7		–	–	–	◪	55	0.16	1.4	–	–	–
WNMG 080408E-NF:HF7	●	0.8		–	–	–	◪	110	0.17	1.7	◪	180	0.19	1.7	◪	570	0.23	1.7		–	–	–	–	–	–
WNMG 080408E-NF:T6310	⬌	0.8	■	200	0.19	1.7	■	140	0.17	1.7	◪	160	0.19	1.7	◪	600	0.23	1.7	◪	60	0.15	1.4	–	–	–
WNMG 080408E-NF:T7325	⬌	0.8	◪	235	0.19	1.7	■	180	0.17	1.7		–	–	–		–	–	–	◪	75	0.15	1.4	–	–	–
WNMG 080408E-NF:T7335	⬌	0.8	◪	225	0.19	1.7	■	175	0.17	1.7		–	–	–		–	–	–	◪	70	0.15	1.4	–	–	–
WNMG 080408E-NF:T8315	⬌	0.8	◪	215	0.19	1.7	■	125	0.17	1.7	◪	200	0.19	1.7	◪	645	0.23	1.7	◪	50	0.15	1.4	–	–	–
WNMG 080408E-NF:T8430	⬌	0.8	■	235	0.19	1.7	■	125	0.17	1.7	◪	190	0.19	1.7	◪	645	0.23	1.7	◪	50	0.15	1.4	–	–	–
WNMG 080408E-NF:T9325	⬌	0.8	■	285	0.19	1.7	■	170	0.17	1.7	◪	270	0.19	1.7		–	–	–	◪	60	0.15	1.4	–	–	–
WNMG 080408E-NF:T9415	●	0.8	■	360	0.19	1.7		–	–	–	◪	340	0.19	1.7		–	–	–		–	–	–	–	–	–
WNMG 080412E-NF:T6310	⬌	1.2	■	185	0.30	2.1	■	130	0.27	2.1	◪	145	0.30	2.1	◪	555	0.36	2.1	◪	55	0.21	1.7	–	–	–
WNMG 080412E-NF:T7325	⬌	1.2	◪	205	0.30	2.1	■	155	0.27	2.1		–	–	–		–	–	–	◪	65	0.21	1.7	–	–	–
WNMG 080412E-NF:T8430	⬌	1.2	■	200	0.30	2.1	■	110	0.27	2.1	◪	165	0.30	2.1	◪	555	0.36	2.1	◪	40	0.21	1.7	–	–	–
WNMG 080412E-NF:T9415	⬌	1.2	■	315	0.30	2.1		–	–	–	◪	295	0.30	2.1		–	–	–		–	–	–	–	–	–

FF

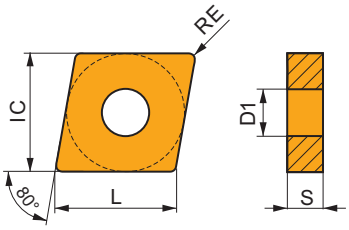


FF talaş kırıcı keskindir ve çeliklerin, paslanmaz çeliklerin ince finisajı için tasarlanmıştır. Pozitif eğim açısı ve pozitif, ince T-land özelliğine sahiptir. Dökme demirler için de şartlara bağlı olarak uygundur.

PRAMET

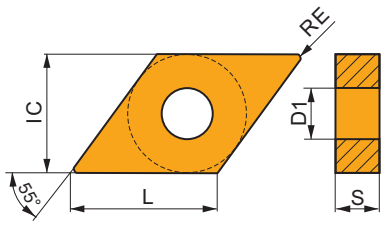
CNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.90	4.76



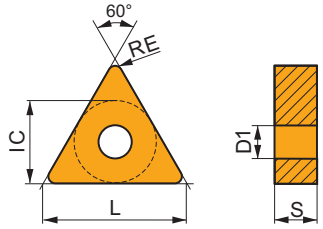
DNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1104	9.525	3.81	11.60	4.76
1504	12.700	5.16	15.50	4.76
1506	12.700	5.16	15.50	6.35



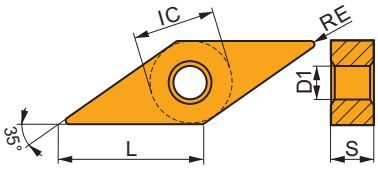
TNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76



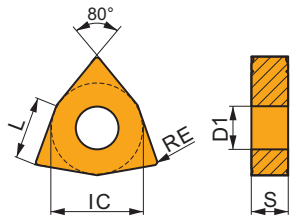
VNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.60	4.76

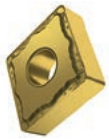
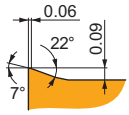
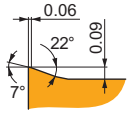
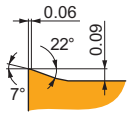
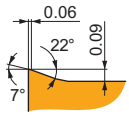
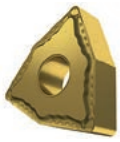
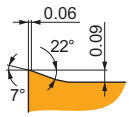


WNMG

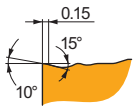
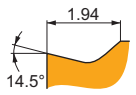
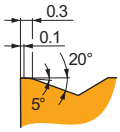
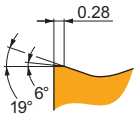
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0604	9.525	3.81	6.50	4.76
0804	12.700	5.16	8.70	4.76



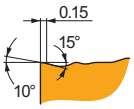
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
FF talaş kırıcı keskindir ve çeliklerin, paslanmaz çeliklerin ince finisajı için tasarlanmıştır. Pozitif eğim açısı ve pozitif, ince T-land özelliğine sahiptir. Dökme demirler için de şartlara bağlı olarak uygundur.																			
CNMG 120404E-FF:T7325	0.4	235	0.12	1.0	180	0.11	1.0	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 120404E-FF:T8315	0.4	220	0.12	1.0	130	0.11	1.0	205	0.12	1.0	–	–	–	–	–	–	–	–	–
CNMG 120404E-FF:T8415	0.4	260	0.12	1.0	135	0.11	1.0	240	0.12	1.0	–	–	–	–	–	–	–	–	–
CNMG 120408E-FF:T7325	0.8	265	0.15	1.0	205	0.14	1.0	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 120408E-FF:T8315	0.8	245	0.15	1.0	145	0.14	1.0	230	0.15	1.0	–	–	–	–	–	–	–	–	–
CNMG 120408E-FF:T8415	0.8	300	0.15	1.0	155	0.14	1.0	270	0.15	1.0	–	–	–	–	–	–	–	–	–
 																			
FF talaş kırıcı keskindir ve çeliklerin, paslanmaz çeliklerin ince finisajı için tasarlanmıştır. Pozitif eğim açısı ve pozitif, ince T-land özelliğine sahiptir. Dökme demirler için de şartlara bağlı olarak uygundur.																			
DNMG 110402E-FF:T8315	0.2	175	0.10	0.8	105	0.09	0.8	165	0.10	0.8	–	–	–	–	–	–	–	–	–
DNMG 110402E-FF:T8415	0.4	215	0.10	0.8	110	0.09	0.8	195	0.10	0.8	–	–	–	–	–	–	–	–	–
DNMG 110404E-FF:T8315	0.4	175	0.12	0.8	105	0.11	0.8	165	0.12	0.8	–	–	–	–	–	–	–	–	–
DNMG 110404E-FF:T8415	0.4	215	0.12	0.8	110	0.11	0.8	195	0.12	0.8	–	–	–	–	–	–	–	–	–
DNMG 110404E-FF:T8430	0.4	205	0.12	0.8	110	0.11	0.8	170	0.12	0.8	–	–	–	–	–	–	–	–	–
DNMG 110408E-FF:T8315	0.8	200	0.15	0.8	120	0.14	0.8	190	0.15	0.8	–	–	–	–	–	–	–	–	–
DNMG 110408E-FF:T8415	0.4	240	0.15	0.8	125	0.14	0.8	215	0.15	0.8	–	–	–	–	–	–	–	–	–
DNMG 150404E-FF:T8315	0.4	175	0.12	1.0	105	0.11	1.0	165	0.12	1.0	–	–	–	–	–	–	–	–	–
DNMG 150604E-FF:T8315	0.4	175	0.12	1.0	105	0.11	1.0	165	0.12	1.0	–	–	–	–	–	–	–	–	–
DNMG 150604E-FF:T8415	0.8	210	0.12	1.0	110	0.11	1.0	190	0.12	1.0	–	–	–	–	–	–	–	–	–
DNMG 150608E-FF:T7325	0.8	210	0.15	1.0	160	0.14	1.0	–	–	–	–	–	–	–	–	–	–	–	–
DNMG 150608E-FF:T8315	0.8	195	0.15	1.0	115	0.14	1.0	185	0.15	1.0	–	–	–	–	–	–	–	–	–
DNMG 150608E-FF:T8415	0.8	240	0.15	1.0	125	0.14	1.0	215	0.15	1.0	–	–	–	–	–	–	–	–	–
 																			
FF talaş kırıcı keskindir ve çeliklerin, paslanmaz çeliklerin ince finisajı için tasarlanmıştır. Pozitif eğim açısı ve pozitif, ince T-land özelliğine sahiptir. Dökme demirler için de şartlara bağlı olarak uygundur.																			
TNMG 160404E-FF:T7325	0.4	200	0.12	1.0	155	0.11	1.0	–	–	–	–	–	–	–	–	–	–	–	–
TNMG 160404E-FF:T8315	0.4	185	0.12	1.0	110	0.11	1.0	175	0.12	1.0	–	–	–	–	–	–	–	–	–
TNMG 160404E-FF:T8415	0.4	225	0.12	1.0	115	0.11	1.0	205	0.12	1.0	–	–	–	–	–	–	–	–	–
TNMG 160404E-FF:T8430	0.4	210	0.12	1.0	115	0.11	1.0	175	0.12	1.0	–	–	–	–	–	–	–	–	–
TNMG 160408E-FF:T8315	0.8	205	0.15	1.0	120	0.14	1.0	190	0.15	1.0	–	–	–	–	–	–	–	–	–
TNMG 160408E-FF:T8415	0.8	250	0.15	1.0	130	0.14	1.0	225	0.15	1.0	–	–	–	–	–	–	–	–	–
 																			
FF talaş kırıcı keskindir ve çeliklerin, paslanmaz çeliklerin ince finisajı için tasarlanmıştır. Pozitif eğim açısı ve pozitif, ince T-land özelliğine sahiptir. Dökme demirler için de şartlara bağlı olarak uygundur.																			
VNMG 160404E-FF:T7325	0.4	165	0.12	1.0	125	0.11	1.0	–	–	–	–	–	–	–	–	–	–	–	–
VNMG 160404E-FF:T8315	0.4	150	0.12	1.0	90	0.11	1.0	140	0.12	1.0	–	–	–	–	–	–	–	–	–
VNMG 160404E-FF:T8415	0.4	185	0.12	1.0	95	0.11	1.0	165	0.12	1.0	–	–	–	–	–	–	–	–	–
VNMG 160404E-FF:T8430	0.4	175	0.12	1.0	95	0.11	1.0	140	0.12	1.0	–	–	–	–	–	–	–	–	–
 																			
FF talaş kırıcı keskindir ve çeliklerin, paslanmaz çeliklerin ince finisajı için tasarlanmıştır. Pozitif eğim açısı ve pozitif, ince T-land özelliğine sahiptir. Dökme demirler için de şartlara bağlı olarak uygundur.																			
WNMG 060402E-FF:T8315	0.2	215	0.10	1.0	125	0.09	1.0	200	0.10	1.0	–	–	–	–	–	–	–	–	–
WNMG 060402E-FF:T8415	0.2	260	0.10	1.0	135	0.09	1.0	240	0.10	1.0	–	–	–	–	–	–	–	–	–
WNMG 060404E-FF:T8315	0.4	220	0.12	1.0	130	0.11	1.0	205	0.12	1.0	–	–	–	–	–	–	–	–	–
WNMG 060404E-FF:T8415	0.4	260	0.12	1.0	135	0.11	1.0	240	0.12	1.0	–	–	–	–	–	–	–	–	–
WNMG 080404E-FF:T7325	0.4	235	0.12	1.0	180	0.11	1.0	–	–	–	–	–	–	–	–	–	–	–	–
WNMG 080404E-FF:T8315	0.4	220	0.12	1.0	130	0.11	1.0	205	0.12	1.0	–	–	–	–	–	–	–	–	–
WNMG 080404E-FF:T8415	0.4	260	0.12	1.0	135	0.11	1.0	240	0.12	1.0	–	–	–	–	–	–	–	–	–
WNMG 080408E-FF:T7325	0.8	265	0.15	1.0	205	0.14	1.0	–	–	–	–	–	–	–	–	–	–	–	–
WNMG 080408E-FF:T8315	0.8	245	0.15	1.0	145	0.14	1.0	230	0.15	1.0	–	–	–	–	–	–	–	–	–
WNMG 080408E-FF:T8415	0.8	300	0.15	1.0	155	0.14	1.0	270	0.15	1.0	–	–	–	–	–	–	–	–	–

FİNİŞ - REHBER

FM			**FM** talaş kırıcı çok yönlüdür ve Çeliklerin ve Dökme demirlerin finiş işlemleri için ilk tercihtir. Hafif pozitif eğim açısı ve pozitif, dar T-land özelliğine sahiptir. Paslanmaz çelikler ve Süper alaşımlar için de şartlara bağlı olarak uygundur.
SF			**SF** talaş kırıcı keskin ve Paslanmaz çeliklerin ve Süper alaşımların finisajı için ilk tercihtir. T-land olmadan hafif pozitif eğim açısına sahiptir. Ayrıca Çelikler, Dökme demirler ve Sert malzemeler için ve şartlara bağlı olarak Demir dışı alaşımlar için de uygundur.
W-M			**W-M** talaş kırıcı silici kenara sahiptir ve Çeliklerin finişi için tasarlanmıştır. Pozitif eğim açısı ve pozitif, ılımlı T-land özelliğine sahiptir. Dökme demirler için de şartlı olarak uygundur.
W-MR			**W-MR** talaş kırıcı silici kenara sahiptir ve Çeliklerin finisajı için tasarlanmıştır. Pozitif eğim açısı ve dengeli, geniş T-land özelliğine sahiptir. Paslanmaz çelikler ve Dökme demirler için de şartlı olarak uygundur.

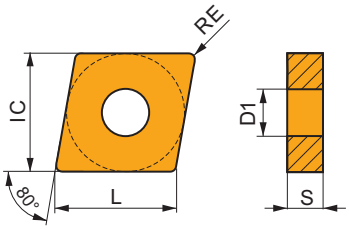
FM



FM talaş kırıcı çok yönlüdür ve Çeliklerin ve Dökme demirlerin finiş işlemleri için ilk tercihtir. Hafif pozitif eğim açısı ve pozitif, dar T-land özelliğine sahiptir. Paslanmaz çelikler ve Süper alaşımlar için de şartlara bağlı olarak uygundur.

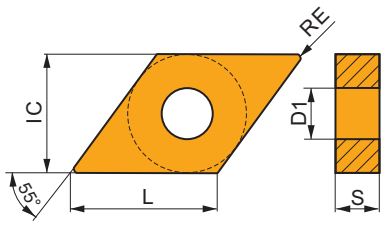
CNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0903	9.525	3.81	9.70	3.18
1204	12.700	5.16	12.90	4.76



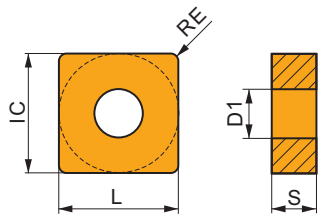
DNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1104	9.525	3.81	11.60	4.76
1504	12.700	5.16	15.50	4.76
1506	12.700	5.16	15.50	6.35



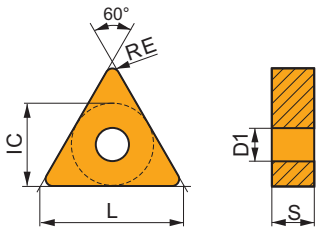
SNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76



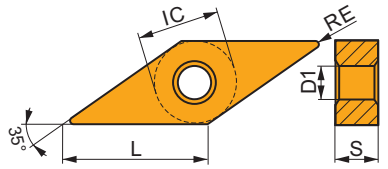
TNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76
2204	12.700	5.16	22.00	4.76



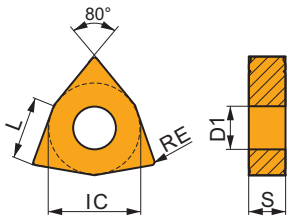
VNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.60	4.76

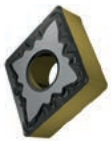
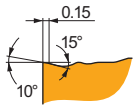
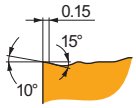


WNMG

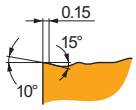
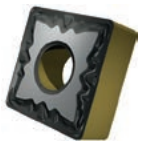
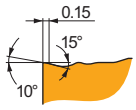
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0604	9.525	3.81	6.50	4.76
06T3	9.525	3.81	6.50	3.97
0804	12.700	5.16	8.70	4.76



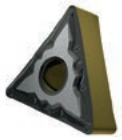
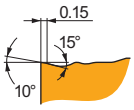
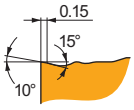
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
FM talaş kırıcı çok yönlüdür ve Çeliklerin ve Dökme demirlerin finiş işlemleri için ilk tercihtir. Hafif pozitif eğim açısı ve pozitif, dar T-land özelliğine sahiptir. Paslanmaz çelikler ve Süper alaşımlar için de şartlara bağlı olarak uygundur.																			
CNMG 090304E-FM:T8430	0.4	195	0.20	1.4	105	0.18	1.4	160	0.20	1.4	–	–	–	40	0.14	1.1	–	–	–
CNMG 090304E-FM:T9325	0.4	240	0.20	1.4	140	0.18	1.4	225	0.20	1.4	–	–	–	50	0.16	1.1	–	–	–
CNMG 090304E-FM:T9415	0.4	305	0.20	1.4	–	–	–	285	0.20	1.4	–	–	–	–	–	–	–	–	–
CNMG 090308E-FM:T8430	0.8	235	0.20	1.4	125	0.18	1.4	190	0.20	1.4	–	–	–	50	0.14	1.1	–	–	–
CNMG 090308E-FM:T9325	0.8	285	0.20	1.4	170	0.18	1.4	270	0.20	1.4	–	–	–	60	0.16	1.1	–	–	–
CNMG 090308E-FM:T9415	0.8	365	0.20	1.4	–	–	–	345	0.20	1.4	–	–	–	–	–	–	–	–	–
CNMG 120404E-FM:T7325	0.4	185	0.20	2.1	140	0.18	2.1	–	–	–	–	–	–	60	0.16	1.7	–	–	–
CNMG 120404E-FM:T7335	0.4	180	0.20	2.1	140	0.18	2.1	–	–	–	–	–	–	55	0.16	1.7	–	–	–
CNMG 120404E-FM:T8315	0.4	175	0.20	2.1	105	0.18	2.1	165	0.20	2.1	–	–	–	40	0.14	1.7	–	–	–
CNMG 120404E-FM:T8415	0.4	215	0.20	2.1	110	0.18	2.1	195	0.20	2.1	–	–	–	45	0.14	1.7	–	–	–
CNMG 120404E-FM:T8430	0.4	190	0.20	2.1	105	0.18	2.1	155	0.20	2.1	–	–	–	40	0.14	1.7	–	–	–
CNMG 120404E-FM:T9325	0.4	230	0.20	2.1	135	0.18	2.1	215	0.20	2.1	–	–	–	50	0.16	1.7	–	–	–
CNMG 120404E-FM:T9415	0.4	290	0.20	2.1	–	–	–	275	0.20	2.1	–	–	–	–	–	–	–	–	–
CNMG 120404E-FM:TT310	0.4	260	0.20	2.1	155	0.18	2.1	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 120408E-FM:T7325	0.8	220	0.20	2.1	170	0.18	2.1	–	–	–	–	–	–	70	0.16	1.7	–	–	–
CNMG 120408E-FM:T7335	0.8	215	0.20	2.1	165	0.18	2.1	–	–	–	–	–	–	65	0.16	1.7	–	–	–
CNMG 120408E-FM:T8315	0.8	205	0.20	2.1	120	0.18	2.1	190	0.20	2.1	–	–	–	50	0.16	1.7	–	–	–
CNMG 120408E-FM:T8415	0.8	250	0.20	2.1	130	0.18	2.1	225	0.20	2.1	–	–	–	55	0.16	1.7	–	–	–
CNMG 120408E-FM:T8430	0.8	225	0.20	2.1	120	0.18	2.1	185	0.20	2.1	–	–	–	45	0.16	1.7	–	–	–
CNMG 120408E-FM:T9310	0.8	335	0.20	2.1	–	–	–	315	0.20	2.1	–	–	–	–	–	–	–	–	–
CNMG 120408E-FM:T9315	0.8	305	0.20	2.1	–	–	–	285	0.20	2.1	–	–	–	–	–	–	–	–	–
CNMG 120408E-FM:T9325	0.8	275	0.20	2.1	165	0.18	2.1	260	0.20	2.1	–	–	–	60	0.16	1.7	–	–	–
CNMG 120408E-FM:T9415	0.8	350	0.20	2.1	–	–	–	330	0.20	2.1	–	–	–	–	–	–	–	–	–
CNMG 120408E-FM:TT310	0.8	310	0.20	2.1	185	0.18	2.1	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 120412E-FM:T7325	1.2	210	0.27	2.1	160	0.24	2.1	–	–	–	–	–	–	65	0.19	1.7	–	–	–
CNMG 120412E-FM:T9325	1.2	255	0.27	2.1	150	0.24	2.1	240	0.27	2.1	–	–	–	55	0.19	1.7	–	–	–
CNMG 120412E-FM:T9415	1.2	330	0.27	2.1	–	–	–	310	0.27	2.1	–	–	–	–	–	–	–	–	–
 																			
FM talaş kırıcı çok yönlüdür ve Çeliklerin ve Dökme demirlerin finiş işlemleri için ilk tercihtir. Hafif pozitif eğim açısı ve pozitif, dar T-land özelliğine sahiptir. Paslanmaz çelikler ve Süper alaşımlar için de şartlara bağlı olarak uygundur.																			
DNMG 110404E-FM:T8315	0.4	150	0.20	0.8	90	0.18	0.8	140	0.20	0.8	–	–	–	35	0.14	0.6	–	–	–
DNMG 110404E-FM:T8415	0.4	185	0.20	0.8	95	0.18	0.8	165	0.20	0.8	–	–	–	40	0.14	0.6	–	–	–
DNMG 110404E-FM:T8430	0.4	165	0.20	0.8	90	0.18	0.8	135	0.20	0.8	–	–	–	35	0.14	0.6	–	–	–
DNMG 110404E-FM:T9325	0.4	200	0.20	0.8	120	0.18	0.8	190	0.20	0.8	–	–	–	45	0.20	0.6	–	–	–
DNMG 110404E-FM:T9415	0.4	260	0.20	0.8	–	–	–	245	0.20	0.8	–	–	–	–	–	–	–	–	–
DNMG 110408E-FM:T7325	0.8	200	0.20	0.8	155	0.18	0.8	–	–	–	–	–	–	65	0.16	0.6	–	–	–
DNMG 110408E-FM:T8315	0.8	180	0.20	0.8	105	0.18	0.8	170	0.20	0.8	–	–	–	45	0.14	0.6	–	–	–
DNMG 110408E-FM:T8415	0.8	220	0.20	0.8	115	0.18	0.8	200	0.20	0.8	–	–	–	50	0.14	0.6	–	–	–
DNMG 110408E-FM:T8430	0.8	195	0.20	0.8	105	0.18	0.8	160	0.20	0.8	–	–	–	40	0.14	0.6	–	–	–
DNMG 110408E-FM:T9310	0.8	295	0.20	0.8	–	–	–	280	0.20	0.8	–	–	–	–	–	–	–	–	–
DNMG 110408E-FM:T9325	0.8	240	0.20	0.8	140	0.18	0.8	225	0.20	0.8	–	–	–	50	0.16	0.6	–	–	–
DNMG 110408E-FM:T9415	0.8	305	0.20	0.8	–	–	–	285	0.20	0.8	–	–	–	–	–	–	–	–	–
DNMG 150404E-FM:T7325	0.4	150	0.20	1.7	115	0.18	1.7	–	–	–	–	–	–	45	0.20	1.4	–	–	–
DNMG 150404E-FM:T8430	0.4	150	0.20	1.7	80	0.18	1.7	125	0.20	1.7	–	–	–	30	0.14	1.4	–	–	–
DNMG 150404E-FM:T9325	0.4	190	0.20	1.7	110	0.18	1.7	180	0.20	1.7	–	–	–	40	0.20	1.4	–	–	–
DNMG 150404E-FM:T9415	0.4	235	0.20	1.7	–	–	–	220	0.20	1.7	–	–	–	–	–	–	–	–	–
DNMG 150408E-FM:T7325	0.8	180	0.20	1.7	140	0.18	1.7	–	–	–	–	–	–	55	0.16	1.4	–	–	–
DNMG 150408E-FM:T8430	0.8	185	0.20	1.7	100	0.18	1.7	150	0.20	1.7	–	–	–	40	0.16	1.4	–	–	–
DNMG 150408E-FM:T9325	0.8	225	0.20	1.7	135	0.18	1.7	210	0.20	1.7	–	–	–	50	0.16	1.4	–	–	–
DNMG 150408E-FM:T9415	0.8	280	0.20	1.7	–	–	–	265	0.20	1.7	–	–	–	–	–	–	–	–	–

Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

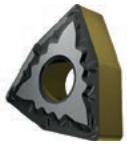
Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
FM talaş kırıcı çok yönlüdür ve Çeliklerin ve Dökme demirlerin finiş işlemleri için ilk tercihtir. Hafif pozitif eğim açısı ve pozitif, dar T-land özelliğine sahiptir. Paslanmaz çelikler ve Süper alaşımlar için de şartlara bağlı olarak uygundur.																			
DNMG 150604E-FM:T7325	0.4	150	0.20	1.7	115	0.18	1.7	–	–	–	–	–	–	45	0.20	1.4	–	–	–
DNMG 150604E-FM:T7335	0.4	150	0.20	1.7	115	0.18	1.7	–	–	–	–	–	–	45	0.20	1.4	–	–	–
DNMG 150604E-FM:T8315	0.4	140	0.20	1.7	80	0.18	1.7	130	0.20	1.7	–	–	–	35	0.14	1.4	–	–	–
DNMG 150604E-FM:T8415	0.4	170	0.20	1.7	90	0.18	1.7	155	0.20	1.7	–	–	–	35	0.14	1.4	–	–	–
DNMG 150604E-FM:T8430	0.4	150	0.20	1.7	80	0.18	1.7	125	0.20	1.7	–	–	–	30	0.14	1.4	–	–	–
DNMG 150604E-FM:T9310	0.4	230	0.20	1.7	–	–	–	215	0.20	1.7	–	–	–	–	–	–	–	–	–
DNMG 150604E-FM:T9315	0.4	210	0.20	1.7	–	–	–	195	0.20	1.7	–	–	–	–	–	–	–	–	–
DNMG 150604E-FM:T9325	0.4	190	0.20	1.7	110	0.18	1.7	180	0.20	1.7	–	–	–	40	0.20	1.4	–	–	–
DNMG 150604E-FM:T9415	0.4	235	0.20	1.7	–	–	–	220	0.20	1.7	–	–	–	–	–	–	–	–	–
DNMG 150608E-FM:T7325	0.8	180	0.20	1.7	140	0.18	1.7	–	–	–	–	–	–	55	0.16	1.4	–	–	–
DNMG 150608E-FM:T7335	0.8	175	0.20	1.7	135	0.18	1.7	–	–	–	–	–	–	55	0.16	1.4	–	–	–
DNMG 150608E-FM:T8315	0.8	170	0.20	1.7	100	0.18	1.7	160	0.20	1.7	–	–	–	40	0.16	1.4	–	–	–
DNMG 150608E-FM:T8415	0.8	210	0.20	1.7	110	0.18	1.7	190	0.20	1.7	–	–	–	45	0.16	1.4	–	–	–
DNMG 150608E-FM:T8430	0.8	185	0.20	1.7	100	0.18	1.7	150	0.20	1.7	–	–	–	40	0.16	1.4	–	–	–
DNMG 150608E-FM:T9310	0.8	275	0.20	1.7	–	–	–	260	0.20	1.7	–	–	–	–	–	–	–	–	–
DNMG 150608E-FM:T9315	0.8	250	0.20	1.7	–	–	–	235	0.20	1.7	–	–	–	–	–	–	–	–	–
DNMG 150608E-FM:T9325	0.8	225	0.20	1.7	135	0.18	1.7	210	0.20	1.7	–	–	–	50	0.16	1.4	–	–	–
DNMG 150608E-FM:T9415	0.8	280	0.20	1.7	–	–	–	265	0.20	1.7	–	–	–	–	–	–	–	–	–
DNMG 150612E-FM:T7325	1.2	180	0.25	1.7	140	0.23	1.7	–	–	–	–	–	–	55	0.18	1.4	–	–	–
DNMG 150612E-FM:T8430	1.2	175	0.25	1.7	95	0.23	1.7	140	0.25	1.7	–	–	–	35	0.18	1.4	–	–	–
DNMG 150612E-FM:T9315	1.2	240	0.25	1.7	–	–	–	225	0.25	1.7	–	–	–	–	–	–	–	–	–
DNMG 150612E-FM:T9325	1.2	215	0.25	1.7	125	0.23	1.7	200	0.25	1.7	–	–	–	45	0.18	1.4	–	–	–
DNMG 150612E-FM:T9415	1.2	275	0.25	1.7	–	–	–	260	0.25	1.7	–	–	–	–	–	–	–	–	–
DNMG 150616E-FM:T9315	1.6	235	0.30	1.7	–	–	–	220	0.30	1.7	–	–	–	–	–	–	–	–	–
DNMG 150616E-FM:T9325	1.6	210	0.30	1.7	125	0.27	1.7	195	0.30	1.7	–	–	–	45	0.21	1.4	–	–	–
DNMG 150616E-FM:T9415	1.6	270	0.30	1.7	–	–	–	255	0.30	1.7	–	–	–	–	–	–	–	–	–
 																			
FM talaş kırıcı çok yönlüdür ve Çeliklerin ve Dökme demirlerin finiş işlemleri için ilk tercihtir. Hafif pozitif eğim açısı ve pozitif, dar T-land özelliğine sahiptir. Paslanmaz çelikler ve Süper alaşımlar için de şartlara bağlı olarak uygundur.																			
SNMG 120404E-FM:T6310	0.4	175	0.20	2.1	125	0.18	2.1	140	0.20	2.1	–	–	–	50	0.14	1.7	–	–	–
SNMG 120404E-FM:T7325	0.4	195	0.20	2.1	150	0.18	2.1	–	–	–	–	–	–	60	0.16	1.7	–	–	–
SNMG 120404E-FM:T8315	0.4	180	0.20	2.1	105	0.18	2.1	170	0.20	2.1	–	–	–	45	0.14	1.7	–	–	–
SNMG 120404E-FM:T8415	0.4	220	0.20	2.1	115	0.18	2.1	200	0.20	2.1	–	–	–	50	0.14	1.7	–	–	–
SNMG 120404E-FM:T8430	0.4	195	0.20	2.1	105	0.18	2.1	160	0.20	2.1	–	–	–	40	0.14	1.7	–	–	–
SNMG 120404E-FM:T9325	0.4	240	0.20	2.1	140	0.18	2.1	225	0.20	2.1	–	–	–	50	0.16	1.7	–	–	–
SNMG 120404E-FM:T9415	0.4	305	0.20	2.1	–	–	–	285	0.20	2.1	–	–	–	–	–	–	–	–	–
SNMG 120408E-FM:T7325	0.8	235	0.20	2.1	180	0.18	2.1	–	–	–	–	–	–	75	0.16	1.7	–	–	–
SNMG 120408E-FM:T8315	0.8	215	0.20	2.1	125	0.18	2.1	200	0.20	2.1	–	–	–	50	0.16	1.7	–	–	–
SNMG 120408E-FM:T8415	0.8	260	0.20	2.1	135	0.18	2.1	240	0.20	2.1	–	–	–	60	0.16	1.7	–	–	–
SNMG 120408E-FM:T8430	0.8	235	0.20	2.1	125	0.18	2.1	190	0.20	2.1	–	–	–	50	0.16	1.7	–	–	–
SNMG 120408E-FM:T9325	0.8	290	0.20	2.1	170	0.18	2.1	275	0.20	2.1	–	–	–	65	0.16	1.7	–	–	–
SNMG 120408E-FM:T9415	0.8	365	0.20	2.1	–	–	–	345	0.20	2.1	–	–	–	–	–	–	–	–	–
SNMG 120412E-FM:T8430	1.2	220	0.27	2.1	120	0.24	2.1	180	0.27	2.1	–	–	–	45	0.19	1.7	–	–	–
SNMG 120412E-FM:T9325	1.2	270	0.27	2.1	160	0.24	2.1	255	0.27	2.1	–	–	–	60	0.19	1.7	–	–	–
SNMG 120412E-FM:T9415	1.2	345	0.27	2.1	–	–	–	325	0.27	2.1	–	–	–	–	–	–	–	–	–
SNMG 120416E-FM:T8430	1.6	220	0.32	2.1	120	0.29	2.1	180	0.32	2.1	–	–	–	45	0.22	1.7	–	–	–

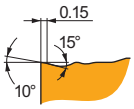
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE	P			M			K			N			S			H		
	(mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)
																			
FM talaş kırıcı çok yönlüdür ve Çeliklerin ve Dökme demirlerin finiş işlemleri için ilk tercihtir. Hafif pozitif eğim açısı ve pozitif, dar T-land özelliğine sahiptir. Paslanmaz çelikler ve Süper alaşımlar için de şartlara bağlı olarak uygundur.																			
TNMG 160404E-FM:T7325	0.4	160	0.20	1.7	120	0.18	1.7	–	–	–	–	–	–	50	0.20	1.4	–	–	–
TNMG 160404E-FM:T7335	0.4	160	0.20	1.7	120	0.18	1.7	–	–	–	–	–	–	50	0.20	1.4	–	–	–
TNMG 160404E-FM:T8315	0.4	150	0.20	1.7	90	0.18	1.7	140	0.20	1.7	–	–	–	35	0.14	1.4	–	–	–
TNMG 160404E-FM:T8415	0.4	185	0.20	1.7	95	0.18	1.7	165	0.20	1.7	–	–	–	40	0.14	1.4	–	–	–
TNMG 160404E-FM:T8430	0.4	165	0.20	1.7	90	0.18	1.7	135	0.20	1.7	–	–	–	35	0.14	1.4	–	–	–
TNMG 160404E-FM:T9325	0.4	200	0.20	1.7	120	0.18	1.7	190	0.20	1.7	–	–	–	45	0.20	1.4	–	–	–
TNMG 160404E-FM:T9415	0.4	250	0.20	1.7	–	–	–	235	0.20	1.7	–	–	–	–	–	–	–	–	–
TNMG 160404E-FM:TT310	0.4	225	0.20	1.7	135	0.18	1.7	–	–	–	–	–	–	–	–	–	–	–	–
TNMG 160408E-FM:T7325	0.8	195	0.20	1.7	150	0.18	1.7	–	–	–	–	–	–	60	0.16	1.4	–	–	–
TNMG 160408E-FM:T7335	0.8	190	0.20	1.7	145	0.18	1.7	–	–	–	–	–	–	60	0.16	1.4	–	–	–
TNMG 160408E-FM:T8315	0.8	180	0.20	1.7	105	0.18	1.7	170	0.20	1.7	–	–	–	45	0.16	1.4	–	–	–
TNMG 160408E-FM:T8415	0.8	220	0.20	1.7	115	0.18	1.7	200	0.20	1.7	–	–	–	50	0.16	1.4	–	–	–
TNMG 160408E-FM:T8430	0.8	195	0.20	1.7	105	0.18	1.7	160	0.20	1.7	–	–	–	40	0.16	1.4	–	–	–
TNMG 160408E-FM:T9310	0.8	290	0.20	1.7	–	–	–	275	0.20	1.7	–	–	–	–	–	–	–	–	–
TNMG 160408E-FM:T9325	0.8	235	0.20	1.7	140	0.18	1.7	220	0.20	1.7	–	–	–	50	0.16	1.4	–	–	–
TNMG 160408E-FM:T9415	0.8	300	0.20	1.7	–	–	–	285	0.20	1.7	–	–	–	–	–	–	–	–	–
TNMG 160408E-FM:TT310	0.8	270	0.20	1.7	160	0.18	1.7	–	–	–	–	–	–	–	–	–	–	–	–
TNMG 160412E-FM:T8430	1.2	185	0.25	1.7	100	0.23	1.7	150	0.25	1.7	–	–	–	40	0.18	1.4	–	–	–
TNMG 160412E-FM:T9325	1.2	225	0.25	1.7	135	0.23	1.7	210	0.25	1.7	–	–	–	50	0.18	1.4	–	–	–
TNMG 160412E-FM:T9415	1.2	290	0.25	1.7	–	–	–	275	0.25	1.7	–	–	–	–	–	–	–	–	–
TNMG 220404E-FM:T8430	0.4	165	0.20	1.7	90	0.18	1.7	135	0.20	1.7	–	–	–	35	0.18	1.4	–	–	–
TNMG 220404E-FM:T9325	0.4	200	0.20	1.7	120	0.18	1.7	190	0.20	1.7	–	–	–	45	0.18	1.4	–	–	–
TNMG 220404E-FM:T9415	0.4	250	0.20	1.7	–	–	–	235	0.20	1.7	–	–	–	–	–	–	–	–	–
TNMG 220408E-FM:T8430	0.8	195	0.20	1.7	105	0.18	1.7	160	0.20	1.7	–	–	–	40	0.16	1.4	–	–	–
TNMG 220408E-FM:T9325	0.8	235	0.20	1.7	140	0.18	1.7	220	0.20	1.7	–	–	–	50	0.16	1.4	–	–	–
TNMG 220408E-FM:T9415	0.8	300	0.20	1.7	–	–	–	285	0.20	1.7	–	–	–	–	–	–	–	–	–
																			
FM talaş kırıcı çok yönlüdür ve Çeliklerin ve Dökme demirlerin finiş işlemleri için ilk tercihtir. Hafif pozitif eğim açısı ve pozitif, dar T-land özelliğine sahiptir. Paslanmaz çelikler ve Süper alaşımlar için de şartlara bağlı olarak uygundur.																			
VNMG 160404E-FM:T7325	0.4	140	0.20	1.2	105	0.18	1.2	–	–	–	–	–	–	45	0.20	1.0	–	–	–
VNMG 160404E-FM:T8430	0.4	135	0.20	1.2	75	0.18	1.2	110	0.20	1.2	–	–	–	25	0.14	1.0	–	–	–
VNMG 160404E-FM:T9315	0.4	190	0.20	1.2	–	–	–	180	0.20	1.2	–	–	–	–	–	–	–	–	–
VNMG 160404E-FM:T9325	0.4	170	0.20	1.2	100	0.18	1.2	160	0.20	1.2	–	–	–	35	0.20	1.0	–	–	–
VNMG 160404E-FM:T9415	0.4	215	0.20	1.2	–	–	–	200	0.20	1.2	–	–	–	–	–	–	–	–	–
VNMG 160408E-FM:T7325	0.8	160	0.20	1.4	120	0.18	1.4	–	–	–	–	–	–	50	0.16	1.1	–	–	–
VNMG 160408E-FM:T8430	0.8	165	0.20	1.4	90	0.18	1.4	135	0.20	1.4	–	–	–	35	0.16	1.1	–	–	–
VNMG 160408E-FM:T9315	0.8	220	0.20	1.4	–	–	–	205	0.20	1.4	–	–	–	–	–	–	–	–	–
VNMG 160408E-FM:T9325	0.8	200	0.20	1.4	120	0.18	1.4	190	0.20	1.4	–	–	–	45	0.16	1.1	–	–	–
VNMG 160408E-FM:T9415	0.8	255	0.20	1.4	–	–	–	240	0.20	1.4	–	–	–	–	–	–	–	–	–
VNMG 160412E-FM:T8430	1.2	165	0.22	1.4	90	0.20	1.4	135	0.22	1.4	–	–	–	35	0.18	1.1	–	–	–
VNMG 160412E-FM:T9315	1.2	225	0.22	1.4	–	–	–	210	0.22	1.4	–	–	–	–	–	–	–	–	–
VNMG 160412E-FM:T9325	1.2	200	0.22	1.4	120	0.20	1.4	190	0.22	1.4	–	–	–	45	0.18	1.1	–	–	–
VNMG 160412E-FM:T9415	1.2	255	0.22	1.4	–	–	–	240	0.22	1.4	–	–	–	–	–	–	–	–	–

Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P			M			K			N			S			H		
			vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)
		(mm)																		

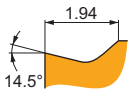




FM talaş kırıcı çok yönlüdür ve Çeliklerin ve Dökme demirlerin finiş işlemleri için ilk tercihtir. Hafif pozitif eğim açısı ve pozitif, dar T-land özelliğine sahiptir. Paslanmaz çelikler ve Süper alaşımlar için de şartlara bağlı olarak uygundur.

WNMG 060404E-FM:T7325	●	0.4	◪	195	0.20	1.4	◪	150	0.18	1.4		–	–	–	–	–	–	◪	60	0.16	1.1	–	–	–
WNMG 060404E-FM:T8315	●	0.4	◪	180	0.20	1.4	◪	105	0.18	1.4	■	170	0.20	1.4	–	–	–	◪	45	0.14	1.1	–	–	–
WNMG 060404E-FM:T8415	●	0.4	■	220	0.20	1.4	◪	115	0.18	1.4	■	200	0.20	1.4	–	–	–	◪	50	0.14	1.1	–	–	–
WNMG 060404E-FM:T8430	●	0.4	■	195	0.20	1.4	◪	105	0.18	1.4	◪	160	0.20	1.4	–	–	–	◪	40	0.14	1.1	–	–	–
WNMG 060404E-FM:T9325	●	0.4	■	240	0.20	1.4	◪	140	0.18	1.4	◪	225	0.20	1.4	–	–	–	◪	50	0.16	1.1	–	–	–
WNMG 060404E-FM:T9415	●	0.4	■	305	0.20	1.4		–	–	–	◪	285	0.20	1.4	–	–	–		–	–	–	–	–	–
WNMG 060404E-FM:TT310	●	0.4	■	275	0.20	1.4	◪	165	0.18	1.4		–	–	–	–	–	–		–	–	–	–	–	–
WNMG 060408E-FM:T7325	⧓	0.8	◪	235	0.20	1.4	◪	180	0.18	1.4		–	–	–	–	–	–	◪	75	0.16	1.1	–	–	–
WNMG 060408E-FM:T8430	⧓	0.8	■	235	0.20	1.4	◪	125	0.18	1.4	◪	190	0.20	1.4	–	–	–	◪	50	0.14	1.1	–	–	–
WNMG 060408E-FM:T9315	●	0.8	■	315	0.20	1.4		–	–	–	◪	295	0.20	1.4	–	–	–		–	–	–	–	–	–
WNMG 060408E-FM:T9325	●	0.8	■	285	0.20	1.4	◪	170	0.18	1.4	◪	270	0.20	1.4	–	–	–	◪	60	0.16	1.1	–	–	–
WNMG 060408E-FM:T9415	●	0.8	■	365	0.20	1.4		–	–	–	◪	345	0.20	1.4	–	–	–		–	–	–	–	–	–
WNMG 060412E-FM:T9415	⧓	1.2	■	350	0.27	1.2		–	–	–	◪	330	0.27	1.2	–	–	–		–	–	–	–	–	–
WNMG 06T304E-FM:T8430	●	0.4	■	195	0.20	1.4	◪	105	0.18	1.4	◪	160	0.20	1.4	–	–	–	◪	40	0.14	1.1	–	–	–
WNMG 06T304E-FM:T9325	●	0.4	■	240	0.20	1.4	◪	140	0.18	1.4	◪	225	0.20	1.4	–	–	–	◪	50	0.16	1.1	–	–	–
WNMG 06T308E-FM:T8430	⧓	0.8	■	235	0.20	1.4	◪	125	0.18	1.4	◪	190	0.20	1.4	–	–	–	◪	50	0.14	1.1	–	–	–
WNMG 06T308E-FM:T9325	●	0.8	■	285	0.20	1.4	◪	170	0.18	1.4	◪	270	0.20	1.4	–	–	–	◪	60	0.16	1.1	–	–	–
WNMG 080404E-FM:T7325	●	0.4	◪	190	0.20	1.9	◪	145	0.18	1.9		–	–	–	–	–	–	◪	60	0.16	1.5	–	–	–
WNMG 080404E-FM:T7335	●	0.4	◪	180	0.20	1.9	◪	140	0.18	1.9		–	–	–	–	–	–	◪	55	0.16	1.5	–	–	–
WNMG 080404E-FM:T8315	●	0.4	◪	180	0.20	1.9	◪	105	0.18	1.9	■	170	0.20	1.9	–	–	–	◪	45	0.14	1.5	–	–	–
WNMG 080404E-FM:T8415	●	0.4	■	215	0.20	1.9	◪	110	0.18	1.9	■	195	0.20	1.9	–	–	–	◪	45	0.14	1.5	–	–	–
WNMG 080404E-FM:T8430	●	0.4	■	190	0.20	1.9	◪	105	0.18	1.9	◪	155	0.20	1.9	–	–	–	◪	40	0.14	1.5	–	–	–
WNMG 080404E-FM:T9325	●	0.4	■	245	0.20	1.2	◪	145	0.18	1.2	◪	230	0.20	1.2	–	–	–	◪	55	0.16	1.0	–	–	–
WNMG 080404E-FM:T9415	●	0.4	■	310	0.20	1.2		–	–	–	◪	290	0.20	1.2	–	–	–		–	–	–	–	–	–
WNMG 080408E-FM:T7325	⧓	0.8	◪	225	0.20	1.9	◪	175	0.18	1.9		–	–	–	–	–	–	◪	70	0.16	1.5	–	–	–
WNMG 080408E-FM:T7335	⧓	0.8	◪	215	0.20	1.9	◪	165	0.18	1.9		–	–	–	–	–	–	◪	65	0.16	1.5	–	–	–
WNMG 080408E-FM:T8315	⧓	0.8	◪	210	0.20	1.9	◪	125	0.18	1.9	■	195	0.20	1.9	–	–	–	◪	50	0.16	1.5	–	–	–
WNMG 080408E-FM:T8415	⧓	0.8	■	250	0.20	1.9	◪	130	0.18	1.9	■	225	0.20	1.9	–	–	–	◪	55	0.16	1.5	–	–	–
WNMG 080408E-FM:T8430	⧓	0.8	■	225	0.20	1.9	◪	120	0.18	1.9	◪	185	0.20	1.9	–	–	–	◪	45	0.16	1.5	–	–	–
WNMG 080408E-FM:T9325	●	0.8	■	280	0.20	1.9	◪	165	0.18	1.9	◪	265	0.20	1.9	–	–	–	◪	60	0.16	1.5	–	–	–
WNMG 080408E-FM:T9415	●	0.8	■	350	0.20	1.9		–	–	–	◪	330	0.20	1.9	–	–	–		–	–	–	–	–	–
WNMG 080412E-FM:T7325	⧓	1.2	◪	220	0.27	1.9	◪	170	0.24	1.9		–	–	–	–	–	–	◪	70	0.19	1.5	–	–	–
WNMG 080412E-FM:T7335	⧓	1.2	◪	205	0.27	1.9	◪	155	0.24	1.9		–	–	–	–	–	–	◪	65	0.19	1.5	–	–	–
WNMG 080412E-FM:T8430	⧓	1.2	■	210	0.27	1.9	◪	115	0.24	1.9	◪	175	0.27	1.9	–	–	–	◪	45	0.19	1.5	–	–	–
WNMG 080412E-FM:T9310	⧓	1.2	■	310	0.27	1.9		–	–	–	◪	290	0.27	1.9	–	–	–		–	–	–	–	–	–
WNMG 080412E-FM:T9325	⧓	1.2	■	255	0.27	1.9	◪	150	0.24	1.9	◪	240	0.27	1.9	–	–	–	◪	55	0.19	1.5	–	–	–
WNMG 080412E-FM:T9415	⧓	1.2	■	335	0.27	1.9		–	–	–	◪	315	0.27	1.9	–	–	–		–	–	–	–	–	–

SF



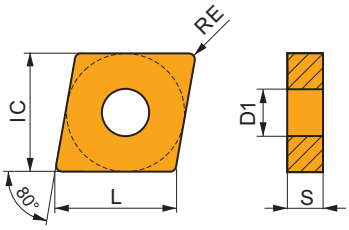


SF talaş kırıcı keskin ve Paslanmaz çeliklerin ve Süper alaşımların finisajı için ilk tercihtir. T-land olmadan hafif pozitif eğim açısına sahiptir. Ayrıca Çelikler, Dökme demirler ve Sert malzemeler için ve şartlara bağlı olarak Demir dışı alaşımlar için de uygundur.

PRAMET

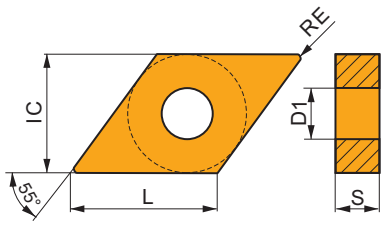
CNGG / CNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.90	4.76



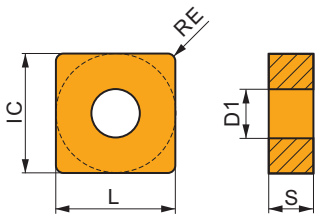
DNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1104	9.525	3.81	11.60	4.76
1504	12.700	5.16	15.50	4.76
1506	12.700	5.16	15.50	6.35



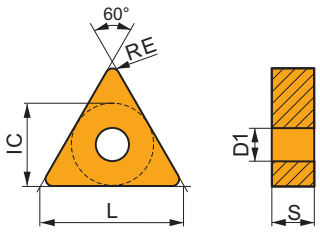
SNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76



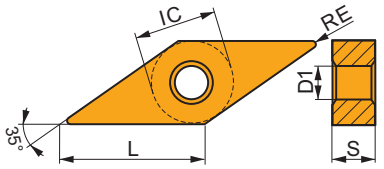
TNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76
2204	12.700	5.16	22.00	4.76



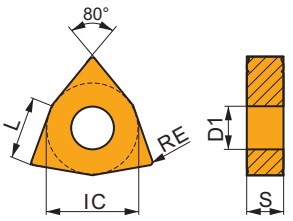
VNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.60	4.76

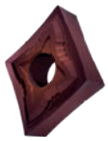
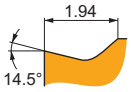
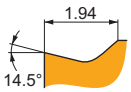
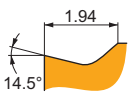


WNMG

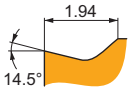
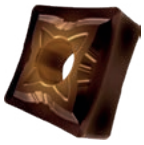
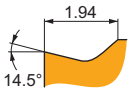
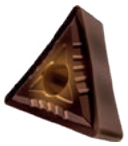
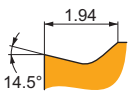
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0604	9.525	3.81	6.50	4.76
0804	12.700	5.16	8.70	4.76



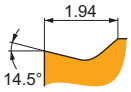
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
SF talaş kırıcı keskin ve Paslanmaz çeliklerin ve Süper alaşımların finisajı için ilk tercihtir. T-land olmadan hafif pozitif eğim açısına sahiptir. Ayrıca Çelikler, Dökme demirler ve Sert malzemeler için ve şartlara bağlı olarak Demir dışı alaşımlar için de uygundur.																			
CNGG 120402E-SF:H07	0.2	–	–	–	105	0.09	1.0	165	0.10	1.0	525	0.12	1.0	50	0.08	0.8	–	–	–
CNGG 120402E-SF:T6310	0.2	195	0.10	1.0	140	0.09	1.0	155	0.10	1.0	585	0.12	1.0	55	0.08	0.8	35	0.10	0.2
CNGG 120402E-SF:T8315	0.2	205	0.10	1.0	120	0.09	1.0	190	0.10	1.0	615	0.12	1.0	50	0.08	0.8	40	0.10	0.2
CNGG 120402E-SF:T8415	0.2	250	0.10	1.0	130	0.09	1.0	225	0.10	1.0	630	0.12	1.0	55	0.08	0.8	40	0.10	0.2
CNGG 120402E-SF:T8430	0.2	240	0.10	1.0	130	0.09	1.0	195	0.10	1.0	660	0.12	1.0	50	0.08	0.8	40	0.10	0.2
 																			
SF talaş kırıcı keskin ve Paslanmaz çeliklerin ve Süper alaşımların finisajı için ilk tercihtir. T-land olmadan hafif pozitif eğim açısına sahiptir. Ayrıca Çelikler, Dökme demirler ve Sert malzemeler için ve şartlara bağlı olarak Demir dışı alaşımlar için de uygundur.																			
CNMG 120404E-SF:H07	0.4	–	–	–	90	0.14	1.0	145	0.15	1.0	470	0.18	1.0	45	0.12	0.8	–	–	–
CNMG 120404E-SF:T6310	0.4	180	0.15	1.0	125	0.14	1.0	145	0.15	1.0	540	0.18	1.0	50	0.12	0.8	35	0.11	0.3
CNMG 120404E-SF:T7325	0.4	205	0.17	1.0	155	0.15	1.0	–	–	–	–	–	–	65	0.15	0.8	–	–	–
CNMG 120404E-SF:T8315	0.4	195	0.15	1.0	115	0.14	1.0	185	0.15	1.0	585	0.18	1.0	45	0.12	0.8	35	0.11	0.3
CNMG 120404E-SF:T8415	0.4	240	0.15	1.0	125	0.14	1.0	215	0.15	1.0	600	0.18	1.0	55	0.12	0.8	40	0.10	0.3
CNMG 120404E-SF:T8430	0.4	220	0.15	1.0	120	0.14	1.0	180	0.15	1.0	600	0.18	1.0	45	0.12	0.8	35	0.11	0.3
CNMG 120404E-SF:T9325	0.4	255	0.17	1.0	150	0.15	1.0	240	0.17	1.0	–	–	–	55	0.15	0.8	–	–	–
CNMG 120404E-SF:T9415	0.4	315	0.17	1.0	–	–	–	295	0.17	1.0	–	–	–	–	–	–	60	0.13	0.3
CNMG 120408E-SF:H07	0.8	–	–	–	95	0.18	1.0	155	0.20	1.0	495	0.24	1.0	50	0.15	0.8	–	–	–
CNMG 120408E-SF:T6310	0.8	200	0.20	1.0	140	0.18	1.0	160	0.20	1.0	600	0.24	1.0	60	0.14	0.8	40	0.10	0.7
CNMG 120408E-SF:T7325	0.8	230	0.20	1.0	175	0.18	1.0	–	–	–	–	–	–	70	0.16	0.8	–	–	–
CNMG 120408E-SF:T7335	0.8	220	0.20	1.0	170	0.18	1.0	–	–	–	–	–	–	70	0.16	0.8	–	–	–
CNMG 120408E-SF:T8315	0.8	210	0.20	1.0	125	0.18	1.0	195	0.20	1.0	630	0.24	1.0	50	0.14	0.8	40	0.10	0.7
CNMG 120408E-SF:T8415	0.8	255	0.20	1.0	135	0.18	1.0	230	0.20	1.0	645	0.24	1.0	55	0.14	0.8	45	0.10	0.7
CNMG 120408E-SF:T8430	0.8	230	0.20	1.0	125	0.18	1.0	185	0.20	1.0	630	0.24	1.0	45	0.14	0.8	35	0.10	0.7
CNMG 120408E-SF:T9325	0.8	280	0.20	1.0	165	0.18	1.0	265	0.20	1.0	–	–	–	60	0.16	0.8	–	–	–
CNMG 120412E-SF:T6310	1.2	190	0.25	1.5	135	0.23	1.5	150	0.25	1.5	570	0.30	1.5	55	0.18	1.2	35	0.13	1.0
CNMG 120412E-SF:T8315	1.2	200	0.25	1.5	120	0.23	1.5	190	0.25	1.5	600	0.30	1.5	50	0.18	1.2	40	0.13	1.0
CNMG 120412E-SF:T8415	1.2	250	0.25	1.5	130	0.23	1.5	225	0.25	1.5	630	0.30	1.5	55	0.17	1.2	40	0.13	1.0
CNMG 120412E-SF:T8430	1.2	210	0.25	1.5	115	0.23	1.5	175	0.25	1.5	585	0.30	1.5	45	0.18	1.2	35	0.13	1.0
 																			
SF talaş kırıcı keskin ve Paslanmaz çeliklerin ve Süper alaşımların finisajı için ilk tercihtir. T-land olmadan hafif pozitif eğim açısına sahiptir. Ayrıca Çelikler, Dökme demirler ve Sert malzemeler için ve şartlara bağlı olarak Demir dışı alaşımlar için de uygundur.																			
DNMG 110404E-SF:T6310	0.4	150	0.15	0.8	105	0.14	0.8	120	0.15	0.8	450	0.18	0.8	45	0.12	0.6	30	0.11	0.3
DNMG 110404E-SF:T8315	0.4	160	0.15	0.8	95	0.14	0.8	150	0.15	0.8	480	0.18	0.8	40	0.12	0.6	30	0.11	0.3
DNMG 110404E-SF:T8415	0.4	190	0.15	0.8	100	0.14	0.8	170	0.15	0.8	480	0.18	0.8	40	0.12	0.6	30	0.10	0.3
DNMG 110404E-SF:T8430	0.4	180	0.15	0.8	95	0.14	0.8	145	0.15	0.8	495	0.18	0.8	35	0.12	0.6	30	0.11	0.3
DNMG 110408E-SF:T6310	0.8	175	0.17	0.8	125	0.15	0.8	140	0.17	0.8	525	0.20	0.8	50	0.14	0.6	35	0.11	0.7
DNMG 110408E-SF:T8415	0.8	220	0.17	0.8	115	0.15	0.8	200	0.17	0.8	555	0.20	0.8	50	0.14	0.6	35	0.11	0.7
DNMG 110408E-SF:T8430	0.8	200	0.17	0.8	110	0.15	0.8	165	0.17	0.8	555	0.20	0.8	40	0.14	0.6	35	0.11	0.7
DNMG 150404E-SF:T6310	0.4	140	0.15	1.5	100	0.14	1.5	110	0.15	1.5	420	0.18	1.5	40	0.12	1.2	25	0.11	0.3
DNMG 150404E-SF:T8315	0.4	150	0.15	1.5	90	0.14	1.5	140	0.15	1.5	450	0.18	1.5	35	0.12	1.2	30	0.11	0.3
DNMG 150404E-SF:T8415	0.4	180	0.15	1.5	90	0.14	1.5	160	0.15	1.5	450	0.18	1.5	40	0.12	1.2	30	0.10	0.3
DNMG 150404E-SF:T8430	0.4	165	0.15	1.5	90	0.14	1.5	135	0.15	1.5	450	0.18	1.5	35	0.12	1.2	25	0.11	0.3
DNMG 150408E-SF:T6310	0.8	160	0.17	1.5	115	0.15	1.5	125	0.17	1.5	480	0.20	1.5	45	0.14	1.2	30	0.11	0.7
DNMG 150408E-SF:T8315	0.8	170	0.17	1.5	100	0.15	1.5	160	0.17	1.5	510	0.20	1.5	40	0.14	1.2	30	0.11	0.7
DNMG 150408E-SF:T8415	0.8	210	0.17	1.5	110	0.15	1.5	190	0.17	1.5	525	0.20	1.5	45	0.14	1.2	35	0.11	0.7
DNMG 150408E-SF:T8430	0.8	190	0.17	1.5	105	0.15	1.5	155	0.17	1.5	525	0.20	1.5	40	0.14	1.2	30	0.11	0.7
DNMG 150604E-SF:H07	0.4	–	–	–	70	0.14	1.5	115	0.15	1.5	360	0.18	1.5	35	0.12	1.2	–	–	–
DNMG 150604E-SF:T6310	0.4	140	0.15	1.5	100	0.14	1.5	110	0.15	1.5	420	0.18	1.5	40	0.12	1.2	25	0.11	0.3
DNMG 150604E-SF:T7325	0.4	155	0.17	1.5	120	0.15	1.5	–	–	–	–	–	–	50	0.15	1.2	–	–	–
DNMG 150604E-SF:T8315	0.4	150	0.15	1.5	90	0.14	1.5	140	0.15	1.5	450	0.18	1.5	35	0.12	1.2	30	0.11	0.3
DNMG 150604E-SF:T8415	0.4	180	0.15	1.5	90	0.14	1.5	160	0.15	1.5	450	0.18	1.5	40	0.12	1.2	30	0.10	0.3
DNMG 150604E-SF:T8430	0.4	165	0.15	1.5	90	0.14	1.5	135	0.15	1.5	450	0.18	1.5	35	0.12	1.2	25	0.11	0.3

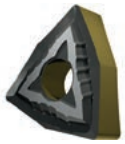
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

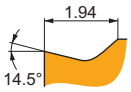
Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
SF talaş kırıcı keskin ve Paslanmaz çeliklerin ve Süper alaşımların finisajı için ilk tercihtir. T-land olmadan hafif pozitif eğim açısına sahiptir. Ayrıca Çelikler, Dökme demirler ve Sert malzemeler için ve şartlara bağlı olarak Demir dışı alaşımlar için de uygundur.																			
DNMG 150608E-SF:H07	0.8	–	–	–	80	0.15	1.5	130	0.17	1.5	415	0.20	1.5	40	0.14	1.2	–	–	–
DNMG 150608E-SF:T6310	0.8	160	0.17	1.5	115	0.15	1.5	125	0.17	1.5	480	0.20	1.5	45	0.14	1.2	30	0.11	0.7
DNMG 150608E-SF:T7325	0.8	185	0.17	1.5	140	0.15	1.5	–	–	–	–	–	–	60	0.15	1.2	–	–	–
DNMG 150608E-SF:T8315	0.8	170	0.17	1.5	100	0.15	1.5	160	0.17	1.5	510	0.20	1.5	40	0.14	1.2	30	0.11	0.7
DNMG 150608E-SF:T8415	0.8	210	0.17	1.5	110	0.15	1.5	190	0.17	1.5	525	0.20	1.5	45	0.14	1.2	35	0.11	0.7
DNMG 150608E-SF:T8430	0.8	190	0.17	1.5	105	0.15	1.5	155	0.17	1.5	525	0.20	1.5	40	0.14	1.2	30	0.11	0.7
DNMG 150608E-SF:T9325	0.8	235	0.17	1.5	140	0.15	1.5	220	0.17	1.5	–	–	–	50	0.15	1.2	–	–	–
DNMG 150608E-SF:T9415	0.8	290	0.17	1.5	–	–	–	275	0.17	1.5	–	–	–	–	–	–	55	0.12	0.7
DNMG 150612E-SF:T6310	1.2	155	0.25	1.5	110	0.23	1.5	125	0.25	1.5	465	0.30	1.5	45	0.18	1.2	30	0.13	0.9
DNMG 150612E-SF:T8415	1.2	195	0.25	1.5	100	0.23	1.5	180	0.25	1.5	495	0.30	1.5	45	0.17	1.2	30	0.13	0.9
 																			
SF talaş kırıcı keskin ve Paslanmaz çeliklerin ve Süper alaşımların finisajı için ilk tercihtir. T-land olmadan hafif pozitif eğim açısına sahiptir. Ayrıca Çelikler, Dökme demirler ve Sert malzemeler için ve şartlara bağlı olarak Demir dışı alaşımlar için de uygundur.																			
SNMG 120408E-SF:H07	0.8	–	–	–	105	0.18	1.0	165	0.20	1.0	525	0.24	1.0	50	0.14	0.8	–	–	–
SNMG 120408E-SF:T6310	0.8	210	0.20	1.0	150	0.18	1.0	165	0.20	1.0	630	0.24	1.0	60	0.14	0.8	40	0.10	0.7
SNMG 120408E-SF:T8415	0.8	275	0.20	1.0	140	0.18	1.0	250	0.20	1.0	690	0.24	1.0	60	0.14	0.8	45	0.10	0.7
SNMG 120408E-SF:T8430	0.8	245	0.20	1.0	135	0.18	1.0	200	0.20	1.0	675	0.24	1.0	50	0.14	0.8	40	0.10	0.7
SNMG 120408E-SF:T9325	0.8	295	0.20	1.0	175	0.18	1.0	280	0.20	1.0	–	–	–	65	0.16	0.8	–	–	–
SNMG 120412E-SF:T6310	1.2	200	0.25	1.5	140	0.23	1.5	160	0.25	1.5	600	0.30	1.5	60	0.18	1.2	40	0.13	1.0
SNMG 120412E-SF:T8415	1.2	260	0.25	1.5	135	0.23	1.5	240	0.25	1.5	660	0.30	1.5	60	0.17	1.2	45	0.13	1.0
SNMG 120412E-SF:T8430	1.2	225	0.25	1.5	120	0.23	1.5	185	0.25	1.5	615	0.30	1.5	45	0.18	1.2	35	0.13	1.0
 																			
SF talaş kırıcı keskin ve Paslanmaz çeliklerin ve Süper alaşımların finisajı için ilk tercihtir. T-land olmadan hafif pozitif eğim açısına sahiptir. Ayrıca Çelikler, Dökme demirler ve Sert malzemeler için ve şartlara bağlı olarak Demir dışı alaşımlar için de uygundur.																			
TNMG 160404E-SF:T6310	0.4	150	0.15	1.3	105	0.14	1.3	120	0.15	1.3	450	0.18	1.3	45	0.12	1.0	30	0.11	0.3
TNMG 160404E-SF:T7325	0.4	170	0.17	1.3	130	0.15	1.3	–	–	–	–	–	–	55	0.15	1.0	–	–	–
TNMG 160404E-SF:T8315	0.4	160	0.15	1.3	95	0.14	1.3	150	0.15	1.3	480	0.18	1.3	40	0.12	1.0	30	0.11	0.3
TNMG 160404E-SF:T8415	0.4	195	0.15	1.3	100	0.14	1.3	180	0.15	1.3	495	0.18	1.3	45	0.12	1.0	30	0.10	0.3
TNMG 160404E-SF:T8430	0.4	180	0.15	1.3	95	0.14	1.3	145	0.15	1.3	495	0.18	1.3	35	0.12	1.0	30	0.11	0.3
TNMG 160408E-SF:T6310	0.8	175	0.17	1.3	125	0.15	1.3	140	0.17	1.3	525	0.20	1.3	50	0.14	1.0	35	0.11	0.7
TNMG 160408E-SF:T8315	0.8	185	0.17	1.3	110	0.15	1.3	175	0.17	1.3	555	0.20	1.3	45	0.14	1.0	35	0.11	0.7
TNMG 160408E-SF:T8415	0.8	225	0.17	1.3	115	0.15	1.3	205	0.17	1.3	570	0.20	1.3	50	0.14	1.0	35	0.11	0.7
TNMG 160408E-SF:T8430	0.8	205	0.17	1.3	110	0.15	1.3	170	0.17	1.3	570	0.20	1.3	45	0.14	1.0	35	0.11	0.7
TNMG 160412E-SF:T6310	1.2	165	0.25	1.5	115	0.23	1.5	130	0.25	1.5	495	0.30	1.5	45	0.18	1.2	30	0.13	0.9
TNMG 160412E-SF:T8415	1.2	210	0.25	1.5	110	0.23	1.5	190	0.25	1.5	525	0.30	1.5	45	0.17	1.2	35	0.13	0.9
TNMG 220404E-SF:T6310	0.4	145	0.17	1.7	100	0.15	1.7	115	0.17	1.7	435	0.20	1.7	40	0.15	1.4	25	0.12	0.3
TNMG 220404E-SF:T8415	0.4	185	0.17	1.7	95	0.15	1.7	165	0.17	1.7	465	0.20	1.7	40	0.15	1.4	30	0.12	0.3
TNMG 220408E-SF:T6310	0.8	170	0.17	1.7	120	0.15	1.7	135	0.17	1.7	510	0.20	1.7	50	0.15	1.4	30	0.12	0.7
TNMG 220408E-SF:T8315	0.8	180	0.17	1.7	105	0.15	1.7	170	0.17	1.7	540	0.20	1.7	45	0.15	1.4	35	0.12	0.7
TNMG 220408E-SF:T8415	0.8	220	0.17	1.7	115	0.15	1.7	200	0.17	1.7	555	0.20	1.7	50	0.15	1.4	35	0.12	0.7
TNMG 220408E-SF:T8430	0.8	195	0.17	1.7	105	0.15	1.7	160	0.17	1.7	540	0.20	1.7	40	0.15	1.4	30	0.12	0.7
TNMG 220412E-SF:T6310	1.2	155	0.30	1.7	110	0.27	1.7	125	0.30	1.7	465	0.36	1.7	45	0.21	1.4	30	0.15	0.9
TNMG 220412E-SF:T8415	1.2	195	0.30	1.7	100	0.27	1.7	180	0.30	1.7	495	0.36	1.7	45	0.21	1.4	30	0.15	0.9

Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P			M			K			N			S			H		
		(mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)
																				
VNMG 160404E-SF:T6310	●	0.4	■	125	0.15	1.2	■	90	0.14	1.2	■	100	0.15	1.2	◪	375	0.18	1.2	■	35	0.14	1.0	■	25	0.15	0.3
VNMG 160404E-SF:T7325	●	0.4	◪	145	0.15	1.2	■	110	0.14	1.2		–	–	–		–	–	–	■	45	0.14	1.0		–	–	–
VNMG 160404E-SF:T8315	●	0.4	◪	135	0.15	1.2	■	80	0.14	1.2	■	125	0.15	1.2	◪	405	0.18	1.2	◪	30	0.14	1.0	■	25	0.15	0.3
VNMG 160404E-SF:T8415	●	0.4	■	160	0.15	1.2	■	85	0.14	1.2	■	145	0.15	1.2	◪	405	0.18	1.2	■	35	0.14	1.0	■	25	0.15	0.3
VNMG 160404E-SF:T8430	●	0.4	■	145	0.15	1.2	■	80	0.14	1.2	◪	120	0.15	1.2	◪	405	0.18	1.2	◪	30	0.14	1.0	◪	25	0.15	0.3
VNMG 160408E-SF:T6310	●	0.8	■	140	0.17	1.4	■	100	0.15	1.4	■	110	0.17	1.4	◪	420	0.20	1.4	■	40	0.14	1.1	■	25	0.11	0.7
VNMG 160408E-SF:T8315	●	0.8	◪	150	0.17	1.4	■	90	0.15	1.4	■	140	0.17	1.4	◪	450	0.20	1.4	◪	35	0.14	1.1	■	30	0.11	0.7
VNMG 160408E-SF:T8415	●	0.8	■	185	0.17	1.4	■	95	0.15	1.4	■	165	0.17	1.4	◪	465	0.20	1.4	■	40	0.14	1.1	■	30	0.11	0.7
VNMG 160408E-SF:T8430	●	0.8	■	165	0.17	1.4	■	90	0.15	1.4	◪	135	0.17	1.4	◪	450	0.20	1.4	◪	35	0.14	1.1	◪	25	0.11	0.7
VNMG 160408E-SF:T9325	●	0.8	■	205	0.17	1.4	■	120	0.15	1.4	◪	190	0.17	1.4		–	–	–	◪	45	0.15	1.1		–	–	–
VNMG 160408E-SF:T9415	●	0.8	■	255	0.17	1.4		–	–	–	◪	240	0.17	1.4		–	–	–		–	–	–	◪	50	0.12	0.7

SF talaş kırıcı keskin ve Paslanmaz çeliklerin ve Süper alaşımların finisajı için ilk tercihtir. T-land olmadan hafif pozitif eğim açısına sahiptir. Ayrıca Çelikler, Dökme demirler ve Sert malzemeler için ve şartlara bağlı olarak Demir dışı alaşımlar için de uygundur.

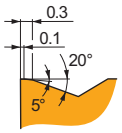




SF talaş kırıcı keskin ve Paslanmaz çeliklerin ve Süper alaşımların finisajı için ilk tercihtir. T-land olmadan hafif pozitif eğim açısına sahiptir. Ayrıca Çelikler, Dökme demirler ve Sert malzemeler için ve şartlara bağlı olarak Demir dışı alaşımlar için de uygundur.

WNMG 060404E-SF:T6310	●	0.4	■	180	0.15	1.0	■	125	0.14	1.0	■	145	0.15	1.0	◪	540	0.18	1.0	■	50	0.12	0.8	■	35	0.11	0.3
WNMG 060404E-SF:T8315	●	0.4	◪	195	0.15	1.0	■	115	0.14	1.0	■	185	0.15	1.0	◪	585	0.18	1.0	◪	45	0.12	0.8	■	35	0.11	0.3
WNMG 060404E-SF:T8415	●	0.4	■	240	0.15	1.0	■	125	0.14	1.0	■	215	0.15	1.0	◪	600	0.18	1.0	■	55	0.12	0.8	■	40	0.10	0.3
WNMG 060404E-SF:T8430	●	0.4	■	220	0.15	1.0	■	120	0.14	1.0	◪	180	0.15	1.0	◪	600	0.18	1.0	◪	45	0.12	0.8	◪	35	0.11	0.3
WNMG 060408E-SF:T6310	⬌	0.8	■	200	0.20	1.0	■	140	0.18	1.0	■	160	0.20	1.0	◪	600	0.24	1.0	■	60	0.14	0.8	■	40	0.10	0.7
WNMG 060408E-SF:T8315	⬌	0.8	◪	210	0.20	1.0	■	125	0.18	1.0	■	195	0.20	1.0	◪	630	0.24	1.0	◪	50	0.14	0.8	■	40	0.10	0.7
WNMG 060408E-SF:T8415	⬌	0.8	■	255	0.20	1.0	■	135	0.18	1.0	■	230	0.20	1.0	◪	645	0.24	1.0	■	55	0.14	0.8	■	45	0.10	0.7
WNMG 060408E-SF:T8430	⬌	0.8	■	230	0.20	1.0	■	125	0.18	1.0	◪	185	0.20	1.0	◪	630	0.24	1.0	◪	45	0.14	0.8	◪	35	0.10	0.7
WNMG 080404E-SF:H07	●	0.4		–	–	–	◪	90	0.14	1.0	■	145	0.15	1.0	◪	470	0.18	1.0	■	45	0.12	0.8		–	–	–
WNMG 080404E-SF:T6310	●	0.4	■	180	0.15	1.0	■	125	0.14	1.0	■	145	0.15	1.0	◪	540	0.18	1.0	■	50	0.12	0.8	■	35	0.11	0.3
WNMG 080404E-SF:T7325	●	0.4	◪	205	0.17	1.0	■	155	0.15	1.0		–	–	–		–	–	–	■	65	0.15	0.8		–	–	–
WNMG 080404E-SF:T8315	●	0.4	◪	195	0.15	1.0	■	115	0.14	1.0	■	185	0.15	1.0	◪	585	0.18	1.0	◪	45	0.12	0.8	■	35	0.11	0.3
WNMG 080404E-SF:T8415	●	0.4	■	240	0.15	1.0	■	125	0.14	1.0	■	215	0.15	1.0	◪	600	0.18	1.0	■	55	0.12	0.8	■	40	0.10	0.3
WNMG 080404E-SF:T8430	●	0.4	■	220	0.15	1.0	■	120	0.14	1.0	◪	180	0.15	1.0	◪	600	0.18	1.0	◪	45	0.12	0.8	◪	35	0.11	0.3
WNMG 080408E-SF:H07	⬌	0.8		–	–	–	◪	95	0.18	1.0	■	155	0.20	1.0	◪	495	0.24	1.0	■	50	0.14	0.8		–	–	–
WNMG 080408E-SF:T6310	⬌	0.8	■	200	0.20	1.0	■	140	0.18	1.0	■	160	0.20	1.0	◪	600	0.24	1.0	■	60	0.14	0.8	■	40	0.10	0.7
WNMG 080408E-SF:T7325	⬌	0.8	◪	230	0.20	1.0	■	175	0.18	1.0		–	–	–		–	–	–	■	70	0.16	0.8		–	–	–
WNMG 080408E-SF:T7335	⬌	0.8	◪	220	0.20	1.0	■	170	0.18	1.0		–	–	–		–	–	–	■	70	0.16	0.8		–	–	–
WNMG 080408E-SF:T8315	⬌	0.8	◪	210	0.20	1.0	■	125	0.18	1.0	■	195	0.20	1.0	◪	630	0.24	1.0	◪	50	0.14	0.8	■	40	0.10	0.7
WNMG 080408E-SF:T8415	⬌	0.8	■	255	0.20	1.0	■	135	0.18	1.0	■	230	0.20	1.0	◪	645	0.24	1.0	■	55	0.14	0.8	■	45	0.10	0.7
WNMG 080408E-SF:T8430	⬌	0.8	■	230	0.20	1.0	■	125	0.18	1.0	◪	185	0.20	1.0	◪	630	0.24	1.0	◪	45	0.14	0.8	◪	35	0.10	0.7
WNMG 080408E-SF:T9325	⬌	0.8	■	280	0.20	1.0	■	165	0.18	1.0	◪	265	0.20	1.0		–	–	–	◪	60	0.16	0.8		–	–	–
WNMG 080408E-SF:T9415	●	0.8	■	355	0.20	1.0		–	–	–	◪	335	0.20	1.0		–	–	–		–	–	–	◪	70	0.13	0.7

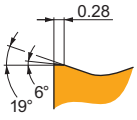
W-M



W-M talaş kırıcı silici kenara sahiptir ve Çeliklerin finişi için tasarlanmıştır. Pozitif eğim açısı ve pozitif, ılımlı T-land özelliğine sahiptir. Dökme demirler için de şartlı olarak uygundur.

PRAMET

W-MR

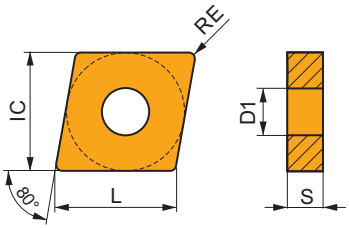


W-MR talaş kırıcı silici kenara sahiptir ve Çeliklerin finisajı için tasarlanmıştır. Pozitif eğim açısı ve dengeli, geniş T-land özelliğine sahiptir. Paslanmaz çelikler ve Dökme demirler için de şartlı olarak uygundur.

PRAMET

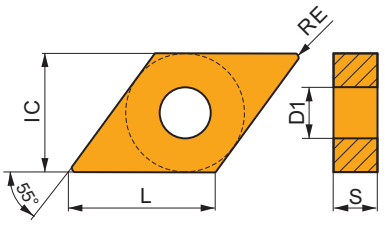
CNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.90	4.76



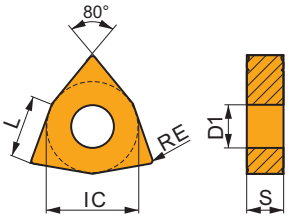
DNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1506	12.700	5.16	15.50	6.35

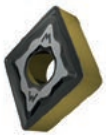
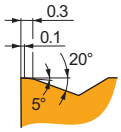
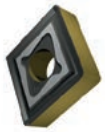
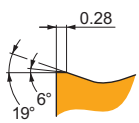
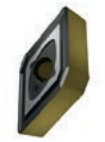
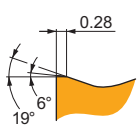
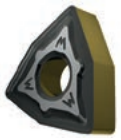
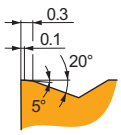
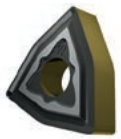
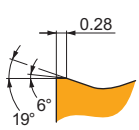


WNMG

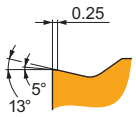
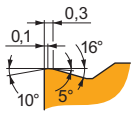
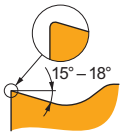
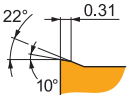
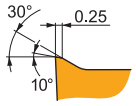
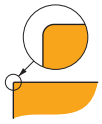
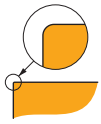
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0604	9.525	3.81	6.50	4.76
0804	12.700	5.16	8.70	4.76



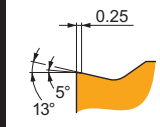
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
W-M talaş kırıcı silici kenara sahiptir ve Çeliklerin finişi için tasarlanmıştır. Pozitif eğim açısı ve pozitif, ılımlı T-land özelliğine sahiptir. Dökme demirler için de şartlı olarak uygundur.																			
CNMG 120408W-M:T5315	0.8	230	0.45	1.5	–	–	–	215	0.45	1.5	–	–	–	–	–	–	–	–	–
CNMG 120408W-M:T9315	0.8	200	0.45	1.5	–	–	–	190	0.45	1.5	–	–	–	–	–	–	–	–	–
CNMG 120408W-M:T9325	0.8	185	0.45	1.5	–	–	–	175	0.45	1.5	–	–	–	–	–	–	–	–	–
CNMG 120408W-M:T9415	0.8	245	0.45	1.5	–	–	–	230	0.45	1.5	–	–	–	–	–	–	–	–	–
 																			
W-MR talaş kırıcı silici kenara sahiptir ve Çeliklerin finisajı için tasarlanmıştır. Pozitif eğim açısı ve dengeli, geniş T-land özelliğine sahiptir. Paslanmaz çelikler ve Dökme demirler için de şartlı olarak uygundur.																			
CNMG 120404W-MR:T9415	0.4	240	0.30	1.5	–	–	–	225	0.30	1.5	–	–	–	–	–	–	–	–	–
CNMG 120408W-MR:T5315	0.8	230	0.45	1.5	–	–	–	215	0.45	1.5	–	–	–	–	–	–	–	–	–
CNMG 120408W-MR:T9325	0.8	185	0.45	1.5	110	0.41	1.5	175	0.45	1.5	–	–	–	–	–	–	–	–	–
CNMG 120408W-MR:T9415	0.8	245	0.45	1.5	–	–	–	230	0.45	1.5	–	–	–	–	–	–	–	–	–
CNMG 120412W-MR:T5315	1.2	230	0.55	1.5	–	–	–	215	0.55	1.5	–	–	–	–	–	–	–	–	–
CNMG 120412W-MR:T9315	1.2	200	0.55	1.5	–	–	–	190	0.55	1.5	–	–	–	–	–	–	–	–	–
CNMG 120412W-MR:T9325	1.2	180	0.55	1.5	105	0.50	1.5	170	0.55	1.5	–	–	–	–	–	–	–	–	–
CNMG 120412W-MR:T9415	1.2	245	0.55	1.5	–	–	–	230	0.55	1.5	–	–	–	–	–	–	–	–	–
 																			
W-MR talaş kırıcı silici kenara sahiptir ve Çeliklerin finisajı için tasarlanmıştır. Pozitif eğim açısı ve dengeli, geniş T-land özelliğine sahiptir. Paslanmaz çelikler ve Dökme demirler için de şartlı olarak uygundur.																			
DNMG 150608W-MR:T9325	0.8	155	0.40	1.5	90	0.36	1.5	145	0.40	1.5	–	–	–	–	–	–	–	–	–
DNMG 150608W-MR:T9415	0.8	205	0.40	1.5	–	–	–	190	0.40	1.5	–	–	–	–	–	–	–	–	–
DNMG 150612W-MR:T9315	1.2	160	0.50	1.5	–	–	–	150	0.50	1.5	–	–	–	–	–	–	–	–	–
DNMG 150612W-MR:T9325	1.2	145	0.50	1.5	85	0.45	1.5	135	0.50	1.5	–	–	–	–	–	–	–	–	–
DNMG 150612W-MR:T9415	1.2	200	0.50	1.5	–	–	–	190	0.50	1.5	–	–	–	–	–	–	–	–	–
 																			
W-M talaş kırıcı silici kenara sahiptir ve Çeliklerin finişi için tasarlanmıştır. Pozitif eğim açısı ve pozitif, ılımlı T-land özelliğine sahiptir. Dökme demirler için de şartlı olarak uygundur.																			
WNMG 060408W-M:T9325	0.8	190	0.45	1.2	–	–	–	180	0.45	1.2	–	–	–	–	–	–	–	–	–
WNMG 060408W-M:T9415	0.8	255	0.45	1.2	–	–	–	240	0.45	1.2	–	–	–	–	–	–	–	–	–
WNMG 060412W-M:T5315	1.2	235	0.55	1.2	–	–	–	220	0.55	1.2	–	–	–	–	–	–	–	–	–
WNMG 060412W-M:T9415	1.2	250	0.55	1.2	–	–	–	235	0.55	1.2	–	–	–	–	–	–	–	–	–
WNMG 080408W-M:T9325	0.8	185	0.45	1.5	–	–	–	175	0.45	1.5	–	–	–	–	–	–	–	–	–
WNMG 080408W-M:T9415	0.8	245	0.45	1.5	–	–	–	230	0.45	1.5	–	–	–	–	–	–	–	–	–
WNMG 080412W-M:T9325	1.2	180	0.55	1.5	–	–	–	170	0.55	1.5	–	–	–	–	–	–	–	–	–
 																			
W-MR talaş kırıcı silici kenara sahiptir ve Çeliklerin finisajı için tasarlanmıştır. Pozitif eğim açısı ve dengeli, geniş T-land özelliğine sahiptir. Paslanmaz çelikler ve Dökme demirler için de şartlı olarak uygundur.																			
WNMG 060408W-MR:T9415	0.8	255	0.45	1.2	–	–	–	240	0.45	1.2	–	–	–	–	–	–	–	–	–
WNMG 080404W-MR:T9415	0.4	240	0.30	1.5	–	–	–	225	0.30	1.5	–	–	–	–	–	–	–	–	–
WNMG 080408W-MR:T5315	0.8	230	0.45	1.5	–	–	–	215	0.45	1.5	–	–	–	–	–	–	–	–	–
WNMG 080408W-MR:T9310	0.8	215	0.45	1.5	–	–	–	200	0.45	1.5	–	–	–	–	–	–	–	–	–
WNMG 080408W-MR:T9325	0.8	185	0.45	1.5	110	0.41	1.5	175	0.45	1.5	–	–	–	–	–	–	–	–	–
WNMG 080408W-MR:T9415	0.8	245	0.45	1.5	–	–	–	230	0.45	1.5	–	–	–	–	–	–	–	–	–
WNMG 080412W-MR:T5315	1.2	230	0.55	1.5	–	–	–	215	0.55	1.5	–	–	–	–	–	–	–	–	–
WNMG 080412W-MR:T9415	1.2	245	0.55	1.5	–	–	–	230	0.55	1.5	–	–	–	–	–	–	–	–	–

ORTA - REHBER

SM			**SM** talaş kırıcı çok yönlüdür ve Çeliklerin ve Süper alaşımların orta düzeyde işlenmesi için ilk tercihtir. Hafif pozitif eğim açısı ve dengeli, ılımlı T-land özelliğine sahiptir. Ayrıca Paslanmaz çelikler, Dökme demirler ve şartlara bağlı olarak Demir dışı alaşımlar ve Sert malzemeler için de uygundur.
M			**M** talaş kırıcı çok yönlüdür ve Dökme demirlerin orta düzeyde işlenmesi için ilk tercihtir. Pozitif eğim açısı ve negatif/kararlı, ılımlı T-land özelliklerine sahiptir. Çelikler için ve şartlı olarak Sert malzemeler için de uygundur.
SI			**SI** talaş kırıcı keskindir ve Çeliklerin, Paslanmaz çeliklerin orta düzeyde işlenmesi için tasarlanmıştır. T-land olmadan pozitif eğim açısına sahiptir. Ayrıca demir dışı alaşımlar ve süper alaşımlar için de şartlara bağlı olarak uygundur.
NMR			**NMR** talaş kırıcı çok yönlüdür ve Paslanmaz çeliklerin orta düzeyde işlenmesi için ilk tercihtir. Pozitif eğim açısı ve pozitif, geniş T-land özelliğine sahiptir. Çelikler ve Süper alaşımlar için de uygundur.
NM			**NM** talaş kırıcı keskindir ve Çeliklerin, Paslanmaz çeliklerin ve Süper alaşımların orta düzeyde işlenmesi için tasarlanmıştır. Son derece pozitif eğim açısı ve pozitif, ılımlı T-land özelliğine sahiptir. Demir dışı alaşımlar için de şartlara bağlı olarak uygundur.
.NMA			**.NMA** düz kesici uç, Dökme demirlerin orta düzeyde işlenmesi için tasarlanmıştır. T-land olmadan nötr eğim açısına sahiptir. Sert malzemeler için de şartlara bağlı olarak uygundur.
.NMA ..S			**.NMA..S** düz kesici uç, Dökme demirlerin orta düzeyde işlenmesi için tasarlanmıştır. Nötr eğim açısına ve negatif, orta T-land özelliğine sahiptir. Sert malzemeler için de şartlı olarak uygundur.

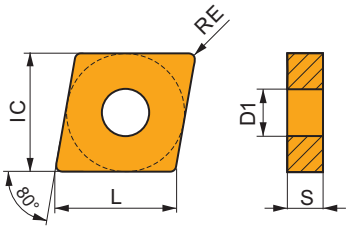
SM



SM talaş kırıcı çok yönlüdür ve Çeliklerin ve Süper alaşımların orta düzeyde işlenmesi için ilk tercihtir. Hafif pozitif eğim açısı ve dengeli, ılımlı T-land özelliğine sahiptir. Ayrıca Paslanmaz çelikler, Dökme demirler ve şartlara bağlı olarak Demir dışı alaşımlar ve Sert malzemeler için de uygundur.

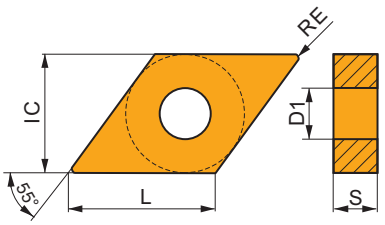
CNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.90	4.76
1606	15.875	6.35	16.10	6.35
1906	19.050	7.94	19.30	6.35



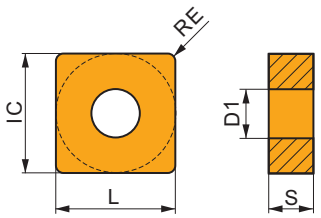
DNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1104	9.525	3.81	11.60	4.76
1504	12.700	5.16	15.50	4.76
1506	12.700	5.16	15.50	6.35



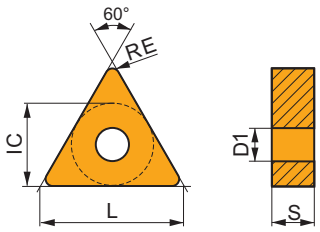
SNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76
1906	19.050	7.94	19.05	6.35



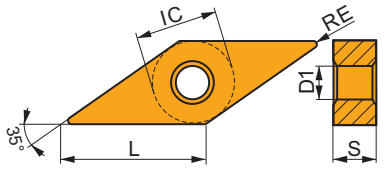
TNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76
2204	12.700	5.16	22.00	4.76



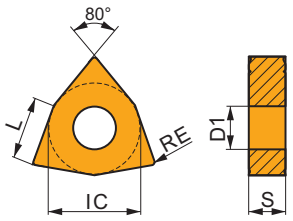
VNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.60	4.76



WNMG

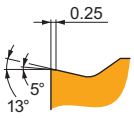
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0604	9.525	3.81	6.50	4.76
0804	12.700	5.16	8.70	4.76



Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE	P			M			K			N			S			H		
		vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)
	(mm)																		



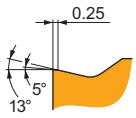




SM talaş kırıcı çok yönlüdür ve Çeliklerin ve Süper alaşımların orta düzeyde işlenmesi için ilk tercihtir. Hafif pozitif eğim açısı ve dengeli, ılımlı T-land özelliğine sahiptir. Ayrıca Paslanmaz çelikler, Dökme demirler ve şartlara bağlı olarak Demir dışı alaşımlar ve Sert malzemeler için de uygundur.

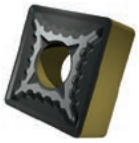
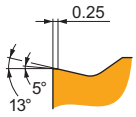
CNMG 120404E-SM:T6310	●	0.4	■	155	0.20	2.0	■	110	0.18	2.0	■	125	0.20	2.0	◪	465	0.24	2.0	■	45	0.18	1.6	◪	30	0.13	0.3
CNMG 120404E-SM:T7325	●	0.4	◪	180	0.20	2.0	■	140	0.18	2.0		–	–	–		–	–	–	■	55	0.18	1.6		–	–	–
CNMG 120404E-SM:T7335	●	0.4	◪	175	0.20	2.0	■	135	0.18	2.0		–	–	–		–	–	–	■	55	0.18	1.6		–	–	–
CNMG 120404E-SM:T8415	●	0.4	■	200	0.20	2.0	■	105	0.18	2.0	■	185	0.20	2.0	◪	510	0.24	2.0	■	45	0.18	1.6	◪	35	0.13	0.3
CNMG 120404E-SM:T8430	●	0.4	■	180	0.20	2.0	■	95	0.18	2.0	◪	145	0.20	2.0	◪	495	0.24	2.0	◪	35	0.18	1.6	◪	30	0.13	0.3
CNMG 120404E-SM:T9325	●	0.4	■	220	0.20	2.0	■	130	0.18	2.0	◪	205	0.20	2.0		–	–	–	◪	45	0.18	1.6		–	–	–
CNMG 120404E-SM:T9415	●	0.4	■	280	0.20	2.0		–	–	–	◪	265	0.20	2.0		–	–	–		–	–	–	◪	55	0.13	0.3
CNMG 120408E-SM:T6310	●	0.8	■	175	0.25	2.0	■	125	0.23	2.0	■	140	0.25	2.0	◪	525	0.30	2.0	■	50	0.20	1.6	◪	35	0.13	0.7
CNMG 120408E-SM:T7325	●	0.8	◪	200	0.25	2.0	■	155	0.23	2.0		–	–	–		–	–	–	■	65	0.20	1.6		–	–	–
CNMG 120408E-SM:T7335	●	0.8	◪	190	0.25	2.0	■	145	0.23	2.0		–	–	–		–	–	–	■	60	0.20	1.6		–	–	–
CNMG 120408E-SM:T8415	●	0.8	■	225	0.25	2.0	■	115	0.23	2.0	■	205	0.25	2.0	◪	570	0.30	2.0	■	50	0.20	1.6	◪	35	0.13	0.7
CNMG 120408E-SM:T8430	●	0.8	■	195	0.25	2.0	■	105	0.23	2.0	◪	160	0.25	2.0	◪	540	0.30	2.0	◪	40	0.20	1.6	◪	30	0.13	0.7
CNMG 120408E-SM:T9325	●	0.8	■	235	0.25	2.0	■	140	0.23	2.0	◪	220	0.25	2.0		–	–	–	◪	50	0.20	1.6		–	–	–
CNMG 120408E-SM:T9415	●	0.8	■	305	0.25	2.0		–	–	–	◪	285	0.25	2.0		–	–	–		–	–	–	◪	60	0.13	0.7
CNMG 120412E-SM:T6310	●	1.2	■	175	0.30	2.0	■	125	0.27	2.0	■	140	0.30	2.0	◪	525	0.36	2.0	■	50	0.24	1.6	◪	35	0.15	1.0
CNMG 120412E-SM:T7325	●	1.2	◪	195	0.30	2.0	■	150	0.27	2.0		–	–	–		–	–	–	■	60	0.24	1.6		–	–	–
CNMG 120412E-SM:T7335	●	1.2	◪	190	0.30	2.0	■	145	0.27	2.0		–	–	–		–	–	–	■	60	0.24	1.6		–	–	–
CNMG 120412E-SM:T8415	●	1.2	■	225	0.30	2.0	■	115	0.27	2.0	■	205	0.30	2.0	◪	570	0.36	2.0	■	50	0.24	1.6	◪	35	0.15	1.0
CNMG 120412E-SM:T8430	●	1.2	■	190	0.30	2.0	■	105	0.27	2.0	◪	155	0.30	2.0	◪	525	0.36	2.0	◪	40	0.24	1.6	◪	30	0.15	1.0
CNMG 120412E-SM:T9325	●	1.2	■	235	0.30	2.0	■	140	0.27	2.0	◪	220	0.30	2.0		–	–	–	◪	50	0.24	1.6		–	–	–
CNMG 120412E-SM:T9415	●	1.2	■	300	0.30	2.0		–	–	–	◪	285	0.30	2.0		–	–	–		–	–	–	◪	60	0.15	1.0
CNMG 160608E-SM:T7325	●	0.8	◪	185	0.26	3.0	■	140	0.23	3.0		–	–	–		–	–	–	■	60	0.23	2.4		–	–	–
CNMG 160608E-SM:T8430	●	0.8	■	180	0.26	3.0	■	95	0.23	3.0	◪	145	0.26	3.0	◪	495	0.31	3.0	◪	35	0.23	2.4	◪	30	0.13	0.7
CNMG 160608E-SM:T9325	●	0.8	■	225	0.26	3.0	■	135	0.23	3.0	◪	210	0.26	3.0		–	–	–	◪	50	0.23	2.4		–	–	–
CNMG 160612E-SM:T6310	●	1.2	■	170	0.30	3.0	■	120	0.27	3.0	■	135	0.30	3.0	◪	510	0.36	3.0	■	50	0.27	2.4	◪	30	0.15	1.0
CNMG 160612E-SM:T7325	●	1.2	◪	190	0.30	3.0	■	145	0.27	3.0		–	–	–		–	–	–	■	60	0.27	2.4		–	–	–
CNMG 160612E-SM:T7335	●	1.2	◪	180	0.30	3.0	■	140	0.27	3.0		–	–	–		–	–	–	■	55	0.27	2.4		–	–	–
CNMG 160612E-SM:T8415	●	1.2	■	215	0.30	3.0	■	110	0.27	3.0	■	195	0.30	3.0	◪	540	0.36	3.0	■	45	0.27	2.4	◪	35	0.15	1.0
CNMG 160612E-SM:T9325	●	1.2	■	225	0.30	3.0	■	135	0.27	3.0	◪	210	0.30	3.0		–	–	–	◪	50	0.27	2.4		–	–	–
CNMG 160612E-SM:T9415	●	1.2	■	290	0.30	3.0		–	–	–	◪	275	0.30	3.0		–	–	–		–	–	–	◪	55	0.15	1.0
CNMG 190612E-SM:T6310	●	1.2	■	165	0.30	4.0	■	115	0.27	4.0	■	130	0.30	4.0	◪	495	0.36	4.0	■	45	0.27	3.2	◪	30	0.15	1.0
CNMG 190612E-SM:T7325	●	1.2	◪	185	0.30	4.0	■	140	0.27	4.0		–	–	–		–	–	–	■	60	0.27	3.2		–	–	–
CNMG 190612E-SM:T7335	●	1.2	◪	175	0.30	4.0	■	135	0.27	4.0		–	–	–		–	–	–	■	55	0.27	3.2		–	–	–
CNMG 190612E-SM:T8415	●	1.2	■	210	0.30	4.0	■	110	0.27	4.0	■	190	0.30	4.0	◪	525	0.36	4.0	■	45	0.27	3.2	◪	35	0.15	1.0
CNMG 190612E-SM:T9415	●	1.2	■	280	0.30	4.0		–	–	–	◪	265	0.30	4.0		–	–	–		–	–	–	◪	55	0.15	1.0

Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE	P			M			K			N			S			H		
	(mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)
																			

SM talaş kırıcı çok yönlüdür ve Çeliklerin ve Süper alaşımların orta düzeyde işlenmesi için ilk tercihtir. Hafif pozitif eğim açısı ve dengeli, ılımlı T-land özelliğine sahiptir. Ayrıca Paslanmaz çelikler, Dökme demirler ve şartlara bağlı olarak Demir dışı alaşımlar ve Sert malzemeler için de uygundur.

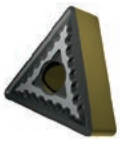
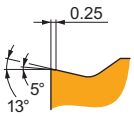
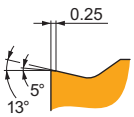
DNMG 110404E-SM:T6310	●	0.4	■	140	0.20	0.8	■	100	0.18	0.8	■	110	0.20	0.8	◪	420	0.24	0.8	■	40	0.18	0.6	◪	25	0.14	0.3
DNMG 110404E-SM:T7325	●	0.4	◪	160	0.20	0.8	■	120	0.18	0.8		–	–	–		–	–	–	■	50	0.18	0.6		–	–	–
DNMG 110404E-SM:T8415	●	0.4	■	180	0.20	0.8	■	90	0.18	0.8	■	160	0.20	0.8	◪	450	0.24	0.8	■	40	0.18	0.6	◪	30	0.14	0.3
DNMG 110404E-SM:T8430	●	0.4	■	155	0.20	0.8	■	85	0.18	0.8	◪	130	0.20	0.8	◪	435	0.24	0.8	◪	30	0.18	0.6	◪	25	0.14	0.3
DNMG 110404E-SM:T9325	●	0.4	■	190	0.20	0.8	■	110	0.18	0.8	◪	180	0.20	0.8		–	–	–	◪	40	0.18	0.6		–	–	–
DNMG 110408E-SM:T6310	●	0.8	■	150	0.25	1.2	■	105	0.23	1.2	■	120	0.25	1.2	◪	450	0.30	1.2	■	45	0.20	1.0	◪	30	0.13	0.7
DNMG 110408E-SM:T7325	●	0.8	◪	170	0.25	1.2	■	130	0.23	1.2		–	–	–		–	–	–	■	55	0.20	1.0		–	–	–
DNMG 110408E-SM:T7335	●	0.8	◪	160	0.25	1.2	■	120	0.23	1.2		–	–	–		–	–	–	■	50	0.20	1.0		–	–	–
DNMG 110408E-SM:T8415	●	0.8	■	190	0.25	1.2	■	100	0.23	1.2	■	170	0.25	1.2	◪	480	0.30	1.2	■	40	0.20	1.0	◪	30	0.13	0.7
DNMG 110408E-SM:T8430	●●	0.8	■	170	0.25	1.2	■	90	0.23	1.2	◪	135	0.25	1.2	◪	465	0.30	1.2	◪	35	0.20	1.0	◪	25	0.13	0.7
DNMG 110408E-SM:T9325	●	0.8	■	200	0.25	1.2	■	120	0.23	1.2	◪	190	0.25	1.2		–	–	–	◪	45	0.20	1.0		–	–	–
DNMG 150404E-SM:T6310	●	0.4	■	130	0.20	1.7	■	90	0.18	1.7	■	100	0.20	1.7	◪	390	0.24	1.7	■	35	0.18	1.4	◪	25	0.14	0.3
DNMG 150404E-SM:T8415	●	0.4	■	165	0.20	1.7	■	85	0.18	1.7	■	150	0.20	1.7	◪	420	0.24	1.7	■	35	0.18	1.4	◪	25	0.14	0.3
DNMG 150408E-SM:T6310	●	0.8	■	140	0.25	1.7	■	100	0.23	1.7	■	110	0.25	1.7	◪	420	0.30	1.7	■	40	0.20	1.4	◪	25	0.13	0.7
DNMG 150408E-SM:T8415	●	0.8	■	185	0.25	1.7	■	95	0.23	1.7	■	165	0.25	1.7	◪	465	0.30	1.7	■	40	0.20	1.4	◪	30	0.13	0.7
DNMG 150604E-SM:T6310	●	0.4	■	130	0.20	1.7	■	90	0.18	1.7	■	100	0.20	1.7	◪	390	0.24	1.7	■	35	0.18	1.4	◪	25	0.14	0.3
DNMG 150604E-SM:T7325	●	0.4	◪	145	0.20	1.7	■	110	0.18	1.7		–	–	–		–	–	–	■	45	0.18	1.4		–	–	–
DNMG 150604E-SM:T7335	●	0.4	◪	140	0.20	1.7	■	105	0.18	1.7		–	–	–		–	–	–	■	45	0.18	1.4		–	–	–
DNMG 150604E-SM:T8415	●	0.4	■	165	0.20	1.7	■	85	0.18	1.7	■	150	0.20	1.7	◪	420	0.24	1.7	■	35	0.18	1.4	◪	25	0.14	0.3
DNMG 150604E-SM:T8430	●	0.4	■	145	0.20	1.7	■	80	0.18	1.7	◪	120	0.20	1.7	◪	405	0.24	1.7	◪	30	0.18	1.4	◪	25	0.14	0.3
DNMG 150604E-SM:T9325	●	0.4	■	180	0.20	1.7	■	105	0.18	1.7	◪	170	0.20	1.7		–	–	–	◪	40	0.18	1.4		–	–	–
DNMG 150604E-SM:T9415	●	0.4	■	225	0.20	1.7		–	–	–	◪	210	0.20	1.7		–	–	–		–	–	–	◪	45	0.14	0.3
DNMG 150608E-SM:T6310	●	0.8	■	140	0.25	1.7	■	100	0.23	1.7	■	110	0.25	1.7	◪	420	0.30	1.7	■	40	0.20	1.4	◪	25	0.13	0.7
DNMG 150608E-SM:T7325	●	0.8	◪	160	0.25	1.7	■	120	0.23	1.7		–	–	–		–	–	–	■	50	0.20	1.4		–	–	–
DNMG 150608E-SM:T7335	●	0.8	◪	155	0.25	1.7	■	120	0.23	1.7		–	–	–		–	–	–	■	50	0.20	1.4		–	–	–
DNMG 150608E-SM:T8415	●	0.8	■	185	0.25	1.7	■	95	0.23	1.7	■	165	0.25	1.7	◪	465	0.30	1.7	■	40	0.20	1.4	◪	30	0.13	0.7
DNMG 150608E-SM:T8430	●●	0.8	■	155	0.25	1.7	■	85	0.23	1.7	◪	130	0.25	1.7	◪	435	0.30	1.7	◪	30	0.20	1.4	◪	25	0.13	0.7
DNMG 150608E-SM:T9325	●	0.8	■	195	0.25	1.7	■	115	0.23	1.7	◪	185	0.25	1.7		–	–	–	◪	40	0.20	1.4		–	–	–
DNMG 150608E-SM:T9415	●	0.8	■	250	0.25	1.7		–	–	–	◪	235	0.25	1.7		–	–	–		–	–	–	◪	50	0.13	0.7
DNMG 150612E-SM:T6310	●●	1.2	■	145	0.30	1.7	■	100	0.27	1.7	■	115	0.30	1.7	◪	435	0.36	1.7	■	40	0.24	1.4	◪	25	0.15	0.9
DNMG 150612E-SM:T7325	●●	1.2	◪	160	0.30	1.7	■	120	0.27	1.7		–	–	–		–	–	–	■	50	0.24	1.4		–	–	–
DNMG 150612E-SM:T8415	●●	1.2	■	185	0.30	1.7	■	95	0.27	1.7	■	165	0.30	1.7	◪	465	0.36	1.7	■	40	0.24	1.4	◪	30	0.15	0.9
DNMG 150612E-SM:T8430	●●	1.2	■	155	0.30	1.7	■	85	0.27	1.7	◪	130	0.30	1.7	◪	435	0.36	1.7	◪	30	0.24	1.4	◪	25	0.15	0.9
DNMG 150612E-SM:T9415	●	1.2	■	245	0.30	1.7		–	–	–	◪	230	0.30	1.7		–	–	–		–	–	–	◪	45	0.15	0.9


SM talaş kırıcı çok yönlüdür ve Çeliklerin ve Süper alaşımların orta düzeyde işlenmesi için ilk tercihtir. Hafif pozitif eğim açısı ve dengeli, ılımlı T-land özelliğine sahiptir. Ayrıca Paslanmaz çelikler, Dökme demirler ve şartlara bağlı olarak Demir dışı alaşımlar ve Sert malzemeler için de uygundur.

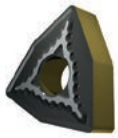
SNMG 120408E-SM:T6310	●●	0.8	■	185	0.25	1.8	■	130	0.23	1.8	■	145	0.25	1.8	◪	555	0.30	1.8	■	55	0.20	1.4	◪	35	0.13	0.7
SNMG 120408E-SM:T7325	●●	0.8	◪	210	0.25	1.8	■	160	0.23	1.8		–	–	–		–	–	–	■	65	0.20	1.4		–	–	–
SNMG 120408E-SM:T7335	●●	0.8	◪	205	0.25	1.8	■	155	0.23	1.8		–	–	–		–	–	–	■	65	0.20	1.4		–	–	–
SNMG 120408E-SM:T8415	●●	0.8	■	240	0.25	1.8	■	125	0.23	1.8	■	215	0.25	1.8	◪	600	0.30	1.8	■	55	0.20	1.4	◪	40	0.13	0.7
SNMG 120408E-SM:T8430	●●	0.8	■	205	0.25	1.8	■	110	0.23	1.8	◪	170	0.25	1.8	◪	570	0.30	1.8	◪	45	0.20	1.4	◪	35	0.13	0.7
SNMG 120408E-SM:T9325	●●	0.8	■	255	0.25	1.8	■	150	0.23	1.8	◪	240	0.25	1.8		–	–	–	◪	55	0.20	1.4		–	–	–
SNMG 120408E-SM:T9415	●●	0.8	■	325	0.25	1.8		–	–	–	◪	305	0.25	1.8		–	–	–		–	–	–	◪	65	0.13	0.7
SNMG 120412E-SM:T7325	●●	1.2	◪	210	0.30	1.8	■	160	0.27	1.8		–	–	–		–	–	–	■	65	0.24	1.4		–	–	–
SNMG 120412E-SM:T9415	●●	1.2	■	325	0.30	1.8		–	–	–	◪	305	0.30	1.8		–	–	–		–	–	–	◪	65	0.15	1.0
SNMG 190612E-SM:T6310	●●	1.2	■	175	0.30	4.0	■	125	0.27	4.0	■	140	0.30	4.0	◪	525	0.36	4.0	■	50	0.27	3.2	◪	35	0.15	1.0
SNMG 190612E-SM:T7325	●●	1.2	◪	195	0.30	4.0	■	150	0.27	4.0		–	–	–		–	–	–	■	60	0.27	3.2		–	–	–
SNMG 190612E-SM:T7335	●●	1.2	◪	185	0.30	4.0	■	140	0.27	4.0		–	–	–		–	–	–	■	60	0.27	3.2		–	–	–
SNMG 190612E-SM:T8415	●●	1.2	■	220	0.30	4.0	■	115	0.27	4.0	■	200	0.30	4.0	◪	555	0.36	4.0	■	50	0.27	3.2	◪	35	0.15	1.0
SNMG 190612E-SM:T9325	●●	1.2	■	230	0.30	4.0	■	135	0.27	4.0	◪	215	0.30	4.0		–	–	–	◪	50	0.27	3.2		–	–	–
SNMG 190616E-SM:T7335	●●	1.6	◪	175	0.40	4.0	■	135	0.36	4.0		–	–	–		–	–	–	■	55	0.32	3.2		–	–	–
SNMG 190616E-SM:T9325	●●	1.6	■	210	0.40	4.0	■	125	0.36	4.0	◪	195	0.40	4.0		–	–	–	◪	45	0.32	3.2		–	–	–

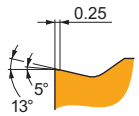
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE	P			M			K			N			S			H		
	(mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)
																			
SM talaş kırıcı çok yönlüdür ve Çeliklerin ve Süper alaşımların orta düzeyde işlenmesi için ilk tercihtir. Hafif pozitif eğim açısı ve dengeli, ılımlı T-land özelliğine sahiptir. Ayrıca Paslanmaz çelikler, Dökme demirler ve şartlara bağlı olarak Demir dışı alaşımlar ve Sert malzemeler için de uygundur.																			
TNMG 160404E-SM:T6310	0.4	135	0.20	1.7	95	0.18	1.7	105	0.20	1.7	405	0.24	1.7	40	0.18	1.4	25	0.14	0.3
TNMG 160404E-SM:T7325	0.4	155	0.20	1.7	120	0.18	1.7	–	–	–	–	–	–	50	0.18	1.4	–	–	–
TNMG 160404E-SM:T7335	0.4	150	0.20	1.7	115	0.18	1.7	–	–	–	–	–	–	45	0.18	1.4	–	–	–
TNMG 160404E-SM:T8415	0.4	170	0.20	1.7	90	0.18	1.7	155	0.20	1.7	435	0.24	1.7	35	0.18	1.4	30	0.14	0.3
TNMG 160404E-SM:T8430	0.4	155	0.20	1.7	85	0.18	1.7	130	0.20	1.7	435	0.24	1.7	30	0.18	1.4	25	0.14	0.3
TNMG 160404E-SM:T9325	0.4	190	0.20	1.7	110	0.18	1.7	180	0.20	1.7	–	–	–	40	0.18	1.4	–	–	–
TNMG 160404E-SM:T9415	0.4	240	0.20	1.7	–	–	–	225	0.20	1.7	–	–	–	–	–	–	45	0.14	0.3
TNMG 160408E-SM:T6310	0.8	150	0.25	1.7	105	0.23	1.7	120	0.25	1.7	450	0.30	1.7	45	0.20	1.4	30	0.13	0.7
TNMG 160408E-SM:T7325	0.8	170	0.25	1.7	130	0.23	1.7	–	–	–	–	–	–	55	0.20	1.4	–	–	–
TNMG 160408E-SM:T7335	0.8	165	0.25	1.7	125	0.23	1.7	–	–	–	–	–	–	50	0.20	1.4	–	–	–
TNMG 160408E-SM:T8415	0.8	195	0.25	1.7	100	0.23	1.7	180	0.25	1.7	495	0.30	1.7	45	0.20	1.4	30	0.13	0.7
TNMG 160408E-SM:T8430	0.8	170	0.25	1.7	90	0.23	1.7	135	0.25	1.7	465	0.30	1.7	35	0.20	1.4	25	0.13	0.7
TNMG 160408E-SM:T9325	0.8	205	0.25	1.7	120	0.23	1.7	190	0.25	1.7	–	–	–	45	0.20	1.4	–	–	–
TNMG 160408E-SM:T9415	0.8	265	0.25	1.7	–	–	–	250	0.25	1.7	–	–	–	–	–	–	50	0.13	0.7
TNMG 160412E-SM:T6310	1.2	155	0.30	1.7	110	0.27	1.7	125	0.30	1.7	465	0.36	1.7	45	0.24	1.4	30	0.15	0.9
TNMG 160412E-SM:T7325	1.2	170	0.30	1.7	130	0.27	1.7	–	–	–	–	–	–	55	0.24	1.4	–	–	–
TNMG 160412E-SM:T7335	1.2	165	0.30	1.7	125	0.27	1.7	–	–	–	–	–	–	50	0.24	1.4	–	–	–
TNMG 160412E-SM:T8415	1.2	195	0.30	1.7	100	0.27	1.7	180	0.30	1.7	495	0.36	1.7	45	0.24	1.4	30	0.15	0.9
TNMG 160412E-SM:T9325	1.2	205	0.30	1.7	120	0.27	1.7	190	0.30	1.7	–	–	–	45	0.24	1.4	–	–	–
TNMG 220404E-SM:T6310	0.4	135	0.20	1.7	95	0.18	1.7	105	0.20	1.7	405	0.24	1.7	40	0.18	1.4	25	0.14	0.3
TNMG 220404E-SM:T7325	0.4	155	0.20	1.7	120	0.18	1.7	–	–	–	–	–	–	50	0.18	1.4	–	–	–
TNMG 220404E-SM:T8415	0.4	170	0.20	1.7	90	0.18	1.7	155	0.20	1.7	435	0.24	1.7	35	0.18	1.4	30	0.14	0.3
TNMG 220404E-SM:T8430	0.4	155	0.20	1.7	85	0.18	1.7	130	0.20	1.7	435	0.24	1.7	30	0.18	1.4	25	0.14	0.3
TNMG 220404E-SM:T9325	0.4	190	0.20	1.7	110	0.18	1.7	180	0.20	1.7	–	–	–	40	0.18	1.4	–	–	–
TNMG 220408E-SM:T6310	0.8	150	0.25	1.7	105	0.23	1.7	120	0.25	1.7	450	0.30	1.7	45	0.20	1.4	30	0.13	0.7
TNMG 220408E-SM:T7325	0.8	170	0.25	1.7	130	0.23	1.7	–	–	–	–	–	–	55	0.20	1.4	–	–	–
TNMG 220408E-SM:T7335	0.8	165	0.25	1.7	125	0.23	1.7	–	–	–	–	–	–	50	0.20	1.4	–	–	–
TNMG 220408E-SM:T8415	0.8	195	0.25	1.7	100	0.23	1.7	180	0.25	1.7	495	0.30	1.7	45	0.20	1.4	30	0.13	0.7
TNMG 220408E-SM:T8430	0.8	170	0.25	1.7	90	0.23	1.7	135	0.25	1.7	465	0.30	1.7	35	0.20	1.4	25	0.13	0.7
TNMG 220408E-SM:T9325	0.8	205	0.25	1.7	120	0.23	1.7	190	0.25	1.7	–	–	–	45	0.20	1.4	–	–	–
TNMG 220408E-SM:T9415	0.8	265	0.25	1.7	–	–	–	250	0.25	1.7	–	–	–	–	–	–	50	0.13	0.7
TNMG 220412E-SM:T6310	1.2	155	0.30	1.7	110	0.27	1.7	125	0.30	1.7	465	0.36	1.7	45	0.24	1.4	30	0.15	0.9
TNMG 220412E-SM:T7325	1.2	170	0.30	1.7	130	0.27	1.7	–	–	–	–	–	–	55	0.24	1.4	–	–	–
TNMG 220412E-SM:T7335	1.2	165	0.30	1.7	125	0.27	1.7	–	–	–	–	–	–	50	0.24	1.4	–	–	–
TNMG 220412E-SM:T8415	1.2	195	0.30	1.7	100	0.27	1.7	180	0.30	1.7	495	0.36	1.7	45	0.24	1.4	30	0.15	0.9
TNMG 220412E-SM:T9325	1.2	205	0.30	1.7	120	0.27	1.7	190	0.30	1.7	–	–	–	45	0.24	1.4	–	–	–
TNMG 220412E-SM:T9415	1.2	260	0.30	1.7	–	–	–	245	0.30	1.7	–	–	–	–	–	–	50	0.15	0.9
																			
SM talaş kırıcı çok yönlüdür ve Çeliklerin ve Süper alaşımların orta düzeyde işlenmesi için ilk tercihtir. Hafif pozitif eğim açısı ve dengeli, ılımlı T-land özelliğine sahiptir. Ayrıca Paslanmaz çelikler, Dökme demirler ve şartlara bağlı olarak Demir dışı alaşımlar ve Sert malzemeler için de uygundur.																			
VNMG 160404E-SM:T6310	0.4	120	0.18	1.2	85	0.16	1.2	95	0.18	1.2	360	0.22	1.2	35	0.16	1.0	20	0.13	0.3
VNMG 160404E-SM:T7325	0.4	135	0.18	1.2	105	0.16	1.2	–	–	–	–	–	–	40	0.16	1.0	–	–	–
VNMG 160404E-SM:T8415	0.4	155	0.18	1.2	80	0.16	1.2	140	0.18	1.2	390	0.22	1.2	35	0.16	1.0	25	0.13	0.3
VNMG 160404E-SM:T8430	0.4	135	0.18	1.2	75	0.16	1.2	110	0.18	1.2	375	0.22	1.2	25	0.16	1.0	20	0.13	0.3
VNMG 160404E-SM:T9325	0.4	170	0.18	1.2	100	0.16	1.2	160	0.18	1.2	–	–	–	35	0.16	1.0	–	–	–
VNMG 160404E-SM:T9415	0.4	210	0.18	1.2	–	–	–	195	0.18	1.2	–	–	–	–	–	–	40	0.13	0.3
VNMG 160408E-SM:T6310	0.8	125	0.25	1.4	90	0.23	1.4	100	0.25	1.4	375	0.30	1.4	35	0.20	1.1	25	0.13	0.7
VNMG 160408E-SM:T7325	0.8	145	0.25	1.4	110	0.23	1.4	–	–	–	–	–	–	45	0.20	1.1	–	–	–
VNMG 160408E-SM:T8415	0.8	160	0.25	1.4	85	0.23	1.4	145	0.25	1.4	405	0.30	1.4	35	0.20	1.1	25	0.13	0.7
VNMG 160408E-SM:T8430	0.8	140	0.25	1.4	75	0.23	1.4	115	0.25	1.4	390	0.30	1.4	30	0.20	1.1	20	0.13	0.7
VNMG 160408E-SM:T9325	0.8	170	0.25	1.4	100	0.23	1.4	160	0.25	1.4	–	–	–	35	0.20	1.1	–	–	–

Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P			M			K			N			S			H		
			vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)

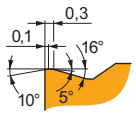




SM talaş kırıcı çok yönlüdür ve Çeliklerin ve Süper alaşımların orta düzeyde işlenmesi için ilk tercihtir. Hafif pozitif eğim açısı ve dengeli, ılımlı T-land özelliğine sahiptir. Ayrıca Paslanmaz çelikler, Dökme demirler ve şartlara bağlı olarak Demir dışı alaşımlar ve Sert malzemeler için de uygundur.

WNMG 060404E-SM:T7335	●	0.4	◪	180	0.20	1.7	■	140	0.18	1.7		–	–	–		–	–	–	■	55	0.18	1.4		–	–	–
WNMG 060404E-SM:T8430	●	0.4	■	185	0.20	1.7	■	100	0.18	1.7	◪	150	0.20	1.7	◪	510	0.24	1.7	◪	40	0.18	1.4	◪	30	0.13	0.3
WNMG 060404E-SM:T9325	●	0.4	■	225	0.20	1.7	■	135	0.18	1.7	◪	210	0.20	1.7		–	–	–	◪	50	0.18	1.4		–	–	–
WNMG 060408E-SM:T6310	⁂	0.8	■	175	0.25	1.7	■	125	0.23	1.7	■	140	0.25	1.7	◪	525	0.30	1.7	■	50	0.20	1.4	◪	35	0.13	0.7
WNMG 060408E-SM:T7325	⁂	0.8	◪	200	0.25	1.7	■	155	0.23	1.7		–	–	–		–	–	–	■	65	0.20	1.4		–	–	–
WNMG 060408E-SM:T7335	⁂	0.8	◪	195	0.25	1.7	■	150	0.23	1.7		–	–	–		–	–	–	■	60	0.20	1.4		–	–	–
WNMG 060408E-SM:T8415	⁂	0.8	■	225	0.25	1.7	■	115	0.23	1.7	■	205	0.25	1.7	◪	570	0.30	1.7	■	50	0.20	1.4	◪	35	0.13	0.7
WNMG 060408E-SM:T8430	⁂	0.8	■	195	0.25	1.7	■	105	0.23	1.7	◪	160	0.25	1.7	◪	540	0.30	1.7	◪	40	0.20	1.4	◪	30	0.13	0.7
WNMG 060408E-SM:T9325	⁂	0.8	■	240	0.25	1.7	■	140	0.23	1.7	◪	225	0.25	1.7		–	–	–	◪	50	0.20	1.4		–	–	–
WNMG 060412E-SM:T7325	⁂	1.2	◪	200	0.30	1.7	■	155	0.27	1.7		–	–	–		–	–	–	■	65	0.24	1.4		–	–	–
WNMG 060412E-SM:T8430	⁂	1.2	■	195	0.30	1.7	■	105	0.27	1.7	◪	160	0.30	1.7	◪	540	0.36	1.7	◪	40	0.24	1.4	◪	30	0.15	1.0
WNMG 060412E-SM:T9325	⁂	1.2	■	240	0.30	1.7	■	140	0.27	1.7	◪	225	0.30	1.7		–	–	–	◪	50	0.24	1.4		–	–	–
WNMG 080404E-SM:T6310	●	0.4	■	155	0.20	2.0	■	110	0.18	2.0	■	125	0.20	2.0	◪	465	0.24	2.0	■	45	0.18	1.6	◪	30	0.13	0.3
WNMG 080404E-SM:T7325	●	0.4	◪	180	0.20	2.0	■	140	0.18	2.0		–	–	–		–	–	–	■	55	0.18	1.6		–	–	–
WNMG 080404E-SM:T7335	●	0.4	◪	175	0.20	2.0	■	135	0.18	2.0		–	–	–		–	–	–	■	55	0.18	1.6		–	–	–
WNMG 080404E-SM:T8415	●	0.4	■	200	0.20	2.0	■	105	0.18	2.0	■	185	0.20	2.0	◪	510	0.24	2.0	■	45	0.18	1.6	◪	35	0.13	0.3
WNMG 080404E-SM:T8430	●	0.4	■	180	0.20	2.0	■	95	0.18	2.0	◪	145	0.20	2.0	◪	495	0.24	2.0	◪	35	0.18	1.6	◪	30	0.13	0.3
WNMG 080404E-SM:T9325	●	0.4	■	220	0.20	2.0	■	130	0.18	2.0	◪	205	0.20	2.0		–	–	–	◪	45	0.18	1.6		–	–	–
WNMG 080404E-SM:T9415	●	0.4	■	280	0.20	2.0		–	–	–	◪	265	0.20	2.0		–	–	–		–	–	–	◪	55	0.13	0.3
WNMG 080408E-SM:T6310	⁂	0.8	■	175	0.25	2.0	■	125	0.23	2.0	■	140	0.25	2.0	◪	525	0.30	2.0	■	50	0.20	1.6	◪	35	0.13	0.7
WNMG 080408E-SM:T7325	⁂	0.8	◪	200	0.25	2.0	■	155	0.23	2.0		–	–	–		–	–	–	■	65	0.20	1.6		–	–	–
WNMG 080408E-SM:T7335	⁂	0.8	◪	190	0.25	2.0	■	145	0.23	2.0		–	–	–		–	–	–	■	60	0.20	1.6		–	–	–
WNMG 080408E-SM:T8415	⁂	0.8	■	225	0.25	2.0	■	115	0.23	2.0	■	205	0.25	2.0	◪	570	0.30	2.0	■	50	0.20	1.6	◪	35	0.13	0.7
WNMG 080408E-SM:T8430	⁂	0.8	■	195	0.25	2.0	■	105	0.23	2.0	◪	160	0.25	2.0	◪	540	0.30	2.0	◪	40	0.20	1.6	◪	30	0.13	0.7
WNMG 080408E-SM:T9325	⁂	0.8	■	235	0.25	2.0	■	140	0.23	2.0	◪	220	0.25	2.0		–	–	–	◪	50	0.20	1.6		–	–	–
WNMG 080408E-SM:T9415	⁂	0.8	■	305	0.25	2.0		–	–	–	◪	285	0.25	2.0		–	–	–		–	–	–	◪	60	0.13	0.7
WNMG 080412E-SM:T6310	⁂	1.2	■	175	0.30	2.0	■	125	0.27	2.0	■	140	0.30	2.0	◪	525	0.36	2.0	■	50	0.24	1.6	◪	35	0.15	1.0
WNMG 080412E-SM:T7325	⁂	1.2	◪	195	0.30	2.0	■	150	0.27	2.0		–	–	–		–	–	–	■	60	0.24	1.6		–	–	–
WNMG 080412E-SM:T7335	⁂	1.2	◪	190	0.30	2.0	■	145	0.27	2.0		–	–	–		–	–	–	■	60	0.24	1.6		–	–	–
WNMG 080412E-SM:T8415	⁂	1.2	■	225	0.30	2.0	■	115	0.27	2.0	■	205	0.30	2.0	◪	570	0.36	2.0	■	50	0.24	1.6	◪	35	0.15	1.0
WNMG 080412E-SM:T8430	⁂	1.2	■	190	0.30	2.0	■	105	0.27	2.0	◪	155	0.30	2.0	◪	525	0.36	2.0	◪	40	0.24	1.6	◪	30	0.15	1.0
WNMG 080412E-SM:T9325	⁂	1.2	■	235	0.30	2.0	■	140	0.27	2.0	◪	220	0.30	2.0		–	–	–	◪	50	0.24	1.6		–	–	–
WNMG 080412E-SM:T9415	⁂	1.2	■	300	0.30	2.0		–	–	–	◪	285	0.30	2.0		–	–	–		–	–	–	◪	60	0.15	1.0

M

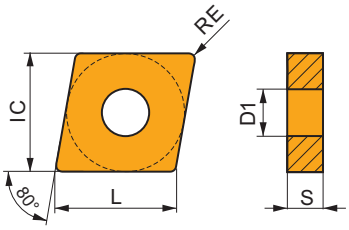


M talaş kırıcı çok yönlüdür ve Dökme demirlerin orta düzeyde işlenmesi için ilk tercihtir. Pozitif eğim açısı ve negatif/kararlı, ılımlı T-land özelliklerine sahiptir. Çelikler için ve şartlı olarak Sert malzemeler için de uygundur.

PRAMET

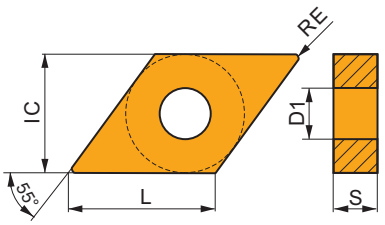
CNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0903	9.525	3.81	9.70	3.18
1204	12.700	5.16	12.90	4.76
1606	15.875	6.35	16.10	6.35
1906	19.050	7.94	19.30	6.35



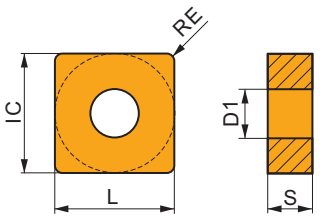
DNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1104	9.525	3.81	11.60	4.76
1504	12.700	5.16	15.50	4.76
1506	12.700	5.16	15.50	6.35



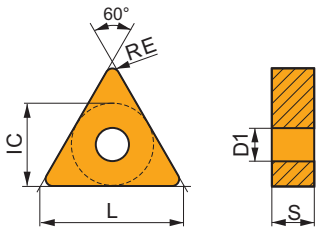
SNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76
1506	15.875	6.35	15.88	6.35
1906	19.050	7.94	19.05	6.35



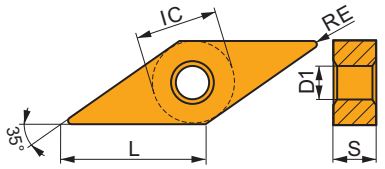
TNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76
2204	12.700	5.16	22.00	4.76



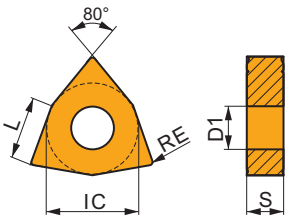
VNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.60	4.76



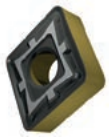
WNMG

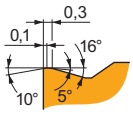
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0604	9.525	3.81	6.50	4.76
0804	12.700	5.16	8.70	4.76



Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P			M			K			N			S			H		
			vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)
		(mm)																		

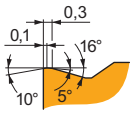




M talaş kırıcı çok yönlüdür ve Dökme demirlerin orta düzeyde işlenmesi için ilk tercihtir. Pozitif eğim açısı ve negatif/kararlı, ılımlı T-land özelliklerine sahiptir. Çelikler için ve şartlı olarak Sert malzemeler için de uygundur.

Product		RE	P			M			K			N			S			H		
CNMG 090308E-M:T9325	⬢	0.8	■	205	0.32	1.8	–	–	–	◪	190	0.32	1.8	–	–	–	–	–	–		–	–	–
CNMG 090308E-M:T9335	⬢	0.8	■	180	0.32	1.8	–	–	–		–	–	–	–	–	–	–	–	–		–	–	–
CNMG 090308E-M:T9415	●	0.8	■	275	0.32	1.8	–	–	–	◪	260	0.32	1.8	–	–	–	–	–	–	◪	55	0.16	0.5
CNMG 120404E-M:T5315	●	0.4	◪	245	0.20	2.1	–	–	–	■	230	0.20	2.1	–	–	–	–	–	–	◪	45	0.13	0.3
CNMG 120404E-M:T9325	●	0.4	■	210	0.20	2.1	–	–	–	◪	195	0.20	2.1	–	–	–	–	–	–		–	–	–
CNMG 120404E-M:T9335	⬢	0.4	■	180	0.20	2.1	–	–	–		–	–	–	–	–	–	–	–	–		–	–	–
CNMG 120404E-M:T9415	⬢	0.4	■	265	0.20	2.1	–	–	–	◪	250	0.20	2.1	–	–	–	–	–	–	◪	50	0.13	0.3
CNMG 120408E-M:6640	⬢	0.8	■	165	0.32	2.1	–	–	–	■	155	0.32	2.1	–	–	–	–	–	–		–	–	–
CNMG 120408E-M:T5305	⬢	0.8	◪	280	0.32	2.1	–	–	–	■	265	0.32	2.1	–	–	–	–	–	–	◪	55	0.16	0.7
CNMG 120408E-M:T5315	⬢	0.8	◪	250	0.32	2.1	–	–	–	■	235	0.32	2.1	–	–	–	–	–	–	◪	50	0.16	0.7
CNMG 120408E-M:T8430	⬢	0.8	■	170	0.32	2.1	–	–	–	◪	135	0.32	2.1	–	–	–	–	–	–	◪	25	0.16	0.7
CNMG 120408E-M:T9310	⬢	0.8	■	245	0.32	2.1	–	–	–	◪	230	0.32	2.1	–	–	–	–	–	–	◪	45	0.16	0.7
CNMG 120408E-M:T9315	⬢	0.8	■	225	0.32	2.1	–	–	–	◪	210	0.32	2.1	–	–	–	–	–	–	◪	45	0.16	0.7
CNMG 120408E-M:T9325	⬢	0.8	■	200	0.32	2.1	–	–	–	◪	190	0.32	2.1	–	–	–	–	–	–		–	–	–
CNMG 120408E-M:T9335	⬢	0.8	■	180	0.32	2.1	–	–	–		–	–	–	–	–	–	–	–	–		–	–	–
CNMG 120408E-M:T9415	⬢	0.8	■	270	0.32	2.1	–	–	–	◪	255	0.32	2.1	–	–	–	–	–	–	◪	50	0.16	0.7
CNMG 120412E-M:T5305	⬢	1.2	◪	275	0.40	2.1	–	–	–	■	260	0.40	2.1	–	–	–	–	–	–	◪	55	0.20	1.0
CNMG 120412E-M:T5315	⬢	1.2	◪	245	0.40	2.1	–	–	–	■	230	0.40	2.1	–	–	–	–	–	–	◪	45	0.20	1.0
CNMG 120412E-M:T9315	⬢	1.2	■	220	0.40	2.1	–	–	–	◪	205	0.40	2.1	–	–	–	–	–	–	◪	40	0.20	1.0
CNMG 120412E-M:T9325	⬢	1.2	■	195	0.40	2.1	–	–	–	◪	185	0.40	2.1	–	–	–	–	–	–		–	–	–
CNMG 120412E-M:T9335	⬢	1.2	■	170	0.40	2.1	–	–	–		–	–	–	–	–	–	–	–	–		–	–	–
CNMG 120412E-M:T9415	⬢	1.2	■	265	0.40	2.1	–	–	–	◪	250	0.40	2.1	–	–	–	–	–	–	◪	50	0.20	1.0
CNMG 120416E-M:T9325	⬢	1.6	■	200	0.40	2.1	–	–	–	◪	190	0.40	2.1	–	–	–	–	–	–		–	–	–
CNMG 120416E-M:T9335	⬢	1.6	■	175	0.40	2.1	–	–	–		–	–	–	–	–	–	–	–	–		–	–	–
CNMG 160608E-M:T9310	⬢	0.8	■	235	0.32	3.6	–	–	–	◪	220	0.32	3.6	–	–	–	–	–	–	◪	45	0.16	0.7
CNMG 160608E-M:T9325	⬢	0.8	■	190	0.32	3.6	–	–	–	◪	180	0.32	3.6	–	–	–	–	–	–		–	–	–
CNMG 160608E-M:T9335	⬢	0.8	■	170	0.32	3.6	–	–	–		–	–	–	–	–	–	–	–	–		–	–	–
CNMG 160608E-M:T9415	⬢	0.8	■	255	0.32	3.6	–	–	–	◪	240	0.32	3.6	–	–	–	–	–	–	◪	50	0.16	0.7
CNMG 160612E-M:T9325	⬢	1.2	■	185	0.40	3.6	–	–	–	◪	175	0.40	3.6	–	–	–	–	–	–		–	–	–
CNMG 160612E-M:T9335	⬢	1.2	■	160	0.40	3.6	–	–	–		–	–	–	–	–	–	–	–	–		–	–	–
CNMG 160612E-M:T9415	⬢	1.2	■	250	0.40	3.6	–	–	–	◪	235	0.40	3.6	–	–	–	–	–	–	◪	50	0.20	1.0
CNMG 160616E-M:T9325	⬢	1.6	■	190	0.40	3.6	–	–	–	◪	180	0.40	3.6	–	–	–	–	–	–		–	–	–
CNMG 160616E-M:T9335	⬢	1.6	■	165	0.40	3.6	–	–	–		–	–	–	–	–	–	–	–	–		–	–	–
CNMG 190608E-M:6630	⬢	0.8	■	175	0.32	4.2	–	–	–	◪	165	0.32	4.2	–	–	–	–	–	–		–	–	–
CNMG 190608E-M:T9325	⬢	0.8	■	190	0.32	4.2	–	–	–	◪	180	0.32	4.2	–	–	–	–	–	–		–	–	–
CNMG 190608E-M:T9335	⬢	0.8	■	165	0.32	4.2	–	–	–		–	–	–	–	–	–	–	–	–		–	–	–
CNMG 190608E-M:T9415	⬢	0.8	■	250	0.32	4.2	–	–	–	◪	235	0.32	4.2	–	–	–	–	–	–	◪	50	0.16	0.7
CNMG 190612E-M:6630	⬢	1.2	■	170	0.40	4.2	–	–	–	◪	160	0.40	4.2	–	–	–	–	–	–		–	–	–
CNMG 190612E-M:6640	⬢	1.2	■	145	0.40	4.2	–	–	–	■	135	0.40	4.2	–	–	–	–	–	–		–	–	–
CNMG 190612E-M:T9325	●	1.2	■	185	0.40	4.2	–	–	–	◪	175	0.40	4.2	–	–	–	–	–	–		–	–	–
CNMG 190612E-M:T9335	●	1.2	■	160	0.40	4.2	–	–	–		–	–	–	–	–	–	–	–	–		–	–	–
CNMG 190612E-M:T9415	●	1.2	■	245	0.40	4.2	–	–	–	◪	230	0.40	4.2	–	–	–	–	–	–	◪	45	0.20	1.0
CNMG 190616E-M:T9325	●	1.6	■	190	0.40	4.2	–	–	–	◪	180	0.40	4.2	–	–	–	–	–	–		–	–	–
CNMG 190616E-M:T9335	●	1.6	■	165	0.40	4.2	–	–	–		–	–	–	–	–	–	–	–	–		–	–	–
CNMG 190616E-M:T9415	●	1.6	■	255	0.40	4.2	–	–	–	◪	240	0.40	4.2	–	–	–	–	–	–	◪	50	0.20	1.3

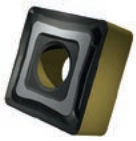
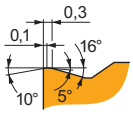
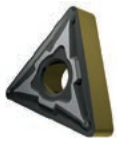
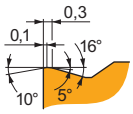
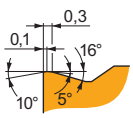
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
																				

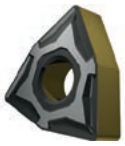
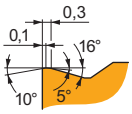
M talaş kırıcı çok yönlüdür ve Dökme demirlerin orta düzeyde işlenmesi için ilk tercihtir. Pozitif eğim açısı ve negatif/kararlı, ılımlı T-land özelliklerine sahiptir. Çelikler için ve şartlı olarak Sert malzemeler için de uygundur.

DNMG 110404E-M:T5315	●	0.4	210	0.20	1.2	–	–	–	195	0.20	1.2	–	–	–	–	–	–	40	0.14	0.3
DNMG 110404E-M:T9325	●	0.4	175	0.20	1.2	–	–	–	165	0.20	1.2	–	–	–	–	–	–	–	–	–
DNMG 110404E-M:T9335	●	0.4	150	0.20	1.2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG 110404E-M:T9415	●	0.4	225	0.20	1.2	–	–	–	210	0.20	1.2	–	–	–	–	–	–	45	0.14	0.3
DNMG 110408E-M:T5315	●	0.8	215	0.30	1.2	–	–	–	200	0.30	1.2	–	–	–	–	–	–	40	0.15	0.7
DNMG 110408E-M:T9325	●	0.8	175	0.30	1.2	–	–	–	165	0.30	1.2	–	–	–	–	–	–	–	–	–
DNMG 110408E-M:T9335	●	0.8	155	0.30	1.2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG 110408E-M:T9415	●	0.8	235	0.30	1.2	–	–	–	220	0.30	1.2	–	–	–	–	–	–	45	0.15	0.7
DNMG 110412E-M:T9325	●	1.2	165	0.40	1.2	–	–	–	155	0.40	1.2	–	–	–	–	–	–	–	–	–
DNMG 110412E-M:T9415	●	1.2	220	0.40	1.2	–	–	–	205	0.40	1.2	–	–	–	–	–	–	40	0.20	0.9
DNMG 150404E-M:T5315	●	0.4	200	0.20	1.9	–	–	–	190	0.20	1.9	–	–	–	–	–	–	40	0.14	0.3
DNMG 150404E-M:T9325	●	0.4	170	0.20	1.9	–	–	–	160	0.20	1.9	–	–	–	–	–	–	–	–	–
DNMG 150404E-M:T9415	●	0.4	210	0.20	1.9	–	–	–	195	0.20	1.9	–	–	–	–	–	–	40	0.14	0.3
DNMG 150408E-M:T5315	●	0.8	205	0.30	1.9	–	–	–	190	0.30	1.9	–	–	–	–	–	–	40	0.15	0.7
DNMG 150408E-M:T9315	●	0.8	190	0.30	1.9	–	–	–	180	0.30	1.9	–	–	–	–	–	–	35	0.15	0.7
DNMG 150408E-M:T9325	●	0.8	170	0.30	1.9	–	–	–	160	0.30	1.9	–	–	–	–	–	–	–	–	–
DNMG 150408E-M:T9335	●	0.8	145	0.30	1.9	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG 150408E-M:T9415	●	0.8	220	0.30	1.9	–	–	–	205	0.30	1.9	–	–	–	–	–	–	40	0.15	0.7
DNMG 150412E-M:T5315	●	1.2	200	0.40	1.9	–	–	–	190	0.40	1.9	–	–	–	–	–	–	40	0.20	0.9
DNMG 150412E-M:T9315	●	1.2	175	0.40	1.9	–	–	–	165	0.40	1.9	–	–	–	–	–	–	35	0.20	0.9
DNMG 150412E-M:T9325	●	1.2	160	0.40	1.9	–	–	–	150	0.40	1.9	–	–	–	–	–	–	–	–	–
DNMG 150412E-M:T9415	●	1.2	210	0.40	1.9	–	–	–	195	0.40	1.9	–	–	–	–	–	–	40	0.20	0.9
DNMG 150604E-M:T5315	●	0.4	200	0.20	1.9	–	–	–	190	0.20	1.9	–	–	–	–	–	–	40	0.14	0.3
DNMG 150604E-M:T9325	●	0.4	170	0.20	1.9	–	–	–	160	0.20	1.9	–	–	–	–	–	–	–	–	–
DNMG 150604E-M:T9335	●	0.4	145	0.20	1.9	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG 150604E-M:T9415	●	0.4	210	0.20	1.9	–	–	–	195	0.20	1.9	–	–	–	–	–	–	40	0.14	0.3
DNMG 150608E-M:T5315	●	0.8	205	0.30	1.9	–	–	–	190	0.30	1.9	–	–	–	–	–	–	40	0.15	0.7
DNMG 150608E-M:T9310	●	0.8	205	0.30	1.9	–	–	–	190	0.30	1.9	–	–	–	–	–	–	40	0.15	0.7
DNMG 150608E-M:T9315	●	0.8	190	0.30	1.9	–	–	–	180	0.30	1.9	–	–	–	–	–	–	35	0.15	0.7
DNMG 150608E-M:T9325	●	0.8	170	0.30	1.9	–	–	–	160	0.30	1.9	–	–	–	–	–	–	–	–	–
DNMG 150608E-M:T9335	●	0.8	145	0.30	1.9	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG 150608E-M:T9415	●	0.8	220	0.30	1.9	–	–	–	205	0.30	1.9	–	–	–	–	–	–	40	0.15	0.7
DNMG 150612E-M:T5315	●	1.2	200	0.40	1.9	–	–	–	190	0.40	1.9	–	–	–	–	–	–	40	0.20	0.9
DNMG 150612E-M:T9310	●	1.2	190	0.40	1.9	–	–	–	180	0.40	1.9	–	–	–	–	–	–	35	0.20	0.9
DNMG 150612E-M:T9315	●	1.2	175	0.40	1.9	–	–	–	165	0.40	1.9	–	–	–	–	–	–	35	0.20	0.9
DNMG 150612E-M:T9325	●	1.2	160	0.40	1.9	–	–	–	150	0.40	1.9	–	–	–	–	–	–	–	–	–
DNMG 150612E-M:T9335	●	1.2	140	0.40	1.9	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG 150612E-M:T9415	●	1.2	210	0.40	1.9	–	–	–	195	0.40	1.9	–	–	–	–	–	–	40	0.20	0.9

Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

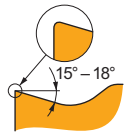
Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
M talaş kırıcı çok yönlüdür ve Dökme demirlerin orta düzeyde işlenmesi için ilk tercihtir. Pozitif eğim açısı ve negatif/kararlı, ılımlı T-land özelliklerine sahiptir. Çelikler için ve şartlı olarak Sert malzemeler için de uygundur.																			
SNMG 120408E-M:T5305	0.8	290	0.32	2.1	–	–	–	275	0.32	2.1	–	–	–	–	–	–	55	0.16	0.7
SNMG 120408E-M:T5315	0.8	260	0.32	2.1	–	–	–	245	0.32	2.1	–	–	–	–	–	–	50	0.16	0.7
SNMG 120408E-M:T9325	0.8	210	0.32	2.1	–	–	–	195	0.32	2.1	–	–	–	–	–	–	–	–	–
SNMG 120408E-M:T9335	0.8	185	0.32	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG 120408E-M:T9415	0.8	280	0.32	2.1	–	–	–	265	0.32	2.1	–	–	–	–	–	–	55	0.16	0.7
SNMG 120412E-M:T9325	1.2	200	0.40	2.1	–	–	–	190	0.40	2.1	–	–	–	–	–	–	–	–	–
SNMG 120412E-M:T9335	1.2	175	0.40	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG 120412E-M:T9415	1.2	275	0.40	2.1	–	–	–	260	0.40	2.1	–	–	–	–	–	–	55	0.20	1.0
SNMG 120416E-M:T9325	1.6	210	0.40	2.1	–	–	–	195	0.40	2.1	–	–	–	–	–	–	–	–	–
SNMG 150612E-M:T9325	1.2	195	0.40	3.4	–	–	–	185	0.40	3.4	–	–	–	–	–	–	–	–	–
SNMG 150612E-M:T9335	1.2	170	0.40	3.4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG 150612E-M:T9415	1.2	260	0.40	3.4	–	–	–	245	0.40	3.4	–	–	–	–	–	–	50	0.20	1.0
SNMG 190612E-M:6630	1.2	175	0.40	4.0	–	–	–	165	0.40	4.0	–	–	–	–	–	–	–	–	–
SNMG 190612E-M:T9325	1.2	190	0.40	4.0	–	–	–	180	0.40	4.0	–	–	–	–	–	–	–	–	–
SNMG 190612E-M:T9335	1.2	165	0.40	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG 190612E-M:T9415	1.2	255	0.40	4.0	–	–	–	240	0.40	4.0	–	–	–	–	–	–	50	0.20	1.0
SNMG 190616E-M:T9325	1.6	200	0.40	4.0	–	–	–	190	0.40	4.0	–	–	–	–	–	–	–	–	–
SNMG 190616E-M:T9335	1.6	175	0.40	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG 190616E-M:T9415	1.6	270	0.40	4.0	–	–	–	255	0.40	4.0	–	–	–	–	–	–	50	0.20	1.3
 																			
M talaş kırıcı çok yönlüdür ve Dökme demirlerin orta düzeyde işlenmesi için ilk tercihtir. Pozitif eğim açısı ve negatif/kararlı, ılımlı T-land özelliklerine sahiptir. Çelikler için ve şartlı olarak Sert malzemeler için de uygundur.																			
TNMG 160404E-M:T5315	0.4	215	0.20	1.6	–	–	–	200	0.20	1.6	–	–	–	–	–	–	40	0.14	0.3
TNMG 160404E-M:T9325	0.4	180	0.20	1.6	–	–	–	170	0.20	1.6	–	–	–	–	–	–	–	–	–
TNMG 160404E-M:T9335	0.4	155	0.20	1.6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG 160404E-M:T9415	0.4	230	0.20	1.6	–	–	–	215	0.20	1.6	–	–	–	–	–	–	45	0.14	0.3
TNMG 160408E-M:T5305	0.8	250	0.30	1.6	–	–	–	235	0.30	1.6	–	–	–	–	–	–	50	0.15	0.7
TNMG 160408E-M:T5315	0.8	225	0.30	1.6	–	–	–	210	0.30	1.6	–	–	–	–	–	–	45	0.15	0.7
TNMG 160408E-M:T9310	0.8	220	0.30	1.6	–	–	–	205	0.30	1.6	–	–	–	–	–	–	40	0.15	0.7
TNMG 160408E-M:T9325	0.8	185	0.30	1.6	–	–	–	175	0.30	1.6	–	–	–	–	–	–	–	–	–
TNMG 160408E-M:T9335	0.8	160	0.30	1.6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG 160408E-M:T9415	0.8	240	0.30	1.6	–	–	–	225	0.30	1.6	–	–	–	–	–	–	45	0.15	0.7
TNMG 160412E-M:T5315	1.2	215	0.40	1.6	–	–	–	200	0.40	1.6	–	–	–	–	–	–	40	0.20	0.9
TNMG 160412E-M:T9325	1.2	170	0.40	1.6	–	–	–	160	0.40	1.6	–	–	–	–	–	–	–	–	–
TNMG 160412E-M:T9335	1.2	145	0.40	1.6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG 160412E-M:T9415	1.2	225	0.40	1.6	–	–	–	210	0.40	1.6	–	–	–	–	–	–	45	0.20	0.9
TNMG 220408E-M:T5315	0.8	215	0.30	2.1	–	–	–	200	0.30	2.1	–	–	–	–	–	–	40	0.15	0.7
TNMG 220408E-M:T9325	0.8	180	0.30	2.1	–	–	–	170	0.30	2.1	–	–	–	–	–	–	–	–	–
TNMG 220408E-M:T9335	0.8	155	0.30	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG 220408E-M:T9415	0.8	230	0.30	2.1	–	–	–	215	0.30	2.1	–	–	–	–	–	–	45	0.15	0.7
TNMG 220412E-M:T5315	1.2	205	0.40	2.1	–	–	–	190	0.40	2.1	–	–	–	–	–	–	40	0.20	0.9
TNMG 220412E-M:T9325	1.2	165	0.40	2.1	–	–	–	155	0.40	2.1	–	–	–	–	–	–	–	–	–
TNMG 220412E-M:T9335	1.2	140	0.40	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG 220412E-M:T9415	1.2	225	0.40	2.1	–	–	–	210	0.40	2.1	–	–	–	–	–	–	45	0.20	0.9
 																			
M talaş kırıcı çok yönlüdür ve Dökme demirlerin orta düzeyde işlenmesi için ilk tercihtir. Pozitif eğim açısı ve negatif/kararlı, ılımlı T-land özelliklerine sahiptir. Çelikler için ve şartlı olarak Sert malzemeler için de uygundur.																			
VNMG 160404E-M:T5315	0.4	180	0.20	1.2	–	–	–	170	0.20	1.2	–	–	–	–	–	–	35	0.14	0.3
VNMG 160404E-M:T9325	0.4	155	0.20	1.2	–	–	–	145	0.20	1.2	–	–	–	–	–	–	–	–	–
VNMG 160404E-M:T9415	0.4	195	0.20	1.2	–	–	–	185	0.20	1.2	–	–	–	–	–	–	35	0.14	0.3
VNMG 160408E-M:T5305	0.8	205	0.30	1.4	–	–	–	190	0.30	1.4	–	–	–	–	–	–	40	0.15	0.7
VNMG 160408E-M:T5315	0.8	185	0.30	1.4	–	–	–	175	0.30	1.4	–	–	–	–	–	–	35	0.15	0.7
VNMG 160408E-M:T9325	0.8	150	0.30	1.4	–	–	–	140	0.30	1.4	–	–	–	–	–	–	–	–	–
VNMG 160408E-M:T9335	0.8	130	0.30	1.4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
VNMG 160408E-M:T9415	0.8	200	0.30	1.4	–	–	–	190	0.30	1.4	–	–	–	–	–	–	40	0.15	0.7
VNMG 160412E-M:T9325	1.2	140	0.40	1.4	–	–	–	130	0.40	1.4	–	–	–	–	–	–	–	–	–

Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																			
WNMG 060404E-M:T5315	0.4	250	0.20	1.8	–	–	–	235	0.20	1.8	–	–	–	–	–	–	50	0.13	0.3
WNMG 060404E-M:T9325	0.4	215	0.20	1.8	–	–	–	200	0.20	1.8	–	–	–	–	–	–	–	–	–
WNMG 060404E-M:T9415	0.4	270	0.20	1.8	–	–	–	255	0.20	1.8	–	–	–	–	–	–	50	0.13	0.3
WNMG 060408E-M:T5315	0.8	255	0.32	1.8	–	–	–	240	0.32	1.8	–	–	–	–	–	–	50	0.16	0.7
WNMG 060408E-M:T9325	0.8	205	0.32	1.8	–	–	–	190	0.32	1.8	–	–	–	–	–	–	–	–	–
WNMG 060408E-M:T9335	0.8	180	0.32	1.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG 060408E-M:T9415	0.8	275	0.32	1.8	–	–	–	260	0.32	1.8	–	–	–	–	–	–	55	0.16	0.7
WNMG 080404E-M:T5315	0.4	260	0.20	1.2	–	–	–	245	0.20	1.2	–	–	–	–	–	–	50	0.13	0.3
WNMG 080404E-M:T9325	0.4	210	0.20	2.1	–	–	–	195	0.20	2.1	–	–	–	–	–	–	–	–	–
WNMG 080404E-M:T9335	0.4	180	0.20	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG 080404E-M:T9415	0.4	265	0.20	2.1	–	–	–	250	0.20	2.1	–	–	–	–	–	–	50	0.13	0.3
WNMG 080408E-M:T5305	0.8	280	0.32	2.1	–	–	–	265	0.32	2.1	–	–	–	–	–	–	55	0.16	0.7
WNMG 080408E-M:T5315	0.8	250	0.32	2.1	–	–	–	235	0.32	2.1	–	–	–	–	–	–	50	0.16	0.7
WNMG 080408E-M:T8430	0.8	170	0.32	2.1	–	–	–	135	0.32	2.1	–	–	–	–	–	–	25	0.16	0.7
WNMG 080408E-M:T9310	0.8	245	0.32	2.1	–	–	–	230	0.32	2.1	–	–	–	–	–	–	45	0.16	0.7
WNMG 080408E-M:T9315	0.8	225	0.32	2.1	–	–	–	210	0.32	2.1	–	–	–	–	–	–	45	0.16	0.7
WNMG 080408E-M:T9325	0.8	200	0.32	2.1	–	–	–	190	0.32	2.1	–	–	–	–	–	–	–	–	–
WNMG 080408E-M:T9335	0.8	180	0.32	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG 080408E-M:T9415	0.8	270	0.32	2.1	–	–	–	255	0.32	2.1	–	–	–	–	–	–	50	0.16	0.7
WNMG 080412E-M:T5305	1.2	275	0.40	2.1	–	–	–	260	0.40	2.1	–	–	–	–	–	–	55	0.20	1.0
WNMG 080412E-M:T5315	1.2	245	0.40	2.1	–	–	–	230	0.40	2.1	–	–	–	–	–	–	45	0.20	1.0
WNMG 080412E-M:T9310	1.2	235	0.40	2.1	–	–	–	220	0.40	2.1	–	–	–	–	–	–	45	0.20	1.0
WNMG 080412E-M:T9315	1.2	220	0.40	2.1	–	–	–	205	0.40	2.1	–	–	–	–	–	–	40	0.20	1.0
WNMG 080412E-M:T9325	1.2	195	0.40	2.1	–	–	–	185	0.40	2.1	–	–	–	–	–	–	–	–	–
WNMG 080412E-M:T9335	1.2	170	0.40	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG 080412E-M:T9415	1.2	265	0.40	2.1	–	–	–	250	0.40	2.1	–	–	–	–	–	–	50	0.20	1.0

M talaş kırıcı çok yönlüdür ve Dökme demirlerin orta düzeyde işlenmesi için ilk tercihtir. Pozitif eğim açısı ve negatif/kararlı, ılımlı T-land özelliklerine sahiptir. Çelikler için ve şartlı olarak Sert malzemeler için de uygundur.

SI

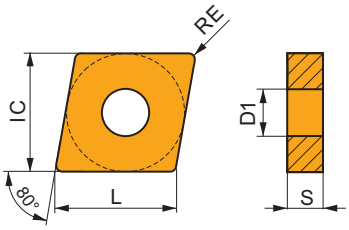




SI talaş kırıcı keskindir ve Çeliklerin, Paslanmaz çeliklerin orta düzeyde işlenmesi için tasarlanmıştır. T-land olmadan pozitif eğim açısına sahiptir. Ayrıca demir dışı alaşımlar ve süper alaşımlar için de şartlara bağlı olarak uygundur.

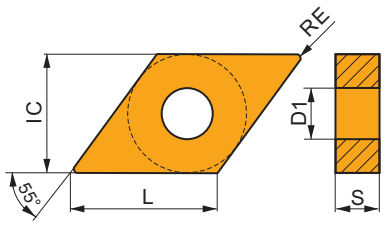
CNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.90	4.76



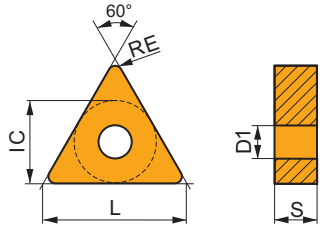
DNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1104	9.525	3.81	11.60	4.76
1504	12.700	5.16	15.50	4.76
1506	12.700	5.16	15.50	6.35



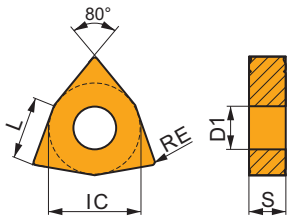
TNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76

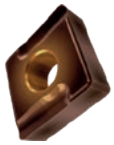
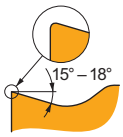
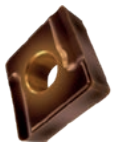
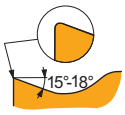
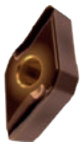
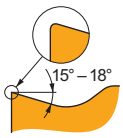


WNMG

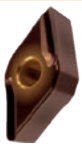
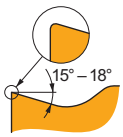
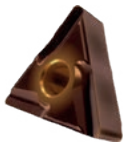
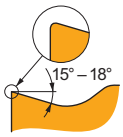
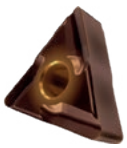
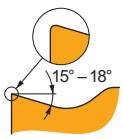
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0604	9.525	3.81	6.50	4.76
0804	12.700	5.16	8.70	4.76



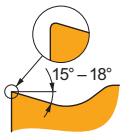
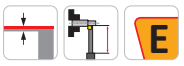
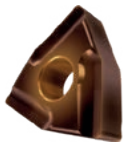
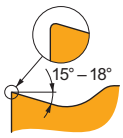
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
  																			
SI talaş kırıcı keskindir ve Çeliklerin, Paslanmaz çeliklerin orta düzeyde işlenmesi için tasarlanmıştır. T-land olmadan pozitif eğim açısına sahiptir. Ayrıca demir dışı alaşımlar ve süper alaşımlar için de şartlara bağlı olarak uygundur.																			
CNMG 120404ER-SI:T7335	0.4	215	0.20	1.7	165	0.18	1.7	–	–	–	–	–	–	65	0.18	1.4	–	–	–
CNMG 120404ER-SI:T8430	0.4	225	0.20	1.7	120	0.18	1.7	–	–	–	615	0.24	1.7	45	0.18	1.4	–	–	–
CNMG 120404ER-SI:T9325	0.4	270	0.20	1.7	160	0.18	1.7	–	–	–	–	–	–	60	0.18	1.4	–	–	–
CNMG 120408ER-SI:T7325	0.8	215	0.35	1.7	165	0.32	1.7	–	–	–	–	–	–	65	0.25	1.4	–	–	–
CNMG 120408ER-SI:T7335	0.8	205	0.35	1.7	155	0.32	1.7	–	–	–	–	–	–	65	0.25	1.4	–	–	–
CNMG 120408ER-SI:T8430	0.8	210	0.35	1.7	115	0.32	1.7	–	–	–	585	0.42	1.7	45	0.25	1.4	–	–	–
CNMG 120408ER-SI:T9325	0.8	255	0.35	1.7	150	0.32	1.7	–	–	–	–	–	–	55	0.25	1.4	–	–	–
CNMG 120412ER-SI:T8430	1.2	225	0.35	1.7	120	0.32	1.7	–	–	–	615	0.42	1.7	45	0.25	1.4	–	–	–
  																			
SI talaş kırıcı keskindir ve Çeliklerin, Paslanmaz çeliklerin orta düzeyde işlenmesi için tasarlanmıştır. T-land olmadan pozitif eğim açısına sahiptir. Ayrıca demir dışı alaşımlar ve süper alaşımlar için de şartlara bağlı olarak uygundur.																			
CNMG 120404EL-SI:T7335	0.4	215	0.20	1.7	165	0.18	1.7	–	–	–	–	–	–	65	0.18	1.4	–	–	–
CNMG 120404EL-SI:T8430	0.4	225	0.20	1.7	120	0.18	1.7	–	–	–	615	0.24	1.7	45	0.18	1.4	–	–	–
CNMG 120404EL-SI:T9325	0.4	270	0.20	1.7	160	0.18	1.7	–	–	–	–	–	–	60	0.18	1.4	–	–	–
CNMG 120408EL-SI:T7325	0.8	215	0.35	1.7	165	0.32	1.7	–	–	–	–	–	–	65	0.25	1.4	–	–	–
CNMG 120408EL-SI:T7335	0.8	205	0.35	1.7	155	0.32	1.7	–	–	–	–	–	–	65	0.25	1.4	–	–	–
CNMG 120408EL-SI:T8430	0.8	210	0.35	1.7	115	0.32	1.7	–	–	–	585	0.42	1.7	45	0.25	1.4	–	–	–
CNMG 120408EL-SI:T9325	0.8	255	0.35	1.7	150	0.32	1.7	–	–	–	–	–	–	55	0.25	1.4	–	–	–
CNMG 120412EL-SI:T8430	1.2	225	0.35	1.7	120	0.32	1.7	–	–	–	615	0.42	1.7	45	0.25	1.4	–	–	–
  																			
SI talaş kırıcı keskindir ve Çeliklerin, Paslanmaz çeliklerin orta düzeyde işlenmesi için tasarlanmıştır. T-land olmadan pozitif eğim açısına sahiptir. Ayrıca demir dışı alaşımlar ve süper alaşımlar için de şartlara bağlı olarak uygundur.																			
DNMG 110404ER-SI:T7325	0.4	185	0.20	1.0	140	0.18	1.0	–	–	–	–	–	–	60	0.18	0.8	–	–	–
DNMG 110404ER-SI:T7335	0.4	180	0.20	1.0	140	0.18	1.0	–	–	–	–	–	–	55	0.18	0.8	–	–	–
DNMG 110404ER-SI:T8430	0.4	185	0.20	1.0	100	0.18	1.0	–	–	–	510	0.24	1.0	40	0.18	0.8	–	–	–
DNMG 110404ER-SI:T9325	0.4	225	0.20	1.0	135	0.18	1.0	–	–	–	–	–	–	50	0.18	0.8	–	–	–
DNMG 110408ER-SI:T7335	0.8	175	0.35	1.0	135	0.32	1.0	–	–	–	–	–	–	55	0.25	0.8	–	–	–
DNMG 110408ER-SI:T8430	0.8	180	0.35	1.0	95	0.32	1.0	–	–	–	495	0.42	1.0	35	0.25	0.8	–	–	–
DNMG 110408ER-SI:T9325	0.8	210	0.35	1.0	125	0.32	1.0	–	–	–	–	–	–	45	0.25	0.8	–	–	–
DNMG 150404ER-SI:T8430	0.4	175	0.20	1.5	95	0.18	1.5	–	–	–	480	0.24	1.5	35	0.18	1.2	–	–	–
DNMG 150404ER-SI:T9325	0.4	220	0.20	1.5	130	0.18	1.5	–	–	–	–	–	–	45	0.18	1.2	–	–	–
DNMG 150408ER-SI:T8430	0.8	170	0.35	1.5	90	0.32	1.5	–	–	–	465	0.42	1.5	35	0.25	1.2	–	–	–
DNMG 150408ER-SI:T9325	0.8	200	0.35	1.5	120	0.32	1.5	–	–	–	–	–	–	45	0.25	1.2	–	–	–
DNMG 150604ER-SI:T7325	0.4	180	0.20	1.5	140	0.18	1.5	–	–	–	–	–	–	55	0.18	1.2	–	–	–
DNMG 150604ER-SI:T7335	0.4	170	0.20	1.5	130	0.18	1.5	–	–	–	–	–	–	55	0.18	1.2	–	–	–
DNMG 150604ER-SI:T8315	0.4	165	0.20	1.5	95	0.18	1.5	–	–	–	495	0.24	1.5	40	0.18	1.2	–	–	–
DNMG 150604ER-SI:T8415	0.4	195	0.20	1.5	100	0.18	1.5	–	–	–	495	0.24	1.5	45	0.18	1.2	–	–	–
DNMG 150604ER-SI:T8430	0.4	175	0.20	1.5	95	0.18	1.5	–	–	–	480	0.24	1.5	35	0.18	1.2	–	–	–
DNMG 150604ER-SI:T9325	0.4	220	0.20	1.5	130	0.18	1.5	–	–	–	–	–	–	45	0.18	1.2	–	–	–
DNMG 150604ER-SI:T9335	0.4	185	0.20	1.5	110	0.18	1.5	–	–	–	–	–	–	40	0.18	1.2	–	–	–
DNMG 150608ER-SI:T7325	0.8	180	0.35	1.5	140	0.32	1.5	–	–	–	–	–	–	55	0.25	1.2	–	–	–
DNMG 150608ER-SI:T7335	0.8	170	0.35	1.5	130	0.32	1.5	–	–	–	–	–	–	55	0.25	1.2	–	–	–
DNMG 150608ER-SI:T8315	0.8	165	0.35	1.5	95	0.32	1.5	–	–	–	495	0.42	1.5	40	0.25	1.2	–	–	–
DNMG 150608ER-SI:T8415	0.8	200	0.35	1.5	105	0.32	1.5	–	–	–	510	0.42	1.5	45	0.24	1.2	–	–	–
DNMG 150608ER-SI:T8430	0.8	170	0.35	1.5	90	0.32	1.5	–	–	–	465	0.42	1.5	35	0.25	1.2	–	–	–
DNMG 150608ER-SI:T9325	0.8	200	0.35	1.5	120	0.32	1.5	–	–	–	–	–	–	45	0.25	1.2	–	–	–
DNMG 150608ER-SI:T9335	0.8	180	0.35	1.5	105	0.32	1.5	–	–	–	–	–	–	40	0.25	1.2	–	–	–

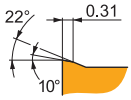
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
  																			
SI talaş kırıcı keskindir ve Çeliklerin, Paslanmaz çeliklerin orta düzeyde işlenmesi için tasarlanmıştır. T-land olmadan pozitif eğim açısına sahiptir. Ayrıca demir dışı alaşımlar ve süper alaşımlar için de şartlara bağlı olarak uygundur.																			
DNMG 110404EL-SI:T8430	0.4	185	0.20	1.0	100	0.18	1.0	–	–	–	510	0.24	1.0	40	0.18	0.8	–	–	–
DNMG 110404EL-SI:T9325	0.4	225	0.20	1.0	135	0.18	1.0	–	–	–	–	–	–	50	0.18	0.8	–	–	–
DNMG 110408EL-SI:T8430	0.8	180	0.35	1.0	95	0.32	1.0	–	–	–	495	0.42	1.0	35	0.25	0.8	–	–	–
DNMG 110408EL-SI:T9325	0.8	210	0.35	1.0	125	0.32	1.0	–	–	–	–	–	–	45	0.25	0.8	–	–	–
DNMG 150404EL-SI:T8430	0.4	175	0.20	1.5	95	0.18	1.5	–	–	–	480	0.24	1.5	35	0.18	1.2	–	–	–
DNMG 150404EL-SI:T9325	0.4	220	0.20	1.5	130	0.18	1.5	–	–	–	–	–	–	45	0.18	1.2	–	–	–
DNMG 150408EL-SI:T7335	0.8	170	0.35	1.5	130	0.32	1.5	–	–	–	–	–	–	55	0.25	1.2	–	–	–
DNMG 150408EL-SI:T8430	0.8	170	0.35	1.5	90	0.32	1.5	–	–	–	465	0.42	1.5	35	0.25	1.2	–	–	–
DNMG 150408EL-SI:T9325	0.8	200	0.35	1.5	120	0.32	1.5	–	–	–	–	–	–	45	0.25	1.2	–	–	–
DNMG 150604EL-SI:T7325	0.4	180	0.20	1.5	140	0.18	1.5	–	–	–	–	–	–	55	0.18	1.2	–	–	–
DNMG 150604EL-SI:T7335	0.4	170	0.20	1.5	130	0.18	1.5	–	–	–	–	–	–	55	0.18	1.2	–	–	–
DNMG 150604EL-SI:T8315	0.4	165	0.20	1.5	95	0.18	1.5	–	–	–	495	0.24	1.5	40	0.18	1.2	–	–	–
DNMG 150604EL-SI:T8430	0.4	175	0.20	1.5	95	0.18	1.5	–	–	–	480	0.24	1.5	35	0.18	1.2	–	–	–
DNMG 150604EL-SI:T9325	0.4	220	0.20	1.5	130	0.18	1.5	–	–	–	–	–	–	45	0.18	1.2	–	–	–
DNMG 150604EL-SI:T9335	0.4	185	0.20	1.5	110	0.18	1.5	–	–	–	–	–	–	40	0.18	1.2	–	–	–
DNMG 150608EL-SI:T7325	0.8	180	0.35	1.5	140	0.32	1.5	–	–	–	–	–	–	55	0.25	1.2	–	–	–
DNMG 150608EL-SI:T7335	0.8	170	0.35	1.5	130	0.32	1.5	–	–	–	–	–	–	55	0.25	1.2	–	–	–
DNMG 150608EL-SI:T8315	0.8	165	0.35	1.5	95	0.32	1.5	–	–	–	495	0.42	1.5	40	0.25	1.2	–	–	–
DNMG 150608EL-SI:T8415	0.8	200	0.35	1.5	105	0.32	1.5	–	–	–	510	0.42	1.5	45	0.24	1.2	–	–	–
DNMG 150608EL-SI:T8430	0.8	170	0.35	1.5	90	0.32	1.5	–	–	–	465	0.42	1.5	35	0.25	1.2	–	–	–
DNMG 150608EL-SI:T9325	0.8	200	0.35	1.5	120	0.32	1.5	–	–	–	–	–	–	45	0.25	1.2	–	–	–
DNMG 150608EL-SI:T9335	0.8	180	0.35	1.5	105	0.32	1.5	–	–	–	–	–	–	40	0.25	1.2	–	–	–
  																			
SI talaş kırıcı keskindir ve Çeliklerin, Paslanmaz çeliklerin orta düzeyde işlenmesi için tasarlanmıştır. T-land olmadan pozitif eğim açısına sahiptir. Ayrıca demir dışı alaşımlar ve süper alaşımlar için de şartlara bağlı olarak uygundur.																			
TNMG 160404ER-SI:T7325	0.4	190	0.20	1.5	145	0.18	1.5	–	–	–	–	–	–	60	0.18	1.2	–	–	–
TNMG 160404ER-SI:T7335	0.4	180	0.20	1.5	140	0.18	1.5	–	–	–	–	–	–	55	0.18	1.2	–	–	–
TNMG 160404ER-SI:T8315	0.4	175	0.20	1.5	105	0.18	1.5	–	–	–	525	0.24	1.5	40	0.18	1.2	–	–	–
TNMG 160404ER-SI:T8415	0.4	210	0.20	1.5	110	0.18	1.5	–	–	–	525	0.24	1.5	45	0.18	1.2	–	–	–
TNMG 160404ER-SI:T8430	0.4	185	0.20	1.5	100	0.18	1.5	–	–	–	510	0.24	1.5	40	0.18	1.2	–	–	–
TNMG 160404ER-SI:T9325	0.4	230	0.20	1.5	135	0.18	1.5	–	–	–	–	–	–	50	0.18	1.2	–	–	–
TNMG 160404ER-SI:T9335	0.4	195	0.20	1.5	115	0.18	1.5	–	–	–	–	–	–	40	0.18	1.2	–	–	–
TNMG 160408ER-SI:T7325	0.8	190	0.35	1.5	145	0.32	1.5	–	–	–	–	–	–	60	0.25	1.2	–	–	–
TNMG 160408ER-SI:T7335	0.8	180	0.35	1.5	140	0.32	1.5	–	–	–	–	–	–	55	0.25	1.2	–	–	–
TNMG 160408ER-SI:T8315	0.8	175	0.35	1.5	105	0.32	1.5	–	–	–	525	0.42	1.5	40	0.25	1.2	–	–	–
TNMG 160408ER-SI:T8415	0.8	215	0.35	1.5	110	0.32	1.5	–	–	–	540	0.42	1.5	45	0.24	1.2	–	–	–
TNMG 160408ER-SI:T8430	0.8	180	0.35	1.5	95	0.32	1.5	–	–	–	495	0.42	1.5	35	0.25	1.2	–	–	–
TNMG 160408ER-SI:T9325	0.8	215	0.35	1.5	125	0.32	1.5	–	–	–	–	–	–	45	0.25	1.2	–	–	–
TNMG 160408ER-SI:T9335	0.8	190	0.35	1.5	110	0.32	1.5	–	–	–	–	–	–	40	0.25	1.2	–	–	–
  																			
SI talaş kırıcı keskindir ve Çeliklerin, Paslanmaz çeliklerin orta düzeyde işlenmesi için tasarlanmıştır. T-land olmadan pozitif eğim açısına sahiptir. Ayrıca demir dışı alaşımlar ve süper alaşımlar için de şartlara bağlı olarak uygundur.																			
TNMG 160404EL-SI:T7325	0.4	190	0.20	1.5	145	0.18	1.5	–	–	–	–	–	–	60	0.18	1.2	–	–	–
TNMG 160404EL-SI:T7335	0.4	180	0.20	1.5	140	0.18	1.5	–	–	–	–	–	–	55	0.18	1.2	–	–	–
TNMG 160404EL-SI:T8315	0.4	175	0.20	1.5	105	0.18	1.5	–	–	–	525	0.24	1.5	40	0.18	1.2	–	–	–
TNMG 160404EL-SI:T8415	0.4	210	0.20	1.5	110	0.18	1.5	–	–	–	525	0.24	1.5	45	0.18	1.2	–	–	–
TNMG 160404EL-SI:T8430	0.4	185	0.20	1.5	100	0.18	1.5	–	–	–	510	0.24	1.5	40	0.18	1.2	–	–	–
TNMG 160404EL-SI:T9325	0.4	230	0.20	1.5	135	0.18	1.5	–	–	–	–	–	–	50	0.18	1.2	–	–	–
TNMG 160404EL-SI:T9335	0.4	195	0.20	1.5	115	0.18	1.5	–	–	–	–	–	–	40	0.18	1.2	–	–	–
TNMG 160408EL-SI:T7325	0.8	190	0.35	1.5	145	0.32	1.5	–	–	–	–	–	–	60	0.25	1.2	–	–	–
TNMG 160408EL-SI:T7335	0.8	180	0.35	1.5	140	0.32	1.5	–	–	–	–	–	–	55	0.25	1.2	–	–	–
TNMG 160408EL-SI:T8315	0.8	175	0.35	1.5	105	0.32	1.5	–	–	–	525	0.42	1.5	40	0.25	1.2	–	–	–
TNMG 160408EL-SI:T8415	0.8	215	0.35	1.5	110	0.32	1.5	–	–	–	540	0.42	1.5	45	0.24	1.2	–	–	–
TNMG 160408EL-SI:T8430	0.8	180	0.35	1.5	95	0.32	1.5	–	–	–	495	0.42	1.5	35	0.25	1.2	–	–	–
TNMG 160408EL-SI:T9325	0.8	215	0.35	1.5	125	0.32	1.5	–	–	–	–	–	–	45	0.25	1.2	–	–	–
TNMG 160408EL-SI:T9335	0.8	190	0.35	1.5	110	0.32	1.5	–	–	–	–	–	–	40	0.25	1.2	–	–	–

Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
  																			
SI talaş kırıcı keskindir ve Çeliklerin, Paslanmaz çeliklerin orta düzeyde işlenmesi için tasarlanmıştır. T-land olmadan pozitif eğim açısına sahiptir. Ayrıca demir dışı alaşımlar ve süper alaşımlar için de şartlara bağlı olarak uygundur.																			
WNMG 060404ER-SI:T8430	0.4	225	0.20	1.7	120	0.18	1.7	–	–	–	615	0.24	1.7	45	0.18	1.4	–	–	–
WNMG 060404ER-SI:T9325	0.4	270	0.20	1.7	160	0.18	1.7	–	–	–	–	–	–	60	0.18	1.4	–	–	–
WNMG 080404ER-SI:T7325	0.4	220	0.20	1.7	170	0.18	1.7	–	–	–	–	–	–	70	0.18	1.4	–	–	–
WNMG 080404ER-SI:T7335	0.4	215	0.20	1.7	165	0.18	1.7	–	–	–	–	–	–	65	0.18	1.4	–	–	–
WNMG 080404ER-SI:T8315	0.4	205	0.20	1.7	120	0.18	1.7	–	–	–	615	0.24	1.7	50	0.18	1.4	–	–	–
WNMG 080404ER-SI:T8415	0.4	250	0.20	1.7	130	0.18	1.7	–	–	–	630	0.24	1.7	55	0.18	1.4	–	–	–
WNMG 080404ER-SI:T8430	0.4	225	0.20	1.7	120	0.18	1.7	–	–	–	615	0.24	1.7	45	0.18	1.4	–	–	–
WNMG 080404ER-SI:T9325	0.4	270	0.20	1.7	160	0.18	1.7	–	–	–	–	–	–	60	0.18	1.4	–	–	–
WNMG 080408ER-SI:T7325	0.8	215	0.35	1.7	165	0.32	1.7	–	–	–	–	–	–	65	0.25	1.4	–	–	–
WNMG 080408ER-SI:T7335	0.8	205	0.35	1.7	155	0.32	1.7	–	–	–	–	–	–	65	0.25	1.4	–	–	–
WNMG 080408ER-SI:T8315	0.8	205	0.35	1.7	120	0.32	1.7	–	–	–	615	0.42	1.7	50	0.25	1.4	–	–	–
WNMG 080408ER-SI:T8430	0.8	210	0.35	1.7	115	0.32	1.7	–	–	–	585	0.42	1.7	45	0.25	1.4	–	–	–
WNMG 080408ER-SI:T9325	0.8	255	0.35	1.7	150	0.32	1.7	–	–	–	–	–	–	55	0.25	1.4	–	–	–
WNMG 080412ER-SI:T8430	1.2	225	0.35	1.7	120	0.32	1.7	–	–	–	615	0.42	1.7	45	0.25	1.4	–	–	–
  																			
SI talaş kırıcı keskindir ve Çeliklerin, Paslanmaz çeliklerin orta düzeyde işlenmesi için tasarlanmıştır. T-land olmadan pozitif eğim açısına sahiptir. Ayrıca demir dışı alaşımlar ve süper alaşımlar için de şartlara bağlı olarak uygundur.																			
WNMG 060404EL-SI:T8430	0.4	225	0.20	1.7	120	0.18	1.7	–	–	–	615	0.24	1.7	45	0.18	1.4	–	–	–
WNMG 060404EL-SI:T9325	0.4	270	0.20	1.7	160	0.18	1.7	–	–	–	–	–	–	60	0.18	1.4	–	–	–
WNMG 080404EL-SI:T7325	0.4	220	0.20	1.7	170	0.18	1.7	–	–	–	–	–	–	70	0.18	1.4	–	–	–
WNMG 080404EL-SI:T7335	0.4	215	0.20	1.7	165	0.18	1.7	–	–	–	–	–	–	65	0.18	1.4	–	–	–
WNMG 080404EL-SI:T8315	0.4	205	0.20	1.7	120	0.18	1.7	–	–	–	615	0.24	1.7	50	0.18	1.4	–	–	–
WNMG 080404EL-SI:T8415	0.4	250	0.20	1.7	130	0.18	1.7	–	–	–	630	0.24	1.7	55	0.18	1.4	–	–	–
WNMG 080404EL-SI:T8430	0.4	225	0.20	1.7	120	0.18	1.7	–	–	–	615	0.24	1.7	45	0.18	1.4	–	–	–
WNMG 080404EL-SI:T9325	0.4	270	0.20	1.7	160	0.18	1.7	–	–	–	–	–	–	60	0.18	1.4	–	–	–
WNMG 080408EL-SI:T7325	0.8	215	0.35	1.7	165	0.32	1.7	–	–	–	–	–	–	65	0.25	1.4	–	–	–
WNMG 080408EL-SI:T7335	0.8	205	0.35	1.7	155	0.32	1.7	–	–	–	–	–	–	65	0.25	1.4	–	–	–
WNMG 080408EL-SI:T8315	0.8	205	0.35	1.7	120	0.32	1.7	–	–	–	615	0.42	1.7	50	0.25	1.4	–	–	–
WNMG 080408EL-SI:T8430	0.8	210	0.35	1.7	115	0.32	1.7	–	–	–	585	0.42	1.7	45	0.25	1.4	–	–	–
WNMG 080408EL-SI:T9325	0.8	255	0.35	1.7	150	0.32	1.7	–	–	–	–	–	–	55	0.25	1.4	–	–	–
WNMG 080412EL-SI:T8430	1.2	225	0.35	1.7	120	0.32	1.7	–	–	–	615	0.42	1.7	45	0.25	1.4	–	–	–

NMR

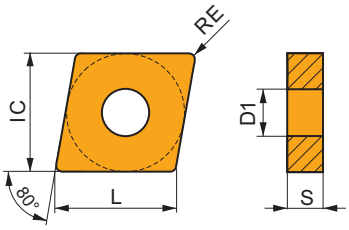




NMR talaş kırıcı çok yönlüdür ve Paslanmaz çeliklerin orta düzeyde işlenmesi için ilk tercihtir. Pozitif eğim açısı ve pozitif, geniş T-land özelliğine sahiptir. Çelikler ve Süper alaşımlar için de uygundur.

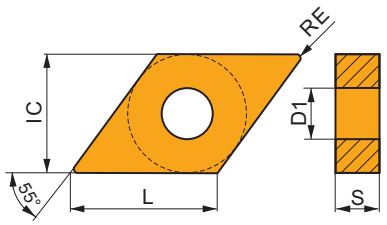
CNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0903	9.525	3.81	9.70	3.18
1204	12.700	5.16	12.90	4.76
1606	15.875	6.35	16.10	6.35
1906	19.050	7.94	19.30	6.35



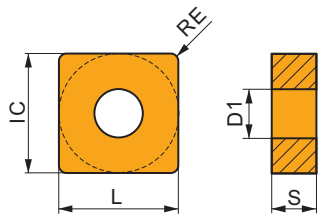
DNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1104	9.525	3.81	11.60	4.76
1504	12.700	5.16	15.50	4.76
1506	12.700	5.16	15.50	6.35



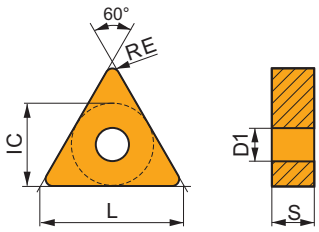
SNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76
1506	15.875	6.35	15.88	6.35
1906	19.050	7.94	19.05	6.35



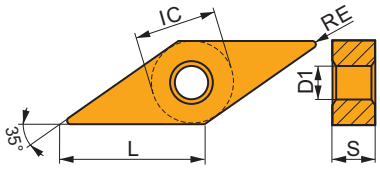
TNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76
2204	12.700	5.16	22.00	4.76



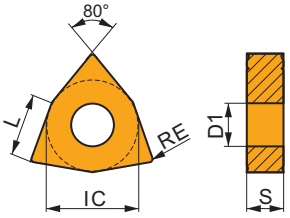
VNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.60	4.76



WNMG

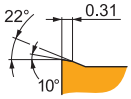
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0604	9.525	3.81	6.50	4.76
0804	12.700	5.16	8.70	4.76



Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	Interrupted/ Continuous cut	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
CNMG 090308E-NMR:T7325	⬌	0.8	175	0.35	1.6	135	0.32	1.6	–	–	–	–	–	–	55	0.25	1.3	–	–	–
CNMG 090308E-NMR:T7335	⬌	0.8	170	0.35	1.6	130	0.32	1.6	–	–	–	–	–	–	55	0.25	1.3	–	–	–
CNMG 120404E-NMR:T7325	●	0.4	155	0.25	2.7	120	0.23	2.7	–	–	–	–	–	–	50	0.20	2.2	–	–	–
CNMG 120404E-NMR:T7335	●	0.4	155	0.25	2.0	120	0.23	2.0	–	–	–	–	–	–	50	0.20	1.6	–	–	–
CNMG 120404E-NMR:T8430	⬌	0.4	150	0.25	2.7	80	0.23	2.7	–	–	–	–	–	–	30	0.20	2.2	–	–	–
CNMG 120404E-NMR:T9325	●	0.4	190	0.25	2.0	110	0.23	2.0	–	–	–	–	–	–	40	0.20	1.6	–	–	–
CNMG 120404E-NMR:T9415	●	0.4	245	0.25	2.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

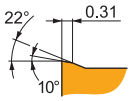
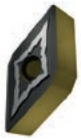
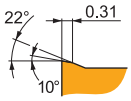




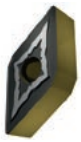
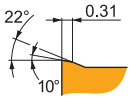
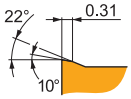
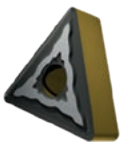
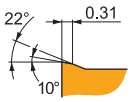


NMR talaş kırıcı çok yönlüdür ve Paslanmaz çeliklerin orta düzeyde işlenmesi için ilk tercihtir. Pozitif eğim açısı ve pozitif, geniş T-land özelliğine sahiptir. Çelikler ve Süper alaşımlar için de uygundur.

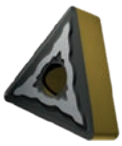
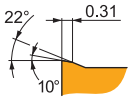
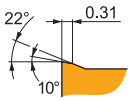
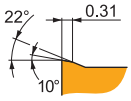
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
  																			
NMR talaş kırıcı çok yönlüdür ve Paslanmaz çeliklerin orta düzeyde işlenmesi için ilk tercihtir. Pozitif eğim açısı ve pozitif, geniş T-land özelliğine sahiptir. Çelikler ve Süper alaşımlar için de uygundur.																			
CNMG 120408E-NMR:T6310	0.8	150	0.35	2.7	105	0.32	2.7	–	–	–	–	–	–	45	0.25	2.2	–	–	–
CNMG 120408E-NMR:T7325	0.8	170	0.35	2.7	130	0.32	2.7	–	–	–	–	–	–	55	0.25	2.2	–	–	–
CNMG 120408E-NMR:T7335	0.8	160	0.35	2.7	120	0.32	2.7	–	–	–	–	–	–	50	0.25	2.2	–	–	–
CNMG 120408E-NMR:T8430	0.8	155	0.35	2.7	85	0.32	2.7	–	–	–	–	–	–	30	0.25	2.2	–	–	–
CNMG 120408E-NMR:T9325	0.8	190	0.35	2.7	110	0.32	2.7	–	–	–	–	–	–	40	0.25	2.2	–	–	–
CNMG 120408E-NMR:T9415	0.8	255	0.35	2.7	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 120412E-NMR:T6310	1.2	150	0.40	2.7	105	0.36	2.7	–	–	–	–	–	–	45	0.28	2.2	–	–	–
CNMG 120412E-NMR:T7325	1.2	170	0.40	2.7	130	0.36	2.7	–	–	–	–	–	–	55	0.28	2.2	–	–	–
CNMG 120412E-NMR:T7335	1.2	160	0.40	2.7	120	0.36	2.7	–	–	–	–	–	–	50	0.28	2.2	–	–	–
CNMG 120412E-NMR:T8430	1.2	155	0.40	2.7	85	0.36	2.7	–	–	–	–	–	–	30	0.28	2.2	–	–	–
CNMG 120412E-NMR:T9325	1.2	190	0.40	2.7	110	0.36	2.7	–	–	–	–	–	–	40	0.28	2.2	–	–	–
CNMG 120412E-NMR:T9415	1.2	255	0.40	2.7	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 120416E-NMR:T7325	1.6	170	0.45	2.7	130	0.41	2.7	–	–	–	–	–	–	55	0.32	2.2	–	–	–
CNMG 120416E-NMR:T7335	1.6	160	0.45	2.7	120	0.41	2.7	–	–	–	–	–	–	50	0.32	2.2	–	–	–
CNMG 120416E-NMR:T8430	1.6	155	0.45	2.7	85	0.41	2.7	–	–	–	–	–	–	30	0.32	2.2	–	–	–
CNMG 160608E-NMR:T7325	0.8	160	0.35	4.0	120	0.32	4.0	–	–	–	–	–	–	50	0.25	3.2	–	–	–
CNMG 160608E-NMR:T7335	0.8	150	0.35	4.0	115	0.32	4.0	–	–	–	–	–	–	45	0.25	3.2	–	–	–
CNMG 160608E-NMR:T9325	0.8	185	0.35	4.0	110	0.32	4.0	–	–	–	–	–	–	40	0.25	3.2	–	–	–
CNMG 160608E-NMR:T9415	0.8	245	0.35	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 160612E-NMR:T7325	1.2	165	0.40	4.0	125	0.36	4.0	–	–	–	–	–	–	50	0.28	3.2	–	–	–
CNMG 160612E-NMR:T7335	1.2	155	0.40	4.0	120	0.36	4.0	–	–	–	–	–	–	50	0.28	3.2	–	–	–
CNMG 160612E-NMR:T8430	1.2	150	0.40	4.0	80	0.36	4.0	–	–	–	–	–	–	30	0.28	3.2	–	–	–
CNMG 160612E-NMR:T9325	1.2	185	0.40	4.0	110	0.36	4.0	–	–	–	–	–	–	40	0.28	3.2	–	–	–
CNMG 160612E-NMR:T9415	1.2	245	0.40	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 160616E-NMR:T7325	1.6	165	0.45	4.0	125	0.41	4.0	–	–	–	–	–	–	50	0.32	3.2	–	–	–
CNMG 160616E-NMR:T7335	1.6	155	0.45	4.0	120	0.41	4.0	–	–	–	–	–	–	50	0.32	3.2	–	–	–
CNMG 160616E-NMR:T8430	1.6	150	0.45	4.0	80	0.41	4.0	–	–	–	–	–	–	30	0.32	3.2	–	–	–
CNMG 160616E-NMR:T9325	1.6	180	0.45	4.0	105	0.41	4.0	–	–	–	–	–	–	40	0.32	3.2	–	–	–
CNMG 160616E-NMR:T9415	1.6	240	0.45	6.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 190608E-NMR:T6310	0.8	140	0.35	5.2	100	0.32	5.2	–	–	–	–	–	–	40	0.25	4.2	–	–	–
CNMG 190608E-NMR:T7325	0.8	155	0.35	5.2	120	0.32	5.2	–	–	–	–	–	–	50	0.25	4.2	–	–	–
CNMG 190608E-NMR:T7335	0.8	150	0.35	5.2	115	0.32	5.2	–	–	–	–	–	–	45	0.25	4.2	–	–	–
CNMG 190608E-NMR:T9325	0.8	180	0.35	5.2	105	0.32	5.2	–	–	–	–	–	–	40	0.25	4.2	–	–	–
CNMG 190608E-NMR:T9415	0.8	225	0.35	8.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 190612E-NMR:T6310	1.2	140	0.40	5.2	100	0.36	5.2	–	–	–	–	–	–	40	0.28	4.2	–	–	–
CNMG 190612E-NMR:T7325	1.2	160	0.40	5.2	120	0.36	5.2	–	–	–	–	–	–	50	0.28	4.2	–	–	–
CNMG 190612E-NMR:T7335	1.2	150	0.40	5.2	115	0.36	5.2	–	–	–	–	–	–	45	0.28	4.2	–	–	–
CNMG 190612E-NMR:T8430	1.2	145	0.40	5.2	80	0.36	5.2	–	–	–	–	–	–	30	0.28	4.2	–	–	–
CNMG 190612E-NMR:T9325	1.2	180	0.40	5.2	105	0.36	5.2	–	–	–	–	–	–	40	0.28	4.2	–	–	–
CNMG 190616E-NMR:T7325	1.6	160	0.45	5.2	120	0.41	5.2	–	–	–	–	–	–	50	0.32	4.2	–	–	–
CNMG 190616E-NMR:T7335	1.6	150	0.45	5.2	115	0.41	5.2	–	–	–	–	–	–	45	0.32	4.2	–	–	–
CNMG 190616E-NMR:T8430	1.6	145	0.45	5.2	80	0.41	5.2	–	–	–	–	–	–	30	0.32	4.2	–	–	–
CNMG 190616E-NMR:T9325	1.6	175	0.45	5.2	105	0.41	5.2	–	–	–	–	–	–	35	0.32	4.2	–	–	–
CNMG 190616E-NMR:T9415	1.6	240	0.45	5.2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
  																			
NMR talaş kırıcı çok yönlüdür ve Paslanmaz çeliklerin orta düzeyde işlenmesi için ilk tercihtir. Pozitif eğim açısı ve pozitif, geniş T-land özelliğine sahiptir. Çelikler ve Süper alaşımlar için de uygundur.																			
DNMG 110404E-NMR:T7325	0.4	150	0.20	0.8	115	0.18	0.8	–	–	–	–	–	–	45	0.18	0.6	–	–	–
DNMG 110404E-NMR:T9325	0.4	185	0.20	0.8	110	0.18	0.8	–	–	–	–	–	–	40	0.18	0.6	–	–	–
DNMG 110408E-NMR:T7325	0.8	155	0.30	0.8	120	0.27	0.8	–	–	–	–	–	–	50	0.24	0.6	–	–	–
DNMG 110408E-NMR:T9415	0.8	240	0.30	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG 110412E-NMR:T7325	1.2	155	0.30	1.6	120	0.27	1.6	–	–	–	–	–	–	50	0.24	1.3	–	–	–
DNMG 110412E-NMR:T9325	1.2	180	0.30	1.6	105	0.27	1.6	–	–	–	–	–	–	40	0.24	1.3	–	–	–

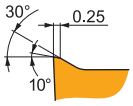
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P			M			K			N			S			H		
			vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)
																				
NMR talaş kırıcı çok yönlüdür ve Paslanmaz çeliklerin orta düzeyde işlenmesi için ilk tercihtir. Pozitif eğim açısı ve pozitif, geniş T-land özelliğine sahiptir. Çelikler ve Süper alaşımlar için de uygundur.																				
DNMG 150404E-NMR:T7325	●	0.4	140	0.20	1.9	105	0.18	1.9	–	–	–	–	–	–	45	0.18	1.5	–	–	–
DNMG 150404E-NMR:T9325	●	0.4	170	0.20	1.9	100	0.18	1.9	–	–	–	–	–	–	35	0.18	1.5	–	–	–
DNMG 150408E-NMR:T7325	●	0.8	145	0.30	1.9	110	0.27	1.9	–	–	–	–	–	–	45	0.24	1.5	–	–	–
DNMG 150408E-NMR:T8430	●	0.8	135	0.30	1.9	75	0.27	1.9	–	–	–	–	–	–	25	0.24	1.5	–	–	–
DNMG 150408E-NMR:T9325	●	0.8	170	0.30	1.9	100	0.27	1.9	–	–	–	–	–	–	35	0.24	1.5	–	–	–
DNMG 150408E-NMR:T9415	●	0.8	220	0.30	1.9	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG 150604E-NMR:T7325	●	0.4	140	0.20	1.9	105	0.18	1.9	–	–	–	–	–	–	45	0.18	1.5	–	–	–
DNMG 150604E-NMR:T7335	●	0.4	130	0.20	1.9	100	0.18	1.9	–	–	–	–	–	–	40	0.18	1.5	–	–	–
DNMG 150604E-NMR:T8430	●	0.4	135	0.20	1.9	75	0.18	1.9	–	–	–	–	–	–	25	0.18	1.5	–	–	–
DNMG 150604E-NMR:T9325	●	0.4	170	0.20	1.9	100	0.18	1.9	–	–	–	–	–	–	35	0.18	1.5	–	–	–
DNMG 150604E-NMR:T9415	●	0.4	210	0.20	1.9	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG 150608E-NMR:T6310	●	0.8	125	0.30	1.9	90	0.27	1.9	–	–	–	–	–	–	35	0.24	1.5	–	–	–
DNMG 150608E-NMR:T7325	●	0.8	145	0.30	1.9	110	0.27	1.9	–	–	–	–	–	–	45	0.24	1.5	–	–	–
DNMG 150608E-NMR:T7335	●	0.8	140	0.30	1.9	105	0.27	1.9	–	–	–	–	–	–	45	0.24	1.5	–	–	–
DNMG 150608E-NMR:T8430	●	0.8	135	0.30	1.9	75	0.27	1.9	–	–	–	–	–	–	25	0.24	1.5	–	–	–
DNMG 150608E-NMR:T9325	●	0.8	170	0.30	1.9	100	0.27	1.9	–	–	–	–	–	–	35	0.24	1.5	–	–	–
DNMG 150608E-NMR:T9415	●	0.8	220	0.30	1.9	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG 150612E-NMR:T7325	●	1.2	155	0.30	1.9	120	0.27	1.9	–	–	–	–	–	–	50	0.24	1.5	–	–	–
DNMG 150612E-NMR:T8430	●	1.2	145	0.30	1.9	80	0.27	1.9	–	–	–	–	–	–	30	0.24	1.5	–	–	–
DNMG 150612E-NMR:T9325	●	1.2	180	0.30	1.9	105	0.27	1.9	–	–	–	–	–	–	40	0.24	1.5	–	–	–
DNMG 150612E-NMR:T9415	●	1.2	235	0.30	1.9	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
																				
NMR talaş kırıcı çok yönlüdür ve Paslanmaz çeliklerin orta düzeyde işlenmesi için ilk tercihtir. Pozitif eğim açısı ve pozitif, geniş T-land özelliğine sahiptir. Çelikler ve Süper alaşımlar için de uygundur.																				
SNMG 120408E-NMR:T7325	●	0.8	175	0.35	2.6	135	0.32	2.6	–	–	–	–	–	–	55	0.25	2.1	–	–	–
SNMG 120408E-NMR:T7335	●	0.8	165	0.35	2.6	125	0.32	2.6	–	–	–	–	–	–	50	0.25	2.1	–	–	–
SNMG 120408E-NMR:T8430	●	0.8	165	0.35	2.6	90	0.32	2.6	–	–	–	–	–	–	35	0.25	2.1	–	–	–
SNMG 120408E-NMR:T9325	●	0.8	200	0.35	2.6	120	0.32	2.6	–	–	–	–	–	–	45	0.25	2.1	–	–	–
SNMG 120412E-NMR:T6310	●	1.2	160	0.40	2.6	115	0.36	2.6	–	–	–	–	–	–	45	0.28	2.1	–	–	–
SNMG 120412E-NMR:T7335	●	1.2	165	0.40	2.6	125	0.36	2.6	–	–	–	–	–	–	50	0.28	2.1	–	–	–
SNMG 120412E-NMR:T9325	●	1.2	200	0.40	2.6	120	0.36	2.6	–	–	–	–	–	–	45	0.28	2.1	–	–	–
SNMG 120416E-NMR:T7325	●	1.6	180	0.45	2.6	140	0.41	2.6	–	–	–	–	–	–	55	0.32	2.1	–	–	–
SNMG 150612E-NMR:T6310	●	1.2	150	0.40	3.8	105	0.36	3.8	–	–	–	–	–	–	45	0.28	3.0	–	–	–
SNMG 150612E-NMR:T7325	●	1.2	170	0.40	3.8	130	0.36	3.8	–	–	–	–	–	–	55	0.28	3.0	–	–	–
SNMG 150612E-NMR:T8430	●	1.2	155	0.40	3.8	85	0.36	3.8	–	–	–	–	–	–	30	0.28	3.0	–	–	–
SNMG 150612E-NMR:T9325	●	1.2	190	0.40	3.8	110	0.36	3.8	–	–	–	–	–	–	40	0.28	3.0	–	–	–
SNMG 190612E-NMR:T6310	●	1.2	145	0.40	5.2	100	0.36	5.2	–	–	–	–	–	–	40	0.28	4.2	–	–	–
SNMG 190612E-NMR:T7325	●	1.2	165	0.40	5.2	125	0.36	5.2	–	–	–	–	–	–	50	0.28	4.2	–	–	–
SNMG 190612E-NMR:T7335	●	1.2	155	0.40	5.2	120	0.36	5.2	–	–	–	–	–	–	50	0.28	4.2	–	–	–
SNMG 190612E-NMR:T9325	●	1.2	185	0.40	5.2	110	0.36	5.2	–	–	–	–	–	–	40	0.28	4.2	–	–	–
SNMG 190616E-NMR:T6310	●	1.6	150	0.45	5.2	105	0.41	5.2	–	–	–	–	–	–	45	0.32	4.2	–	–	–
SNMG 190616E-NMR:T7325	●	1.6	170	0.45	5.2	130	0.41	5.2	–	–	–	–	–	–	55	0.32	4.2	–	–	–
SNMG 190616E-NMR:T7335	●	1.6	155	0.45	5.2	120	0.41	5.2	–	–	–	–	–	–	50	0.32	4.2	–	–	–
SNMG 190616E-NMR:T8430	●	1.6	150	0.45	5.2	80	0.41	5.2	–	–	–	–	–	–	30	0.32	4.2	–	–	–
SNMG 190616E-NMR:T9415	●	1.6	250	0.45	5.2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
																				
NMR talaş kırıcı çok yönlüdür ve Paslanmaz çeliklerin orta düzeyde işlenmesi için ilk tercihtir. Pozitif eğim açısı ve pozitif, geniş T-land özelliğine sahiptir. Çelikler ve Süper alaşımlar için de uygundur.																				
TNMG 160404E-NMR:T6310	●	0.4	130	0.20	1.7	90	0.18	1.7	–	–	–	–	–	–	35	0.18	1.4	–	–	–
TNMG 160404E-NMR:T7325	●	0.4	145	0.20	1.7	110	0.18	1.7	–	–	–	–	–	–	45	0.18	1.4	–	–	–
TNMG 160404E-NMR:T7335	●	0.4	145	0.20	1.7	110	0.18	1.7	–	–	–	–	–	–	45	0.18	1.4	–	–	–
TNMG 160404E-NMR:T8430	●	0.4	145	0.20	1.7	80	0.18	1.7	–	–	–	–	–	–	30	0.18	1.4	–	–	–
TNMG 160404E-NMR:T9325	●	0.4	180	0.20	1.7	105	0.18	1.7	–	–	–	–	–	–	40	0.18	1.4	–	–	–

Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
   **NMR** talaş kırıcı çok yönlüdür ve Paslanmaz çeliklerin orta düzeyde işlenmesi için ilk tercihtir. Pozitif eğim açısı ve pozitif, geniş T-land özelliğine sahiptir. Çelikler ve Süper alaşımlar için de uygundur.																			
TNMG 160408E-NMR:T6310	0.8	140	0.30	1.7	100	0.27	1.7	–	–	–	–	–	–	40	0.24	1.4	–	–	–
TNMG 160408E-NMR:T7325	0.8	155	0.30	1.7	120	0.27	1.7	–	–	–	–	–	–	50	0.24	1.4	–	–	–
TNMG 160408E-NMR:T7335	0.8	145	0.30	1.7	110	0.27	1.7	–	–	–	–	–	–	45	0.24	1.4	–	–	–
TNMG 160408E-NMR:T8430	0.8	150	0.30	1.7	80	0.27	1.7	–	–	–	–	–	–	30	0.24	1.4	–	–	–
TNMG 160408E-NMR:T9325	0.8	185	0.30	1.7	110	0.27	1.7	–	–	–	–	–	–	40	0.24	1.4	–	–	–
TNMG 160408E-NMR:T9415	0.8	235	0.30	1.7	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG 160412E-NMR:T7325	1.2	165	0.30	1.7	125	0.27	1.7	–	–	–	–	–	–	50	0.24	1.4	–	–	–
TNMG 160412E-NMR:T8430	1.2	155	0.30	1.7	85	0.27	1.7	–	–	–	–	–	–	30	0.24	1.4	–	–	–
TNMG 160412E-NMR:T9415	1.2	250	0.30	1.7	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG 220408E-NMR:T6310	0.8	135	0.30	2.1	95	0.27	2.1	–	–	–	–	–	–	40	0.24	1.7	–	–	–
TNMG 220408E-NMR:T7325	0.8	150	0.30	2.1	115	0.27	2.1	–	–	–	–	–	–	45	0.24	1.7	–	–	–
TNMG 220408E-NMR:T7335	0.8	145	0.30	2.1	110	0.27	2.1	–	–	–	–	–	–	45	0.24	1.7	–	–	–
TNMG 220408E-NMR:T8430	0.8	145	0.30	2.1	80	0.27	2.1	–	–	–	–	–	–	30	0.24	1.7	–	–	–
TNMG 220408E-NMR:T9325	0.8	180	0.30	2.1	105	0.27	2.1	–	–	–	–	–	–	40	0.24	1.7	–	–	–
TNMG 220412E-NMR:T6310	1.2	140	0.30	2.1	100	0.27	2.1	–	–	–	–	–	–	40	0.24	1.7	–	–	–
TNMG 220412E-NMR:T7325	1.2	160	0.30	2.1	120	0.27	2.1	–	–	–	–	–	–	50	0.24	1.7	–	–	–
TNMG 220412E-NMR:T9325	1.2	190	0.30	2.1	110	0.27	2.1	–	–	–	–	–	–	40	0.24	1.7	–	–	–
TNMG 220412E-NMR:T9415	1.2	245	0.30	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
   **NMR** talaş kırıcı çok yönlüdür ve Paslanmaz çeliklerin orta düzeyde işlenmesi için ilk tercihtir. Pozitif eğim açısı ve pozitif, geniş T-land özelliğine sahiptir. Çelikler ve Süper alaşımlar için de uygundur.																			
VNMG 160404E-NMR:T7325	0.4	125	0.20	1.2	95	0.18	1.2	–	–	–	–	–	–	40	0.18	1.0	–	–	–
VNMG 160404E-NMR:T9325	0.4	155	0.20	1.2	90	0.18	1.2	–	–	–	–	–	–	30	0.18	1.0	–	–	–
VNMG 160408E-NMR:T7325	0.8	130	0.30	1.4	100	0.27	1.4	–	–	–	–	–	–	40	0.24	1.1	–	–	–
VNMG 160408E-NMR:T8430	0.8	125	0.30	1.4	65	0.27	1.4	–	–	–	–	–	–	25	0.24	1.1	–	–	–
VNMG 160408E-NMR:T9325	0.8	150	0.30	1.4	90	0.27	1.4	–	–	–	–	–	–	30	0.24	1.1	–	–	–
VNMG 160408E-NMR:T9415	0.8	200	0.30	1.4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
VNMG 160412E-NMR:T8430	1.2	130	0.30	1.4	70	0.27	1.4	–	–	–	–	–	–	25	0.24	1.1	–	–	–
   **NMR** talaş kırıcı çok yönlüdür ve Paslanmaz çeliklerin orta düzeyde işlenmesi için ilk tercihtir. Pozitif eğim açısı ve pozitif, geniş T-land özelliğine sahiptir. Çelikler ve Süper alaşımlar için de uygundur.																			
WNMG 060404E-NMR:T6310	0.4	145	0.25	1.6	100	0.23	1.6	–	–	–	–	–	–	40	0.20	1.3	–	–	–
WNMG 060404E-NMR:T7325	0.4	160	0.25	1.6	120	0.23	1.6	–	–	–	–	–	–	50	0.20	1.3	–	–	–
WNMG 060404E-NMR:T8430	0.4	165	0.25	1.6	90	0.23	1.6	–	–	–	–	–	–	35	0.20	1.3	–	–	–
WNMG 060404E-NMR:T9325	0.4	200	0.25	1.6	120	0.23	1.6	–	–	–	–	–	–	45	0.20	1.3	–	–	–
WNMG 060408E-NMR:T7325	0.8	175	0.35	1.6	135	0.32	1.6	–	–	–	–	–	–	55	0.25	1.3	–	–	–
WNMG 060408E-NMR:T7335	0.8	170	0.35	1.6	130	0.32	1.6	–	–	–	–	–	–	55	0.25	1.3	–	–	–
WNMG 060408E-NMR:T8430	0.8	155	0.35	2.7	85	0.32	2.7	–	–	–	–	–	–	30	0.25	2.2	–	–	–
WNMG 060408E-NMR:T9325	0.8	200	0.35	1.6	120	0.32	1.6	–	–	–	–	–	–	45	0.25	1.3	–	–	–
WNMG 080404E-NMR:T6310	0.4	140	0.25	2.7	100	0.23	2.7	–	–	–	–	–	–	40	0.20	2.2	–	–	–
WNMG 080404E-NMR:T7325	0.4	155	0.25	2.7	120	0.23	2.7	–	–	–	–	–	–	50	0.20	2.2	–	–	–
WNMG 080404E-NMR:T7335	0.4	150	0.25	2.7	115	0.23	2.7	–	–	–	–	–	–	45	0.20	2.2	–	–	–
WNMG 080404E-NMR:T8430	0.4	150	0.25	2.7	80	0.23	2.7	–	–	–	–	–	–	30	0.20	2.2	–	–	–
WNMG 080404E-NMR:T9415	0.4	240	0.25	2.7	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG 080408E-NMR:T6310	0.8	150	0.35	2.7	105	0.32	2.7	–	–	–	–	–	–	45	0.25	2.2	–	–	–
WNMG 080408E-NMR:T7325	0.8	170	0.35	2.7	130	0.32	2.7	–	–	–	–	–	–	55	0.25	2.2	–	–	–
WNMG 080408E-NMR:T7335	0.8	160	0.35	2.7	120	0.32	2.7	–	–	–	–	–	–	50	0.25	2.2	–	–	–
WNMG 080408E-NMR:T8430	0.8	155	0.35	2.7	85	0.32	2.7	–	–	–	–	–	–	30	0.25	2.2	–	–	–
WNMG 080408E-NMR:T9325	0.8	190	0.35	2.7	110	0.32	2.7	–	–	–	–	–	–	40	0.25	2.2	–	–	–
WNMG 080408E-NMR:T9415	0.8	255	0.35	2.7	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG 080412E-NMR:T6310	1.2	150	0.40	2.7	105	0.36	2.7	–	–	–	–	–	–	45	0.28	2.2	–	–	–
WNMG 080412E-NMR:T7325	1.2	170	0.40	2.7	130	0.36	2.7	–	–	–	–	–	–	55	0.28	2.2	–	–	–
WNMG 080412E-NMR:T7335	1.2	160	0.40	2.7	120	0.36	2.7	–	–	–	–	–	–	50	0.28	2.2	–	–	–
WNMG 080412E-NMR:T8430	1.2	155	0.40	2.7	85	0.36	2.7	–	–	–	–	–	–	30	0.28	2.2	–	–	–
WNMG 080412E-NMR:T9325	1.2	190	0.40	2.7	110	0.36	2.7	–	–	–	–	–	–	40	0.28	2.2	–	–	–
WNMG 080412E-NMR:T9415	1.2	255	0.40	2.7	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

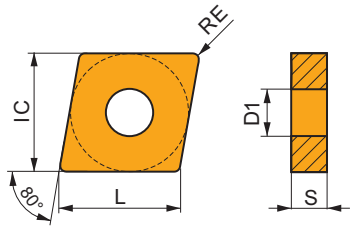
NM



NM talaş kırıcı keskindir ve Çeliklerin, Paslanmaz çeliklerin ve Süper alaşımların orta düzeyde işlenmesi için tasarlanmıştır. Son derece pozitif eğim açısı ve pozitif, ılımlı T-land özelliğine sahiptir. Demir dışı alaşımlar için de şartlara bağlı olarak uygundur.

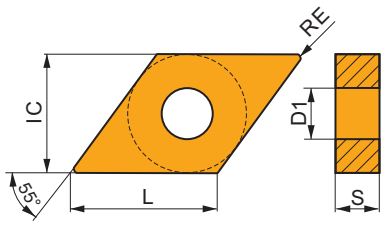
CNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.90	4.76
1606	15.875	6.35	16.10	6.35
1906	19.050	7.94	19.30	6.35



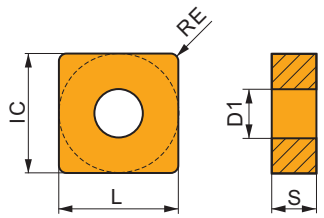
DNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1104	9.525	3.81	11.60	4.76
1504	12.700	5.16	15.50	4.76
1506	12.700	5.16	15.50	6.35



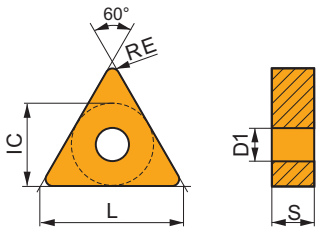
SNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76



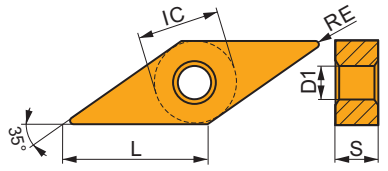
TNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76
2204	12.700	5.16	22.00	4.76



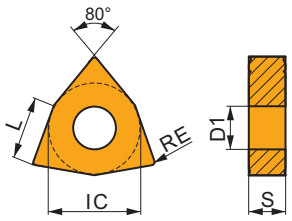
VNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.60	4.76

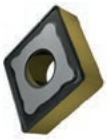
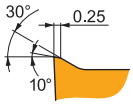
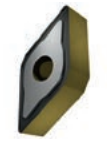
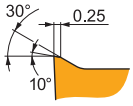


WNMG

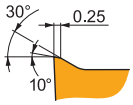
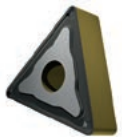
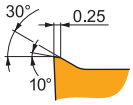
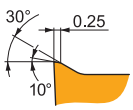
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0604	9.525	3.81	6.50	4.76
0804	12.700	5.16	8.70	4.76



Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

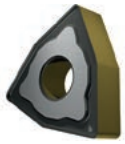
Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
NM talaş kırıcı keskindir ve Çeliklerin, Paslanmaz çeliklerin ve Süper alaşımların orta düzeyde işlenmesi için tasarlanmıştır. Son derece pozitif eğim açısı ve pozitif, ılımlı T-land özelliğine sahiptir. Demir dışı alaşımlar için de şartlara bağlı olarak uygundur.																			
CNMG 120404E-NM:T7325	0.4	195	0.20	2.1	150	0.18	2.1	–	–	–	–	–	–	60	0.16	1.7	–	–	–
CNMG 120404E-NM:T7335	0.4	190	0.20	2.1	145	0.18	2.1	–	–	–	–	–	–	60	0.16	1.7	–	–	–
CNMG 120404E-NM:T8430	0.4	195	0.20	2.1	105	0.18	2.1	–	–	–	540	0.24	2.1	40	0.16	1.7	–	–	–
CNMG 120404E-NM:T9325	0.4	240	0.20	2.1	140	0.18	2.1	–	–	–	–	–	–	50	0.16	1.7	–	–	–
CNMG 120404E-NM:T9415	0.4	305	0.20	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 120408E-NM:T7325	0.8	215	0.25	2.1	165	0.23	2.1	–	–	–	–	–	–	65	0.20	1.7	–	–	–
CNMG 120408E-NM:T7335	0.8	210	0.25	2.1	160	0.23	2.1	–	–	–	–	–	–	65	0.20	1.7	–	–	–
CNMG 120408E-NM:T8315	0.8	205	0.25	2.1	120	0.23	2.1	–	–	–	615	0.30	2.1	50	0.20	1.7	–	–	–
CNMG 120408E-NM:T8415	0.8	245	0.25	2.1	125	0.23	2.1	–	–	–	615	0.30	2.1	55	0.20	1.7	–	–	–
CNMG 120408E-NM:T8430	0.8	210	0.25	2.1	115	0.23	2.1	–	–	–	585	0.30	2.1	45	0.20	1.7	–	–	–
CNMG 120408E-NM:T9315	0.8	290	0.25	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 120408E-NM:T9325	0.8	260	0.25	2.1	155	0.23	2.1	–	–	–	–	–	–	55	0.20	1.7	–	–	–
CNMG 120408E-NM:T9415	0.8	335	0.25	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 120412E-NM:T7325	1.2	215	0.30	2.1	165	0.27	2.1	–	–	–	–	–	–	65	0.24	1.7	–	–	–
CNMG 120412E-NM:T7335	1.2	210	0.30	2.1	160	0.27	2.1	–	–	–	–	–	–	65	0.24	1.7	–	–	–
CNMG 120412E-NM:T8430	1.2	210	0.30	2.1	115	0.27	2.1	–	–	–	585	0.36	2.1	45	0.24	1.7	–	–	–
CNMG 120412E-NM:T9325	1.2	255	0.30	2.1	150	0.27	2.1	–	–	–	–	–	–	55	0.24	1.7	–	–	–
CNMG 160608E-NM:T7325	0.8	195	0.30	3.6	150	0.27	3.6	–	–	–	–	–	–	60	0.27	2.9	–	–	–
CNMG 160608E-NM:T7335	0.8	190	0.30	3.6	145	0.27	3.6	–	–	–	–	–	–	60	0.27	2.9	–	–	–
CNMG 160608E-NM:T8430	0.8	185	0.30	3.6	100	0.27	3.6	–	–	–	510	0.36	3.6	40	0.27	2.9	–	–	–
CNMG 160608E-NM:T9325	0.8	225	0.30	3.6	135	0.27	3.6	–	–	–	–	–	–	50	0.27	2.9	–	–	–
CNMG 160612E-NM:T7325	1.2	205	0.30	3.6	155	0.27	3.6	–	–	–	–	–	–	65	0.27	2.9	–	–	–
CNMG 160612E-NM:T7335	1.2	200	0.30	3.6	155	0.27	3.6	–	–	–	–	–	–	65	0.27	2.9	–	–	–
CNMG 160612E-NM:T8315	1.2	195	0.30	3.6	115	0.27	3.6	–	–	–	585	0.36	3.6	45	0.27	2.9	–	–	–
CNMG 160612E-NM:T9325	1.2	240	0.30	3.6	140	0.27	3.6	–	–	–	–	–	–	50	0.27	2.9	–	–	–
CNMG 190612E-NM:T7325	1.2	195	0.35	4.2	150	0.32	4.2	–	–	–	–	–	–	60	0.32	3.4	–	–	–
CNMG 190612E-NM:T7335	1.2	180	0.35	4.2	140	0.32	4.2	–	–	–	–	–	–	55	0.32	3.4	–	–	–
CNMG 190612E-NM:T8430	1.2	180	0.35	4.2	95	0.32	4.2	–	–	–	495	0.42	4.2	35	0.32	3.4	–	–	–
CNMG 190612E-NM:T9325	1.2	220	0.35	4.2	130	0.32	4.2	–	–	–	–	–	–	45	0.32	3.4	–	–	–
 																			
NM talaş kırıcı keskindir ve Çeliklerin, Paslanmaz çeliklerin ve Süper alaşımların orta düzeyde işlenmesi için tasarlanmıştır. Son derece pozitif eğim açısı ve pozitif, ılımlı T-land özelliğine sahiptir. Demir dışı alaşımlar için de şartlara bağlı olarak uygundur.																			
DNMG 110404E-NM:T7325	0.4	175	0.20	0.8	135	0.18	0.8	–	–	–	–	–	–	55	0.20	0.6	–	–	–
DNMG 110404E-NM:T7335	0.4	165	0.20	0.8	125	0.18	0.8	–	–	–	–	–	–	50	0.20	0.6	–	–	–
DNMG 110404E-NM:T8430	0.4	175	0.20	0.8	95	0.18	0.8	–	–	–	480	0.24	0.8	35	0.20	0.6	–	–	–
DNMG 110404E-NM:T9325	0.4	210	0.20	0.8	125	0.18	0.8	–	–	–	–	–	–	45	0.20	0.6	–	–	–
DNMG 110408E-NM:T7325	0.8	190	0.25	0.8	145	0.23	0.8	–	–	–	–	–	–	60	0.20	0.6	–	–	–
DNMG 110408E-NM:T7335	0.8	185	0.25	0.8	140	0.23	0.8	–	–	–	–	–	–	60	0.20	0.6	–	–	–
DNMG 110408E-NM:T8315	0.8	180	0.25	0.8	105	0.23	0.8	–	–	–	540	0.30	0.8	45	0.20	0.6	–	–	–
DNMG 110408E-NM:T8415	0.8	215	0.25	0.8	110	0.23	0.8	–	–	–	540	0.30	0.8	45	0.20	0.6	–	–	–
DNMG 110408E-NM:T8430	0.8	190	0.25	0.8	105	0.23	0.8	–	–	–	525	0.30	0.8	40	0.20	0.6	–	–	–
DNMG 110408E-NM:T9325	0.8	230	0.25	0.8	135	0.23	0.8	–	–	–	–	–	–	50	0.20	0.6	–	–	–
DNMG 150408E-NM:T8430	0.8	175	0.25	1.9	95	0.23	1.9	–	–	–	480	0.30	1.9	35	0.20	1.5	–	–	–
DNMG 150408E-NM:T9325	0.8	210	0.25	1.9	125	0.23	1.9	–	–	–	–	–	–	45	0.20	1.5	–	–	–
DNMG 150604E-NM:T7325	0.4	160	0.20	1.9	120	0.18	1.9	–	–	–	–	–	–	50	0.20	1.5	–	–	–
DNMG 150604E-NM:T7335	0.4	150	0.20	1.9	115	0.18	1.9	–	–	–	–	–	–	45	0.20	1.5	–	–	–
DNMG 150604E-NM:T8430	0.4	155	0.20	1.9	85	0.18	1.9	–	–	–	435	0.24	1.9	30	0.20	1.5	–	–	–
DNMG 150604E-NM:T9325	0.4	195	0.20	1.9	115	0.18	1.9	–	–	–	–	–	–	40	0.20	1.5	–	–	–
DNMG 150608E-NM:T7325	0.8	175	0.25	1.9	135	0.23	1.9	–	–	–	–	–	–	55	0.20	1.5	–	–	–
DNMG 150608E-NM:T7335	0.8	170	0.25	1.9	130	0.23	1.9	–	–	–	–	–	–	55	0.20	1.5	–	–	–
DNMG 150608E-NM:T8315	0.8	165	0.25	1.9	95	0.23	1.9	–	–	–	495	0.30	1.9	40	0.20	1.5	–	–	–
DNMG 150608E-NM:T8430	0.8	175	0.25	1.9	95	0.23	1.9	–	–	–	480	0.30	1.9	35	0.20	1.5	–	–	–
DNMG 150608E-NM:T9325	0.8	210	0.25	1.9	125	0.23	1.9	–	–	–	–	–	–	45	0.20	1.5	–	–	–
DNMG 150608E-NM:T9415	0.8	275	0.25	1.9	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG 150612E-NM:T7325	1.2	175	0.30	1.9	135	0.27	1.9	–	–	–	–	–	–	55	0.24	1.5	–	–	–
DNMG 150612E-NM:T7335	1.2	170	0.30	1.9	130	0.27	1.9	–	–	–	–	–	–	55	0.24	1.5	–	–	–
DNMG 150612E-NM:T9325	1.2	205	0.30	1.9	120	0.27	1.9	–	–	–	–	–	–	45	0.24	1.5	–	–	–

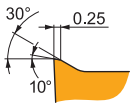
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
NM talaş kırıcı keskindir ve Çeliklerin, Paslanmaz çeliklerin ve Süper alaşımların orta düzeyde işlenmesi için tasarlanmıştır. Son derece pozitif eğim açısı ve pozitif, ılımlı T-land özelliğine sahiptir. Demir dışı alaşımlar için de şartlara bağlı olarak uygundur.																			
SNMG 120408E-NM:T7325	0.8	225	0.25	2.1	175	0.23	2.1	–	–	–	–	–	–	70	0.20	1.7	–	–	–
SNMG 120408E-NM:T7335	0.8	220	0.25	2.1	170	0.23	2.1	–	–	–	–	–	–	70	0.20	1.7	–	–	–
SNMG 120408E-NM:T8430	0.8	225	0.25	2.1	120	0.23	2.1	–	–	–	615	0.30	2.1	45	0.20	1.7	–	–	–
SNMG 120408E-NM:T9325	0.8	275	0.25	2.1	165	0.23	2.1	–	–	–	–	–	–	60	0.20	1.7	–	–	–
SNMG 120412E-NM:T7325	1.2	225	0.30	2.1	175	0.27	2.1	–	–	–	–	–	–	70	0.24	1.7	–	–	–
SNMG 120412E-NM:T7335	1.2	220	0.30	2.1	170	0.27	2.1	–	–	–	–	–	–	70	0.24	1.7	–	–	–
SNMG 120412E-NM:T9325	1.2	270	0.30	2.1	160	0.27	2.1	–	–	–	–	–	–	60	0.24	1.7	–	–	–
 																			
NM talaş kırıcı keskindir ve Çeliklerin, Paslanmaz çeliklerin ve Süper alaşımların orta düzeyde işlenmesi için tasarlanmıştır. Son derece pozitif eğim açısı ve pozitif, ılımlı T-land özelliğine sahiptir. Demir dışı alaşımlar için de şartlara bağlı olarak uygundur.																			
TNMG 160404E-NM:T7325	0.4	170	0.20	1.9	130	0.18	1.9	–	–	–	–	–	–	55	0.20	1.5	–	–	–
TNMG 160404E-NM:T7335	0.4	160	0.20	1.9	120	0.18	1.9	–	–	–	–	–	–	50	0.20	1.5	–	–	–
TNMG 160404E-NM:T8430	0.4	170	0.20	1.9	90	0.18	1.9	–	–	–	465	0.24	1.9	35	0.20	1.5	–	–	–
TNMG 160404E-NM:T9325	0.4	210	0.20	1.9	125	0.18	1.9	–	–	–	–	–	–	45	0.20	1.5	–	–	–
TNMG 160408E-NM:T7325	0.8	190	0.25	1.9	145	0.23	1.9	–	–	–	–	–	–	60	0.20	1.5	–	–	–
TNMG 160408E-NM:T7335	0.8	180	0.25	1.9	140	0.23	1.9	–	–	–	–	–	–	55	0.20	1.5	–	–	–
TNMG 160408E-NM:T8315	0.8	175	0.25	1.9	105	0.23	1.9	–	–	–	525	0.30	1.9	40	0.20	1.5	–	–	–
TNMG 160408E-NM:T8415	0.8	215	0.25	1.9	110	0.23	1.9	–	–	–	540	0.30	1.9	45	0.20	1.5	–	–	–
TNMG 160408E-NM:T8430	0.8	185	0.25	1.9	100	0.23	1.9	–	–	–	510	0.30	1.9	40	0.20	1.5	–	–	–
TNMG 160408E-NM:T9325	0.8	225	0.25	1.9	135	0.23	1.9	–	–	–	–	–	–	50	0.20	1.5	–	–	–
TNMG 160408E-NM:T9415	0.8	290	0.25	1.9	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG 220408E-NM:T7325	0.8	190	0.25	1.7	145	0.23	1.7	–	–	–	–	–	–	60	0.20	1.4	–	–	–
TNMG 220408E-NM:T7335	0.8	185	0.25	1.7	140	0.23	1.7	–	–	–	–	–	–	60	0.20	1.4	–	–	–
TNMG 220408E-NM:T8315	0.8	175	0.25	1.7	105	0.23	1.7	–	–	–	525	0.30	1.7	40	0.20	1.4	–	–	–
TNMG 220408E-NM:T8415	0.8	215	0.25	1.7	110	0.23	1.7	–	–	–	540	0.30	1.7	45	0.20	1.4	–	–	–
TNMG 220408E-NM:T8430	0.8	185	0.25	1.7	100	0.23	1.7	–	–	–	510	0.30	1.7	40	0.20	1.4	–	–	–
TNMG 220408E-NM:T9325	0.8	225	0.25	1.7	135	0.23	1.7	–	–	–	–	–	–	50	0.20	1.4	–	–	–
TNMG 220412E-NM:T7325	1.2	190	0.30	1.7	145	0.27	1.7	–	–	–	–	–	–	60	0.24	1.4	–	–	–
TNMG 220412E-NM:T7335	1.2	180	0.30	2.1	140	0.27	2.1	–	–	–	–	–	–	55	0.24	1.7	–	–	–
TNMG 220412E-NM:T9325	1.2	215	0.30	2.1	125	0.27	2.1	–	–	–	–	–	–	45	0.24	1.7	–	–	–
 																			
NM talaş kırıcı keskindir ve Çeliklerin, Paslanmaz çeliklerin ve Süper alaşımların orta düzeyde işlenmesi için tasarlanmıştır. Son derece pozitif eğim açısı ve pozitif, ılımlı T-land özelliğine sahiptir. Demir dışı alaşımlar için de şartlara bağlı olarak uygundur.																			
VNMG 160404E-NM:T7325	0.4	145	0.20	1.2	110	0.18	1.2	–	–	–	–	–	–	45	0.20	1.0	–	–	–
VNMG 160404E-NM:T7335	0.4	140	0.20	1.2	105	0.18	1.2	–	–	–	–	–	–	45	0.20	1.0	–	–	–
VNMG 160404E-NM:T8315	0.4	135	0.20	1.2	80	0.18	1.2	–	–	–	405	0.24	1.2	30	0.20	1.0	–	–	–
VNMG 160404E-NM:T8415	0.4	160	0.20	1.2	85	0.18	1.2	–	–	–	405	0.24	1.2	35	0.20	1.0	–	–	–
VNMG 160404E-NM:T8430	0.4	145	0.20	1.2	80	0.18	1.2	–	–	–	405	0.24	1.2	30	0.20	1.0	–	–	–
VNMG 160404E-NM:T9325	0.4	180	0.20	1.2	105	0.18	1.2	–	–	–	–	–	–	40	0.20	1.0	–	–	–
VNMG 160408E-NM:T7325	0.8	160	0.25	1.4	120	0.23	1.4	–	–	–	–	–	–	50	0.20	1.1	–	–	–
VNMG 160408E-NM:T7335	0.8	155	0.25	1.4	120	0.23	1.4	–	–	–	–	–	–	50	0.20	1.1	–	–	–
VNMG 160408E-NM:T8315	0.8	145	0.25	1.4	85	0.23	1.4	–	–	–	435	0.30	1.4	35	0.20	1.1	–	–	–
VNMG 160408E-NM:T8415	0.8	180	0.25	1.4	90	0.23	1.4	–	–	–	450	0.30	1.4	40	0.20	1.1	–	–	–
VNMG 160408E-NM:T8430	0.8	155	0.25	1.4	85	0.23	1.4	–	–	–	435	0.30	1.4	30	0.20	1.1	–	–	–
VNMG 160408E-NM:T9325	0.8	190	0.25	1.4	110	0.23	1.4	–	–	–	–	–	–	40	0.20	1.1	–	–	–

Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P			M			K			N			S			H		
			vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)





NM talaş kırıcı keskindir ve Çeliklerin, Paslanmaz çeliklerin ve Süper alaşımların orta düzeyde işlenmesi için tasarlanmıştır. Son derece pozitif eğim açısı ve pozitif, ılımlı T-land özelliğine sahiptir. Demir dışı alaşımlar için de şartlara bağlı olarak uygundur.

WNMG 060404E-NM:T7325	●	0.4	◪	200	0.20	1.8	■	155	0.18	1.8		–	–	–		–	–	–	■	65	0.16	1.4		–	–	–
WNMG 060404E-NM:T7335	●	0.4	◪	195	0.20	1.8	■	150	0.18	1.8		–	–	–		–	–	–	■	60	0.16	1.4		–	–	–
WNMG 060404E-NM:T8430	●	0.4	■	185	0.25	1.8	■	100	0.23	1.8		–	–	–	◪	510	0.30	1.8	◪	40	0.20	1.4		–	–	–
WNMG 060404E-NM:T9325	●	0.4	■	245	0.20	1.8	■	145	0.18	1.8		–	–	–		–	–	–	◪	55	0.16	1.4		–	–	–
WNMG 060408E-NM:T7325	●●	0.8	◪	220	0.25	1.8	■	170	0.23	1.8		–	–	–		–	–	–	■	70	0.20	1.4		–	–	–
WNMG 060408E-NM:T7335	●●	0.8	◪	215	0.25	1.8	■	165	0.23	1.8		–	–	–		–	–	–	■	65	0.20	1.4		–	–	–
WNMG 060408E-NM:T8430	●●	0.8	■	220	0.25	1.8	■	120	0.23	1.8		–	–	–	◪	600	0.30	1.8	◪	45	0.20	1.4		–	–	–
WNMG 060408E-NM:T9325	●●	0.8	■	265	0.25	1.8	■	155	0.23	1.8		–	–	–		–	–	–	◪	55	0.20	1.4		–	–	–
WNMG 060412E-NM:T7325	●●	1.2	◪	220	0.30	1.8	■	170	0.27	1.8		–	–	–		–	–	–	■	70	0.24	1.4		–	–	–
WNMG 060412E-NM:T7335	●●	1.2	◪	220	0.30	1.2	■	170	0.27	1.2		–	–	–		–	–	–	■	70	0.24	1.0		–	–	–
WNMG 060412E-NM:T9325	●●	1.2	■	255	0.30	1.8	■	150	0.27	1.8		–	–	–		–	–	–	◪	55	0.24	1.4		–	–	–
WNMG 080404E-NM:T7325	●	0.4	◪	195	0.20	2.1	■	150	0.18	2.1		–	–	–		–	–	–	■	60	0.16	1.7		–	–	–
WNMG 080404E-NM:T7335	●	0.4	◪	190	0.20	2.1	■	145	0.18	2.1		–	–	–		–	–	–	■	60	0.16	1.7		–	–	–
WNMG 080404E-NM:T8430	●	0.4	■	180	0.25	2.1	■	95	0.23	2.1		–	–	–	◪	495	0.30	2.1	◪	35	0.20	1.7		–	–	–
WNMG 080404E-NM:T9315	●	0.4	■	270	0.20	2.1		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–
WNMG 080404E-NM:T9325	●	0.4	■	240	0.20	2.1	■	140	0.18	2.1		–	–	–		–	–	–	◪	50	0.16	1.7		–	–	–
WNMG 080404E-NM:T9415	●	0.4	■	305	0.20	2.1		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–
WNMG 080408E-NM:T7325	●●	0.8	◪	215	0.25	2.1	■	165	0.23	2.1		–	–	–		–	–	–	■	65	0.20	1.7		–	–	–
WNMG 080408E-NM:T7335	●●	0.8	◪	210	0.25	2.1	■	160	0.23	2.1		–	–	–		–	–	–	■	65	0.20	1.7		–	–	–
WNMG 080408E-NM:T8315	●●	0.8	◪	205	0.25	2.1	■	120	0.23	2.1		–	–	–	◪	615	0.30	2.1	◪	50	0.20	1.7		–	–	–
WNMG 080408E-NM:T8430	●●	0.8	■	210	0.25	2.1	■	115	0.23	2.1		–	–	–	◪	585	0.30	2.1	◪	45	0.20	1.7		–	–	–
WNMG 080408E-NM:T9315	●●	0.8	■	290	0.25	2.1		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–
WNMG 080408E-NM:T9325	●●	0.8	■	260	0.25	2.1	■	155	0.23	2.1		–	–	–		–	–	–	◪	55	0.20	1.7		–	–	–
WNMG 080408E-NM:T9415	●●	0.8	■	335	0.25	2.1		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–
WNMG 080412E-NM:T7325	●●	1.2	◪	215	0.30	2.1	■	165	0.27	2.1		–	–	–		–	–	–	■	65	0.24	1.7		–	–	–
WNMG 080412E-NM:T7335	●●	1.2	◪	210	0.30	2.1	■	160	0.27	2.1		–	–	–		–	–	–	■	65	0.24	1.7		–	–	–
WNMG 080412E-NM:T8315	●●	1.2	◪	205	0.30	2.1	■	120	0.27	2.1		–	–	–	◪	615	0.36	2.1	◪	50	0.24	1.7		–	–	–
WNMG 080412E-NM:T8415	●●	1.2	■	245	0.30	2.1	■	125	0.27	2.1		–	–	–	◪	615	0.36	2.1	■	55	0.24	1.7		–	–	–
WNMG 080412E-NM:T9325	●●	1.2	■	255	0.30	2.1	■	150	0.27	2.1		–	–	–		–	–	–	◪	55	0.24	1.7		–	–	–

.NMA





.NMA düz kesici uç, Dökme demirlerin orta düzeyde işlenmesi için tasarlanmıştır. T-land olmadan nötr eğim açısına sahiptir. Sert malzemeler için de şartlara bağlı olarak uygundur.

PRAMET

.NMA ..S



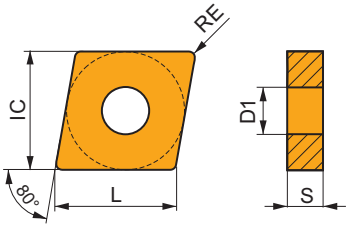


.NMA..S düz kesici uç, Dökme demirlerin orta düzeyde işlenmesi için tasarlanmıştır. Nötr eğim açısına ve negatif, orta T-land özelliğine sahiptir. Sert malzemeler için de şartlı olarak uygundur.

PRAMET

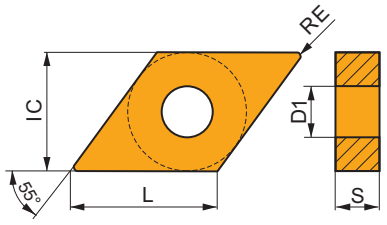
CNMA

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.90	4.76
1606	15.875	6.35	16.10	6.35
1906	19.050	7.94	19.30	6.35



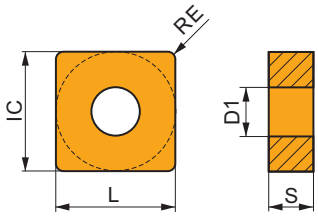
DNMA

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1504	12.700	5.16	15.50	4.76
1506	12.700	5.16	15.50	6.35



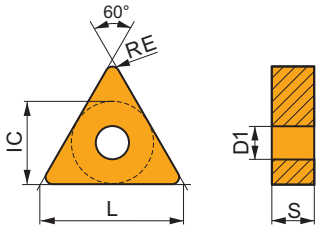
SNMA

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76
1506	15.875	6.35	15.88	6.35
1906	19.050	7.94	19.05	6.35
2507	25.400	9.12	25.40	7.94
2509	25.400	9.12	25.40	9.53



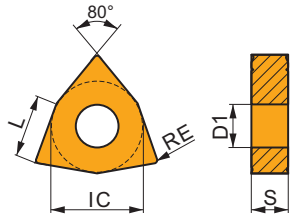
TNMA

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76
2204	12.700	5.16	22.00	4.76

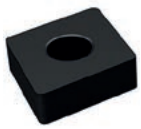
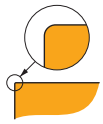
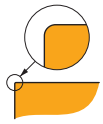
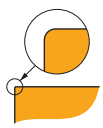
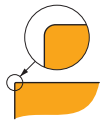


WNMA

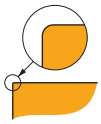
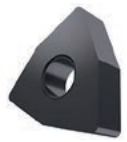
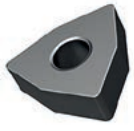
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0804	12.700	5.16	8.70	4.76



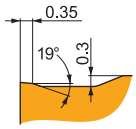
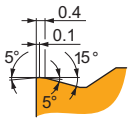
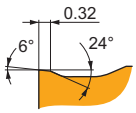
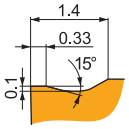
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P			M			K			N			S			H		
			vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)
																				
.NMA düz kesici uç, Dökme demirlerin orta düzeyde işlenmesi için tasarlanmıştır. T-land olmadan nötr eğim açısına sahiptir. Sert malzemeler için de şartlara bağlı olarak uygundur.																				
CNMA 120404:T5305	●	0.4	–	–	–	–	–	–	235	0.10	4.0	–	–	–	–	–	–	50	0.10	0.3
CNMA 120404:T5315	●	0.4	–	–	–	–	–	–	200	0.10	4.0	–	–	–	–	–	–	40	0.10	0.3
CNMA 120408:T5305	●	0.8	–	–	–	–	–	–	220	0.20	4.0	–	–	–	–	–	–	45	0.10	0.7
CNMA 120408:T5315	◆	0.8	–	–	–	–	–	–	190	0.20	4.0	–	–	–	–	–	–	40	0.10	0.7
CNMA 120408:T6310	◆	0.8	–	–	–	–	–	–	100	0.20	4.0	–	–	–	–	–	–	25	0.10	0.7
CNMA 120408:T8415	◆	0.8	–	–	–	–	–	–	145	0.20	4.0	–	–	–	–	–	–	25	0.14	0.5
CNMA 120412:T5305	◆	1.2	–	–	–	–	–	–	195	0.30	4.0	–	–	–	–	–	–	40	0.15	1.0
CNMA 120412:T5315	◆	1.2	–	–	–	–	–	–	180	0.30	4.0	–	–	–	–	–	–	35	0.15	1.0
CNMA 120412:T6310	◆	1.2	–	–	–	–	–	–	95	0.30	4.0	–	–	–	–	–	–	20	0.15	1.0
CNMA 120412:T8415	◆	1.2	–	–	–	–	–	–	135	0.30	4.0	–	–	–	–	–	–	25	0.21	0.5
CNMA 120416:T5305	◆	1.6	–	–	–	–	–	–	190	0.40	4.0	–	–	–	–	–	–	40	0.20	1.3
CNMA 120416:T5315	◆	1.6	–	–	–	–	–	–	170	0.40	4.0	–	–	–	–	–	–	35	0.20	1.3
CNMA 160612:T5305	◆	1.2	–	–	–	–	–	–	190	0.30	5.0	–	–	–	–	–	–	40	0.15	1.0
CNMA 160612:T5315	◆	1.2	–	–	–	–	–	–	175	0.30	5.0	–	–	–	–	–	–	35	0.15	1.0
CNMA 160616:T5315	◆	1.6	–	–	–	–	–	–	165	0.40	5.0	–	–	–	–	–	–	35	0.20	1.3
CNMA 190612:T5305	◆	1.2	–	–	–	–	–	–	190	0.30	6.0	–	–	–	–	–	–	40	0.15	1.0
CNMA 190612:T5315	◆	1.2	–	–	–	–	–	–	170	0.30	6.0	–	–	–	–	–	–	35	0.15	1.0
CNMA 190616:T5305	◆	1.6	–	–	–	–	–	–	180	0.40	6.0	–	–	–	–	–	–	35	0.20	1.3
CNMA 190616:T5315	◆	1.6	–	–	–	–	–	–	160	0.40	6.0	–	–	–	–	–	–	30	0.20	1.3
																				
.NMA..S düz kesici uç, Dökme demirlerin orta düzeyde işlenmesi için tasarlanmıştır. Nötr eğim açısına ve negatif, orta T-land özelliğine sahiptir. Sert malzemeler için de şartlı olarak uygundur.																				
CNMA 120408S:T5305	◆	0.8	–	–	–	–	–	–	220	0.20	4.0	–	–	–	–	–	–	45	0.10	0.7
CNMA 120412S:T5305	◆	1.2	–	–	–	–	–	–	190	0.40	4.0	–	–	–	–	–	–	40	0.20	1.3
CNMA 160612S:T5305	◆	1.2	–	–	–	–	–	–	190	0.30	5.0	–	–	–	–	–	–	40	0.15	1.0
CNMA 190616S:T5305	◆	1.6	–	–	–	–	–	–	180	0.40	6.0	–	–	–	–	–	–	35	0.20	1.3
																				
.NMA düz kesici uç, Dökme demirlerin orta düzeyde işlenmesi için tasarlanmıştır. T-land olmadan nötr eğim açısına sahiptir. Sert malzemeler için de şartlara bağlı olarak uygundur.																				
DNMA 150408:T5305	●	0.8	–	–	–	–	–	–	190	0.20	1.7	–	–	–	–	–	–	40	0.10	0.7
DNMA 150408:T5315	●	0.8	–	–	–	–	–	–	165	0.20	1.7	–	–	–	–	–	–	35	0.10	0.7
DNMA 150604:T5305	●	0.4	–	–	–	–	–	–	205	0.10	1.7	–	–	–	–	–	–	40	0.10	0.3
DNMA 150604:T5315	●	0.4	–	–	–	–	–	–	180	0.10	1.7	–	–	–	–	–	–	35	0.10	0.3
DNMA 150604:T6310	●	0.4	–	–	–	–	–	–	85	0.10	1.7	–	–	–	–	–	–	20	0.07	0.3
DNMA 150604:T8415	●	0.4	–	–	–	–	–	–	130	0.10	1.7	–	–	–	–	–	–	25	0.07	0.5
DNMA 150608:T5305	●	0.8	–	–	–	–	–	–	190	0.20	1.7	–	–	–	–	–	–	40	0.10	0.7
DNMA 150608:T5315	●	0.8	–	–	–	–	–	–	165	0.20	1.7	–	–	–	–	–	–	35	0.10	0.7
DNMA 150608:T6310	◆	0.8	–	–	–	–	–	–	85	0.20	1.7	–	–	–	–	–	–	20	0.10	0.7
DNMA 150608:T8415	◆	0.8	–	–	–	–	–	–	125	0.20	1.7	–	–	–	–	–	–	20	0.14	0.5
DNMA 150612:T5305	●	1.2	–	–	–	–	–	–	200	0.20	1.7	–	–	–	–	–	–	40	0.10	0.9
DNMA 150612:T5315	◆	1.2	–	–	–	–	–	–	175	0.20	1.7	–	–	–	–	–	–	35	0.10	0.9
																				
.NMA düz kesici uç, Dökme demirlerin orta düzeyde işlenmesi için tasarlanmıştır. T-land olmadan nötr eğim açısına sahiptir. Sert malzemeler için de şartlara bağlı olarak uygundur.																				
SNMA 120408:T5305	◆	0.8	–	–	–	–	–	–	230	0.20	4.0	–	–	–	–	–	–	45	0.10	0.7
SNMA 120408:T5315	◆	0.8	–	–	–	–	–	–	200	0.20	4.0	–	–	–	–	–	–	40	0.10	0.7
SNMA 120408:T6310	◆	0.8	–	–	–	–	–	–	100	0.20	4.0	–	–	–	–	–	–	25	0.10	0.7
SNMA 120408:T8415	◆	0.8	–	–	–	–	–	–	150	0.20	4.0	–	–	–	–	–	–	25	0.14	0.5
SNMA 120412:T5305	◆	1.2	–	–	–	–	–	–	205	0.30	4.0	–	–	–	–	–	–	40	0.15	1.0
SNMA 120412:T5315	◆	1.2	–	–	–	–	–	–	190	0.30	4.0	–	–	–	–	–	–	40	0.15	1.0
SNMA 150612:T5305	◆	1.2	–	–	–	–	–	–	200	0.30	5.0	–	–	–	–	–	–	40	0.15	1.0
SNMA 150612:T5315	◆	1.2	–	–	–	–	–	–	185	0.30	5.0	–	–	–	–	–	–	35	0.15	1.0
SNMA 190612:T5305	◆	1.2	–	–	–	–	–	–	195	0.30	6.0	–	–	–	–	–	–	40	0.15	1.0
SNMA 190612:T5315	◆	1.2	–	–	–	–	–	–	180	0.30	6.0	–	–	–	–	–	–	35	0.15	1.0

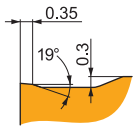
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
   **.NMA** düz kesici uç, Dökme demirlerin orta düzeyde işlenmesi için tasarlanmıştır. T-land olmadan nötr eğim açısına sahiptir. Sert malzemeler için de şartlara bağlı olarak uygundur.																			
SNMA 190616:T5305	1.6	–	–	–	–	–	–	190	0.40	6.0	–	–	–	–	–	–	40	0.20	1.3
SNMA 190616:T5315	1.6	–	–	–	–	–	–	170	0.40	6.0	–	–	–	–	–	–	35	0.20	1.3
SNMA 250724:T5305	2.4	–	–	–	–	–	–	95	0.60	8.0	–	–	–	–	–	–	20	0.30	2.0
SNMA 250724:T5315	2.4	–	–	–	–	–	–	90	0.60	8.0	–	–	–	–	–	–	15	0.30	2.0
SNMA 250924:T5305	2.4	–	–	–	–	–	–	95	0.60	8.0	–	–	–	–	–	–	20	0.30	2.0
SNMA 250924:T5315	2.4	–	–	–	–	–	–	90	0.60	8.0	–	–	–	–	–	–	15	0.30	2.0
   **.NMA..S** düz kesici uç, Dökme demirlerin orta düzeyde işlenmesi için tasarlanmıştır. Nötr eğim açısına ve negatif, orta T-land özelliğine sahiptir. Sert malzemeler için de şartlı olarak uygundur.																			
SNMA 190616S:T5305	1.6	–	–	–	–	–	–	195	0.30	6.0	–	–	–	–	–	–	40	0.15	1.0
SNMA 250924S:T5305	2.4	–	–	–	–	–	–	95	0.60	8.0	–	–	–	–	–	–	20	0.30	2.0
   **.NMA** düz kesici uç, Dökme demirlerin orta düzeyde işlenmesi için tasarlanmıştır. T-land olmadan nötr eğim açısına sahiptir. Sert malzemeler için de şartlara bağlı olarak uygundur.																			
TNMA 160404:T5305	0.4	–	–	–	–	–	–	220	0.10	1.5	–	–	–	–	–	–	45	0.10	0.3
TNMA 160404:T5315	0.4	–	–	–	–	–	–	190	0.10	1.5	–	–	–	–	–	–	40	0.10	0.3
TNMA 160408:T5305	0.8	–	–	–	–	–	–	205	0.20	1.5	–	–	–	–	–	–	40	0.10	0.7
TNMA 160408:T5315	0.8	–	–	–	–	–	–	180	0.20	1.5	–	–	–	–	–	–	35	0.10	0.7
TNMA 160408:T6310	0.8	–	–	–	–	–	–	90	0.20	1.5	–	–	–	–	–	–	20	0.10	0.7
TNMA 160408:T8415	0.8	–	–	–	–	–	–	135	0.20	1.5	–	–	–	–	–	–	25	0.14	0.5
TNMA 160412:T5305	1.2	–	–	–	–	–	–	215	0.20	1.5	–	–	–	–	–	–	45	0.10	0.9
TNMA 160412:T5315	1.2	–	–	–	–	–	–	190	0.20	1.5	–	–	–	–	–	–	40	0.10	0.9
TNMA 220408:T5305	0.8	–	–	–	–	–	–	195	0.20	2.0	–	–	–	–	–	–	40	0.10	0.7
TNMA 220408:T5315	0.8	–	–	–	–	–	–	175	0.20	2.0	–	–	–	–	–	–	35	0.10	0.7
TNMA 220408:T6310	0.8	–	–	–	–	–	–	90	0.20	2.0	–	–	–	–	–	–	20	0.10	0.7
TNMA 220408:T8415	0.8	–	–	–	–	–	–	130	0.20	2.0	–	–	–	–	–	–	25	0.14	0.5
TNMA 220412:T5305	1.2	–	–	–	–	–	–	205	0.20	2.0	–	–	–	–	–	–	40	0.10	0.9
TNMA 220412:T5315	1.2	–	–	–	–	–	–	185	0.20	2.0	–	–	–	–	–	–	35	0.10	0.9
   **.NMA..S** düz kesici uç, Dökme demirlerin orta düzeyde işlenmesi için tasarlanmıştır. Nötr eğim açısına ve negatif, orta T-land özelliğine sahiptir. Sert malzemeler için de şartlı olarak uygundur.																			
TNMA 160408S:T5305	0.8	–	–	–	–	–	–	205	0.20	1.5	–	–	–	–	–	–	40	0.10	0.7
   **.NMA** düz kesici uç, Dökme demirlerin orta düzeyde işlenmesi için tasarlanmıştır. T-land olmadan nötr eğim açısına sahiptir. Sert malzemeler için de şartlara bağlı olarak uygundur.																			
WNMA 080404:T5305	0.4	–	–	–	–	–	–	235	0.10	4.0	–	–	–	–	–	–	50	0.10	0.3
WNMA 080404:T5315	0.4	–	–	–	–	–	–	200	0.10	4.0	–	–	–	–	–	–	40	0.10	0.3
WNMA 080408:T5305	0.8	–	–	–	–	–	–	220	0.20	4.0	–	–	–	–	–	–	45	0.10	0.7
WNMA 080408:T5315	0.8	–	–	–	–	–	–	190	0.20	4.0	–	–	–	–	–	–	40	0.10	0.7
WNMA 080408:T6310	0.8	–	–	–	–	–	–	100	0.20	4.0	–	–	–	–	–	–	25	0.10	0.7
WNMA 080408:T8415	0.8	–	–	–	–	–	–	145	0.20	4.0	–	–	–	–	–	–	25	0.14	0.5
WNMA 080412:T5305	1.2	–	–	–	–	–	–	195	0.30	4.0	–	–	–	–	–	–	40	0.15	1.0
WNMA 080412:T5315	1.2	–	–	–	–	–	–	180	0.30	4.0	–	–	–	–	–	–	35	0.15	1.0
WNMA 080412:T6310	1.2	–	–	–	–	–	–	95	0.30	4.0	–	–	–	–	–	–	20	0.15	1.0
WNMA 080412:T8415	1.2	–	–	–	–	–	–	135	0.30	4.0	–	–	–	–	–	–	25	0.21	0.5
   **.NMA..S** düz kesici uç, Dökme demirlerin orta düzeyde işlenmesi için tasarlanmıştır. Nötr eğim açısına ve negatif, orta T-land özelliğine sahiptir. Sert malzemeler için de şartlı olarak uygundur.																			
WNMA 080408S:T5305	0.8	–	–	–	–	–	–	220	0.20	4.0	–	–	–	–	–	–	45	0.10	0.7

KABA İŞLEME - REHBER

RM			**RM** talaş kırıcı sağlamdır ve Çeliklerin kaba işlenmesi için ilk tercihtir. Pozitif eğim açısı ve dengeli, geniş T-land özelliğine sahiptir. Ayrıca Paslanmaz çelikler, Dökme demirler ve şartlara bağlı olarak Süper alaşımlar için de uygundur.
R			**R** talaş kırıcı sağlamdır ve Çeliklerin ve Dökme demirlerin kaba işlenmesi için tasarlanmıştır. Hafif pozitif eğim açısı ve negatif/kararlı, ekstra geniş çift T-land özelliğine sahiptir. Sert malzemeler için de şartlı olarak uygundur.
NRM			**NRM** talaş kırıcı çok yönlüdür ve Paslanmaz çeliklerin kaba işlenmesi için ilk tercihtir. Pozitif eğim açısı ve dengeli, geniş T-land özelliğine sahiptir. Çelikler ve Süper alaşımlar için de uygundur.
KR			**KR** talaş kırıcı sağlamdır ve dökme demirlerin kaba işlenmesi için ilk tercihtir. Hafif pozitif eğim açısı ve geniş T-land özelliğine sahiptir. Çelikler için ve şartlı olarak Sert malzemeler için de uygundur.

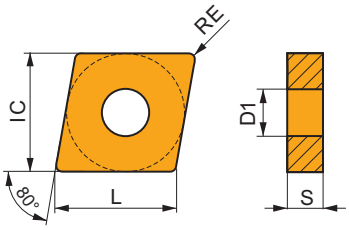
RM



RM talaş kırıcı sağlamdır ve Çeliklerin kaba işlenmesi için ilk tercihtir. Pozitif eğim açısı ve dengeli, geniş T-land özelliğine sahiptir. Ayrıca Paslanmaz çelikler, Dökme demirler ve şartlara bağlı olarak Süper alaşımlar için de uygundur.

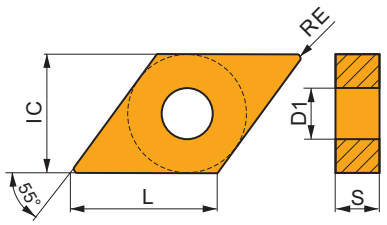
CNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.90	4.76
1606	15.875	6.35	16.10	6.35
1906	19.050	7.94	19.30	6.35
2509	25.400	9.12	25.80	9.53



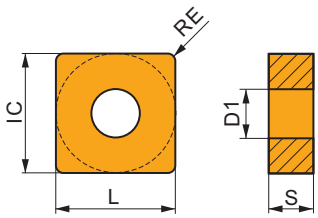
DNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1104	9.525	3.81	11.60	4.76
1504	12.700	5.16	15.50	4.76
1506	12.700	5.16	15.50	6.35



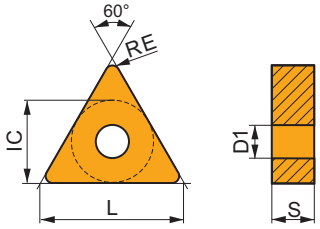
SNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76
1506	15.875	6.35	15.88	6.35
1906	19.050	7.94	19.05	6.35
2509	25.400	9.12	25.40	9.53



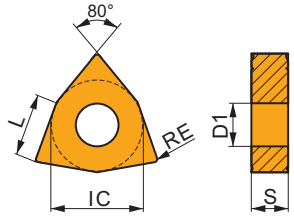
TNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76
2204	12.700	5.16	22.00	4.76
2706	15.875	6.35	27.50	6.35
3309	19.050	7.94	33.00	9.53



WNMG

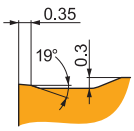
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0604	9.525	3.81	6.50	4.76
0804	12.700	5.16	8.70	4.76



Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE	P			M			K			N			S			H		
		vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)
	(mm)																		

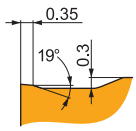
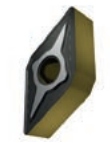
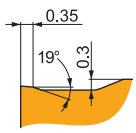




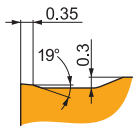
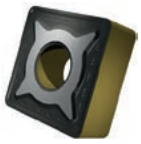
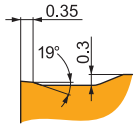
RM talaş kırıcı sağlamdır ve Çeliklerin kaba işlenmesi için ilk tercihtir. Pozitif eğim açısı ve dengeli, geniş T-land özelliğine sahiptir. Ayrıca Paslanmaz çelikler, Dökme demirler ve şartlara bağlı olarak Süper alaşımlar için de uygundur.

CNMG 120408E-RM:T5305	●	0.8	◪	275	0.40	4.0		–	–	–	■	260	0.40	4.0		–	–	–		–	–	–		–	–	–
CNMG 120408E-RM:T5315	❁	0.8	◪	250	0.40	4.0		–	–	–	■	235	0.40	4.0		–	–	–		–	–	–		–	–	–
CNMG 120408E-RM:T6310	❁	0.8	■	155	0.40	4.0	■	110	0.36	4.0	■	125	0.40	4.0		–	–	–	◪	45	0.28	3.2		–	–	–
CNMG 120408E-RM:T7325	❁	0.8	◪	180	0.40	4.0	■	140	0.36	4.0		–	–	–		–	–	–	◪	55	0.28	3.2		–	–	–
CNMG 120408E-RM:T7335	❁	0.8	◪	165	0.40	4.0	■	125	0.36	4.0		–	–	–		–	–	–	◪	50	0.28	3.2		–	–	–
CNMG 120408E-RM:T8315	❁	0.8	◪	165	0.40	4.0	■	95	0.36	4.0	■	155	0.40	4.0		–	–	–	◪	40	0.28	3.2		–	–	–
CNMG 120408E-RM:T8415	❁	0.8	■	195	0.40	4.0	■	100	0.36	4.0	■	180	0.40	4.0		–	–	–	◪	45	0.28	3.2		–	–	–
CNMG 120408E-RM:T8430	❁	0.8	■	165	0.40	4.0	■	90	0.36	4.0	◪	135	0.40	4.0		–	–	–	◪	35	0.28	3.2		–	–	–
CNMG 120408E-RM:T9310	❁	0.8	■	240	0.40	4.0		–	–	–	◪	225	0.40	4.0		–	–	–		–	–	–		–	–	–
CNMG 120408E-RM:T9315	❁	0.8	■	220	0.40	4.0		–	–	–	◪	205	0.40	4.0		–	–	–		–	–	–		–	–	–
CNMG 120408E-RM:T9325	❁	0.8	■	200	0.40	4.0	■	120	0.36	4.0	◪	190	0.40	4.0		–	–	–	◪	45	0.28	3.2		–	–	–
CNMG 120408E-RM:T9335	❁	0.8	■	170	0.40	4.0	■	100	0.36	4.0		–	–	–		–	–	–	◪	35	0.28	3.2		–	–	–
CNMG 120408E-RM:T9415	❁	0.8	■	265	0.40	4.0		–	–	–	◪	250	0.40	4.0		–	–	–		–	–	–		–	–	–
CNMG 120412E-RM:T5305	❁	1.2	◪	280	0.45	4.0		–	–	–	■	265	0.45	4.0		–	–	–		–	–	–		–	–	–
CNMG 120412E-RM:T5315	❁	1.2	◪	250	0.45	4.0		–	–	–	■	235	0.45	4.0		–	–	–		–	–	–		–	–	–
CNMG 120412E-RM:T6310	❁	1.2	■	160	0.45	4.0	■	115	0.41	4.0	■	125	0.45	4.0		–	–	–	◪	45	0.32	3.2		–	–	–
CNMG 120412E-RM:T7325	❁	1.2	◪	180	0.45	4.0	■	140	0.41	4.0		–	–	–		–	–	–	◪	55	0.32	3.2		–	–	–
CNMG 120412E-RM:T7335	❁	1.2	◪	170	0.45	4.0	■	130	0.41	4.0		–	–	–		–	–	–	◪	55	0.32	3.2		–	–	–
CNMG 120412E-RM:T8415	❁	1.2	■	200	0.45	4.0	■	105	0.41	4.0	■	185	0.45	4.0		–	–	–	◪	45	0.32	3.2		–	–	–
CNMG 120412E-RM:T8430	✱	1.2	■	170	0.45	4.0	■	90	0.41	4.0	◪	135	0.45	4.0		–	–	–	◪	35	0.32	3.2		–	–	–
CNMG 120412E-RM:T9310	❁	1.2	■	240	0.45	4.0		–	–	–	◪	225	0.45	4.0		–	–	–		–	–	–		–	–	–
CNMG 120412E-RM:T9315	❁	1.2	■	220	0.45	4.0		–	–	–	◪	205	0.45	4.0		–	–	–		–	–	–		–	–	–
CNMG 120412E-RM:T9325	❁	1.2	■	200	0.45	4.0	■	120	0.41	4.0	◪	190	0.45	4.0		–	–	–	◪	45	0.32	3.2		–	–	–
CNMG 120412E-RM:T9335	❁	1.2	■	175	0.45	4.0	■	105	0.41	4.0		–	–	–		–	–	–	◪	35	0.32	3.2		–	–	–
CNMG 120412E-RM:T9415	❁	1.2	■	270	0.45	4.0		–	–	–	◪	255	0.45	4.0		–	–	–		–	–	–		–	–	–
CNMG 120416E-RM:T5315	❁	1.6	◪	255	0.50	4.0		–	–	–	■	240	0.50	4.0		–	–	–		–	–	–		–	–	–
CNMG 120416E-RM:T7335	❁	1.6	◪	175	0.50	4.0	■	135	0.45	4.0		–	–	–		–	–	–	◪	55	0.35	3.2		–	–	–
CNMG 120416E-RM:T8430	✱	1.6	■	170	0.50	4.0	■	90	0.45	4.0	◪	135	0.50	4.0		–	–	–	◪	35	0.35	3.2		–	–	–
CNMG 120416E-RM:T9325	❁	1.6	■	205	0.50	4.0	■	120	0.45	4.0	◪	190	0.50	4.0		–	–	–	◪	45	0.35	3.2		–	–	–
CNMG 120416E-RM:T9335	❁	1.6	■	175	0.50	4.0	■	105	0.45	4.0		–	–	–		–	–	–	◪	35	0.35	3.2		–	–	–
CNMG 120416E-RM:T9415	❁	1.6	■	275	0.50	4.0		–	–	–	◪	260	0.50	4.0		–	–	–		–	–	–		–	–	–
CNMG 160608E-RM:T5305	❁	0.8	◪	265	0.40	6.0		–	–	–	■	250	0.40	6.0		–	–	–		–	–	–		–	–	–
CNMG 160608E-RM:T5315	❁	0.8	◪	240	0.40	6.0		–	–	–	■	225	0.40	6.0		–	–	–		–	–	–		–	–	–
CNMG 160608E-RM:T8430	❁	0.8	■	155	0.40	6.0	■	85	0.36	6.0	◪	130	0.40	6.0		–	–	–	◪	30	0.28	4.8		–	–	–
CNMG 160608E-RM:T9325	❁	0.8	■	190	0.40	6.0	■	110	0.36	6.0	◪	180	0.40	6.0		–	–	–	◪	40	0.28	4.8		–	–	–
CNMG 160608E-RM:T9335	❁	0.8	■	165	0.40	6.0	■	95	0.36	6.0		–	–	–		–	–	–	◪	35	0.28	4.8		–	–	–
CNMG 160608E-RM:T9415	❁	0.8	■	255	0.40	6.0		–	–	–	◪	240	0.40	6.0		–	–	–		–	–	–		–	–	–
CNMG 160612E-RM:T5305	❁	1.2	◪	270	0.45	6.0		–	–	–	■	255	0.45	6.0		–	–	–		–	–	–		–	–	–
CNMG 160612E-RM:T6310	❁	1.2	■	155	0.45	6.0	■	110	0.41	6.0	■	125	0.45	6.0		–	–	–	◪	45	0.32	4.8		–	–	–
CNMG 160612E-RM:T7325	❁	1.2	◪	170	0.45	6.0	■	130	0.41	6.0		–	–	–		–	–	–	◪	55	0.32	4.8		–	–	–
CNMG 160612E-RM:T7335	❁	1.2	◪	165	0.45	6.0	■	125	0.41	6.0		–	–	–		–	–	–	◪	50	0.32	4.8		–	–	–
CNMG 160612E-RM:T8415	❁	1.2	■	195	0.45	6.0	■	100	0.41	6.0	■	180	0.45	6.0		–	–	–	◪	45	0.32	4.8		–	–	–
CNMG 160612E-RM:T8430	✱	1.2	■	155	0.45	6.0	■	85	0.41	6.0	◪	130	0.45	6.0		–	–	–	◪	30	0.32	4.8		–	–	–
CNMG 160612E-RM:T9310	❁	1.2	■	230	0.45	6.0		–	–	–	◪	215	0.45	6.0		–	–	–		–	–	–		–	–	–
CNMG 160612E-RM:T9315	❁	1.2	■	215	0.45	6.0		–	–	–	◪	200	0.45	6.0		–	–	–		–	–	–		–	–	–
CNMG 160612E-RM:T9325	❁	1.2	■	195	0.45	6.0	■	115	0.41	6.0	◪	185	0.45	6.0		–	–	–	◪	40	0.32	4.8		–	–	–
CNMG 160612E-RM:T9335	❁	1.2	■	165	0.45	6.0	■	95	0.41	6.0		–	–	–		–	–	–	◪	35	0.32	4.8		–	–	–
CNMG 160612E-RM:T9415	❁	1.2	■	260	0.45	6.0		–	–	–	◪	245	0.45	6.0		–	–	–		–	–	–		–	–	–
CNMG 160616E-RM:T5305	❁	1.6	◪	270	0.50	6.0		–	–	–	■	255	0.50	6.0		–	–	–		–	–	–		–	–	–
CNMG 160616E-RM:T5315	❁	1.6	◪	245	0.50	6.0		–	–	–	■	230	0.50	6.0		–	–	–		–	–	–		–	–	–
CNMG 160616E-RM:T7325	❁	1.6	◪	175	0.50	6.0	■	135	0.45	6.0		–	–	–		–	–	–	◪	55	0.35	4.8		–	–	–
CNMG 160616E-RM:T7335	❁	1.6	◪	165	0.50	6.0	■	125	0.45	6.0		–	–	–		–	–	–	◪	50	0.35	4.8		–	–	–
CNMG 160616E-RM:T9310	❁	1.6	■	225	0.50	6.0		–	–	–	◪	210	0.50	6.0		–	–	–		–	–	–		–	–	–
CNMG 160616E-RM:T9315	❁	1.6	■	215	0.50	6.0		–	–	–	◪	200	0.50	6.0		–	–	–		–	–	–		–	–	–
CNMG 160616E-RM:T9325	❁	1.6	■	190	0.50	6.0	■	110	0.45	6.0	◪	180	0.50	6.0		–	–	–	◪	40	0.35	4.8		–	–	–
CNMG 160616E-RM:T9335	❁	1.6	■	165	0.50	6.0	■	95	0.45	6.0		–	–	–		–	–	–	◪	35	0.35	4.8		–	–	–
CNMG 160616E-RM:T9415	❁	1.6	■	265	0.50	6.0		–	–	–	◪	250	0.50	6.0		–	–	–		–	–	–		–	–	–

Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

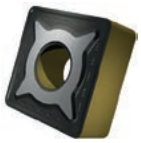
Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
RM talaş kırıcı sağlamdır ve Çeliklerin kaba işlenmesi için ilk tercihtir. Pozitif eğim açısı ve dengeli, geniş T-land özelliğine sahiptir. Ayrıca Paslanmaz çelikler, Dökme demirler ve şartlara bağlı olarak Süper alaşımlar için de uygundur.																			
CNMG 190608E-RM:T5305	0.8	260	0.40	7.5	–	–	–	245	0.40	7.5	–	–	–	–	–	–	–	–	–
CNMG 190608E-RM:T5315	0.8	230	0.40	7.5	–	–	–	215	0.40	7.5	–	–	–	–	–	–	–	–	–
CNMG 190608E-RM:T7335	0.8	155	0.40	7.5	120	0.36	7.5	–	–	–	–	–	–	50	0.28	6.0	–	–	–
CNMG 190608E-RM:T9325	0.8	190	0.40	7.5	110	0.36	7.5	180	0.40	7.5	–	–	–	40	0.28	6.0	–	–	–
CNMG 190608E-RM:T9335	0.8	160	0.40	7.5	95	0.36	7.5	–	–	–	–	–	–	35	0.28	6.0	–	–	–
CNMG 190608E-RM:T9415	0.8	250	0.40	7.5	–	–	–	235	0.40	7.5	–	–	–	–	–	–	–	–	–
CNMG 190612E-RM:T5305	1.2	260	0.45	7.5	–	–	–	245	0.45	7.5	–	–	–	–	–	–	–	–	–
CNMG 190612E-RM:T5315	1.2	240	0.45	7.5	–	–	–	225	0.45	7.5	–	–	–	–	–	–	–	–	–
CNMG 190612E-RM:T6310	1.2	155	0.45	7.5	110	0.41	7.5	125	0.45	7.5	–	–	–	45	0.32	6.0	–	–	–
CNMG 190612E-RM:T7325	1.2	170	0.45	7.5	130	0.41	7.5	–	–	–	–	–	–	55	0.32	6.0	–	–	–
CNMG 190612E-RM:T7335	1.2	160	0.45	7.5	120	0.41	7.5	–	–	–	–	–	–	50	0.32	6.0	–	–	–
CNMG 190612E-RM:T8415	1.2	195	0.45	7.5	100	0.41	7.5	180	0.45	7.5	–	–	–	45	0.32	6.0	–	–	–
CNMG 190612E-RM:T8430	1.2	150	0.45	7.5	80	0.41	7.5	125	0.45	7.5	–	–	–	30	0.32	6.0	–	–	–
CNMG 190612E-RM:T9325	1.2	185	0.45	7.5	110	0.41	7.5	175	0.45	7.5	–	–	–	40	0.32	6.0	–	–	–
CNMG 190612E-RM:T9335	1.2	165	0.45	7.5	95	0.41	7.5	–	–	–	–	–	–	35	0.32	6.0	–	–	–
CNMG 190612E-RM:T9415	1.2	250	0.45	7.5	–	–	–	235	0.45	7.5	–	–	–	–	–	–	–	–	–
CNMG 190616E-RM:T5305	1.6	265	0.50	7.5	–	–	–	250	0.50	7.5	–	–	–	–	–	–	–	–	–
CNMG 190616E-RM:T6310	1.6	155	0.50	7.5	110	0.45	7.5	125	0.50	7.5	–	–	–	45	0.35	6.0	–	–	–
CNMG 190616E-RM:T7325	1.6	175	0.50	7.5	135	0.45	7.5	–	–	–	–	–	–	55	0.35	6.0	–	–	–
CNMG 190616E-RM:T7335	1.6	160	0.50	7.5	120	0.45	7.5	–	–	–	–	–	–	50	0.35	6.0	–	–	–
CNMG 190616E-RM:T8415	1.6	195	0.50	7.5	100	0.45	7.5	180	0.50	7.5	–	–	–	45	0.35	6.0	–	–	–
CNMG 190616E-RM:T8430	1.6	150	0.50	7.5	80	0.45	7.5	125	0.50	7.5	–	–	–	30	0.35	6.0	–	–	–
CNMG 190616E-RM:T9315	1.6	210	0.50	7.5	–	–	–	195	0.50	7.5	–	–	–	–	–	–	–	–	–
CNMG 190616E-RM:T9325	1.6	190	0.50	7.5	110	0.45	7.5	180	0.50	7.5	–	–	–	40	0.35	6.0	–	–	–
CNMG 190616E-RM:T9335	1.6	160	0.50	7.5	95	0.45	7.5	–	–	–	–	–	–	35	0.35	6.0	–	–	–
CNMG 190616E-RM:T9415	1.6	255	0.50	7.5	–	–	–	240	0.50	7.5	–	–	–	–	–	–	–	–	–
CNMG 250924E-RM:T7325	2.4	105	0.80	12.0	80	0.72	12.0	–	–	–	–	–	–	30	0.56	9.6	–	–	–
CNMG 250924E-RM:T7335	2.4	100	0.80	12.0	75	0.72	12.0	–	–	–	–	–	–	30	0.56	9.6	–	–	–
CNMG 250924E-RM:T9226	2.4	90	0.80	12.0	50	0.72	12.0	85	0.80	12.0	–	–	–	15	0.56	9.6	–	–	–
CNMG 250924E-RM:T9325	2.4	105	0.80	12.0	60	0.72	12.0	95	0.80	12.0	–	–	–	20	0.56	9.6	–	–	–
CNMG 250924E-RM:T9335	2.4	85	0.80	12.0	50	0.72	12.0	–	–	–	–	–	–	15	0.56	9.6	–	–	–
CNMG 250924E-RM:T9415	2.4	125	0.80	12.0	–	–	–	115	0.80	12.0	–	–	–	–	–	–	–	–	–
 																			
RM talaş kırıcı sağlamdır ve Çeliklerin kaba işlenmesi için ilk tercihtir. Pozitif eğim açısı ve dengeli, geniş T-land özelliğine sahiptir. Ayrıca Paslanmaz çelikler, Dökme demirler ve şartlara bağlı olarak Süper alaşımlar için de uygundur.																			
DNMG 110408E-RM:T9325	0.8	170	0.40	2.0	100	0.36	2.0	160	0.40	2.0	–	–	–	35	0.28	1.6	–	–	–
DNMG 110408E-RM:T9415	0.8	230	0.40	2.0	–	–	–	215	0.40	2.0	–	–	–	–	–	–	–	–	–
DNMG 110412E-RM:T9325	1.2	205	0.30	2.0	120	0.27	2.0	190	0.30	2.0	–	–	–	45	0.21	1.6	–	–	–
DNMG 110412E-RM:T9415	1.2	265	0.30	2.0	–	–	–	250	0.30	2.0	–	–	–	–	–	–	–	–	–
DNMG 150408E-RM:T9325	0.8	165	0.40	3.0	95	0.36	3.0	155	0.40	3.0	–	–	–	35	0.28	2.4	–	–	–
DNMG 150408E-RM:T9335	0.8	140	0.40	3.0	80	0.36	3.0	–	–	–	–	–	–	30	0.28	2.4	–	–	–
DNMG 150408E-RM:T9415	0.8	220	0.40	3.0	–	–	–	205	0.40	3.0	–	–	–	–	–	–	–	–	–
DNMG 150412E-RM:T7325	1.2	155	0.40	3.0	120	0.36	3.0	–	–	–	–	–	–	50	0.28	2.4	–	–	–
DNMG 150412E-RM:T9325	1.2	170	0.40	3.0	100	0.36	3.0	160	0.40	3.0	–	–	–	35	0.28	2.4	–	–	–
DNMG 150412E-RM:T9335	1.2	150	0.40	3.0	90	0.36	3.0	–	–	–	–	–	–	30	0.28	2.4	–	–	–
DNMG 150412E-RM:T9415	1.2	230	0.40	3.0	–	–	–	215	0.40	3.0	–	–	–	–	–	–	–	–	–
DNMG 150608E-RM:T5305	0.8	230	0.40	3.0	–	–	–	215	0.40	3.0	–	–	–	–	–	–	–	–	–
DNMG 150608E-RM:T5315	0.8	205	0.40	3.0	–	–	–	190	0.40	3.0	–	–	–	–	–	–	–	–	–
DNMG 150608E-RM:T7325	0.8	145	0.40	3.0	110	0.36	3.0	–	–	–	–	–	–	45	0.28	2.4	–	–	–
DNMG 150608E-RM:T7335	0.8	135	0.40	3.0	105	0.36	3.0	–	–	–	–	–	–	40	0.28	2.4	–	–	–
DNMG 150608E-RM:T8315	0.8	135	0.40	3.0	80	0.36	3.0	125	0.40	3.0	–	–	–	30	0.28	2.4	–	–	–
DNMG 150608E-RM:T8415	0.8	160	0.40	3.0	85	0.36	3.0	145	0.40	3.0	–	–	–	35	0.28	2.4	–	–	–
DNMG 150608E-RM:T8430	0.8	135	0.40	3.0	75	0.36	3.0	110	0.40	3.0	–	–	–	25	0.28	2.4	–	–	–
DNMG 150608E-RM:T9325	0.8	165	0.40	3.0	95	0.36	3.0	155	0.40	3.0	–	–	–	35	0.28	2.4	–	–	–
DNMG 150608E-RM:T9335	0.8	140	0.40	3.0	80	0.36	3.0	–	–	–	–	–	–	30	0.28	2.4	–	–	–
DNMG 150608E-RM:T9415	0.8	220	0.40	3.0	–	–	–	205	0.40	3.0	–	–	–	–	–	–	–	–	–

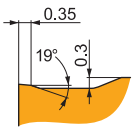
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P			M			K			N			S			H		
		(mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)
																				
RM talaş kırıcı sağlamdır ve Çeliklerin kaba işlenmesi için ilk tercihtir. Pozitif eğim açısı ve dengeli, geniş T-land özelliğine sahiptir. Ayrıca Paslanmaz çelikler, Dökme demirler ve şartlara bağlı olarak Süper alaşımlar için de uygundur.																				
DNMG 150612E-RM:T5305	●	1.2	240	0.40	3.0	–	–	–	225	0.40	3.0	–	–	–	–	–	–	–	–	–
DNMG 150612E-RM:T5315	❖	1.2	215	0.40	3.0	–	–	–	200	0.40	3.0	–	–	–	–	–	–	–	–	–
DNMG 150612E-RM:T7325	❖	1.2	155	0.40	3.0	120	0.36	3.0	–	–	–	–	–	–	50	0.28	2.4	–	–	–
DNMG 150612E-RM:T8430	❖	1.2	140	0.40	3.0	75	0.36	3.0	115	0.40	3.0	–	–	–	30	0.28	2.4	–	–	–
DNMG 150612E-RM:T9325	❖	1.2	170	0.40	3.0	100	0.36	3.0	160	0.40	3.0	–	–	–	35	0.28	2.4	–	–	–
DNMG 150612E-RM:T9335	❖	1.2	150	0.40	3.0	90	0.36	3.0	–	–	–	–	–	–	30	0.28	2.4	–	–	–
DNMG 150612E-RM:T9415	❖	1.2	230	0.40	3.0	–	–	–	215	0.40	3.0	–	–	–	–	–	–	–	–	–
DNMG 150616E-RM:T5315	❖	1.6	225	0.40	3.0	–	–	–	210	0.40	3.0	–	–	–	–	–	–	–	–	–
DNMG 150616E-RM:T9325	❖	1.6	180	0.40	3.0	105	0.36	3.0	170	0.40	3.0	–	–	–	40	0.28	2.4	–	–	–
DNMG 150616E-RM:T9335	❖	1.6	155	0.40	3.0	90	0.36	3.0	–	–	–	–	–	–	30	0.28	2.4	–	–	–
DNMG 150616E-RM:T9415	❖	1.6	245	0.40	3.0	–	–	–	230	0.40	3.0	–	–	–	–	–	–	–	–	–
																				
RM talaş kırıcı sağlamdır ve Çeliklerin kaba işlenmesi için ilk tercihtir. Pozitif eğim açısı ve dengeli, geniş T-land özelliğine sahiptir. Ayrıca Paslanmaz çelikler, Dökme demirler ve şartlara bağlı olarak Süper alaşımlar için de uygundur.																				
SNMG 120408E-RM:T5305	❖	0.8	290	0.40	4.0	–	–	–	275	0.40	4.0	–	–	–	–	–	–	–	–	–
SNMG 120408E-RM:T6310	❖	0.8	165	0.40	4.0	115	0.36	4.0	130	0.40	4.0	–	–	–	45	0.28	3.2	–	–	–
SNMG 120408E-RM:T7325	❖	0.8	185	0.40	4.0	140	0.36	4.0	–	–	–	–	–	–	60	0.28	3.2	–	–	–
SNMG 120408E-RM:T7335	❖	0.8	175	0.40	4.0	135	0.36	4.0	–	–	–	–	–	–	55	0.28	3.2	–	–	–
SNMG 120408E-RM:T8315	❖	0.8	175	0.40	4.0	105	0.36	4.0	165	0.40	4.0	–	–	–	40	0.28	3.2	–	–	–
SNMG 120408E-RM:T8415	❖	0.8	210	0.40	4.0	110	0.36	4.0	190	0.40	4.0	–	–	–	45	0.28	3.2	–	–	–
SNMG 120408E-RM:T8430	❖	0.8	175	0.40	4.0	95	0.36	4.0	140	0.40	4.0	–	–	–	35	0.28	3.2	–	–	–
SNMG 120408E-RM:T9325	❖	0.8	210	0.40	4.0	125	0.36	4.0	195	0.40	4.0	–	–	–	45	0.28	3.2	–	–	–
SNMG 120408E-RM:T9335	❖	0.8	180	0.40	4.0	105	0.36	4.0	–	–	–	–	–	–	40	0.28	3.2	–	–	–
SNMG 120408E-RM:T9415	❖	0.8	280	0.40	4.0	–	–	–	265	0.40	4.0	–	–	–	–	–	–	–	–	–
SNMG 120412E-RM:T6310	❖	1.2	165	0.45	4.0	115	0.41	4.0	130	0.45	4.0	–	–	–	45	0.32	3.2	–	–	–
SNMG 120412E-RM:T7325	❖	1.2	190	0.45	4.0	145	0.41	4.0	–	–	–	–	–	–	60	0.32	3.2	–	–	–
SNMG 120412E-RM:T7335	❖	1.2	180	0.45	4.0	140	0.41	4.0	–	–	–	–	–	–	55	0.32	3.2	–	–	–
SNMG 120412E-RM:T8415	❖	1.2	215	0.45	4.0	110	0.41	4.0	195	0.45	4.0	–	–	–	45	0.32	3.2	–	–	–
SNMG 120412E-RM:T9325	❖	1.2	210	0.45	4.0	125	0.41	4.0	195	0.45	4.0	–	–	–	45	0.32	3.2	–	–	–
SNMG 120412E-RM:T9335	❖	1.2	185	0.45	4.0	110	0.41	4.0	–	–	–	–	–	–	40	0.32	3.2	–	–	–
SNMG 120412E-RM:T9415	❖	1.2	280	0.45	4.0	–	–	–	265	0.45	4.0	–	–	–	–	–	–	–	–	–
SNMG 120416E-RM:T8430	✱	1.6	175	0.50	4.0	95	0.45	4.0	140	0.50	4.0	–	–	–	35	0.35	3.2	–	–	–
SNMG 120416E-RM:T9325	❖	1.6	215	0.50	4.0	125	0.45	4.0	200	0.50	4.0	–	–	–	45	0.35	3.2	–	–	–
SNMG 120416E-RM:T9335	❖	1.6	180	0.50	4.0	105	0.45	4.0	–	–	–	–	–	–	40	0.35	3.2	–	–	–
SNMG 120416E-RM:T9415	❖	1.6	290	0.50	4.0	–	–	–	275	0.50	4.0	–	–	–	–	–	–	–	–	–
SNMG 150612E-RM:T6310	❖	1.2	165	0.45	5.0	115	0.41	5.0	130	0.45	5.0	–	–	–	45	0.32	4.0	–	–	–
SNMG 150612E-RM:T7325	❖	1.2	185	0.45	5.0	140	0.41	5.0	–	–	–	–	–	–	60	0.32	4.0	–	–	–
SNMG 150612E-RM:T8415	❖	1.2	215	0.45	5.0	110	0.41	5.0	195	0.45	5.0	–	–	–	45	0.32	4.0	–	–	–
SNMG 150612E-RM:T9325	❖	1.2	205	0.45	5.0	120	0.41	5.0	190	0.45	5.0	–	–	–	45	0.32	4.0	–	–	–
SNMG 150612E-RM:T9335	❖	1.2	180	0.45	5.0	105	0.41	5.0	–	–	–	–	–	–	40	0.32	4.0	–	–	–
SNMG 150612E-RM:T9415	❖	1.2	275	0.45	5.0	–	–	–	260	0.45	5.0	–	–	–	–	–	–	–	–	–
SNMG 150616E-RM:T7335	❖	1.6	175	0.50	5.0	135	0.45	5.0	–	–	–	–	–	–	55	0.35	4.0	–	–	–
SNMG 150616E-RM:T9325	❖	1.6	205	0.50	5.0	120	0.45	5.0	190	0.50	5.0	–	–	–	45	0.35	4.0	–	–	–
SNMG 150616E-RM:T9335	❖	1.6	180	0.50	5.0	105	0.45	5.0	–	–	–	–	–	–	40	0.35	4.0	–	–	–
SNMG 150616E-RM:T9415	❖	1.6	285	0.50	5.0	–	–	–	270	0.50	5.0	–	–	–	–	–	–	–	–	–
SNMG 190612E-RM:T5305	❖	1.2	275	0.45	7.0	–	–	–	260	0.45	7.0	–	–	–	–	–	–	–	–	–
SNMG 190612E-RM:T5315	❖	1.2	250	0.45	7.0	–	–	–	235	0.45	7.0	–	–	–	–	–	–	–	–	–
SNMG 190612E-RM:T7325	❖	1.2	180	0.45	7.0	140	0.41	7.0	–	–	–	–	–	–	55	0.32	5.6	–	–	–
SNMG 190612E-RM:T7335	❖	1.2	165	0.45	7.0	125	0.41	7.0	–	–	–	–	–	–	50	0.32	5.6	–	–	–
SNMG 190612E-RM:T9325	❖	1.2	195	0.45	7.0	115	0.41	7.0	185	0.45	7.0	–	–	–	40	0.32	5.6	–	–	–
SNMG 190612E-RM:T9335	❖	1.2	175	0.45	7.0	105	0.41	7.0	–	–	–	–	–	–	35	0.32	5.6	–	–	–
SNMG 190612E-RM:T9415	❖	1.2	270	0.45	7.0	–	–	–	255	0.45	7.0	–	–	–	–	–	–	–	–	–

Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

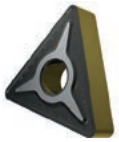
Product		RE	P			M			K			N			S			H		
			vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)
		(mm)																		

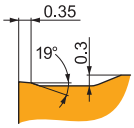




RM talaş kırıcı sağlamdır ve Çeliklerin kaba işlenmesi için ilk tercihtir. Pozitif eğim açısı ve dengeli, geniş T-land özelliğine sahiptir. Ayrıca Paslanmaz çelikler, Dökme demirler ve şartlara bağlı olarak Süper alaşımlar için de uygundur.

SNMG 190616E-RM:T5305	●	1.6	285	0.50	7.0	–	–	–	270	0.50	7.0	–	–	–	–	–	–	–	–	–
SNMG 190616E-RM:T6310	●	1.6	160	0.50	7.0	115	0.45	7.0	125	0.50	7.0	–	–	–	45	0.35	5.6	–	–	–
SNMG 190616E-RM:T7335	●	1.6	170	0.50	7.0	130	0.45	7.0	–	–	–	–	–	–	55	0.35	5.6	–	–	–
SNMG 190616E-RM:T8415	✱	1.6	210	0.50	7.0	110	0.45	7.0	190	0.50	7.0	–	–	–	45	0.35	5.6	–	–	–
SNMG 190616E-RM:T8430	✱	1.6	165	0.50	7.0	90	0.45	7.0	135	0.50	7.0	–	–	–	35	0.35	5.6	–	–	–
SNMG 190616E-RM:T9325	●	1.6	200	0.50	7.0	120	0.45	7.0	190	0.50	7.0	–	–	–	45	0.35	5.6	–	–	–
SNMG 190616E-RM:T9335	●	1.6	175	0.50	7.0	105	0.45	7.0	–	–	–	–	–	–	35	0.35	5.6	–	–	–
SNMG 190616E-RM:T9415	●	1.6	270	0.50	7.0	–	–	–	255	0.50	7.0	–	–	–	–	–	–	–	–	–
SNMG 250924E-RM:T7325	✱	2.4	110	0.80	12.0	85	0.72	12.0	–	–	–	–	–	–	35	0.56	9.6	–	–	–
SNMG 250924E-RM:T7335	✱	2.4	105	0.80	12.0	80	0.72	12.0	–	–	–	–	–	–	30	0.56	9.6	–	–	–
SNMG 250924E-RM:T9226	●	2.4	95	0.80	12.0	55	0.72	12.0	90	0.80	12.0	–	–	–	20	0.56	9.6	–	–	–
SNMG 250924E-RM:T9315	●	2.4	125	0.80	12.0	–	–	–	115	0.80	12.0	–	–	–	–	–	–	–	–	–
SNMG 250924E-RM:T9325	●	2.4	110	0.80	12.0	65	0.72	12.0	100	0.80	12.0	–	–	–	20	0.56	9.6	–	–	–
SNMG 250924E-RM:T9335	✱	2.4	90	0.80	12.0	50	0.72	12.0	–	–	–	–	–	–	20	0.56	9.6	–	–	–
SNMG 250924E-RM:T9415	●	2.4	130	0.80	12.0	–	–	–	120	0.80	12.0	–	–	–	–	–	–	–	–	–



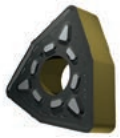


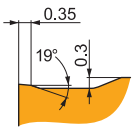
RM talaş kırıcı sağlamdır ve Çeliklerin kaba işlenmesi için ilk tercihtir. Pozitif eğim açısı ve dengeli, geniş T-land özelliğine sahiptir. Ayrıca Paslanmaz çelikler, Dökme demirler ve şartlara bağlı olarak Süper alaşımlar için de uygundur.

TNMG 160408E-RM:T5305	●	0.8	245	0.40	3.0	–	–	–	230	0.40	3.0	–	–	–	–	–	–	–	–	–
TNMG 160408E-RM:T5315	●	0.8	215	0.40	3.0	–	–	–	200	0.40	3.0	–	–	–	–	–	–	–	–	–
TNMG 160408E-RM:T7325	●	0.8	155	0.40	3.0	120	0.36	3.0	–	–	–	–	–	–	50	0.28	2.4	–	–	–
TNMG 160408E-RM:T7335	●	0.8	145	0.40	3.0	110	0.36	3.0	–	–	–	–	–	–	45	0.28	2.4	–	–	–
TNMG 160408E-RM:T9325	●	0.8	175	0.40	3.0	105	0.36	3.0	165	0.40	3.0	–	–	–	35	0.28	2.4	–	–	–
TNMG 160408E-RM:T9335	●	0.8	150	0.40	3.0	90	0.36	3.0	–	–	–	–	–	–	30	0.28	2.4	–	–	–
TNMG 160408E-RM:T9415	●	0.8	235	0.40	3.0	–	–	–	220	0.40	3.0	–	–	–	–	–	–	–	–	–
TNMG 160412E-RM:T5305	●	1.2	255	0.40	3.0	–	–	–	240	0.40	3.0	–	–	–	–	–	–	–	–	–
TNMG 160412E-RM:T7335	●	1.2	155	0.40	3.0	120	0.36	3.0	–	–	–	–	–	–	50	0.28	2.4	–	–	–
TNMG 160412E-RM:T8430	●	1.2	150	0.40	3.0	80	0.36	3.0	125	0.40	3.0	–	–	–	30	0.28	2.4	–	–	–
TNMG 160412E-RM:T9325	●	1.2	185	0.40	3.0	110	0.36	3.0	175	0.40	3.0	–	–	–	40	0.28	2.4	–	–	–
TNMG 160412E-RM:T9335	●	1.2	160	0.40	3.0	95	0.36	3.0	–	–	–	–	–	–	35	0.28	2.4	–	–	–
TNMG 160412E-RM:T9415	●	1.2	245	0.40	3.0	–	–	–	230	0.40	3.0	–	–	–	–	–	–	–	–	–
TNMG 220408E-RM:T7325	●	0.8	150	0.40	4.0	115	0.36	4.0	–	–	–	–	–	–	45	0.28	3.2	–	–	–
TNMG 220408E-RM:T9325	●	0.8	170	0.40	4.0	100	0.36	4.0	160	0.40	4.0	–	–	–	35	0.28	3.2	–	–	–
TNMG 220408E-RM:T9335	●	0.8	145	0.40	4.0	85	0.36	4.0	–	–	–	–	–	–	30	0.28	3.2	–	–	–
TNMG 220408E-RM:T9415	●	0.8	225	0.40	4.0	–	–	–	210	0.40	4.0	–	–	–	–	–	–	–	–	–
TNMG 220412E-RM:T5305	●	1.2	245	0.40	4.0	–	–	–	230	0.40	4.0	–	–	–	–	–	–	–	–	–
TNMG 220412E-RM:T7325	●	1.2	160	0.40	4.0	120	0.36	4.0	–	–	–	–	–	–	50	0.28	3.2	–	–	–
TNMG 220412E-RM:T7335	●	1.2	150	0.40	4.0	115	0.36	4.0	–	–	–	–	–	–	45	0.28	3.2	–	–	–
TNMG 220412E-RM:T9325	●	1.2	180	0.40	4.0	105	0.36	4.0	170	0.40	4.0	–	–	–	40	0.28	3.2	–	–	–
TNMG 220412E-RM:T9335	●	1.2	155	0.40	4.0	90	0.36	4.0	–	–	–	–	–	–	30	0.28	3.2	–	–	–
TNMG 220412E-RM:T9415	●	1.2	235	0.40	4.0	–	–	–	220	0.40	4.0	–	–	–	–	–	–	–	–	–
TNMG 220416E-RM:T7325	●	1.6	165	0.40	4.0	125	0.36	4.0	–	–	–	–	–	–	50	0.28	3.2	–	–	–
TNMG 220416E-RM:T9325	●	1.6	185	0.40	4.0	110	0.36	4.0	175	0.40	4.0	–	–	–	40	0.28	3.2	–	–	–
TNMG 220416E-RM:T9335	●	1.6	160	0.40	4.0	95	0.36	4.0	–	–	–	–	–	–	35	0.28	3.2	–	–	–
TNMG 220416E-RM:T9415	●	1.6	250	0.40	4.0	–	–	–	235	0.40	4.0	–	–	–	–	–	–	–	–	–
TNMG 270612E-RM:T7325	●	1.2	110	0.40	6.0	85	0.36	6.0	–	–	–	–	–	–	35	0.28	4.8	–	–	–
TNMG 270612E-RM:T9325	●	1.2	120	0.40	6.0	70	0.36	6.0	110	0.40	6.0	–	–	–	25	0.28	4.8	–	–	–
TNMG 270616E-RM:T7325	●	1.6	115	0.40	6.0	85	0.36	6.0	–	–	–	–	–	–	35	0.28	4.8	–	–	–
TNMG 270616E-RM:T9325	●	1.6	125	0.40	6.0	75	0.36	6.0	115	0.40	6.0	–	–	–	25	0.28	4.8	–	–	–
TNMG 270616E-RM:T9335	●	1.6	100	0.40	6.0	60	0.36	6.0	–	–	–	–	–	–	20	0.28	4.8	–	–	–
TNMG 270616E-RM:T9415	●	1.6	140	0.40	6.0	–	–	–	130	0.40	6.0	–	–	–	–	–	–	–	–	–
TNMG 270624E-RM:T7325	●	2.4	115	0.50	6.0	85	0.45	6.0	–	–	–	–	–	–	35	0.35	4.8	–	–	–
TNMG 270624E-RM:T9325	●	2.4	120	0.50	6.0	70	0.45	6.0	110	0.50	6.0	–	–	–	25	0.35	4.8	–	–	–
TNMG 270624E-RM:T9335	●	2.4	95	0.50	6.0	55	0.45	6.0	–	–	–	–	–	–	20	0.35	4.8	–	–	–
TNMG 270632E-RM:T9335	●	3.2	90	0.60	6.0	50	0.54	6.0	–	–	–	–	–	–	20	0.42	4.8	–	–	–
TNMG 330924E-RM:T9226	●	2.4	100	0.50	10.0	60	0.45	10.0	95	0.50	10.0	–	–	–	20	0.35	8.0	–	–	–
TNMG 330924E-RM:T9335	●	2.4	90	0.50	10.0	50	0.45	10.0	–	–	–	–	–	–	20	0.35	8.0	–	–	–

Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)

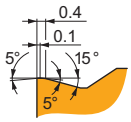




RM talaş kırıcı sağlamdır ve Çeliklerin kaba işlenmesi için ilk tercihtir. Pozitif eğim açısı ve dengeli, geniş T-land özelliğine sahiptir. Ayrıca Paslanmaz çelikler, Dökme demirler ve şartlara bağlı olarak Süper alaşımlar için de uygundur.

WNMG 060412E-RM:T9315	●	1.2	■	230	0.45	3.0		–	–	–	◪	215	0.45	3.0		–	–	–		–	–	–		–	–	–
WNMG 060412E-RM:T9325	●	1.2	■	230	0.45	1.2	■	135	0.41	1.2	◪	215	0.45	1.2		–	–	–	◪	50	0.32	1.0		–	–	–
WNMG 060412E-RM:T9415	●	1.2	■	280	0.45	3.0		–	–	–	◪	265	0.45	3.0		–	–	–		–	–	–		–	–	–
WNMG 080408E-RM:T5305	●	0.8	◪	275	0.40	4.0		–	–	–	■	260	0.40	4.0		–	–	–		–	–	–		–	–	–
WNMG 080408E-RM:T5315	●	0.8	◪	250	0.40	4.0		–	–	–	■	235	0.40	4.0		–	–	–		–	–	–		–	–	–
WNMG 080408E-RM:T7325	●	0.8	◪	180	0.40	4.0	■	140	0.36	4.0		–	–	–		–	–	–	◪	55	0.28	3.2		–	–	–
WNMG 080408E-RM:T7335	●	0.8	◪	165	0.40	4.0	■	125	0.36	4.0		–	–	–		–	–	–	◪	50	0.28	3.2		–	–	–
WNMG 080408E-RM:T8315	●	0.8	◪	165	0.40	4.0	■	95	0.36	4.0	■	155	0.40	4.0		–	–	–	◪	40	0.28	3.2		–	–	–
WNMG 080408E-RM:T8415	●	0.8	■	195	0.40	4.0	■	100	0.36	4.0	■	180	0.40	4.0		–	–	–	◪	45	0.28	3.2		–	–	–
WNMG 080408E-RM:T8430	●	0.8	■	165	0.40	4.0	■	90	0.36	4.0	◪	135	0.40	4.0		–	–	–	◪	35	0.28	3.2		–	–	–
WNMG 080408E-RM:T9310	●	0.8	■	240	0.40	4.0		–	–	–	◪	225	0.40	4.0		–	–	–		–	–	–		–	–	–
WNMG 080408E-RM:T9315	●	0.8	■	220	0.40	4.0		–	–	–	◪	205	0.40	4.0		–	–	–		–	–	–		–	–	–
WNMG 080408E-RM:T9325	●	0.8	■	200	0.40	4.0	■	120	0.36	4.0	◪	190	0.40	4.0		–	–	–	◪	45	0.28	3.2		–	–	–
WNMG 080408E-RM:T9335	●	0.8	■	170	0.40	4.0	■	100	0.36	4.0		–	–	–		–	–	–	◪	35	0.28	3.2		–	–	–
WNMG 080408E-RM:T9415	●	0.8	■	265	0.40	4.0		–	–	–	◪	250	0.40	4.0		–	–	–		–	–	–		–	–	–
WNMG 080412E-RM:T5305	●	1.2	◪	280	0.45	4.0		–	–	–	■	265	0.45	4.0		–	–	–		–	–	–		–	–	–
WNMG 080412E-RM:T5315	●	1.2	◪	250	0.45	4.0		–	–	–	■	235	0.45	4.0		–	–	–		–	–	–		–	–	–
WNMG 080412E-RM:T9325	●	1.2	■	200	0.45	4.0	■	120	0.41	4.0	◪	190	0.45	4.0		–	–	–	◪	45	0.32	3.2		–	–	–
WNMG 080412E-RM:T9335	●	1.2	■	175	0.45	4.0	■	105	0.41	4.0		–	–	–		–	–	–	◪	35	0.32	3.2		–	–	–
WNMG 080412E-RM:T9415	●	1.2	■	270	0.45	4.0		–	–	–	◪	255	0.45	4.0		–	–	–		–	–	–		–	–	–
WNMG 080416E-RM:T5305	●	1.6	◪	280	0.50	4.0		–	–	–	■	265	0.50	4.0		–	–	–		–	–	–		–	–	–
WNMG 080416E-RM:T5315	●	1.6	◪	255	0.50	4.0		–	–	–	■	240	0.50	4.0		–	–	–		–	–	–		–	–	–
WNMG 080416E-RM:T8430	✱	1.6	■	170	0.50	4.0	■	90	0.45	4.0	◪	135	0.50	4.0		–	–	–	◪	35	0.35	3.2		–	–	–
WNMG 080416E-RM:T9310	●	1.6	■	240	0.50	4.0		–	–	–	◪	225	0.50	4.0		–	–	–		–	–	–		–	–	–
WNMG 080416E-RM:T9325	●	1.6	■	205	0.50	4.0	■	120	0.45	4.0	◪	190	0.50	4.0		–	–	–	◪	45	0.35	3.2		–	–	–
WNMG 080416E-RM:T9335	●	1.6	■	175	0.50	4.0	■	105	0.45	4.0		–	–	–		–	–	–	◪	35	0.35	3.2		–	–	–
WNMG 080416E-RM:T9415	●	1.6	■	275	0.50	4.0		–	–	–	◪	260	0.50	4.0		–	–	–		–	–	–		–	–	–

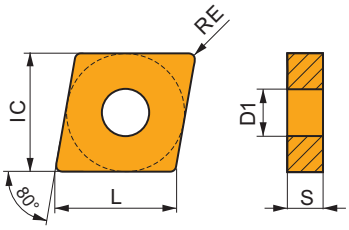
R



R talaş kırıcı sağlamdır ve Çeliklerin ve Dökme demirlerin kaba işlenmesi için tasarlanmıştır. Hafif pozitif eğim açısı ve negatif/kararlı, ekstra geniş çift T-land özelliğine sahiptir. Sert malzemeler için de şartlı olarak uygundur.

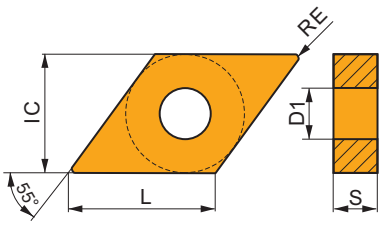
CNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.90	4.76
1606	15.880	6.35	16.10	6.35
1906	19.050	7.94	19.30	6.35



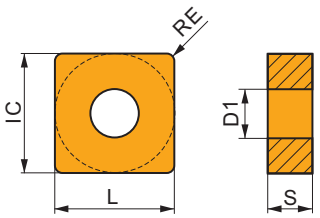
DNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1504	12.700	5.16	15.50	4.76
1506	12.700	5.16	15.50	6.35



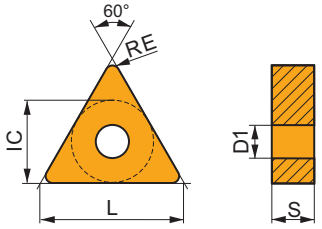
SNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76
1506	15.875	6.35	15.88	6.35
1906	19.050	7.94	19.05	6.35



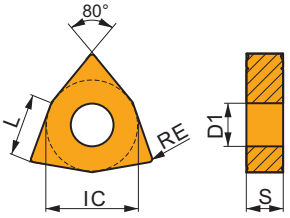
TNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76
2204	12.700	5.16	22.00	4.76

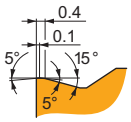
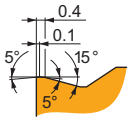
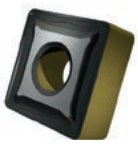
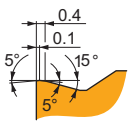


WNMG

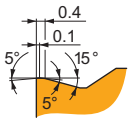
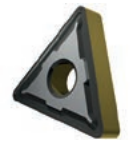
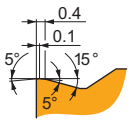
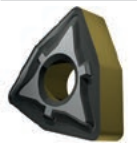
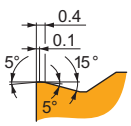
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0804	12.700	5.16	8.70	4.76



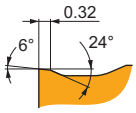
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
R talaş kırıcı sağlamdır ve Çeliklerin ve Dökme demirlerin kaba işlenmesi için tasarlanmıştır. Hafif pozitif eğim açısı ve negatif/kararlı, ekstra geniş çift T-land özelliğine sahiptir. Sert malzemeler için de şartlı olarak uygundur.																			
CNMG 120408E-R:6640	0.8	140	0.40	4.0	–	–	–	130	0.40	4.0	–	–	–	–	–	–	–	–	–
CNMG 120408E-R:T5305	0.8	240	0.40	4.0	–	–	–	225	0.40	4.0	–	–	–	–	–	–	45	0.20	0.7
CNMG 120408E-R:T5315	0.8	215	0.40	4.0	–	–	–	200	0.40	4.0	–	–	–	–	–	–	40	0.20	0.7
CNMG 120408E-R:T9325	0.8	175	0.40	4.0	–	–	–	165	0.40	4.0	–	–	–	–	–	–	–	–	–
CNMG 120408E-R:T9335	0.8	150	0.40	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 120408E-R:T9415	0.8	230	0.40	4.0	–	–	–	215	0.40	4.0	–	–	–	–	–	–	45	0.20	0.7
CNMG 120412E-R:T9325	1.2	175	0.45	4.0	–	–	–	165	0.45	4.0	–	–	–	–	–	–	–	–	–
CNMG 120412E-R:T9335	1.2	155	0.45	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 120412E-R:T9415	1.2	235	0.45	4.0	–	–	–	220	0.45	4.0	–	–	–	–	–	–	45	0.23	1.0
CNMG 120416E-R:T5315	1.6	225	0.50	4.0	–	–	–	210	0.50	4.0	–	–	–	–	–	–	45	0.25	1.3
CNMG 120416E-R:T9335	1.6	150	0.50	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 160608E-R:T5315	0.8	210	0.40	5.5	–	–	–	195	0.40	5.5	–	–	–	–	–	–	40	0.20	0.7
CNMG 160612E-R:T5315	1.2	215	0.45	5.5	–	–	–	200	0.45	5.5	–	–	–	–	–	–	40	0.23	1.0
CNMG 160612E-R:T7335	1.2	145	0.45	5.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 160612E-R:T9315	1.2	190	0.45	5.5	–	–	–	180	0.45	5.5	–	–	–	–	–	–	35	0.23	1.0
CNMG 160612E-R:T9325	1.2	170	0.45	5.5	–	–	–	160	0.45	5.5	–	–	–	–	–	–	–	–	–
CNMG 160612E-R:T9415	1.2	230	0.45	5.5	–	–	–	215	0.45	5.5	–	–	–	–	–	–	45	0.23	1.0
CNMG 190612E-R:6630	1.2	150	0.45	7.0	–	–	–	140	0.45	7.0	–	–	–	–	–	–	–	–	–
CNMG 190612E-R:6640	1.2	135	0.45	7.0	–	–	–	125	0.45	7.0	–	–	–	–	–	–	–	–	–
CNMG 190612E-R:T5315	1.2	210	0.45	7.0	–	–	–	195	0.45	7.0	–	–	–	–	–	–	40	0.23	1.0
CNMG 190612E-R:T9325	1.2	165	0.45	7.0	–	–	–	155	0.45	7.0	–	–	–	–	–	–	–	–	–
CNMG 190612E-R:T9335	1.2	145	0.45	7.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 190612E-R:T9415	1.2	225	0.45	7.0	–	–	–	210	0.45	7.0	–	–	–	–	–	–	45	0.23	1.0
CNMG 190616E-R:6630	1.6	150	0.50	7.0	–	–	–	140	0.50	7.0	–	–	–	–	–	–	–	–	–
CNMG 190616E-R:6640	1.6	130	0.50	7.0	–	–	–	120	0.50	7.0	–	–	–	–	–	–	–	–	–
CNMG 190616E-R:T5315	1.6	210	0.50	7.0	–	–	–	195	0.50	7.0	–	–	–	–	–	–	40	0.25	1.3
CNMG 190616E-R:T9315	1.6	180	0.50	7.0	–	–	–	170	0.50	7.0	–	–	–	–	–	–	35	0.25	1.3
CNMG 190616E-R:T9325	1.6	165	0.50	7.0	–	–	–	155	0.50	7.0	–	–	–	–	–	–	–	–	–
CNMG 190616E-R:T9335	1.6	145	0.50	7.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 190616E-R:T9415	1.6	225	0.50	7.0	–	–	–	210	0.50	7.0	–	–	–	–	–	–	45	0.25	1.3
 																			
R talaş kırıcı sağlamdır ve Çeliklerin ve Dökme demirlerin kaba işlenmesi için tasarlanmıştır. Hafif pozitif eğim açısı ve negatif/kararlı, ekstra geniş çift T-land özelliğine sahiptir. Sert malzemeler için de şartlı olarak uygundur.																			
DNMG 150408E-R:T5315	0.8	175	0.40	3.0	–	–	–	165	0.40	3.0	–	–	–	–	–	–	35	0.20	0.7
DNMG 150608E-R:T5305	0.8	200	0.40	3.0	–	–	–	190	0.40	3.0	–	–	–	–	–	–	40	0.20	0.7
DNMG 150608E-R:T5315	0.8	175	0.40	3.0	–	–	–	165	0.40	3.0	–	–	–	–	–	–	35	0.20	0.7
DNMG 150608E-R:T9325	0.8	140	0.40	3.0	–	–	–	130	0.40	3.0	–	–	–	–	–	–	–	–	–
DNMG 150608E-R:T9415	0.8	190	0.40	3.0	–	–	–	180	0.40	3.0	–	–	–	–	–	–	35	0.20	0.7
DNMG 150612E-R:T5315	1.2	185	0.40	3.0	–	–	–	175	0.40	3.0	–	–	–	–	–	–	35	0.20	0.9
DNMG 150612E-R:T9325	1.2	150	0.40	3.0	–	–	–	140	0.40	3.0	–	–	–	–	–	–	–	–	–
DNMG 150612E-R:T9415	1.2	200	0.40	3.0	–	–	–	190	0.40	3.0	–	–	–	–	–	–	40	0.20	0.9
DNMG 150616E-R:T9325	1.6	155	0.40	3.0	–	–	–	145	0.40	3.0	–	–	–	–	–	–	–	–	–
 																			
R talaş kırıcı sağlamdır ve Çeliklerin ve Dökme demirlerin kaba işlenmesi için tasarlanmıştır. Hafif pozitif eğim açısı ve negatif/kararlı, ekstra geniş çift T-land özelliğine sahiptir. Sert malzemeler için de şartlı olarak uygundur.																			
SNMG 120408E-R:6640	0.8	145	0.40	3.8	–	–	–	135	0.40	3.8	–	–	–	–	–	–	–	–	–
SNMG 120408E-R:T5305	0.8	250	0.40	3.8	–	–	–	235	0.40	3.8	–	–	–	–	–	–	50	0.20	0.7
SNMG 120408E-R:T9325	0.8	180	0.40	3.8	–	–	–	170	0.40	3.8	–	–	–	–	–	–	–	–	–
SNMG 120408E-R:T9335	0.8	155	0.40	3.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG 120412E-R:T9325	1.2	180	0.45	3.8	–	–	–	170	0.45	3.8	–	–	–	–	–	–	–	–	–
SNMG 120412E-R:T9335	1.2	160	0.45	3.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG 120416E-R:T9325	1.6	185	0.50	3.8	–	–	–	175	0.50	3.8	–	–	–	–	–	–	–	–	–
SNMG 120416E-R:T9415	1.6	250	0.50	3.8	–	–	–	235	0.50	3.8	–	–	–	–	–	–	50	0.25	1.3

Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE	P			M			K			N			S			H		
	(mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)
		**R** talaş kırıcı sağlamdır ve Çeliklerin ve Dökme demirlerin kaba işlenmesi için tasarlanmıştır. Hafif pozitif eğim açısı ve negatif/kararlı, ekstra geniş çift T-land özelliğine sahiptir. Sert malzemeler için de şartlı olarak uygundur.																	
SNMG 150612E-R:T5315	1.2	230	0.45	4.5	–	–	–	215	0.45	4.5	–	–	–	–	–	–	45	0.23	1.0
SNMG 150612E-R:T9325	1.2	180	0.45	4.5	–	–	–	170	0.45	4.5	–	–	–	–	–	–	–	–	–
SNMG 150612E-R:T9415	1.2	245	0.45	4.5	–	–	–	230	0.45	4.5	–	–	–	–	–	–	45	0.23	1.0
SNMG 150616E-R:T5315	1.6	230	0.50	4.5	–	–	–	215	0.50	4.5	–	–	–	–	–	–	45	0.25	1.3
SNMG 150616E-R:T9325	1.6	180	0.50	4.5	–	–	–	170	0.50	4.5	–	–	–	–	–	–	–	–	–
SNMG 190612E-R:6630	1.2	160	0.45	6.0	–	–	–	150	0.45	6.0	–	–	–	–	–	–	–	–	–
SNMG 190612E-R:6640	1.2	140	0.45	6.0	–	–	–	130	0.45	6.0	–	–	–	–	–	–	–	–	–
SNMG 190612E-R:T9325	1.2	175	0.45	6.0	–	–	–	165	0.45	6.0	–	–	–	–	–	–	–	–	–
SNMG 190616E-R:6630	1.6	165	0.50	6.0	–	–	–	155	0.50	6.0	–	–	–	–	–	–	–	–	–
SNMG 190616E-R:T9325	1.6	175	0.50	6.0	–	–	–	165	0.50	6.0	–	–	–	–	–	–	–	–	–
SNMG 190616E-R:T9335	1.6	150	0.50	6.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG 190616E-R:T9415	1.6	240	0.50	6.0	–	–	–	225	0.50	6.0	–	–	–	–	–	–	45	0.25	1.3
		**R** talaş kırıcı sağlamdır ve Çeliklerin ve Dökme demirlerin kaba işlenmesi için tasarlanmıştır. Hafif pozitif eğim açısı ve negatif/kararlı, ekstra geniş çift T-land özelliğine sahiptir. Sert malzemeler için de şartlı olarak uygundur.																	
TNMG 160408E-R:T5305	0.8	210	0.40	3.0	–	–	–	195	0.40	3.0	–	–	–	–	–	–	40	0.20	0.7
TNMG 160408E-R:T5315	0.8	185	0.40	3.0	–	–	–	175	0.40	3.0	–	–	–	–	–	–	35	0.20	0.7
TNMG 160408E-R:T9325	0.8	150	0.40	3.0	–	–	–	140	0.40	3.0	–	–	–	–	–	–	–	–	–
TNMG 160408E-R:T9335	0.8	130	0.40	3.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG 160408E-R:T9415	0.8	205	0.40	3.0	–	–	–	190	0.40	3.0	–	–	–	–	–	–	40	0.20	0.7
TNMG 160412E-R:T5315	1.2	195	0.40	3.0	–	–	–	185	0.40	3.0	–	–	–	–	–	–	35	0.20	0.9
TNMG 160412E-R:T9325	1.2	160	0.40	3.0	–	–	–	150	0.40	3.0	–	–	–	–	–	–	–	–	–
TNMG 160412E-R:T9335	1.2	140	0.40	3.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG 160412E-R:T9415	1.2	215	0.40	3.0	–	–	–	200	0.40	3.0	–	–	–	–	–	–	40	0.20	0.9
TNMG 220408E-R:T9325	0.8	145	0.40	4.0	–	–	–	135	0.40	4.0	–	–	–	–	–	–	–	–	–
TNMG 220408E-R:T9335	0.8	125	0.40	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG 220408E-R:T9415	0.8	195	0.40	4.0	–	–	–	185	0.40	4.0	–	–	–	–	–	–	35	0.20	0.7
TNMG 220412E-R:T9325	1.2	155	0.40	4.0	–	–	–	145	0.40	4.0	–	–	–	–	–	–	–	–	–
TNMG 220412E-R:T9415	1.2	205	0.40	4.0	–	–	–	190	0.40	4.0	–	–	–	–	–	–	40	0.20	0.9
TNMG 220416E-R:T9325	1.6	165	0.40	4.0	–	–	–	155	0.40	4.0	–	–	–	–	–	–	–	–	–
		**R** talaş kırıcı sağlamdır ve Çeliklerin ve Dökme demirlerin kaba işlenmesi için tasarlanmıştır. Hafif pozitif eğim açısı ve negatif/kararlı, ekstra geniş çift T-land özelliğine sahiptir. Sert malzemeler için de şartlı olarak uygundur.																	
WNMG 080408E-R:T5305	0.8	245	0.40	3.5	–	–	–	230	0.40	3.5	–	–	–	–	–	–	45	0.20	0.7
WNMG 080408E-R:T5315	0.8	220	0.40	3.5	–	–	–	205	0.40	3.5	–	–	–	–	–	–	40	0.20	0.7
WNMG 080408E-R:T9310	0.8	210	0.40	3.5	–	–	–	195	0.40	3.5	–	–	–	–	–	–	40	0.20	0.7
WNMG 080408E-R:T9325	0.8	175	0.40	3.5	–	–	–	165	0.40	3.5	–	–	–	–	–	–	–	–	–
WNMG 080408E-R:T9335	0.8	155	0.40	3.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG 080408E-R:T9415	0.8	235	0.40	3.5	–	–	–	220	0.40	3.5	–	–	–	–	–	–	45	0.20	0.7
WNMG 080412E-R:T5305	1.2	250	0.45	3.5	–	–	–	235	0.45	3.5	–	–	–	–	–	–	50	0.23	1.0
WNMG 080412E-R:T5315	1.2	225	0.45	3.5	–	–	–	210	0.45	3.5	–	–	–	–	–	–	45	0.23	1.0
WNMG 080412E-R:T9310	1.2	215	0.45	3.5	–	–	–	200	0.45	3.5	–	–	–	–	–	–	40	0.23	1.0
WNMG 080412E-R:T9325	1.2	180	0.45	3.5	–	–	–	170	0.45	3.5	–	–	–	–	–	–	–	–	–
WNMG 080412E-R:T9335	1.2	155	0.45	3.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG 080412E-R:T9415	1.2	240	0.45	3.5	–	–	–	225	0.45	3.5	–	–	–	–	–	–	45	0.23	1.0

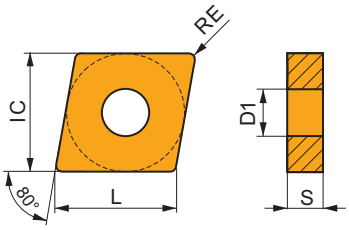
NRM



NRM talaş kırıcı çok yönlüdür ve Paslanmaz çeliklerin kaba işlenmesi için ilk tercihtir. Pozitif eğim açısı ve dengeli, geniş T-land özelliğine sahiptir. Çelikler ve Süper alaşımlar için de uygundur.

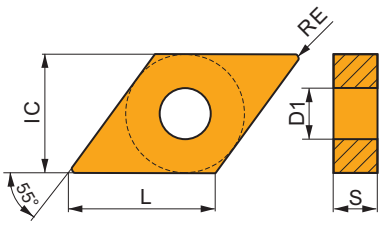
CNMG / CNMM

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.90	4.76
1606	15.875	6.35	16.10	6.35
1906	19.050	7.94	19.30	6.35
2509	25.400	9.12	25.80	9.53



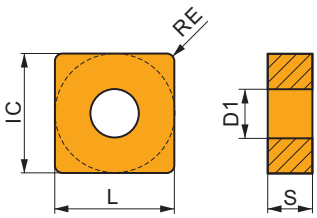
DNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1506	12.700	5.16	15.50	6.35



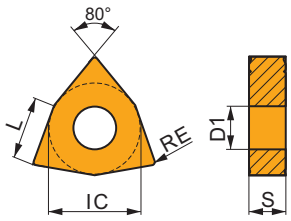
SNMG / SNMM

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76
1506	15.875	6.35	15.88	6.35
2507	25.400	9.12	25.40	7.94
2509	25.400	9.12	25.40	9.53

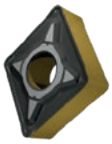
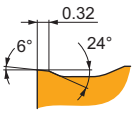
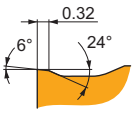
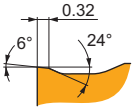


WNMG

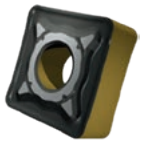
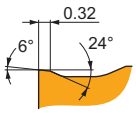
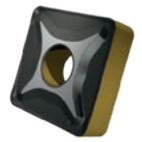
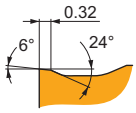
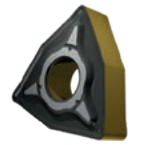
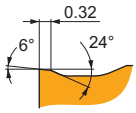
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0804	12.700	5.16	8.70	4.76



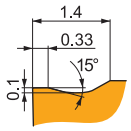
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE	P			M			K			N			S			H		
	(mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)
 		**NRM** talaş kırıcı çok yönlüdür ve Paslanmaz çeliklerin kaba işlenmesi için ilk tercihtir. Pozitif eğim açısı ve dengeli, geniş T-land özelliğine sahiptir. Çelikler ve Süper alaşımlar için de uygundur.																	
CNMG 120408-NRM:T7325	0.8	160	0.35	4.0	120	0.32	4.0	–	–	–	–	–	–	50	0.28	3.2	–	–	–
CNMG 120408-NRM:T8430	0.8	150	0.35	4.0	80	0.32	4.0	–	–	–	–	–	–	30	0.25	3.2	–	–	–
CNMG 120408-NRM:T9415	0.8	245	0.35	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 120412-NRM:T7325	1.2	165	0.40	4.0	125	0.36	4.0	–	–	–	–	–	–	50	0.28	3.2	–	–	–
CNMG 120412-NRM:T8430	1.2	150	0.40	4.0	80	0.36	4.0	–	–	–	–	–	–	30	0.28	3.2	–	–	–
CNMG 120412-NRM:T9415	1.2	245	0.40	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 160608-NRM:T7325	0.8	155	0.35	6.0	120	0.32	6.0	–	–	–	–	–	–	50	0.28	4.8	–	–	–
CNMG 160608-NRM:T9415	0.8	235	0.35	6.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 160612-NRM:T7325	1.2	155	0.40	6.0	120	0.36	6.0	–	–	–	–	–	–	50	0.32	4.8	–	–	–
CNMG 160612-NRM:T7335	1.2	150	0.40	6.0	115	0.36	6.0	–	–	–	–	–	–	45	0.32	4.8	–	–	–
CNMG 160612-NRM:T9415	1.2	235	0.40	6.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 160616-NRM:T7325	1.6	155	0.45	6.0	120	0.41	6.0	–	–	–	–	–	–	50	0.36	4.8	–	–	–
CNMG 160616-NRM:T7335	1.6	150	0.45	6.0	115	0.41	6.0	–	–	–	–	–	–	45	0.36	4.8	–	–	–
CNMG 160616-NRM:T8430	1.6	145	0.45	6.0	80	0.41	6.0	–	–	–	–	–	–	30	0.32	4.8	–	–	–
CNMG 160616-NRM:T9415	1.6	240	0.45	6.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 190612-NRM:T7325	1.2	155	0.40	8.0	120	0.36	8.0	–	–	–	–	–	–	50	0.32	6.4	–	–	–
CNMG 190612-NRM:T8430	1.2	140	0.40	8.0	75	0.36	8.0	–	–	–	–	–	–	30	0.28	6.4	–	–	–
CNMG 190612-NRM:T9415	1.2	230	0.40	8.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 190616-NRM:T7325	1.6	150	0.45	8.0	115	0.41	8.0	–	–	–	–	–	–	45	0.36	6.4	–	–	–
CNMG 190616-NRM:T7335	1.6	145	0.45	8.0	110	0.41	8.0	–	–	–	–	–	–	45	0.36	6.4	–	–	–
CNMG 190616-NRM:T8430	1.6	140	0.45	8.0	75	0.41	8.0	–	–	–	–	–	–	30	0.32	6.4	–	–	–
CNMG 190616-NRM:T9415	1.6	230	0.45	8.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 250924-NRM:T7325	2.4	95	0.70	10.0	70	0.63	10.0	–	–	–	–	–	–	30	0.49	8.0	–	–	–
CNMG 250924-NRM:T7335	2.4	90	0.70	10.0	70	0.63	10.0	–	–	–	–	–	–	25	0.49	8.0	–	–	–
 		**NRM** talaş kırıcı çok yönlüdür ve Paslanmaz çeliklerin kaba işlenmesi için ilk tercihtir. Pozitif eğim açısı ve dengeli, geniş T-land özelliğine sahiptir. Çelikler ve Süper alaşımlar için de uygundur.																	
CNMM 250924-NRM:T7325	2.4	95	0.70	10.0	70	0.63	10.0	–	–	–	–	–	–	30	0.49	8.0	–	–	–
CNMM 250924-NRM:T7335	2.4	90	0.70	10.0	70	0.63	10.0	–	–	–	–	–	–	25	0.49	8.0	–	–	–
 		**NRM** talaş kırıcı çok yönlüdür ve Paslanmaz çeliklerin kaba işlenmesi için ilk tercihtir. Pozitif eğim açısı ve dengeli, geniş T-land özelliğine sahiptir. Çelikler ve Süper alaşımlar için de uygundur.																	
DNMG 150608-NRM:T7335	0.8	130	0.30	3.0	100	0.27	3.0	–	–	–	–	–	–	40	0.24	2.4	–	–	–
DNMG 150608-NRM:T9415	0.8	210	0.30	3.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE	P				M				K				N				S				H			
		vc (m/min)	f (mm/rev)	ap (mm)		vc (m/min)	f (mm/rev)	ap (mm)		vc (m/min)	f (mm/rev)	ap (mm)		vc (m/min)	f (mm/rev)	ap (mm)		vc (m/min)	f (mm/rev)	ap (mm)		vc (m/min)	f (mm/rev)	ap (mm)	
						**NRM** talaş kırıcı çok yönlüdür ve Paslanmaz çeliklerin kaba işlenmesi için ilk tercihtir. Pozitif eğim açısı ve dengeli, geniş T-land özelliğine sahiptir. Çelikler ve Süper alaşımlar için de uygundur.																			
SNMG 120408-NRM:T7325	0.8	◪	175	0.35	2.6	■	135	0.32	2.6		–	–	–		–	–	–	■	55	0.28	2.1		–	–	–
SNMG 120412-NRM:T8430	1.2	■	165	0.40	3.0	■	90	0.36	3.0		–	–	–		–	–	–	◪	35	0.28	2.4		–	–	–
SNMG 120412-NRM:T9415	1.2	■	265	0.40	3.0		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–
SNMG 150612-NRM:T7325	1.2	◪	170	0.40	4.0	■	130	0.36	4.0		–	–	–		–	–	–	■	55	0.32	3.2		–	–	–
SNMG 150616-NRM:T7325	1.6	◪	170	0.45	5.0	■	130	0.41	5.0		–	–	–		–	–	–	■	55	0.36	4.0		–	–	–
SNMG 150616-NRM:T8430	1.6	■	150	0.45	5.0	■	80	0.41	5.0		–	–	–		–	–	–	◪	30	0.32	4.0		–	–	–
SNMG 150616-NRM:T9415	1.6	■	250	0.45	5.0		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–
SNMG 250924-NRM:T7325	2.4	◪	105	0.70	9.0	■	80	0.63	9.0		–	–	–		–	–	–	■	30	0.49	7.2		–	–	–
SNMG 250924-NRM:T9415	2.4	■	125	0.70	9.0		–	–	–	◪	115	0.70	9.0		–	–	–		–	–	–		–	–	–
						**NRM** talaş kırıcı çok yönlüdür ve Paslanmaz çeliklerin kaba işlenmesi için ilk tercihtir. Pozitif eğim açısı ve dengeli, geniş T-land özelliğine sahiptir. Çelikler ve Süper alaşımlar için de uygundur.																			
SNMM 250716-NRM:T9415	– 1.6	■	140	0.45	9.0		–	–	–	◪	130	0.45	9.0		–	–	–		–	–	–		–	–	–
SNMM 250724-NRM:T9415	2.4	■	130	0.65	9.0		–	–	–	◪	120	0.65	9.0		–	–	–		–	–	–		–	–	–
SNMM 250924-NRM:T7325	2.4	◪	105	0.70	9.0	■	80	0.63	9.0		–	–	–		–	–	–	■	30	0.49	7.2		–	–	–
SNMM 250924-NRM:T7335	2.4	◪	95	0.70	9.0	■	70	0.63	9.0		–	–	–		–	–	–	■	30	0.49	7.2		–	–	–
SNMM 250924-NRM:T8430	2.4	■	130	0.70	9.0	■	70	0.63	9.0	◪	105	0.70	9.0		–	–	–	◪	25	0.49	7.2		–	–	–
						**NRM** talaş kırıcı çok yönlüdür ve Paslanmaz çeliklerin kaba işlenmesi için ilk tercihtir. Pozitif eğim açısı ve dengeli, geniş T-land özelliğine sahiptir. Çelikler ve Süper alaşımlar için de uygundur.																			
WNMG 080408-NRM:T7325	0.8	◪	170	0.35	2.7	■	130	0.32	2.7		–	–	–		–	–	–	■	55	0.28	2.2		–	–	–
WNMG 080408-NRM:T7335	0.8	◪	160	0.35	2.7	■	120	0.32	2.7		–	–	–		–	–	–	■	50	0.28	2.2		–	–	–
WNMG 080408-NRM:T9415	0.8	■	255	0.35	2.7		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–
WNMG 080412-NRM:T7325	1.2	◪	170	0.40	2.7	■	130	0.36	2.7		–	–	–		–	–	–	■	55	0.28	2.2		–	–	–
WNMG 080412-NRM:T8430	1.2	■	155	0.40	2.7	■	85	0.36	2.7		–	–	–		–	–	–	◪	30	0.28	2.2		–	–	–
WNMG 080412-NRM:T9315	1.2	■	215	0.40	2.7		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–
WNMG 080412-NRM:T9415	1.2	■	255	0.40	2.7		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–

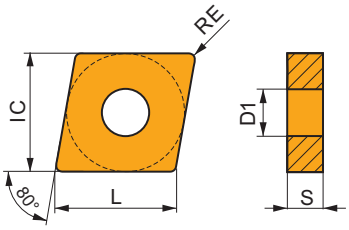
KR



KR talaş kırıcı sağlamdır ve dökme demirlerin kaba işlenmesi için ilk tercihtir. Hafif pozitif eğim açısı ve geniş T-land özelliğine sahiptir. Çelikler için ve şartlı olarak Sert malzemeler için de uygundur.

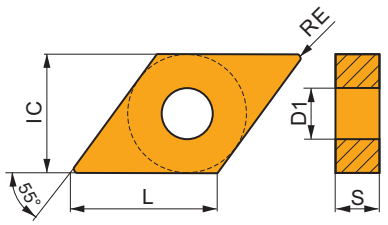
CNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.90	4.76



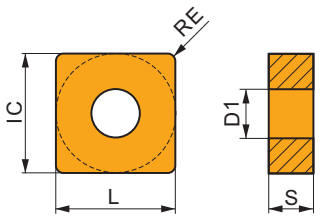
DNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1506	12.700	5.16	15.50	6.35



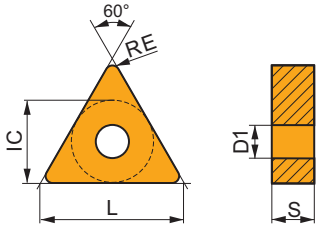
SNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76



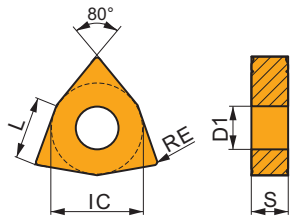
TNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76

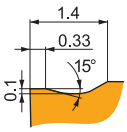
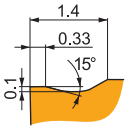
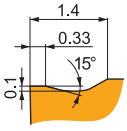
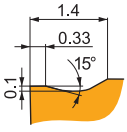
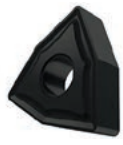
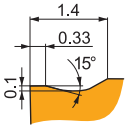


WNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0804	12.700	5.16	8.70	4.76

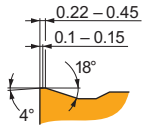


Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
  																			
KR talaş kırıcı sağlamdır ve dökme demirlerin kaba işlenmesi için ilk tercihtir. Hafif pozitif eğim açısı ve geniş T-land özelliğine sahiptir. Çelikler için ve şartlı olarak Sert malzemeler için de uygundur.																			
CNMG 120408E-KR:T5305	0.8	255	0.35	4.0	–	–	–	240	0.35	4.0	–	–	–	–	–	–	50	0.18	0.7
CNMG 120408E-KR:T5315	0.8	225	0.35	4.0	–	–	–	210	0.35	4.0	–	–	–	–	–	–	45	0.18	0.7
CNMG 120412E-KR:T5305	1.2	255	0.40	4.0	–	–	–	240	0.40	4.0	–	–	–	–	–	–	50	0.20	1.0
CNMG 120412E-KR:T5315	1.2	230	0.40	4.0	–	–	–	215	0.40	4.0	–	–	–	–	–	–	45	0.20	1.0
CNMG 120416E-KR:T5315	1.6	230	0.45	4.0	–	–	–	215	0.45	4.0	–	–	–	–	–	–	45	0.32	0.8
CNMG 160612E-KR:T5315	1.2	230	0.45	4.5	–	–	–	215	0.45	4.5	–	–	–	–	–	–	45	0.32	0.8
CNMG 160616E-KR:T5315	1.6	230	0.50	4.5	–	–	–	215	0.50	4.5	–	–	–	–	–	–	45	0.35	0.8
CNMG 190612E-KR:T5315	1.2	220	0.45	7.0	–	–	–	205	0.45	7.0	–	–	–	–	–	–	40	0.32	0.8
CNMG 190616E-KR:T5315	1.6	220	0.50	7.0	–	–	–	205	0.50	7.0	–	–	–	–	–	–	40	0.35	0.8
  																			
KR talaş kırıcı sağlamdır ve dökme demirlerin kaba işlenmesi için ilk tercihtir. Hafif pozitif eğim açısı ve geniş T-land özelliğine sahiptir. Çelikler için ve şartlı olarak Sert malzemeler için de uygundur.																			
DNMG 150608E-KR:T5315	0.8	195	0.35	3.0	–	–	–	185	0.35	3.0	–	–	–	–	–	–	35	0.25	0.8
DNMG 150612E-KR:T5315	1.2	195	0.40	3.0	–	–	–	185	0.40	3.0	–	–	–	–	–	–	35	0.28	0.8
  																			
KR talaş kırıcı sağlamdır ve dökme demirlerin kaba işlenmesi için ilk tercihtir. Hafif pozitif eğim açısı ve geniş T-land özelliğine sahiptir. Çelikler için ve şartlı olarak Sert malzemeler için de uygundur.																			
SNMG 120408E-KR:T5305	0.8	265	0.35	3.8	–	–	–	250	0.35	3.8	–	–	–	–	–	–	50	0.18	0.7
SNMG 120408E-KR:T5315	0.8	235	0.35	3.8	–	–	–	220	0.35	3.8	–	–	–	–	–	–	45	0.18	0.7
SNMG 120412E-KR:T5315	1.2	240	0.40	3.8	–	–	–	225	0.40	3.8	–	–	–	–	–	–	45	0.20	1.0
SNMG 120416E-KR:T5315	1.6	260	0.45	3.8	–	–	–	245	0.45	3.8	–	–	–	–	–	–	50	0.32	0.8
SNMG 150612E-KR:T5315	1.2	240	0.45	4.5	–	–	–	225	0.45	4.5	–	–	–	–	–	–	45	0.32	0.8
SNMG 150616E-KR:T5315	1.6	240	0.50	4.5	–	–	–	225	0.50	4.5	–	–	–	–	–	–	45	0.35	0.8
SNMG 190616E-KR:T5315	1.6	230	0.50	7.0	–	–	–	215	0.50	7.0	–	–	–	–	–	–	45	0.35	0.8
  																			
KR talaş kırıcı sağlamdır ve dökme demirlerin kaba işlenmesi için ilk tercihtir. Hafif pozitif eğim açısı ve geniş T-land özelliğine sahiptir. Çelikler için ve şartlı olarak Sert malzemeler için de uygundur.																			
TNMG 160408E-KR:T5305	0.8	220	0.35	3.0	–	–	–	205	0.35	3.0	–	–	–	–	–	–	40	0.18	0.7
TNMG 160408E-KR:T5315	0.8	200	0.35	3.0	–	–	–	190	0.35	3.0	–	–	–	–	–	–	40	0.18	0.7
TNMG 220408E-KR:T5315	0.8	200	0.35	4.0	–	–	–	190	0.35	4.0	–	–	–	–	–	–	40	0.25	0.8
TNMG 220412E-KR:T5315	1.2	205	0.40	4.0	–	–	–	190	0.40	4.0	–	–	–	–	–	–	40	0.28	0.8
  																			
KR talaş kırıcı sağlamdır ve dökme demirlerin kaba işlenmesi için ilk tercihtir. Hafif pozitif eğim açısı ve geniş T-land özelliğine sahiptir. Çelikler için ve şartlı olarak Sert malzemeler için de uygundur.																			
WNMG 080408E-KR:T5305	0.8	255	0.35	3.5	–	–	–	240	0.35	3.5	–	–	–	–	–	–	50	0.18	0.7
WNMG 080408E-KR:T5315	0.8	230	0.35	3.5	–	–	–	215	0.35	3.5	–	–	–	–	–	–	45	0.18	0.7
WNMG 080412E-KR:T5315	1.2	235	0.40	3.5	–	–	–	220	0.40	3.5	–	–	–	–	–	–	45	0.20	1.0

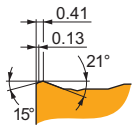
AĞIR KABA İŞLEME - REHBER

OR



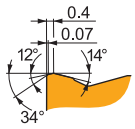
OR talaş kırıcı sağlamdır ve Çeliklerin ağır kaba işlenmesi için ilk tercihtir. Pozitif eğim açısı ve negatif/kararlı, ekstra geniş çift T-land özelliğine sahiptir. Dökme demirler için ve şartlı olarak Paslanmaz çelikler ve Süper alaşımlar için de uygundur.

NR2



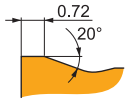
NR2 talaş kırıcı sağlamdır ve Paslanmaz çeliklerin ağır kaba işlenmesi için ilk tercihtir. Pozitif eğim açısı ve negatif/negatif, ekstra geniş çift T-land özelliğine sahiptir. Çelikler için ve şartlı olarak Dökme demirler ve Süper alaşımlar için de uygundur.

HR



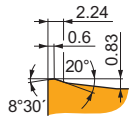
HR talaş kırıcı sağlamdır ve Çeliklerin ve Dökme demirlerin ağır kaba işlenmesi için tasarlanmıştır. Hafif pozitif eğim açısı ve negatif/negatif, ekstra geniş çift T-land özelliğine sahiptir. Paslanmaz çelikler için de şartlı olarak uygundur.

HR2



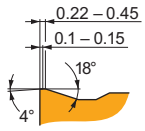
HR2 talaş kırıcı sağlamdır ve Çeliklerin ve Dökme demirlerin ağır kaba işlenmesi için tasarlanmıştır. Pozitif eğim açısı ve dengeli, ekstra geniş çift T-land özelliğine sahiptir. Paslanmaz çelikler için de şartlı olarak uygundur.

923



923 talaş kırıcı sağlamdır ve Paslanmaz çeliklerin ağır kaba işlenmesi için tasarlanmıştır. Pozitif eğim açısı ve negatif/kararlı, ekstra geniş çift T-land özelliğine sahiptir. Çelikler ve Dökme demirler için de şartlı olarak uygundur.

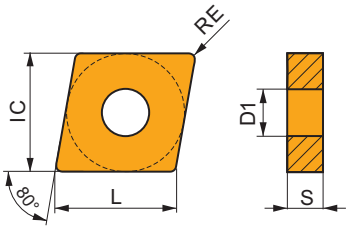
OR



OR talaş kırıcı sağlamdır ve Çeliklerin ağır kaba işlenmesi için ilk tercihtir. Pozitif eğim açısı ve negatif/kararlı, ekstra geniş çift T-land özelliğine sahiptir. Dökme demirler için ve şartlı olarak Paslanmaz çelikler ve Süper alaşımlar için de uygundur.

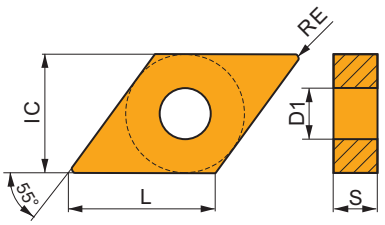
CNMM

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.90	4.76
1606	15.875	6.35	16.10	6.35
1906	19.050	7.94	19.30	6.35
2509	25.400	9.12	25.80	9.53



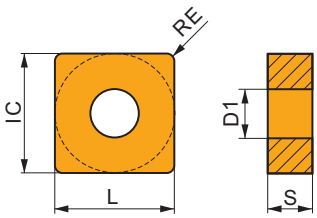
DNMM

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1506	12.700	5.16	15.50	6.35



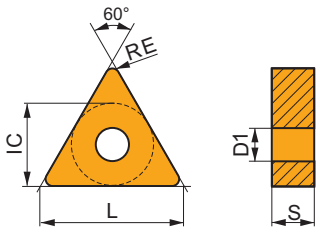
SNMM

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76
1506	15.875	6.35	15.88	6.35
1906	19.050	7.94	19.05	6.35
2507	25.400	9.12	25.40	7.94
2509	25.400	9.12	25.40	9.53



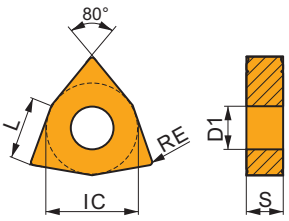
TNMM

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76
2204	12.700	5.16	22.00	4.76

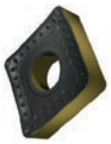
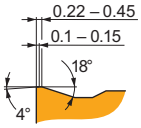
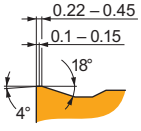


WNMM

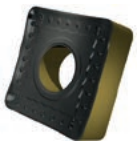
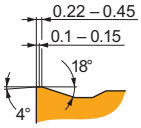
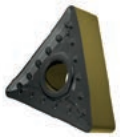
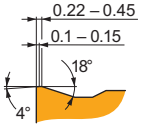
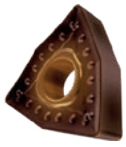
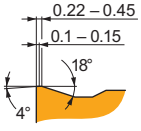
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0804	12.700	5.16	8.70	4.76
1306	19.050	7.94	13.00	6.35



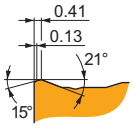
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
OR talaş kırıcı sağlamdır ve Çeliklerin ağır kaba işlenmesi için ilk tercihtir. Pozitif eğim açısı ve negatif/kararlı, ekstra geniş çift T-land özelliğine sahiptir. Dökme demirler için ve şartlı olarak Paslanmaz çelikler ve Süper alaşımlar için de uygundur.																			
CNMM 120408E-OR:T8430	0.8	150	0.40	5.0	80	0.36	5.0	125	0.40	5.0	–	–	–	30	0.28	4.0	–	–	–
CNMM 120408E-OR:T9325	0.8	185	0.40	5.0	110	0.36	5.0	175	0.40	5.0	–	–	–	40	0.28	4.0	–	–	–
CNMM 120408E-OR:T9335	0.8	160	0.40	5.0	95	0.36	5.0	–	–	–	–	–	–	35	0.28	4.0	–	–	–
CNMM 120408E-OR:T9415	0.8	250	0.40	5.0	–	–	–	235	0.40	5.0	–	–	–	–	–	–	–	–	–
CNMM 120412E-OR:T9325	1.2	185	0.45	5.0	110	0.41	5.0	175	0.45	5.0	–	–	–	40	0.36	4.0	–	–	–
CNMM 120412E-OR:T9335	1.2	165	0.45	5.0	95	0.41	5.0	–	–	–	–	–	–	35	0.36	4.0	–	–	–
CNMM 120412E-OR:T9415	1.2	250	0.45	5.0	–	–	–	235	0.45	5.0	–	–	–	–	–	–	–	–	–
CNMM 120416E-OR:T9325	1.6	190	0.50	5.0	110	0.45	5.0	180	0.50	5.0	–	–	–	40	0.40	4.0	–	–	–
CNMM 160608E-OR:T9325	0.8	180	0.40	6.0	105	0.36	6.0	170	0.40	6.0	–	–	–	40	0.32	4.8	–	–	–
CNMM 160608E-OR:T9415	0.8	245	0.40	6.0	–	–	–	230	0.40	6.0	–	–	–	–	–	–	–	–	–
CNMM 160612E-OR:T8430	1.2	150	0.45	6.0	80	0.41	6.0	125	0.45	6.0	–	–	–	30	0.36	4.8	–	–	–
CNMM 160612E-OR:T9325	1.2	185	0.45	6.0	110	0.41	6.0	175	0.45	6.0	–	–	–	40	0.36	4.8	–	–	–
CNMM 160612E-OR:T9415	1.2	250	0.45	6.0	–	–	–	235	0.45	6.0	–	–	–	–	–	–	–	–	–
CNMM 160616E-OR:T9325	1.6	180	0.50	6.0	105	0.45	6.0	170	0.50	6.0	–	–	–	40	0.40	4.8	–	–	–
CNMM 160616E-OR:T9415	1.6	250	0.50	6.0	–	–	–	235	0.50	6.0	–	–	–	–	–	–	–	–	–
CNMM 190612E-OR:T8430	1.2	140	0.45	9.0	75	0.41	9.0	115	0.45	9.0	–	–	–	30	0.36	7.2	–	–	–
CNMM 190612E-OR:T9325	1.2	175	0.45	9.0	105	0.41	9.0	165	0.45	9.0	–	–	–	35	0.36	7.2	–	–	–
CNMM 190612E-OR:T9335	1.2	150	0.45	9.0	90	0.41	9.0	–	–	–	–	–	–	30	0.36	7.2	–	–	–
CNMM 190612E-OR:T9415	1.2	240	0.45	9.0	–	–	–	225	0.45	9.0	–	–	–	–	–	–	–	–	–
CNMM 190616E-OR:6630	1.6	160	0.50	9.0	95	0.45	9.0	150	0.50	9.0	–	–	–	40	0.40	7.2	–	–	–
CNMM 190616E-OR:T8430	1.6	140	0.50	9.0	75	0.45	9.0	115	0.50	9.0	–	–	–	30	0.40	7.2	–	–	–
CNMM 190616E-OR:T9325	1.6	175	0.50	9.0	105	0.45	9.0	165	0.50	9.0	–	–	–	35	0.40	7.2	–	–	–
CNMM 190616E-OR:T9335	1.6	155	0.50	9.0	90	0.45	9.0	–	–	–	–	–	–	30	0.40	7.2	–	–	–
CNMM 190616E-OR:T9415	1.6	240	0.50	9.0	–	–	–	225	0.50	9.0	–	–	–	–	–	–	–	–	–
CNMM 190624E-OR:T9315	2.4	165	0.80	9.0	–	–	–	155	0.80	9.0	–	–	–	–	–	–	–	–	–
CNMM 190624E-OR:T9325	2.4	150	0.80	9.0	90	0.72	9.0	140	0.80	9.0	–	–	–	30	0.56	7.2	–	–	–
CNMM 190624E-OR:T9415	2.4	215	0.80	9.0	–	–	–	200	0.80	9.0	–	–	–	–	–	–	–	–	–
CNMM 250924E-OR:6630	2.4	80	1.00	12.0	45	0.90	12.0	75	1.00	12.0	–	–	–	20	0.70	9.6	–	–	–
CNMM 250924E-OR:T8430	2.4	75	1.00	12.0	40	0.90	12.0	60	1.00	12.0	–	–	–	15	0.70	9.6	–	–	–
CNMM 250924E-OR:T9325	2.4	95	1.00	12.0	55	0.90	12.0	90	1.00	12.0	–	–	–	20	0.70	9.6	–	–	–
CNMM 250924E-OR:T9335	2.4	75	1.00	12.0	45	0.90	12.0	–	–	–	–	–	–	15	0.70	9.6	–	–	–
CNMM 250924E-OR:T9415	2.4	110	1.00	12.0	–	–	–	100	1.00	12.0	–	–	–	–	–	–	–	–	–
 																			
OR talaş kırıcı sağlamdır ve Çeliklerin ağır kaba işlenmesi için ilk tercihtir. Pozitif eğim açısı ve negatif/kararlı, ekstra geniş çift T-land özelliğine sahiptir. Dökme demirler için ve şartlı olarak Paslanmaz çelikler ve Süper alaşımlar için de uygundur.																			
DNMM 150608E-OR:T9325	0.8	155	0.40	3.0	90	0.36	3.0	145	0.40	3.0	–	–	–	30	0.28	2.4	–	–	–
DNMM 150612E-OR:T9325	1.2	165	0.40	3.0	95	0.36	3.0	155	0.40	3.0	–	–	–	35	0.32	2.4	–	–	–
DNMM 150612E-OR:T9335	1.2	145	0.40	3.0	85	0.36	3.0	–	–	–	–	–	–	30	0.32	2.4	–	–	–
DNMM 150612E-OR:T9415	1.2	220	0.40	3.0	–	–	–	205	0.40	3.0	–	–	–	–	–	–	–	–	–
DNMM 150616E-OR:T9325	1.6	165	0.45	3.0	95	0.41	3.0	155	0.45	3.0	–	–	–	35	0.41	2.4	–	–	–

Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
OR talaş kırıcı sağlamdır ve Çeliklerin ağır kaba işlenmesi için ilk tercihtir. Pozitif eğim açısı ve negatif/kararlı, ekstra geniş çift T-land özelliğine sahiptir. Dökme demirler için ve şartlı olarak Paslanmaz çelikler ve Süper alaşımlar için de uygundur.																			
SNMM 120408E-OR:T9325	0.8	195	0.40	4.7	115	0.36	4.7	185	0.40	4.7	–	–	–	40	0.32	3.8	–	–	–
SNMM 120408E-OR:T9335	0.8	175	0.40	4.7	105	0.36	4.7	–	–	–	–	–	–	35	0.32	3.8	–	–	–
SNMM 120408E-OR:T9415	0.8	265	0.40	4.7	–	–	–	250	0.40	4.7	–	–	–	–	–	–	–	–	–
SNMM 120412E-OR:T9325	1.2	200	0.45	4.7	120	0.41	4.7	190	0.45	4.7	–	–	–	45	0.36	3.8	–	–	–
SNMM 120412E-OR:T9415	1.2	270	0.45	4.7	–	–	–	255	0.45	4.7	–	–	–	–	–	–	–	–	–
SNMM 120416E-OR:T9325	1.6	200	0.50	4.7	120	0.45	4.7	190	0.50	4.7	–	–	–	45	0.40	3.8	–	–	–
SNMM 150608E-OR:T9325	0.8	190	0.40	6.0	110	0.36	6.0	180	0.40	6.0	–	–	–	40	0.36	4.8	–	–	–
SNMM 150612E-OR:T9325	1.2	195	0.45	6.0	115	0.41	6.0	185	0.45	6.0	–	–	–	40	0.36	4.8	–	–	–
SNMM 150616E-OR:T9325	1.6	190	0.50	6.0	110	0.45	6.0	180	0.50	6.0	–	–	–	40	0.40	4.8	–	–	–
SNMM 150616E-OR:T9415	1.6	265	0.50	6.0	–	–	–	250	0.50	6.0	–	–	–	–	–	–	–	–	–
SNMM 190612E-OR:T8430	1.2	150	0.45	8.0	80	0.41	8.0	125	0.45	8.0	–	–	–	30	0.36	6.4	–	–	–
SNMM 190612E-OR:T9325	1.2	190	0.45	8.0	110	0.41	8.0	180	0.45	8.0	–	–	–	40	0.36	6.4	–	–	–
SNMM 190612E-OR:T9335	1.2	165	0.45	8.0	95	0.41	8.0	–	–	–	–	–	–	35	0.36	6.4	–	–	–
SNMM 190612E-OR:T9415	1.2	250	0.45	8.0	–	–	–	235	0.45	8.0	–	–	–	–	–	–	–	–	–
SNMM 190616E-OR:6630	1.6	175	0.50	8.0	105	0.45	8.0	165	0.50	8.0	–	–	–	40	0.40	6.4	–	–	–
SNMM 190616E-OR:T8345	1.6	125	0.50	8.0	75	0.45	8.0	115	0.50	8.0	–	–	–	30	0.40	6.4	–	–	–
SNMM 190616E-OR:T8430	1.6	155	0.50	8.0	85	0.45	8.0	130	0.50	8.0	–	–	–	30	0.40	6.4	–	–	–
SNMM 190616E-OR:T9325	1.6	185	0.50	8.0	110	0.45	8.0	175	0.50	8.0	–	–	–	40	0.40	6.4	–	–	–
SNMM 190616E-OR:T9335	1.6	160	0.50	8.0	95	0.45	8.0	–	–	–	–	–	–	35	0.40	6.4	–	–	–
SNMM 190616E-OR:T9415	1.6	260	0.50	8.0	–	–	–	245	0.50	8.0	–	–	–	–	–	–	–	–	–
SNMM 190624E-OR:T9325	2.4	165	0.80	8.0	95	0.72	8.0	155	0.80	8.0	–	–	–	35	0.56	6.4	–	–	–
SNMM 190624E-OR:T9415	2.4	225	0.80	8.0	–	–	–	210	0.80	8.0	–	–	–	–	–	–	–	–	–
SNMM 250716E-OR:T9226	1.6	115	0.50	12.0	65	0.45	12.0	105	0.50	12.0	–	–	–	20	0.45	9.6	–	–	–
SNMM 250716E-OR:T9325	1.6	120	0.55	12.0	70	0.50	12.0	110	0.55	12.0	–	–	–	25	0.50	9.6	–	–	–
SNMM 250724E-OR:T8345	2.4	55	1.00	12.0	30	0.90	12.0	50	1.00	12.0	–	–	–	10	0.70	9.6	–	–	–
SNMM 250724E-OR:T8430	2.4	80	1.00	12.0	45	0.90	12.0	65	1.00	12.0	–	–	–	15	0.70	9.6	–	–	–
SNMM 250724E-OR:T9325	2.4	100	1.00	12.0	60	0.90	12.0	95	1.00	12.0	–	–	–	20	0.70	9.6	–	–	–
SNMM 250724E-OR:T9335	2.4	80	1.00	12.0	45	0.90	12.0	–	–	–	–	–	–	15	0.70	9.6	–	–	–
SNMM 250724E-OR:T9415	2.4	120	1.00	12.0	–	–	–	110	1.00	12.0	–	–	–	–	–	–	–	–	–
SNMM 250924E-OR:T8430	2.4	80	1.00	12.0	45	0.90	12.0	65	1.00	12.0	–	–	–	15	0.70	9.6	–	–	–
SNMM 250924E-OR:T9325	2.4	100	1.00	12.0	60	0.90	12.0	95	1.00	12.0	–	–	–	20	0.70	9.6	–	–	–
SNMM 250924E-OR:T9335	2.4	80	1.00	12.0	45	0.90	12.0	–	–	–	–	–	–	15	0.70	9.6	–	–	–
SNMM 250924E-OR:T9415	2.4	120	1.00	12.0	–	–	–	110	1.00	12.0	–	–	–	–	–	–	–	–	–
 																			
OR talaş kırıcı sağlamdır ve Çeliklerin ağır kaba işlenmesi için ilk tercihtir. Pozitif eğim açısı ve negatif/kararlı, ekstra geniş çift T-land özelliğine sahiptir. Dökme demirler için ve şartlı olarak Paslanmaz çelikler ve Süper alaşımlar için de uygundur.																			
TNMM 160408E-OR:T9325	0.8	165	0.40	3.0	95	0.36	3.0	155	0.40	3.0	–	–	–	35	0.28	2.4	–	–	–
TNMM 160408E-OR:T9415	0.8	225	0.40	3.0	–	–	–	210	0.40	3.0	–	–	–	–	–	–	–	–	–
TNMM 220408E-OR:T9325	0.8	160	0.40	4.0	95	0.36	4.0	150	0.40	4.0	–	–	–	35	0.32	3.2	–	–	–
TNMM 220408E-OR:T9335	0.8	140	0.40	4.0	80	0.36	4.0	–	–	–	–	–	–	30	0.32	3.2	–	–	–
TNMM 220412E-OR:T9325	1.2	175	0.40	3.0	105	0.36	3.0	165	0.40	3.0	–	–	–	35	0.32	2.4	–	–	–
TNMM 220412E-OR:T9335	1.2	150	0.40	3.0	90	0.36	3.0	–	–	–	–	–	–	30	0.32	2.4	–	–	–
 																			
OR talaş kırıcı sağlamdır ve Çeliklerin ağır kaba işlenmesi için ilk tercihtir. Pozitif eğim açısı ve negatif/kararlı, ekstra geniş çift T-land özelliğine sahiptir. Dökme demirler için ve şartlı olarak Paslanmaz çelikler ve Süper alaşımlar için de uygundur.																			
WNMM 080408E-OR:T8430	0.8	155	0.40	4.0	85	0.36	4.0	130	0.40	4.0	–	–	–	30	0.28	3.2	–	–	–
WNMM 080408E-OR:T9325	0.8	190	0.40	4.0	110	0.36	4.0	180	0.40	4.0	–	–	–	40	0.28	3.2	–	–	–
WNMM 080408E-OR:T9335	0.8	165	0.40	4.0	95	0.36	4.0	–	–	–	–	–	–	35	0.28	3.2	–	–	–
WNMM 080412E-OR:T9325	1.2	190	0.45	4.0	110	0.41	4.0	180	0.45	4.0	–	–	–	40	0.36	3.2	–	–	–
WNMM 080416E-OR:T9325	1.6	195	0.50	4.0	115	0.45	4.0	185	0.50	4.0	–	–	–	40	0.40	3.2	–	–	–
WNMM 130612E-OR:T9325	1.2	185	0.45	6.0	110	0.41	6.0	175	0.45	6.0	–	–	–	40	0.36	4.8	–	–	–
WNMM 130616E-OR:T9325	1.6	180	0.50	6.0	105	0.45	6.0	170	0.50	6.0	–	–	–	40	0.40	4.8	–	–	–

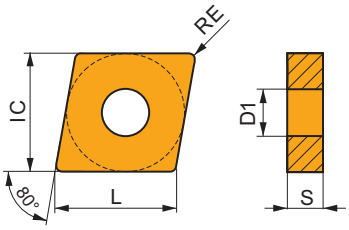
NR2



NR2 talaş kırıcı sağlamdır ve Paslanmaz çeliklerin ağır kaba işlenmesi için ilk tercihtir. Pozitif eğim açısı ve negatif/negatif, ekstra geniş çift T-land özelliğine sahiptir. Çelikler için ve şartlı olarak Dökme demirler ve Süper alaşımlar için de uygundur.

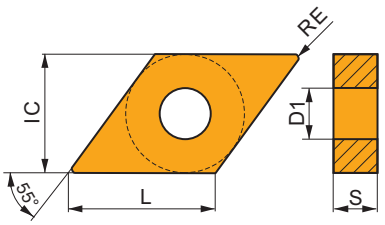
CNMM

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.90	4.76
1606	15.875	6.35	16.10	6.35
1906	19.050	7.94	19.30	6.35
2509	25.400	9.12	25.80	9.53



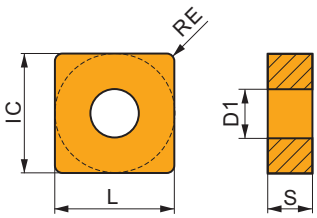
DNMM

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1506	12.700	5.16	15.50	6.35



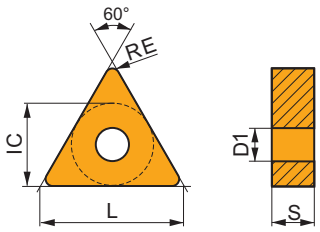
SNMM

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76
1506	15.875	6.35	15.88	6.35
1906	19.050	7.94	19.05	6.35
2507	25.400	9.12	25.40	7.94
2509	25.400	9.12	25.40	9.53



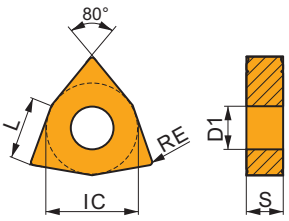
TNMM

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76
2204	12.700	5.16	22.00	4.76

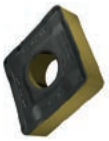
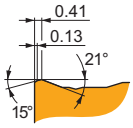
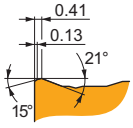


WNMM

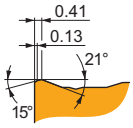
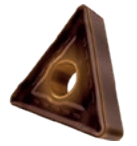
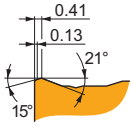
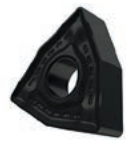
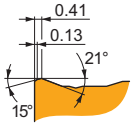
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0804	12.700	5.16	8.70	4.76



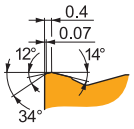
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE	P			M			K			N			S			H		
		vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)
 		**NR2** talaş kırıcı sağlamdır ve Paslanmaz çeliklerin ağır kaba işlenmesi için ilk tercihtir. Pozitif eğim açısı ve negatif/negatif, ekstra geniş çift T-land özelliğine sahiptir. Çelikler için ve şartlı olarak Dökme demirler ve Süper alaşımlar için de uygundur.																	
CNMM 120408E-NR2:T7325	0.8	165	0.40	5.0	125	0.36	5.0	–	–	–	–	–	–	50	0.28	4.0	–	–	–
CNMM 120408E-NR2:T7335	0.8	155	0.40	5.0	120	0.36	5.0	–	–	–	–	–	–	50	0.28	4.0	–	–	–
CNMM 120408E-NR2:T8430	0.8	150	0.40	5.0	80	0.36	5.0	125	0.40	5.0	–	–	–	30	0.28	4.0	–	–	–
CNMM 120408E-NR2:T9325	0.8	185	0.40	5.0	110	0.36	5.0	175	0.40	5.0	–	–	–	40	0.28	4.0	–	–	–
CNMM 120408E-NR2:T9415	0.8	250	0.40	5.0	–	–	–	235	0.40	5.0	–	–	–	–	–	–	–	–	–
CNMM 120412E-NR2:T7335	1.2	155	0.45	5.0	120	0.41	5.0	–	–	–	–	–	–	50	0.32	4.0	–	–	–
CNMM 120412E-NR2:T8430	1.2	150	0.45	5.0	80	0.41	5.0	125	0.45	5.0	–	–	–	30	0.32	4.0	–	–	–
CNMM 120412E-NR2:T9325	1.2	185	0.45	5.0	110	0.41	5.0	175	0.45	5.0	–	–	–	40	0.32	4.0	–	–	–
CNMM 160608E-NR2:T8430	0.8	150	0.40	6.0	80	0.36	6.0	125	0.40	6.0	–	–	–	30	0.32	4.8	–	–	–
CNMM 160608E-NR2:T9325	0.8	180	0.40	6.0	105	0.36	6.0	170	0.40	6.0	–	–	–	40	0.32	4.8	–	–	–
CNMM 160612E-NR2:T7325	1.2	165	0.45	6.0	125	0.41	6.0	–	–	–	–	–	–	50	0.36	4.8	–	–	–
CNMM 160612E-NR2:T7335	1.2	155	0.45	6.0	120	0.41	6.0	–	–	–	–	–	–	50	0.36	4.8	–	–	–
CNMM 160612E-NR2:T8430	1.2	150	0.45	6.0	80	0.41	6.0	125	0.45	6.0	–	–	–	30	0.36	4.8	–	–	–
CNMM 160612E-NR2:T9325	1.2	185	0.45	6.0	110	0.41	6.0	175	0.45	6.0	–	–	–	40	0.36	4.8	–	–	–
CNMM 160616E-NR2:T7325	1.6	165	0.50	6.0	125	0.45	6.0	–	–	–	–	–	–	50	0.40	4.8	–	–	–
CNMM 160616E-NR2:T7335	1.6	160	0.50	6.0	120	0.45	6.0	–	–	–	–	–	–	50	0.40	4.8	–	–	–
CNMM 160616E-NR2:T9325	1.6	180	0.50	6.0	105	0.45	6.0	170	0.50	6.0	–	–	–	40	0.40	4.8	–	–	–
CNMM 190612E-NR2:T7325	1.2	155	0.45	9.0	120	0.41	9.0	–	–	–	–	–	–	50	0.36	7.2	–	–	–
CNMM 190612E-NR2:T7335	1.2	145	0.45	9.0	110	0.41	9.0	–	–	–	–	–	–	45	0.36	7.2	–	–	–
CNMM 190612E-NR2:T8430	1.2	140	0.45	9.0	75	0.41	9.0	115	0.45	9.0	–	–	–	30	0.36	7.2	–	–	–
CNMM 190612E-NR2:T9325	1.2	175	0.45	9.0	105	0.41	9.0	165	0.45	9.0	–	–	–	35	0.36	7.2	–	–	–
CNMM 190616E-NR2:T7325	1.6	160	0.50	9.0	120	0.45	9.0	–	–	–	–	–	–	50	0.40	7.2	–	–	–
CNMM 190616E-NR2:T7335	1.6	150	0.50	9.0	115	0.45	9.0	–	–	–	–	–	–	45	0.40	7.2	–	–	–
CNMM 190616E-NR2:T8430	1.6	140	0.50	9.0	75	0.45	9.0	115	0.50	9.0	–	–	–	30	0.40	7.2	–	–	–
CNMM 190616E-NR2:T9325	1.6	175	0.50	9.0	105	0.45	9.0	165	0.50	9.0	–	–	–	35	0.40	7.2	–	–	–
CNMM 190616E-NR2:T9415	1.6	240	0.50	9.0	–	–	–	225	0.50	9.0	–	–	–	–	–	–	–	–	–
CNMM 190624E-NR2:T7335	2.4	130	0.80	9.0	100	0.72	9.0	–	–	–	–	–	–	40	0.56	7.2	–	–	–
CNMM 190624E-NR2:T9325	2.4	150	0.80	9.0	90	0.72	9.0	140	0.80	9.0	–	–	–	30	0.56	7.2	–	–	–
CNMM 250924E-NR2:T7335	2.4	95	0.80	12.0	70	0.72	12.0	–	–	–	–	–	–	30	0.56	9.6	–	–	–
CNMM 250924E-NR2:T8430	2.4	80	0.80	12.0	45	0.72	12.0	65	0.80	12.0	–	–	–	15	0.56	9.6	–	–	–
CNMM 250924E-NR2:T9325	2.4	100	0.80	12.0	60	0.72	12.0	95	0.80	12.0	–	–	–	20	0.56	9.6	–	–	–
CNMM 250924E-NR2:T9415	2.4	120	0.80	12.0	–	–	–	110	0.80	12.0	–	–	–	–	–	–	–	–	–
 		**NR2** talaş kırıcı sağlamdır ve Paslanmaz çeliklerin ağır kaba işlenmesi için ilk tercihtir. Pozitif eğim açısı ve negatif/negatif, ekstra geniş çift T-land özelliğine sahiptir. Çelikler için ve şartlı olarak Dökme demirler ve Süper alaşımlar için de uygundur.																	
DNMM 150608E-NR2:T9325	0.8	155	0.40	3.0	90	0.36	3.0	145	0.40	3.0	–	–	–	30	0.32	2.4	–	–	–

Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
NR2 talaş kırıcı sağlamdır ve Paslanmaz çeliklerin ağır kaba işlenmesi için ilk tercihtir. Pozitif eğim açısı ve negatif/negatif, ekstra geniş çift T-land özelliğine sahiptir. Çelikler için ve şartlı olarak Dökme demirler ve Süper alaşımlar için de uygundur.																			
SNMM 120408E-NR2:T7325	0.8	175	0.40	4.7	135	0.36	4.7	–	–	–	–	–	–	55	0.32	3.8	–	–	–
SNMM 120408E-NR2:T7335	0.8	170	0.40	4.7	130	0.36	4.7	–	–	–	–	–	–	55	0.32	3.8	–	–	–
SNMM 120408E-NR2:T8430	0.8	165	0.40	4.7	90	0.36	4.7	135	0.40	4.7	–	–	–	35	0.32	3.8	–	–	–
SNMM 120408E-NR2:T9325	0.8	195	0.40	4.7	115	0.36	4.7	185	0.40	4.7	–	–	–	40	0.32	3.8	–	–	–
SNMM 120412E-NR2:T7335	1.2	165	0.45	4.7	125	0.41	4.7	–	–	–	–	–	–	50	0.36	3.8	–	–	–
SNMM 120412E-NR2:T8430	1.2	165	0.45	4.7	90	0.41	4.7	135	0.45	4.7	–	–	–	35	0.36	3.8	–	–	–
SNMM 120412E-NR2:T9325	1.2	200	0.45	4.7	120	0.41	4.7	190	0.45	4.7	–	–	–	45	0.36	3.8	–	–	–
SNMM 150612E-NR2:T7335	1.2	165	0.45	6.0	125	0.41	6.0	–	–	–	–	–	–	50	0.36	4.8	–	–	–
SNMM 150612E-NR2:T8430	1.2	165	0.45	6.0	90	0.41	6.0	135	0.45	6.0	–	–	–	35	0.36	4.8	–	–	–
SNMM 150612E-NR2:T9325	1.2	195	0.45	6.0	115	0.41	6.0	185	0.45	6.0	–	–	–	40	0.36	4.8	–	–	–
SNMM 150616E-NR2:T7335	1.6	165	0.50	6.0	125	0.45	6.0	–	–	–	–	–	–	50	0.40	4.8	–	–	–
SNMM 150616E-NR2:T9325	1.6	190	0.50	6.0	110	0.45	6.0	180	0.50	6.0	–	–	–	40	0.40	4.8	–	–	–
SNMM 190612E-NR2:T7335	1.2	160	0.45	8.0	120	0.41	8.0	–	–	–	–	–	–	50	0.36	6.4	–	–	–
SNMM 190612E-NR2:T9325	1.2	190	0.45	8.0	110	0.41	8.0	180	0.45	8.0	–	–	–	40	0.36	6.4	–	–	–
SNMM 190616E-NR2:T7325	1.6	175	0.50	8.0	135	0.45	8.0	–	–	–	–	–	–	55	0.40	6.4	–	–	–
SNMM 190616E-NR2:T7335	1.6	160	0.50	8.0	120	0.45	8.0	–	–	–	–	–	–	50	0.40	6.4	–	–	–
SNMM 190616E-NR2:T8430	1.6	155	0.50	8.0	85	0.45	8.0	130	0.50	8.0	–	–	–	30	0.40	6.4	–	–	–
SNMM 190616E-NR2:T9325	1.6	185	0.50	8.0	110	0.45	8.0	175	0.50	8.0	–	–	–	40	0.40	6.4	–	–	–
SNMM 190616E-NR2:T9415	1.6	260	0.50	8.0	–	–	–	245	0.50	8.0	–	–	–	–	–	–	–	–	–
SNMM 190624E-NR2:T7325	2.4	155	0.80	8.0	120	0.72	8.0	–	–	–	–	–	–	50	0.56	6.4	–	–	–
SNMM 190624E-NR2:T7335	2.4	145	0.80	8.0	110	0.72	8.0	–	–	–	–	–	–	45	0.56	6.4	–	–	–
SNMM 190624E-NR2:T9325	2.4	165	0.80	8.0	95	0.72	8.0	155	0.80	8.0	–	–	–	35	0.56	6.4	–	–	–
SNMM 250724E-NR2:T7335	2.4	100	0.80	12.0	75	0.72	12.0	–	–	–	–	–	–	30	0.56	9.6	–	–	–
SNMM 250724E-NR2:T8430	2.4	85	0.80	12.0	45	0.72	12.0	70	0.80	12.0	–	–	–	15	0.56	9.6	–	–	–
SNMM 250724E-NR2:T9226	2.4	95	0.80	12.0	55	0.72	12.0	90	0.80	12.0	–	–	–	20	0.56	9.6	–	–	–
SNMM 250724E-NR2:T9325	2.4	105	0.80	12.0	60	0.72	12.0	95	0.80	12.0	–	–	–	20	0.56	9.6	–	–	–
SNMM 250724E-NR2:T9415	2.4	125	0.80	12.0	–	–	–	115	0.80	12.0	–	–	–	–	–	–	–	–	–
SNMM 250924E-NR2:T7325	2.4	105	0.80	12.0	80	0.72	12.0	–	–	–	–	–	–	30	0.56	9.6	–	–	–
SNMM 250924E-NR2:T7335	2.4	100	0.80	12.0	75	0.72	12.0	–	–	–	–	–	–	30	0.56	9.6	–	–	–
SNMM 250924E-NR2:T9325	2.4	105	0.80	12.0	60	0.72	12.0	95	0.80	12.0	–	–	–	20	0.56	9.6	–	–	–
SNMM 250924E-NR2:T9415	2.4	125	0.80	12.0	–	–	–	115	0.80	12.0	–	–	–	–	–	–	–	–	–
 																			
NR2 talaş kırıcı sağlamdır ve Paslanmaz çeliklerin ağır kaba işlenmesi için ilk tercihtir. Pozitif eğim açısı ve negatif/negatif, ekstra geniş çift T-land özelliğine sahiptir. Çelikler için ve şartlı olarak Dökme demirler ve Süper alaşımlar için de uygundur.																			
TNMM 160408E-NR2:T9325	0.8	165	0.40	3.0	95	0.36	3.0	155	0.40	3.0	–	–	–	35	0.28	2.4	–	–	–
TNMM 220408E-NR2:T9325	0.8	160	0.40	4.0	95	0.36	4.0	150	0.40	4.0	–	–	–	35	0.28	3.2	–	–	–
TNMM 220412E-NR2:T8430	1.2	140	0.40	4.0	75	0.36	4.0	115	0.40	4.0	–	–	–	30	0.32	3.2	–	–	–
TNMM 220412E-NR2:T9325	1.2	170	0.40	4.0	100	0.36	4.0	160	0.40	4.0	–	–	–	35	0.32	3.2	–	–	–
 																			
NR2 talaş kırıcı sağlamdır ve Paslanmaz çeliklerin ağır kaba işlenmesi için ilk tercihtir. Pozitif eğim açısı ve negatif/negatif, ekstra geniş çift T-land özelliğine sahiptir. Çelikler için ve şartlı olarak Dökme demirler ve Süper alaşımlar için de uygundur.																			
WNMM 080408E-NR2:T7335	0.8	160	0.40	4.0	120	0.36	4.0	–	–	–	–	–	–	50	0.28	3.2	–	–	–
WNMM 080408E-NR2:T9325	0.8	190	0.40	4.0	110	0.36	4.0	180	0.40	4.0	–	–	–	40	0.28	3.2	–	–	–
WNMM 080412E-NR2:T9325	1.2	190	0.45	4.0	110	0.41	4.0	180	0.45	4.0	–	–	–	40	0.32	3.2	–	–	–

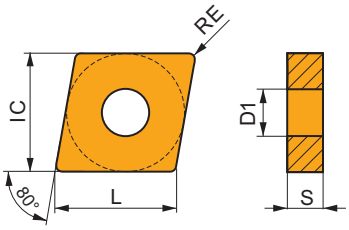
HR



HR talaş kırıcı sağlamdır ve Çeliklerin ve Dökme demirlerin ağır kaba işlenmesi için tasarlanmıştır. Hafif pozitif eğim açısı ve negatif/negatif, ekstra geniş çift T-land özelliğine sahiptir. Paslanmaz çelikler için de şartlı olarak uygundur.

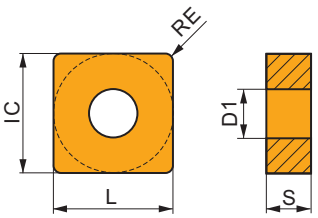
CNMM

	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1906	19.050	7.94	19.30	6.35
2509	25.400	9.12	25.80	9.53



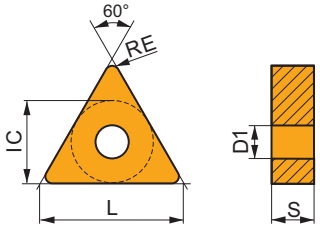
SNMM

	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1906	19.050	7.94	19.05	6.35
2507	25.400	9.12	25.40	7.94
2509	25.400	9.12	25.40	9.53

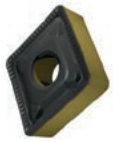
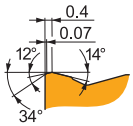
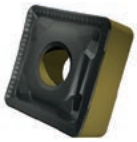
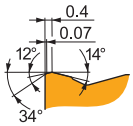
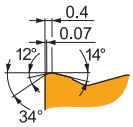


TNMM

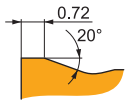
	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
2706	15.875	6.35	27.50	6.35



Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE	P			M			K			N			S			H		
	(mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)
		**HR** talaş kırıcı sağlamdır ve Çeliklerin ve Dökme demirlerin ağır kaba işlenmesi için tasarlanmıştır. Hafif pozitif eğim açısı ve negatif/negatif, ekstra geniş çift T-land özelliğine sahiptir. Paslanmaz çelikler için de şartlı olarak uygundur.																	
CNMM 190616E-HR:6630	1.6	85	0.60	10.0	50	0.54	10.0	80	0.60	10.0	–	–	–	–	–	–	–	–	–
CNMM 190616E-HR:6640	1.6	75	0.60	10.0	45	0.54	10.0	70	0.60	10.0	–	–	–	–	–	–	–	–	–
CNMM 190616E-HR:T8345	1.6	55	0.60	10.0	30	0.54	10.0	50	0.60	10.0	–	–	–	–	–	–	–	–	–
CNMM 190616E-HR:T9325	1.6	105	0.60	10.0	60	0.54	10.0	95	0.60	10.0	–	–	–	–	–	–	–	–	–
CNMM 190616E-HR:T9335	1.6	80	0.60	10.0	45	0.54	10.0	–	–	–	–	–	–	–	–	–	–	–	–
CNMM 190624E-HR:6630	2.4	90	0.65	10.0	50	0.59	10.0	85	0.65	10.0	–	–	–	–	–	–	–	–	–
CNMM 190624E-HR:T8345	2.4	60	0.65	10.0	35	0.59	10.0	55	0.65	10.0	–	–	–	–	–	–	–	–	–
CNMM 190624E-HR:T9325	2.4	100	0.65	10.0	60	0.59	10.0	95	0.65	10.0	–	–	–	–	–	–	–	–	–
CNMM 190624E-HR:T9335	2.4	85	0.65	10.0	50	0.59	10.0	–	–	–	–	–	–	–	–	–	–	–	–
CNMM 190624E-HR:T9415	2.4	120	0.65	10.0	–	–	–	110	0.65	10.0	–	–	–	–	–	–	–	–	–
CNMM 250924E-HR:6630	2.4	85	0.65	14.0	50	0.59	14.0	80	0.65	14.0	–	–	–	–	–	–	–	–	–
CNMM 250924E-HR:6640	2.4	75	0.65	14.0	45	0.59	14.0	70	0.65	14.0	–	–	–	–	–	–	–	–	–
CNMM 250924E-HR:T8345	2.4	55	0.65	14.0	30	0.59	14.0	50	0.65	14.0	–	–	–	–	–	–	–	–	–
CNMM 250924E-HR:T9315	2.4	110	0.65	14.0	–	–	–	100	0.65	14.0	–	–	–	–	–	–	–	–	–
CNMM 250924E-HR:T9325	2.4	100	0.65	14.0	60	0.59	14.0	95	0.65	14.0	–	–	–	–	–	–	–	–	–
CNMM 250924E-HR:T9335	2.4	80	0.65	14.0	45	0.59	14.0	–	–	–	–	–	–	–	–	–	–	–	–
CNMM 250924E-HR:T9415	2.4	120	0.65	14.0	–	–	–	110	0.65	14.0	–	–	–	–	–	–	–	–	–
		**HR** talaş kırıcı sağlamdır ve Çeliklerin ve Dökme demirlerin ağır kaba işlenmesi için tasarlanmıştır. Hafif pozitif eğim açısı ve negatif/negatif, ekstra geniş çift T-land özelliğine sahiptir. Paslanmaz çelikler için de şartlı olarak uygundur.																	
SNMM 190616E-HR:6630	1.6	90	0.60	9.0	50	0.54	9.0	85	0.60	9.0	–	–	–	–	–	–	–	–	–
SNMM 190616E-HR:T8345	1.6	60	0.60	9.0	35	0.54	9.0	55	0.60	9.0	–	–	–	–	–	–	–	–	–
SNMM 190616E-HR:T9325	1.6	110	0.60	9.0	65	0.54	9.0	100	0.60	9.0	–	–	–	–	–	–	–	–	–
SNMM 190616E-HR:T9335	1.6	85	0.60	9.0	50	0.54	9.0	–	–	–	–	–	–	–	–	–	–	–	–
SNMM 190624E-HR:T9315	2.4	120	0.65	9.0	–	–	–	110	0.65	9.0	–	–	–	–	–	–	–	–	–
SNMM 190624E-HR:T9325	2.4	115	0.65	9.0	65	0.59	9.0	105	0.65	9.0	–	–	–	–	–	–	–	–	–
SNMM 190624E-HR:T9335	2.4	90	0.65	9.0	50	0.59	9.0	–	–	–	–	–	–	–	–	–	–	–	–
SNMM 190624E-HR:T9415	2.4	130	0.65	9.0	–	–	–	120	0.65	9.0	–	–	–	–	–	–	–	–	–
SNMM 250716E-HR:T8345	1.6	60	0.60	13.0	35	0.54	13.0	55	0.60	13.0	–	–	–	–	–	–	–	–	–
SNMM 250716E-HR:T9325	1.6	100	0.60	13.0	60	0.54	13.0	95	0.60	13.0	–	–	–	–	–	–	–	–	–
SNMM 250716E-HR:T9335	1.6	85	0.60	13.0	50	0.54	13.0	–	–	–	–	–	–	–	–	–	–	–	–
SNMM 250724E-HR:6630	2.4	90	0.65	13.0	50	0.59	13.0	85	0.65	13.0	–	–	–	–	–	–	–	–	–
SNMM 250724E-HR:6640	2.4	80	0.65	13.0	45	0.59	13.0	75	0.65	13.0	–	–	–	–	–	–	–	–	–
SNMM 250724E-HR:T8345	2.4	55	0.65	13.0	30	0.59	13.0	50	0.65	13.0	–	–	–	–	–	–	–	–	–
SNMM 250724E-HR:T9325	2.4	105	0.65	13.0	60	0.59	13.0	95	0.65	13.0	–	–	–	–	–	–	–	–	–
SNMM 250724E-HR:T9335	2.4	85	0.65	13.0	50	0.59	13.0	–	–	–	–	–	–	–	–	–	–	–	–
SNMM 250724E-HR:T9415	2.4	125	0.65	13.0	–	–	–	115	0.65	13.0	–	–	–	–	–	–	–	–	–
SNMM 250732E-HR:T9325	3.2	95	0.80	13.0	55	0.72	13.0	90	0.80	13.0	–	–	–	–	–	–	–	–	–
SNMM 250924E-HR:6630	2.4	90	0.65	13.0	50	0.59	13.0	85	0.65	13.0	–	–	–	–	–	–	–	–	–
SNMM 250924E-HR:T8345	2.4	55	0.65	13.0	30	0.59	13.0	50	0.65	13.0	–	–	–	–	–	–	–	–	–
SNMM 250924E-HR:T9325	2.4	105	0.65	13.0	60	0.59	13.0	95	0.65	13.0	–	–	–	–	–	–	–	–	–
SNMM 250924E-HR:T9335	2.4	85	0.65	13.0	50	0.59	13.0	–	–	–	–	–	–	–	–	–	–	–	–
SNMM 250924E-HR:T9415	2.4	125	0.65	13.0	–	–	–	115	0.65	13.0	–	–	–	–	–	–	–	–	–
SNMM 250932E-HR:T9325	3.2	95	0.80	13.0	55	0.72	13.0	90	0.80	13.0	–	–	–	–	–	–	–	–	–
		**HR** talaş kırıcı sağlamdır ve Çeliklerin ve Dökme demirlerin ağır kaba işlenmesi için tasarlanmıştır. Hafif pozitif eğim açısı ve negatif/negatif, ekstra geniş çift T-land özelliğine sahiptir. Paslanmaz çelikler için de şartlı olarak uygundur.																	
TNMM 270616E-HR:T9325	1.6	90	0.60	7.0	50	0.54	7.0	85	0.60	7.0	–	–	–	–	–	–	–	–	–
TNMM 270616E-HR:T9335	1.6	75	0.60	7.0	45	0.54	7.0	–	–	–	–	–	–	–	–	–	–	–	–
TNMM 270624E-HR:T9226	2.4	80	0.65	7.0	45	0.59	7.0	75	0.65	7.0	–	–	–	–	–	–	–	–	–

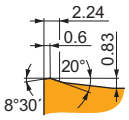
HR2



HR2 talaş kırıcı sağlamdır ve Çeliklerin ve Dökme demirlerin ağır kaba işlenmesi için tasarlanmıştır. Pozitif eğim açısı ve dengeli, ekstra geniş çift T-land özelliğine sahiptir. Paslanmaz çelikler için de şartlı olarak uygundur.

PRAMET

923

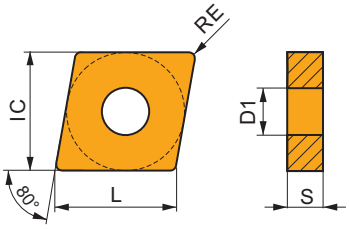


923 talaş kırıcı sağlamdır ve Paslanmaz çeliklerin ağır kaba işlenmesi için tasarlanmıştır. Pozitif eğim açısı ve negatif/kararlı, ekstra geniş çift T-land özelliğine sahiptir. Çelikler ve Dökme demirler için de şartlı olarak uygundur.

PRAMET

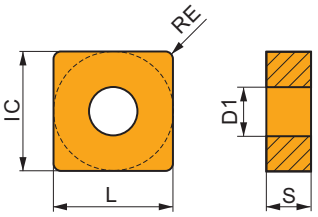
CNMM

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1906	19.050	7.94	19.30	6.35
2509	25.400	9.12	25.80	9.53

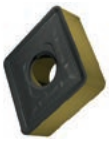
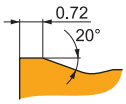
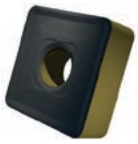
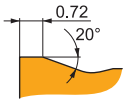
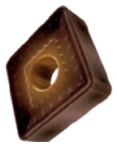
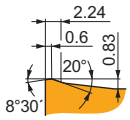
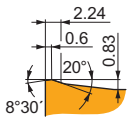


SNMM

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1906	19.050	7.94	19.05	6.35
2507	25.400	9.12	25.40	7.94
2509	25.400	9.12	25.40	9.53



Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

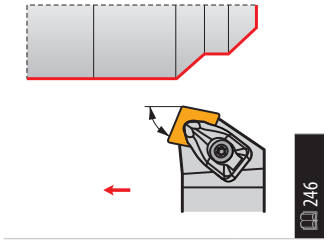
Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
			**HR2** talaş kırıcı sağlamdır ve Çeliklerin ve Dökme demirlerin ağır kaba işlenmesi için tasarlanmıştır. Pozitif eğim açısı ve dengeli, ekstra geniş çift T-land özelliğine sahiptir. Paslanmaz çelikler için de şartlı olarak uygundur.																	
CNMM 190616-HR2:T9226		1.6	85	0.65	10.0	50	0.59	10.0	80	0.65	10.0	–	–	–	–	–	–	–	–	–
CNMM 190616-HR2:T9335		1.6	80	0.65	10.0	45	0.59	10.0	–	–	–	–	–	–	–	–	–	–	–	–
CNMM 190616-HR2:T9415		1.6	115	0.65	10.0	–	–	–	105	0.65	10.0	–	–	–	–	–	–	–	–	–
CNMM 190624-HR2:T9226		2.4	80	0.85	10.0	45	0.77	10.0	75	0.85	10.0	–	–	–	–	–	–	–	–	–
CNMM 190624-HR2:T9415		2.4	110	0.85	10.0	–	–	–	100	0.85	10.0	–	–	–	–	–	–	–	–	–
CNMM 250924-HR2:T9315		2.4	100	0.85	12.0	–	–	–	95	0.85	12.0	–	–	–	–	–	–	–	–	–
CNMM 250924-HR2:T9335		2.4	75	0.85	12.0	45	0.77	12.0	–	–	–	–	–	–	–	–	–	–	–	–
CNMM 250924-HR2:T9415		2.4	110	0.85	12.0	–	–	–	100	0.85	12.0	–	–	–	–	–	–	–	–	–
			**HR2** talaş kırıcı sağlamdır ve Çeliklerin ve Dökme demirlerin ağır kaba işlenmesi için tasarlanmıştır. Pozitif eğim açısı ve dengeli, ekstra geniş çift T-land özelliğine sahiptir. Paslanmaz çelikler için de şartlı olarak uygundur.																	
SNMM 190616-HR2:T9335		1.6	85	0.65	8.9	50	0.59	8.9	–	–	–	–	–	–	–	–	–	–	–	–
SNMM 190616-HR2:T9415		1.6	125	0.65	8.9	–	–	–	115	0.65	8.9	–	–	–	–	–	–	–	–	–
SNMM 190624-HR2:T9335		2.4	80	0.85	8.9	45	0.77	8.9	–	–	–	–	–	–	–	–	–	–	–	–
SNMM 190624-HR2:T9415		2.4	120	0.85	8.9	–	–	–	110	0.85	8.9	–	–	–	–	–	–	–	–	–
SNMM 250724-HR2:T9226		2.4	85	0.85	11.0	50	0.77	11.0	80	0.85	11.0	–	–	–	–	–	–	–	–	–
SNMM 250724-HR2:T9335		2.4	80	0.85	11.0	45	0.77	11.0	–	–	–	–	–	–	–	–	–	–	–	–
SNMM 250924-HR2:T9226		2.4	85	0.85	11.0	50	0.77	11.0	80	0.85	11.0	–	–	–	–	–	–	–	–	–
SNMM 250924-HR2:T9315		2.4	105	0.85	11.0	–	–	–	95	0.85	11.0	–	–	–	–	–	–	–	–	–
SNMM 250924-HR2:T9335		2.4	80	0.85	11.0	45	0.77	11.0	–	–	–	–	–	–	–	–	–	–	–	–
SNMM 250924-HR2:T9415		2.4	115	0.85	11.0	–	–	–	105	0.85	11.0	–	–	–	–	–	–	–	–	–
SNMM 250932-HR2:T9335		3.2	75	1.00	11.0	45	0.90	11.0	–	–	–	–	–	–	–	–	–	–	–	–
			**923** talaş kırıcı sağlamdır ve Paslanmaz çeliklerin ağır kaba işlenmesi için tasarlanmıştır. Pozitif eğim açısı ve negatif/kararlı, ekstra geniş çift T-land özelliğine sahiptir. Çelikler ve Dökme demirler için de şartlı olarak uygundur.																	
CNMM 250924S-923:T8430		2.4	75	0.85	12.0	40	0.77	12.0	60	0.85	12.0	–	–	–	15	0.60	9.6	–	–	–
CNMM 250924S-923:T9335		2.4	75	0.85	12.0	45	0.77	12.0	–	–	–	–	–	–	15	0.60	9.6	–	–	–
			**923** talaş kırıcı sağlamdır ve Paslanmaz çeliklerin ağır kaba işlenmesi için tasarlanmıştır. Pozitif eğim açısı ve negatif/kararlı, ekstra geniş çift T-land özelliğine sahiptir. Çelikler ve Dökme demirler için de şartlı olarak uygundur.																	
SNMM 190616S-923:T8345		1.6	100	0.65	8.9	60	0.59	8.9	95	0.65	8.9	–	–	–	25	0.52	7.1	–	–	–
SNMM 190616S-923:T8430		1.6	125	0.65	8.9	65	0.59	8.9	100	0.65	8.9	–	–	–	25	0.52	7.1	–	–	–
SNMM 190616S-923:T9335		1.6	130	0.65	8.9	75	0.59	8.9	–	–	–	–	–	–	25	0.52	7.1	–	–	–
SNMM 250724S-923:T8430		2.4	80	0.85	11.0	45	0.77	11.0	65	0.85	11.0	–	–	–	15	0.60	8.8	–	–	–
SNMM 250724S-923:T9335		2.4	80	0.85	11.0	45	0.77	11.0	–	–	–	–	–	–	15	0.60	8.8	–	–	–
SNMM 250924S-923:T8345		2.4	55	0.85	11.0	30	0.77	11.0	50	0.85	11.0	–	–	–	10	0.60	8.8	–	–	–
SNMM 250924S-923:T8430		2.4	80	0.85	11.0	45	0.77	11.0	65	0.85	11.0	–	–	–	15	0.60	8.8	–	–	–
SNMM 250924S-923:T9226		2.4	85	0.85	11.0	50	0.77	11.0	80	0.85	11.0	–	–	–	15	0.60	8.8	–	–	–
SNMM 250924S-923:T9335		2.4	80	0.85	11.0	45	0.77	11.0	–	–	–	–	–	–	15	0.60	8.8	–	–	–
SNMM 250924S-923:T9415		2.4	115	0.85	11.0	–	–	–	105	0.85	11.0	–	–	–	–	–	–	–	–	–

CN

ISO TORNALAMA - DIŞ - REHBER

DCBN(RL) EXT 75°

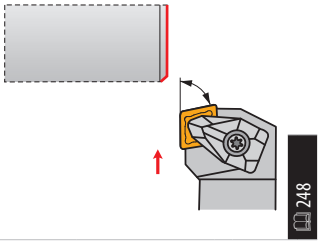
CN..



246

DCKN(RL) EXT 75°

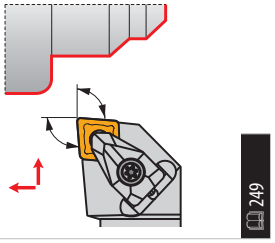
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248

DCLN(RL) EXT 95°

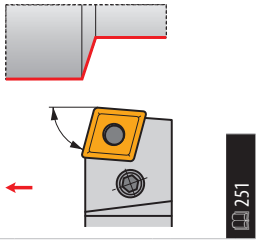
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249

PCBN(RL) EXT 75°

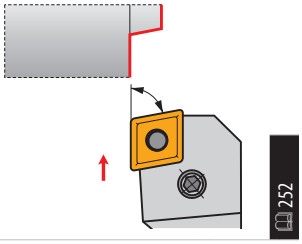
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251

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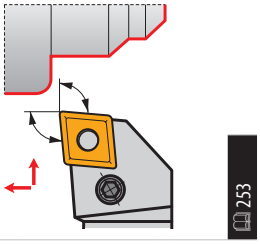
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252

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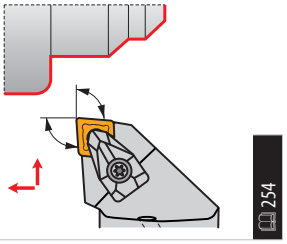
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253

C.-DCLN(RL) EXT 95°

CN..



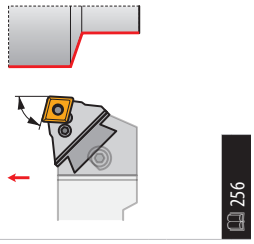
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CN

ISO TORNALAMA - AĞIR KABA - REHBER

KHP-CBNR 75°

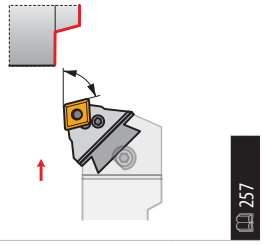
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256

KHP-CBNL 75°

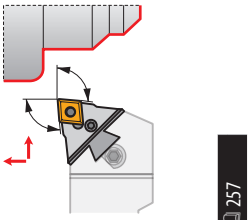
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257

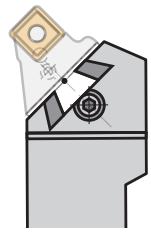
KHP-CLNR 95°

CN..



257

DKH(RL)



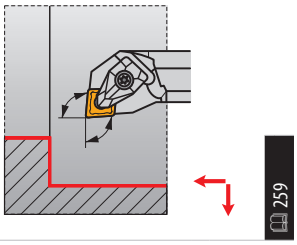
258

CN

ISO TORNALAMA - İÇ - REHBER

DCLN(RL) INT 95°

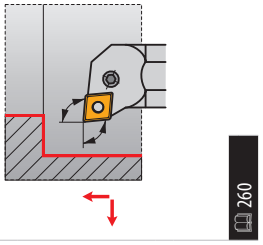
CN..



259

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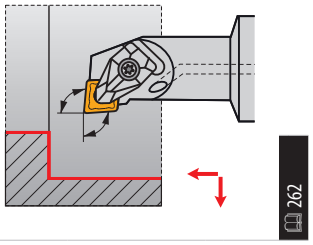
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260

C.-DCLN(RL) INT 95°

CN..



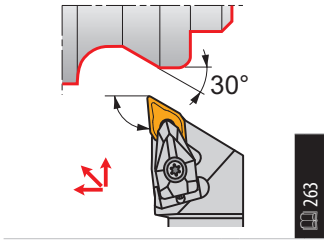
262

DN

ISO TORNALAMA - DIŞ - REHBER

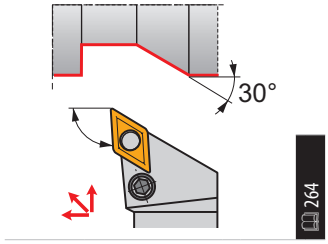
DDJN(RL) EXT 93°

DN..



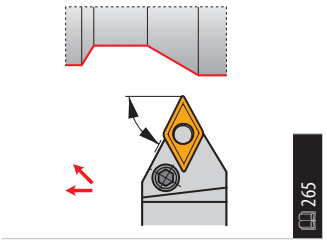
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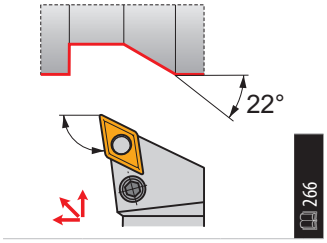
PDNN(RL) EXT 62°30´

DN..



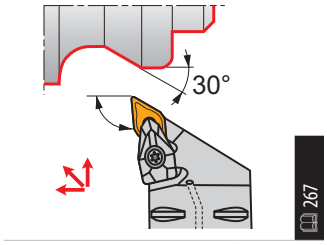
PDXN(RL) EXT 98°

DN..



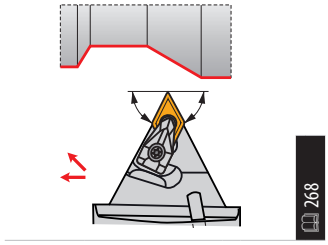
C.-DDJN(RL) EXT 93°

DN..



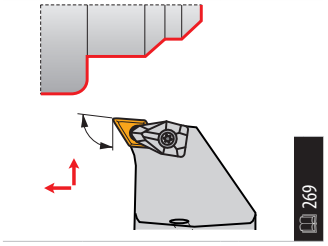
C.-DDNNN EXT 62.5°

DN..



C.-DDUN(RL) EXT 93°

DN..

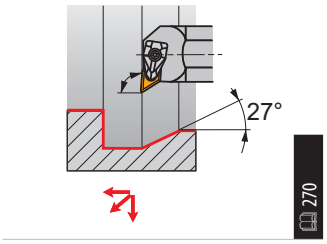


DN

ISO TORNALAMA - İÇ - REHBER

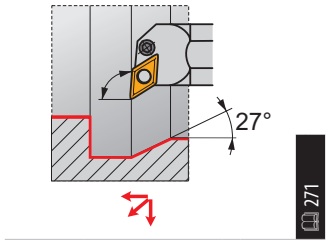
DDUN(RL) INT 93°

DN..



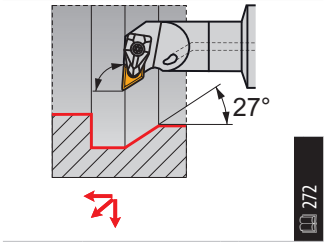
PDUN(RL) INT 93°

DN..



C.-DDUN(RL) INT 93°

DN..

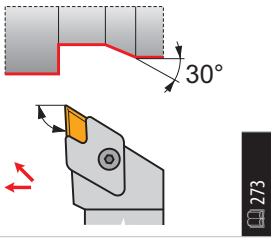


KN

ISO TORNALAMA - DIŞ - REHBER

CKJN(RL) EXT 93°

KN..



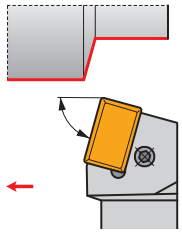
273

LN

ISO TORNALAMA - DIŞ - REHBER

PLBN(RL) EXT 75°

LN..



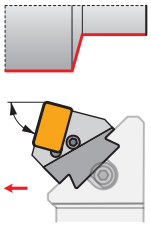
274

LN

ISO TORNALAMA - AĞIR KABA - REHBER

KHP-LBNR 75°

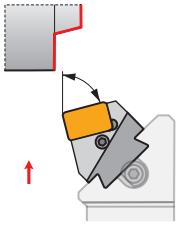
LN..



275

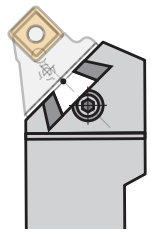
KHP-LBNL 75°

LN..



275

DKH(RL)



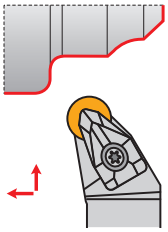
276

RN

ISO TORNALAMA - DIŞ - REHBER

DRSN(RL) EXT

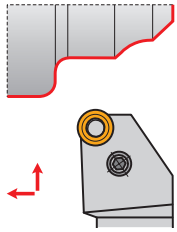
RN..



277

PRSN(RL) EXT

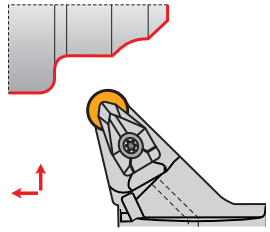
RN..



278

C.-DRSN(RL) EXT

RN..

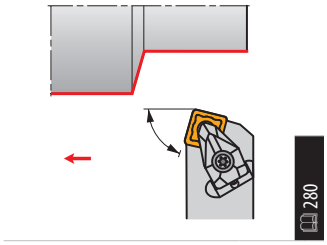


279

SN

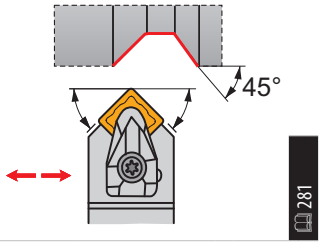
ISO TORNALAMA - DIŞ - REHBER

DSBN(RL) EXT 45°
SN..



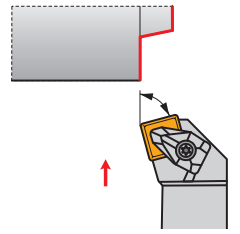
280

DSDNN EXT 45°
SN..



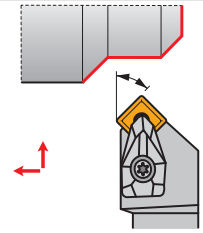
281

DSKN(RL) EXT 75°
SN..



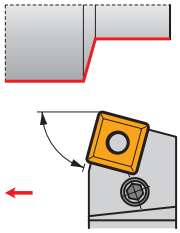
282

DSSN(RL) EXT 45°
SN..



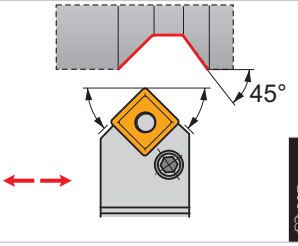
283

PSBN(RL) EXT 75°
SN..



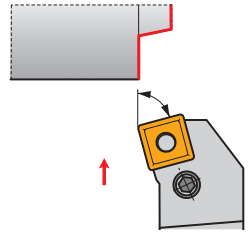
285

PSDNN EXT 45°
SN..



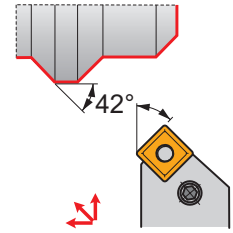
287

PSKN(RL) EXT 75°
SN..



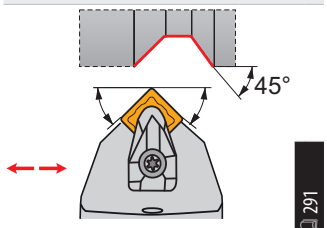
288

PSSN(RL) EXT 45°
SN..



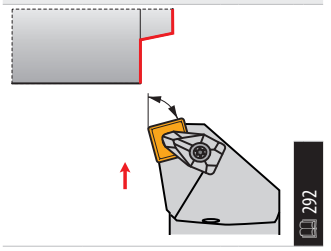
290

C.-DSDNN EXT 45°
SN..



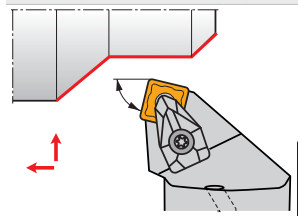
291

C.-DSKN(RL) EXT 75°
SN..



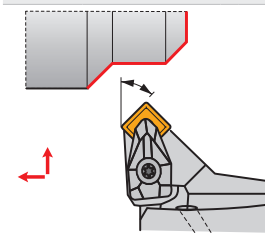
292

C.-DSRN(RL) EXT 75°
SN..



293

C.-DSSN(RL) EXT 45°
SN..

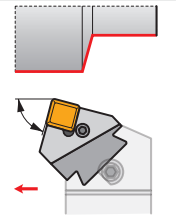


294

SN

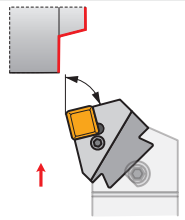
ISO TORNALAMA - DIŞ - REHBER

KHP-SBNR 75°
SN..



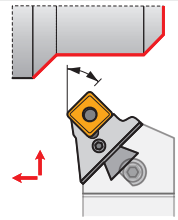
295

KHP-SBNL 75°
SN..



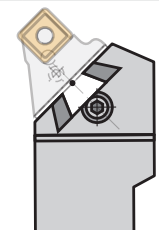
295

KHP-SSNR/L 45°
SN..



296

DKH(RL)

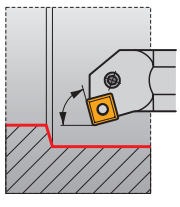


297

SN

ISO TORNALAMA - İÇ - REHBER

PSKN(RL) INT 75°
SN..



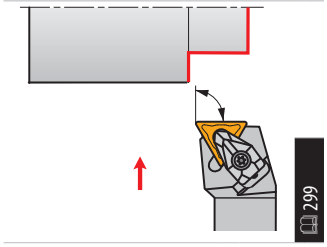
298

TN

ISO TORNALAMA - DIŞ - REHBER

DTFN(RL) EXT 90°

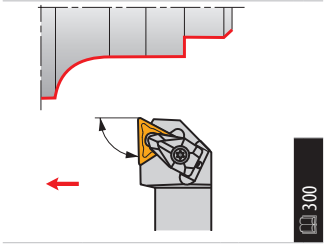
TN..



299

DTGN(RL) EXT 90°

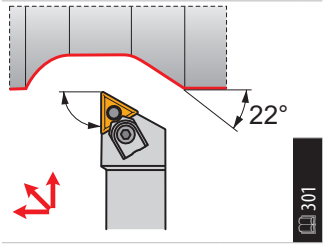
TN..



300

MTJN(RL) EXT 93°

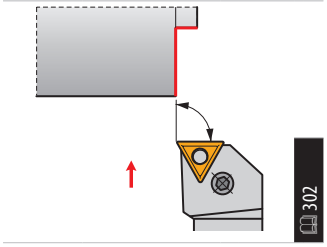
TN..



301

PTFN(RL) EXT 90°

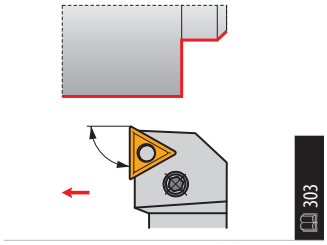
TN..



302

PTGN(RL) EXT 90°

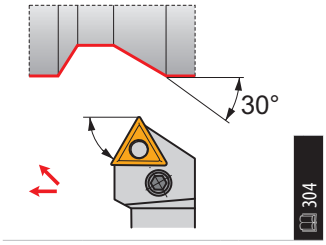
TN..



303

PTTN(RL) EXT 60°

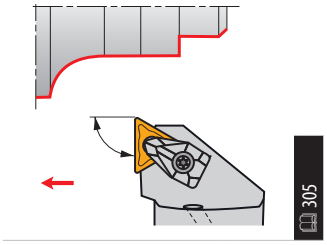
TN..



304

C.-DTJN(RL) EXT 93°

TN..



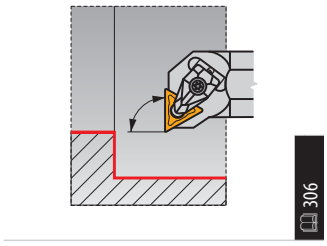
305

TN

ISO TORNALAMA - İÇ - REHBER

DTFN(RL) INT 90°

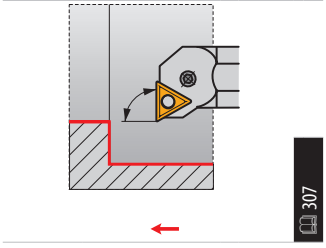
TN..



306

PTFN(RL) INT 90°

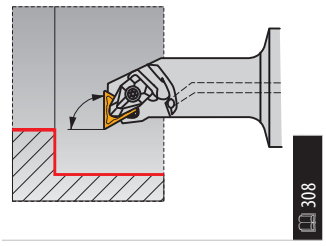
TN..



307

C.-DTFN(RL) INT 91°

TN..



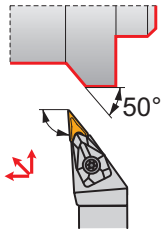
308

VN

ISO TORNALAMA - DIŞ - REHBER

DVJN(RL) EXT 93°

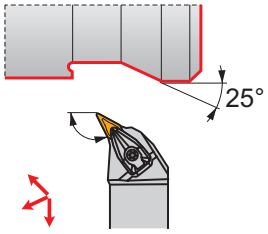
VN..



309

DVPN(RL) EXT 62°30´

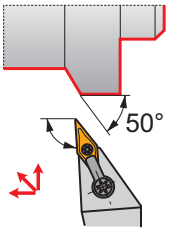
VN..



310

MVJN(RL) EXT 93°

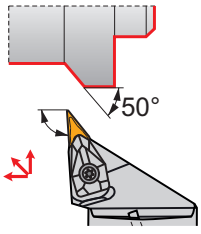
VN..



311

C.-DVJN(RL) EXT 93°

VN..



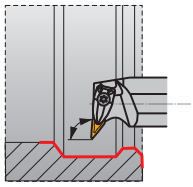
312

VN

ISO TORNALAMA - İÇ - REHBER

DVUN(RL) INT

VN..



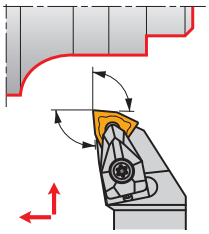
313

WN

ISO TORNALAMA - DIŞ - REHBER

DWLN(RL) EXT 95°

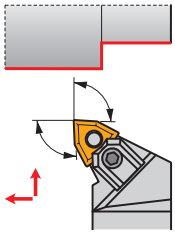
WN..



314

MWLN(RL) EXT 95°

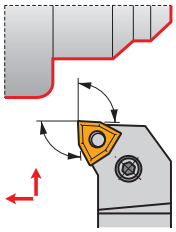
WN..



316

PWLN(RL) EXT 95°

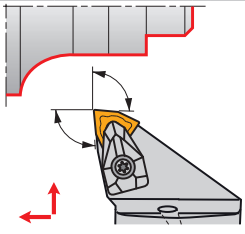
WN..



317

C.-DWLN(RL) EXT 95°

WN..



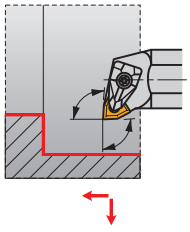
318

WN

ISO TORNALAMA - İÇ - REHBER

DWLN(RL) INT 95°

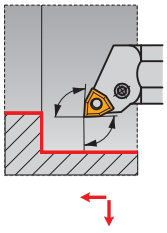
WN..



319

PWLN(RL) INT 95°

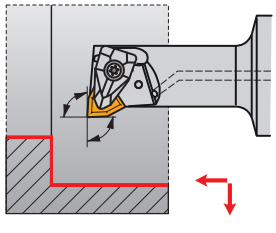
WN..



320

C.-DWLN(RL) INT 95°

WN..



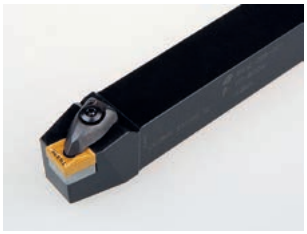
321

DCBN(RL) EXT

P M K N S H

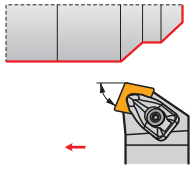
PRAMET

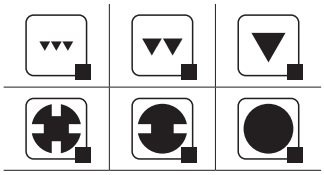
D

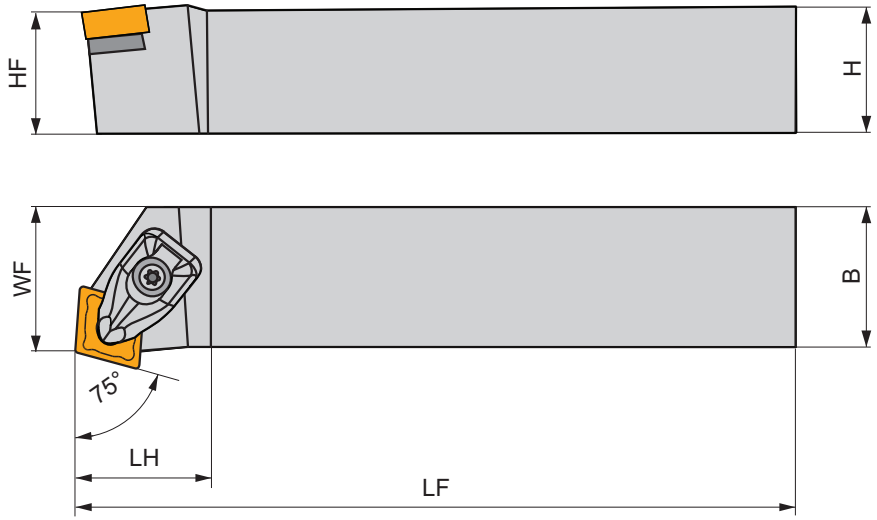


CN.. Uç için Çift Sıkmalı 75° Dış Kateri

Çift sıkmalı 75° Sağ/Sol dış kater. Negatif CN.. 12 - 19 uçlarla çap, alın ve pah tornalama için uygundur. 20x20 - 40x40mm şaft ölçüleri. Gövde uzun takım ömrü için işlem görmüştür.











	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg			
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)				
R	DCBNR 2020 K 12	20	20	20	17	125	34.2	-6	-6	0.43	GI043	DC12	AT001
	DCBNR 2525 M 12	25	25	25	22	150	34.6	-6	-6	0.76	GI043	DC12	AT001
	DCBNR 3225 P 12	32	25	32	22	170	34.6	-6	-6	1.09	GI043	DC12	AT001
	DCBNR 2525 M 16	25	25	25	22	150	41.5	-6	-6	0.80	GI050	DC16	AT005
	DCBNR 3225 P 16	32	25	32	22	170	32.0	-6	-6	1.11	GI050	DC16	AT005
	DCBNR 3232 P 19	32	32	32	27	170	46.1	-6	-6	1.39	GI042	DC19	–
L	DCBNL 2525 M 12	25	25	25	22	150	34.6	-6	-6	0.76	GI043	DC12	AT001
	DCBNL 3225 P 12	32	25	32	22	170	34.6	-6	-6	1.09	GI043	DC12	AT001
	DCBNL 2525 M 16	25	25	25	22	150	41.5	-6	-6	0.79	GI050	DC16	AT005
	DCBNL 3225 P 16	32	25	32	22	170	32.0	-6	-6	1.11	GI050	DC16	AT005
	DCBNL 3232 P 19	32	32	32	27	170	46.1	-6	-6	1.39	GI042	DC19	–

GI042	CN.. 1906..
GI043	CN.. 1204..
GI050	CN.. 1606..

		Nm				
DC12	DCS 12	3.9	DCS 234-01	US 2002-T15P	FLAG T15P/3,5	–
DC16	DCS 16	6.4	DCS 234-03	US 2007-T20P	–	LK T20P
DC19	DCS 19	6.4	DCS 236-01	US 2007-T20P	–	LK T20P

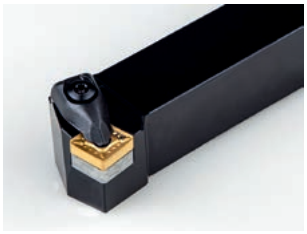
AT001a	CN.. 1207..	–	DCS 234-02
AT005a	CN.. 1607..	–	DCS 234-04
AT001b	CER CN.N 1204..	DCS 12C4	–
AT001c	CER CN.A 1204..	DCS 12C2	–
AT005b	CER CN.N 1606..	DCS 16C4	–
AT005c	CER CN.A 1606..	DCS 16C2	–

DCKN(RL) EXT

P M K N S H

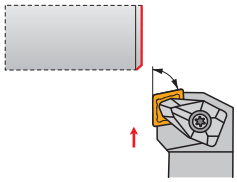
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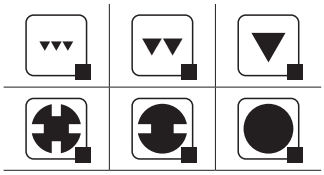
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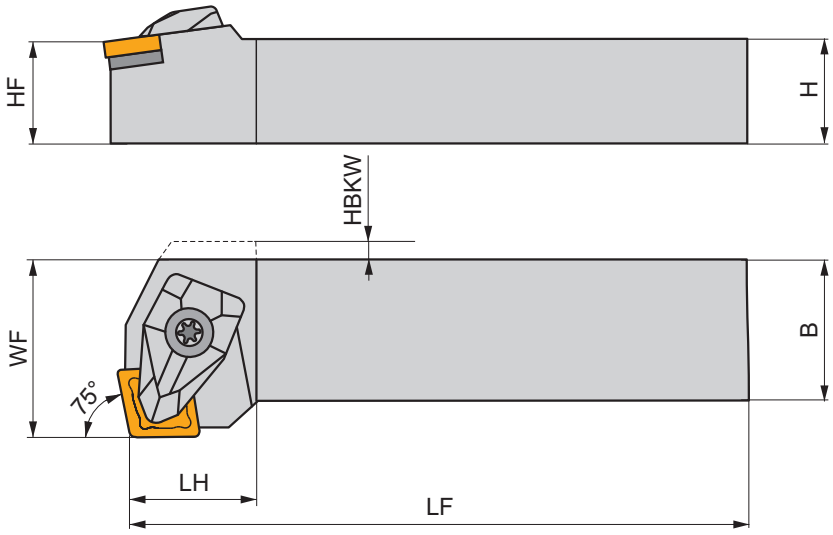


CN.. Uç için Çift Sıkmalı 75° (Alın) Dış Kateri

Çift sıkmalı 75° Sağ/Sol dış kater. Negatif CN.. 12 veya 16 uçlarla alın ve pah tornalama için uygundur. 20x20 - 32x32mm şaft ölçüleri. Gövde uzun takım ömrü için işlem görmüştür.











	Product	H	B	HF	WF	LF	LH	HBKW	LAMS	GAMO	kg			
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)				
R	DCKNR 2020 K 12	20	20	20	25	125	21.2	4.5	-6	-6	0.46	GI043	DC12	AT001
	DCKNR 2525 M 12	25	25	25	32	150	21.1	–	-6	-6	0.80	GI043	DC12	AT001
	DCKNR 3225 P 12	32	25	32	32	170	21.1	–	-6	-6	1.14	GI043	DC12	AT001
	DCKNR 3232 P 16	32	32	32	40	170	26.0	–	-6	-6	1.46	GI050	DC16	AT005
L	DCKNL 2525 M 12	25	25	25	32	150	21.1	–	-6	-6	0.80	GI043	DC12	AT001
	DCKNL 3225 P 12	32	25	32	32	170	21.1	–	-6	-6	1.13	GI043	DC12	AT001
	DCKNL 3232 P 16	32	32	32	40	170	26.0	–	-6	-6	1.45	GI050	DC16	AT005

GI043	CN.. 1204..
GI050	CN.. 1606..

		Nm				
DC12	DCS 12	3.9	DCS 234-01	US 2002-T15P	FLAG T15P/3,5	–
DC16	DCS 16	6.4	DCS 234-03	US 2007-T20P	–	LK T20P

AT001a	CN.. 1207..	–	DCS 234-02
AT005a	CN.. 1607..	–	DCS 234-04
AT001b	CER CN.N 1204..	DCS 12C4	–
AT001c	CER CN.A 1204..	DCS 12C2	–

AT005b	CER CN.N 1606..	DCS 16C4	–
AT005c	CER CN.A 1606..	DCS 16C2	–

DCLN(RL) EXT

P M K N S H

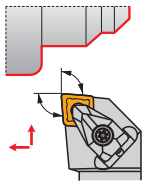
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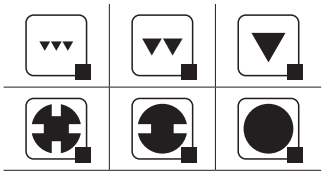
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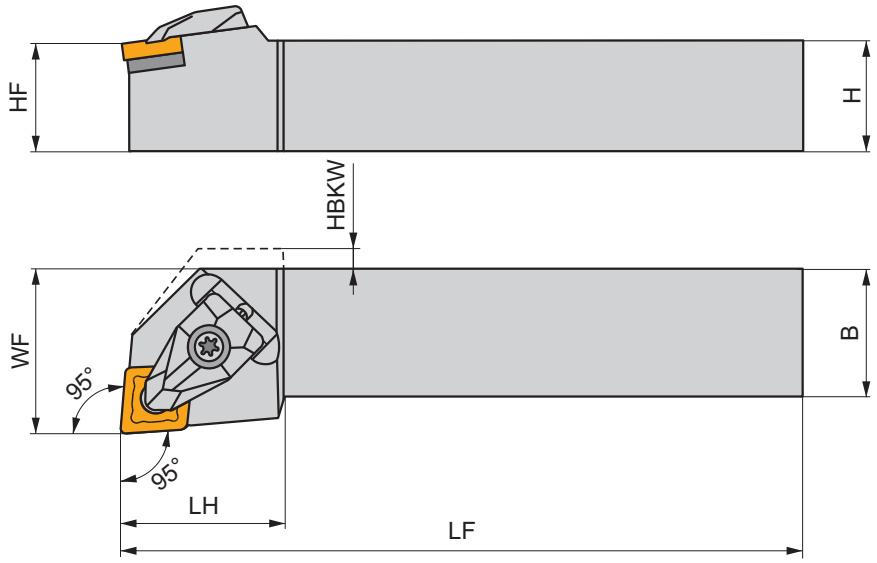


CN.. Uç için Çift Sıkmalı 95° Dış Kateri

Çift sıkmalı 95° Sağ/Sol dış kater. Negatif CN.. 09 - 19 uçlarla çap, alın ve pah tornalama için uygundur. 16x16 - 40x40mm şaft ölçüleri. Gövde uzun takım ömrü için işlem görmüştür.









	Product	H	B	HF	WF	LF	LH	HBKW	LAMS	GAMO	kg			
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)				
R	DCLNR 1616 H 09	16	16	16	20	100	25.0	–	-6	-6	0.24	GI133	DC09	–
	DCLNR 2020 K 09	20	20	20	25	125	25.0	–	-6	-6	0.44	GI133	DC09	–
	DCLNR 2525 M 09	25	25	25	32	150	25.0	–	-6	-6	0.77	GI133	DC09	–
	DCLNR 1616 H 12	16	16	16	20	100	32.3	4.5	-6	-6	0.26	GI043	DCI12	AT001
	DCLNR 2020 K 12	20	20	20	25	125	30.0	–	-6	-6	0.44	GI043	DC12	AT001
	DCLNR 2525 M 12	25	25	25	32	150	30.0	–	-6	-6	0.78	GI043	DC12	AT001
	DCLNR 3225 P 12	32	25	32	32	170	30.0	–	-6	-6	1.07	GI043	DC12	AT001
	DCLNR 2525 M 16	25	25	25	32	150	39.0	–	-6	-6	0.81	GI050	DC16	AT005
	DCLNR 3225 P 16	32	25	32	32	170	35.0	–	-6	-6	1.13	GI050	DC16	AT005
	DCLNR 3232 P 19	32	32	32	40	170	40.0	–	-6	-6	1.40	GI042	DC19	–
	DCLNR 4040 S 19	40	40	40	50	250	43.4	–	-6	-6	3.20	GI042	DC19	–
L	DCLNL 1616 H 09	16	16	16	20	100	24.8	–	-6	-6	0.22	GI133	DC09	–
	DCLNL 2020 K 09	20	20	20	25	125	24.8	–	-6	-6	0.42	GI133	DC09	–
	DCLNL 2525 M 09	25	25	25	32	150	24.8	–	-6	-6	0.76	GI133	DC09	–
	DCLNL 1616 H 12	16	16	16	20	100	32.2	4.5	-6	-6	0.26	GI043	DCI12	AT001
	DCLNL 2020 K 12	20	20	20	25	125	32.0	–	-6	-6	0.44	GI043	DC12	AT001
	DCLNL 2525 M 12	25	25	25	32	150	32.0	–	-6	-6	0.78	GI043	DC12	AT001
	DCLNL 3225 P 12	32	25	32	32	170	32.0	–	-6	-6	1.10	GI043	DC12	AT001
	DCLNL 2525 M 16	25	25	25	32	150	39.0	–	-6	-6	0.81	GI050	DC16	AT005
	DCLNL 3225 P 16	32	25	32	32	170	39.0	–	-6	-6	1.10	GI050	DC16	AT005
	DCLNL 3232 P 19	32	32	32	40	170	43.2	–	-6	-6	1.41	GI042	DC19	–
	DCLNL 4040 S 19	40	40	40	50	250	43.4	–	-6	-6	3.26	GI042	DC19	–

GI042	CN.. 1906..
GI043	CN.. 1204..

GI050	CN.. 1606..
GI133	CN.. 0903..

DC09	DCS 09	1.7	DCS 236-04	US 2004-T09P	FLAG T09P	–
DC12	DCS 12	3.9	DCS 234-01	US 2002-T15P	FLAG T15P/3,5	–
DC16	DCS 16	6.4	DCS 234-03	US 2007-T20P	–	LK T20P
DC19	DCS 19	6.4	DCS 236-01	US 2007-T20P	–	LK T20P
DCI12	DCS 12	3.9	DCS 236-03	US 2002-T15P	FLAG T15P/3,5	–

AT001a	CN.. 1207..	–	DCS 234-02
AT005a	CN.. 1607..	–	DCS 234-04
AT001b	CER CN.N 1204..	DCS 12C4	–
AT001c	CER CN.A 1204..	DCS 12C2	–
AT005b	CER CN.N 1606..	DCS 16C4	–
AT005c	CER CN.A 1606..	DCS 16C2	–

PCBN(RL) EXT

P M K N S H

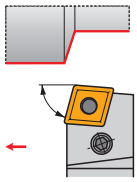
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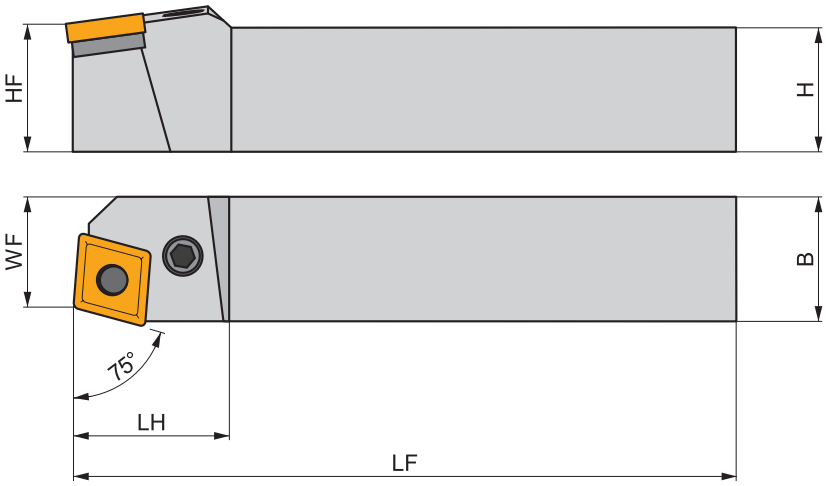
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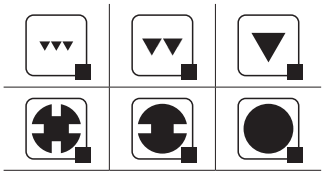


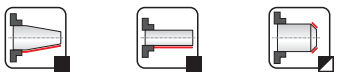
CN.. Uç için Levyeli 75° Açılı Dış Kater

Levyeli, 75° açılı Sağ/Sol dış kater. Negatif CN.. 12, 16 veya 19 uçlarla çap,alın, konik ve pah tornalamak için uygundur. 20x20'den 50x50'ye kadar mevcuttur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	H	B	HF	WF	LF	LH	LAMS	GAMO			
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)	kg		
R	PCBNR 2020 K 12	20	20	20	17	125	28.0	-5	-6	0.40	GI043	PC01
	PCBNR 2525 M 12	25	25	25	22	150	36.0	-6	-6	0.74	GI043	PC01
	PCBNR 3232 P 16	32	32	32	27	170	34.0	-5	-6	1.34	GI050	PC02
	PCBNR 3232 P 19	32	32	32	27	170	42.0	-5	-6	1.10	GI042	PC03
	PCBNR 4040 S 19	40	40	40	35	250	45.0	-6	-6	3.05	GI042	PC03
	PCBNR 4040 S 25	40	40	40	41	250	48.0	-5	-6	3.09	GI062	PC04
	PCBNR 5050 T 25	50	50	50	51	300	50.0	-5	-6	5.80	GI062	PC04
L	PCBNL 2020 K 12	20	20	20	17	125	28.0	-5	-6	0.38	GI043	PC01
	PCBNL 2525 M 12	25	25	25	22	150	28.0	-5	-6	0.73	GI043	PC01
	PCBNL 3232 P 16	32	32	32	27	170	34.0	-5	-6	1.25	GI050	PC02
	PCBNL 3232 P 19	32	32	32	27	170	42.0	-5	-6	1.10	GI042	PC03
	PCBNL 4040 S 19	40	40	40	35	250	48.0	-5	-6	3.10	GI042	PC03
	PCBNL 4040 S 25	40	40	40	41	250	48.0	-5	-6	3.12	GI062	PC04
	PCBNL 5050 T 25	50	50	50	51	300	50.0	-5	-6	5.80	GI062	PC04

GI042	CN.. 1906..
GI043	CN.. 1204..
GI050	CN.. 1606..
GI062	CN.. 2509..

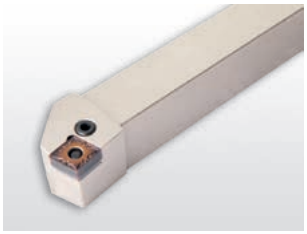
PC01	PCS 612	CL 012	CS 608	3.0	M 8x1	20.7	TR 12	MT 05	HXK 3
PC02	PCS 616	CL 016	CS 618	3.0	M 8x1	22.5	TR 15	MT 07	HXK 3
PC03	PCS 619	CL 019	CS 610	3.5	M 10x1	27.2	TR 19	MT 06	HXK 4
PC04	PCS 625	CL 025	CS 612	4.0	M 12x1	36	TR 25	MT 08	HXK 5

PCKN(RL) EXT

P M K N S H

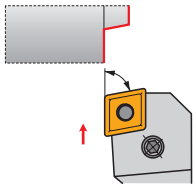
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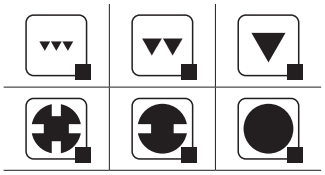
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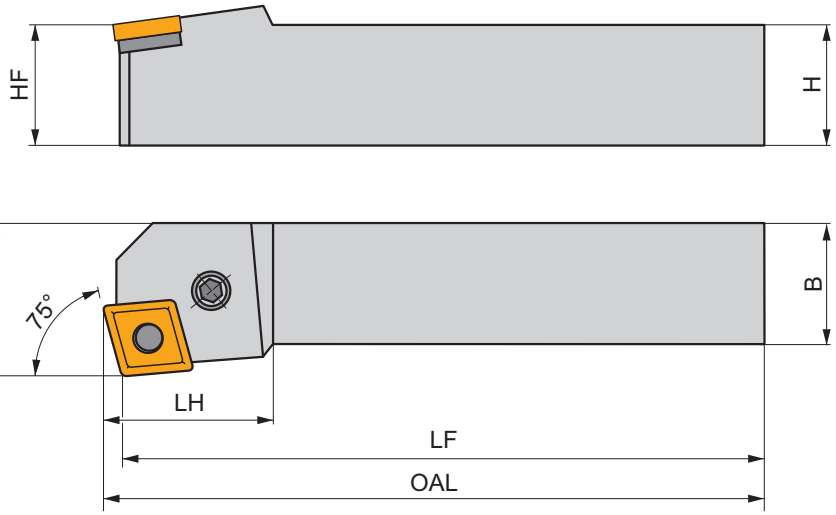


CN.. Uç için Levyeli 75° Açılı (Alın) Dış Kateri

Levyeli, 75° açılı Sağ/Sol dış kater. Negatif CN.. 12, 16 veya 19 uçlarla alın ve pah tornalamak için uygundur. 20x20'den 32x25'e kadar mevcuttur. Gövde uzun takım ömrü için işlem görmüştür.











	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	**PCKNR 2020 K 12**	20	20	20	25	125	28.0	-6	-5	0.42	GI043	PC01
	PCKNR 2525 M 12	25	25	25	32	150	28.0	-6	-5	0.76	GI043	PC01
	PCKNR 3232 P 16	32	32	32	40	170	34.0	-6	-5	1.42	GI050	PC02
	PCKNR 3232 P 19	32	32	32	40	170	34.0	-6	-5	1.40	GI042	PC03
	PCKNR 4040 S 19	40	40	40	50	250	45.0	-6	-5	3.25	GI042	PC03
L	**PCKNL 2020 K 12**	20	20	20	25	125	28.0	-6	-5	0.42	GI043	PC01
	PCKNL 2525 M 12	25	25	25	32	150	28.0	-6	-5	0.77	GI043	PC01
	PCKNL 3232 P 16	32	32	32	40	170	34.0	-6	-5	1.40	GI050	PC02
	PCKNL 3232 P 19	32	32	32	40	170	45.0	-6	-6	1.40	GI042	PC03
	PCKNL 4040 S 19	40	40	40	50	250	45.0	-6	-5	3.27	GI042	PC03

GI042	CN.. 1906..
GI043	CN.. 1204..
GI050	CN.. 1606..

				Nm					
PC01	PCS 612	CL 012	CS 608	3.0	M 8x1	20.7	TR 12	MT 05	HXK 3
PC02	PCS 616	CL 016	CS 618	3.0	M 8x1	22.5	TR 15	MT 07	HXK 3
PC03	PCS 619	CL 019	CS 610	3.5	M 10x1	27.2	TR 19	MT 06	HXK 4

PCLN(RL) EXT

P M K N S H

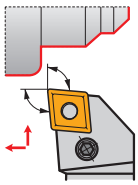
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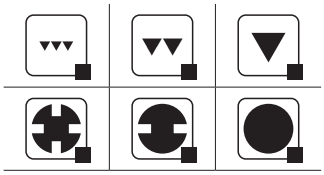
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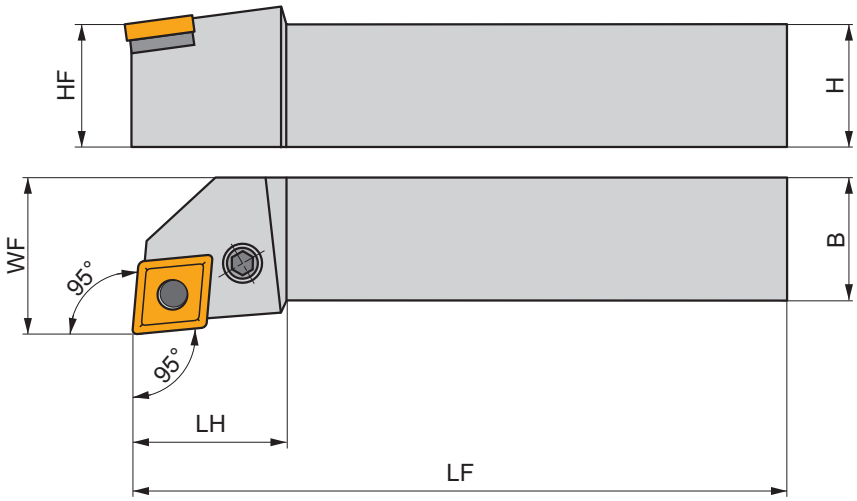


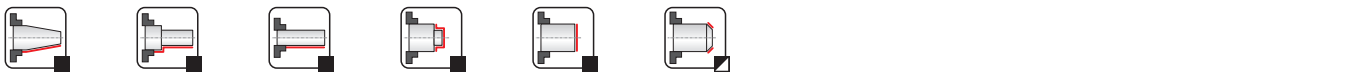
CN.. Uç için Levyeli 95° Açılı Dış Kater

Levyeli, 95° açılı Sağ/Sol dış kater. Negatif CN.. 12, 16, 19 veya 25 uçlarla çap,alın, konik ve pah tornalamak için uygundur. 20x20'den 50x50'ye kadar mevcuttur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	PCLNR 2020 K 12	20	20	20	25	125	28.0	-6	-6	0.42	GI043	PC01
	PCLNR 2525 M 12	25	25	25	32	150	28.0	-6	-6	0.68	GI043	PC01
	PCLNR 3225 P 12	32	25	32	32	170	28.0	-6	-6	0.98	GI043	PC01
	PCLNR 3225 P 16	32	25	32	32	170	34.0	-6	-6	1.09	GI050	PC02
	PCLNR 3232 P 19	32	32	32	40	170	45.0	-6	-6	1.38	GI042	PC03
	PCLNR 4040 S 19	40	40	40	50	250	45.0	-6	-6	3.10	GI042	PC03
	PCLNR 4040 S 25	40	40	40	50	250	45.0	-6	-6	3.15	GI062	PC04
	PCLNR 5050 T 25	50	50	50	60	300	50.0	-6	-6	5.90	GI062	PC04
L	PCLNL 2020 K 12	20	20	20	25	125	28.0	-6	-6	0.42	GI043	PC01
	PCLNL 2525 M 12	25	25	25	32	150	28.0	-6	-6	0.75	GI043	PC01
	PCLNL 3225 P 12	32	25	32	32	170	28.0	-6	-6	1.06	GI043	PC01
	PCLNL 3225 P 16	32	25	32	32	170	34.0	-6	-6	1.08	GI050	PC02
	PCLNL 3232 P 19	32	32	32	40	170	42.0	-6	-6	1.38	GI042	PC03
	PCLNL 4040 S 19	40	40	40	50	250	45.0	-6	-6	3.16	GI042	PC03
	PCLNL 4040 S 25	40	40	40	50	250	45.0	-6	-6	3.17	GI062	PC04
	PCLNL 5050 T 25	50	50	50	60	300	50.0	-6	-6	5.90	GI062	PC04

GI042	CN.. 1906..
GI043	CN.. 1204..
GI050	CN.. 1606..
GI062	CN.. 2509..

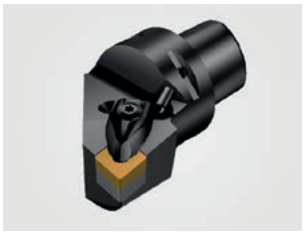
				Nm					
PC01	PCS 612	CL 012	CS 608	3.0	M 8x1	20.7	TR 12	MT 05	HXK 3
PC02	PCS 616	CL 016	CS 618	3.0	M 8x1	22.5	TR 15	MT 07	HXK 3
PC03	PCS 619	CL 019	CS 610	3.5	M 10x1	27.2	TR 19	MT 06	HXK 4
PC04	PCS 625	CL 025	CS 612	4.0	M 12x1	36	TR 25	MT 08	HXK 5

C.-DCLN(RL) EXT

P M K N S H

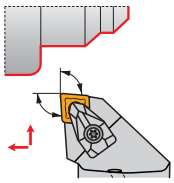
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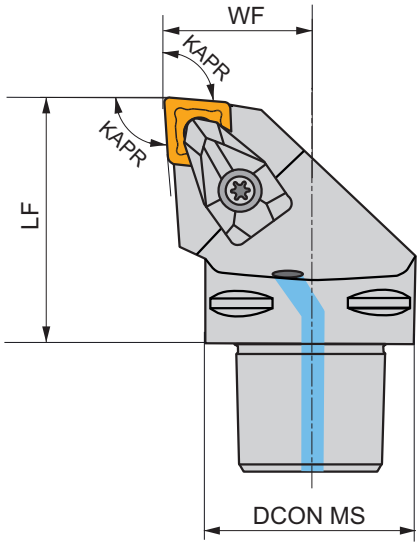
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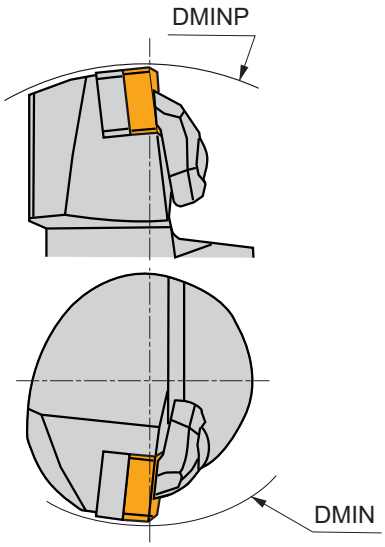


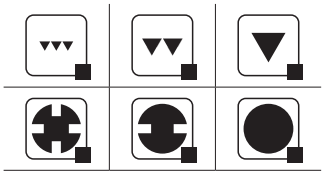
CN.. Uç için Çift Sıkmalı, 95° Açılı Hızlı Değiştirme Dış Takımı

Çift sıkmalı, 95° açılı, içten su vermeli Sağ/Sol dış kater. Negatif CN.. 12 veya 19 uçlarla çap, alın, konik ve pah tornalamak için uygundur. C4 - C6 şaftlı mevcuttur. Tutucu uzun takım ömrü için işlem görmüştür.











	Product	DCON MS (mm)	DMIN (mm)	DMINP (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg			
R	C3-DCLNR-22045-12	32	60	121	22	45	95	-6	-6	✓	0.25	GI043	C-DC12	AT001
	C4-DCLNR-27050-12	40	110	140	27	50	95	-6	-6	✓	0.44	GI043	C-DC12	AT001
	C4-DCLNR-27055-16	40	125	145	27	55	95	-6	-6	✓	0.47	GI050	C-DC16	AT005
	C5-DCLNR-35060-12	50	110	165	35	60	95	-6	-6	✓	0.79	GI043	C-DC12	AT001
	C5-DCLNR-35060-16	50	125	165	35	60	95	-6	-6	✓	0.80	GI050	C-DC16	AT005
	C6-DCLNR-45065-12	63	110	190	45	65	95	-6	-6	✓	1.32	GI043	C-DC12	AT001
	C6-DCLNR-45065-16	63	125	190	45	65	95	-6	-6	✓	1.34	GI050	C-DC16	AT005
	C6-DCLNR-45065-19	63	81	190	45	65	95	-6	-6	✓	1.34	GI042	C-DC19	–
	C8-DCLNR-55080-19	80	100	250	55	80	95	-6	-6	✓	2.58	GI042	C-DC19	–
L	C4-DCLNL-27050-12	40	110	140	27	50	95	-6	-6	✓	0.44	GI043	C-DC12	AT001
	C4-DCLNL-27055-16	40	125	145	27	55	95	-6	-6	✓	0.47	GI050	C-DC16	AT005
	C5-DCLNL-35060-12	50	110	165	35	60	95	-6	-6	✓	0.79	GI043	C-DC12	AT001
	C5-DCLNL-35060-16	50	125	165	35	60	95	-6	-6	✓	0.80	GI050	C-DC16	AT005
	C6-DCLNL-45065-12	63	110	190	45	65	95	-6	-6	✓	1.32	GI043	C-DC12	AT001
	C6-DCLNL-45065-16	63	125	190	45	65	95	-6	-6	✓	1.34	GI050	C-DC16	AT005
	C6-DCLNL-45065-19	63	81	190	45	65	95	-6	-6	✓	1.34	GI042	C-DC19	–
	C8-DCLNL-55080-16	80	125	250	55	80	95	-6	-6	✓	2.58	GI050	C-DC16	AT005
	C8-DCLNL-55080-19	80	100	250	55	80	95	-6	-6	✓	2.58	GI042	C-DC19	–

GI042	CN.. 1906..
GI043	CN.. 1204..
GI050	CN.. 1606..

							
C-DC12	DCS 12	3.9	DCS 234-01	US 2002-T15P	FLAG T15P/3,5	–	CN 045-01
C-DC16	DCS 16	6.4	DCS 234-03	US 2007-T20P	–	LK T20P	CN 045-01
C-DC19	DCS 19	6.4	DCS 236-01	US 2007-T20P	–	LK T20P	CN 045-01

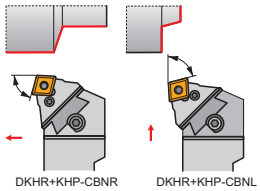
			
AT001a	CN.. 1207..	–	DCS 234-02
AT005a	CN.. 1607..	–	DCS 234-04
AT001b	CER CN.N 1204..	DCS 12C4	–
AT001c	CER CN.A 1204..	DCS 12C2	–
AT005b	CER CN.N 1606..	DCS 16C4	–
AT005c	CER CN.A 1606..	DCS 16C2	–

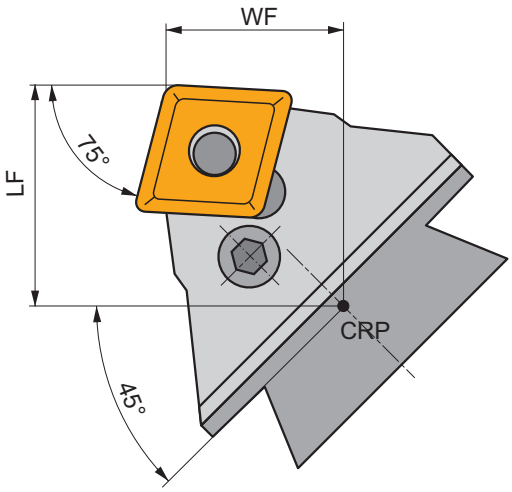
KHP-CBN(RL)

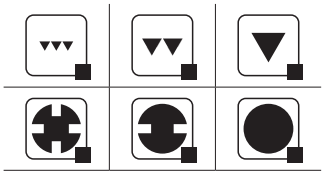


Modüler KHP Levyeli Torna Kartuşu, 75° Kesme Açılı, CN.. Uç için

DKH takım tutucu şaft için kırlangıç bağlantılı, 75° açılı Sağ/Sol levyeli kartuş. Negatif CN..25 uçlarla çap, alın, konik ve pah tornalamak için uygundur. Tutucu uzun takım ömrü için işlem görmüştür.





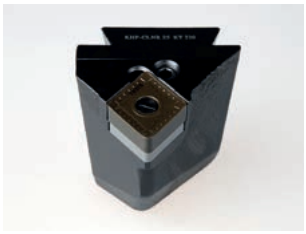


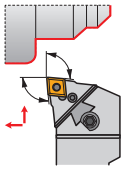
	Product	WF (mm)	LF (mm)	LAMS (°)	GAMO (°)	kg		
R	**KHP-CBNR 25**	32	47	-6	-6	1.54	GI062	PC60
L	**KHP-CBNL 25**	32	47	-6	-6	1.56	GI062	PC60

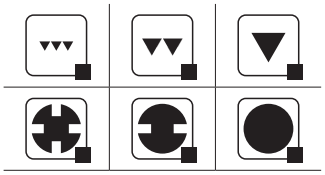
GI062	CN.. 2509..

PC60	CNU 250620	PU 06	US 39	8.0	M 10x1	33	NT 08	MT 08	HXK 5

KHP-CLN(RL)

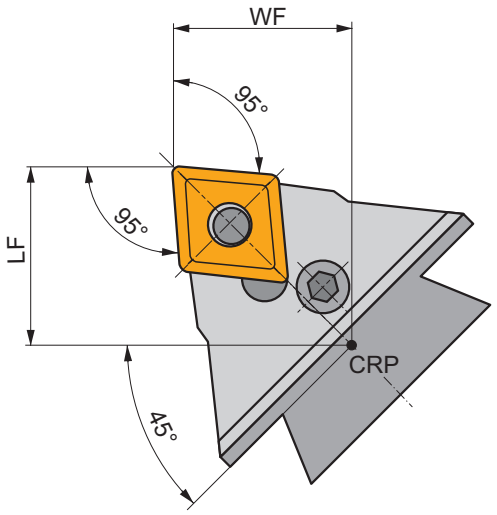


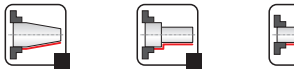




Modüler KHP Levyeli Torna Kartuşu, 95° Kesme Açılı, CN.. Uç için

DKH takım tutucu şaft için kırlangıç bağlantılı, 95° açılı Sağ/Sol levyeli kartuş. Negatif CN.. 19 veya 25 uçlarla çap, alın, konik ve pah tornalamak için uygundur. Tutucu uzun takım ömrü için işlem görmüştür.





	Product	WF (mm)	LF (mm)	LAMS (°)	GAMO (°)	kg		
R	**KHP-CLNR 19**	35	45	-6	-6	1.69	GI042	PC50
	KHP-CLNR 25	35	45	-6	-6	1.25	GI062	PC60
L	**KHP-CLNL 19**	35	45	-6	-6	1.30	GI042	PC50
	KHP-CLNL 25	35	45	-6	-6	1.25	GI062	PC60

GI042	CN.. 1906..
GI062	CN.. 2509..

				Nm					
PC50	CNU 190416	PU 05	US 38	8.0	M 10x1	29	NT 06	MT 06	HXK 5
PC60	CNU 250620	PU 06	US 39	8.0	M 10x1	33	NT 08	MT 08	HXK 5

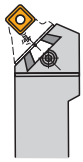
DKH(RL)

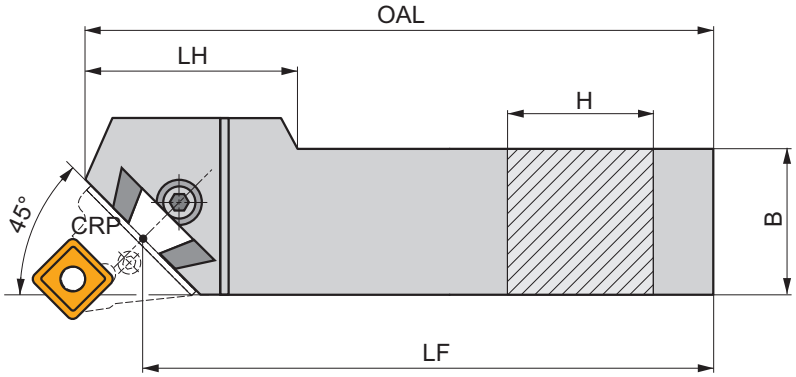
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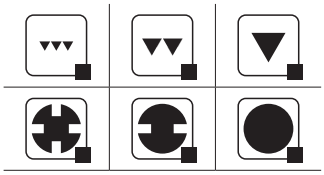


KHP/KHS Ağır Tornalama Kartuşları için Dış Kater Şaftı

KHP/KHS kartuşlar için kırlangıçlı Sağ/Sol takım şaftı. Ağır tornalama için uygundur. 40x50'den 60x80mm'ye kadar mevcut. Gövde uzun takım ömrü için işlem görmüştür.







	Product	H (mm)	B (mm)	LF (mm)	OAL (mm)	LH (mm)	kg		
R	**DKHR 4050 V**	40	50	400	425	100.0	7.10	GI098	DKH10
	DKHR 5060 W	50	60	450	475	110.0	11.30	GI098	DKH10
	DKHR 6080 W-A	60	80	450	485	90.0	19.65	GI098	DKH10
L	**DKHL 4050 V**	40	50	400	425	100.0	7.10	GI098	DKH10
	DKHL 5060 W	50	60	450	475	110.0	11.30	GI098	DKH10
	DKHL 6080 W-A	60	80	450	485	90.0	19.28	GI098	DKH10

GI098	KHP	KHS

DKH10	SR 14	HXK 10

DCLN(RL) INT

P M K N S H

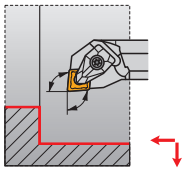
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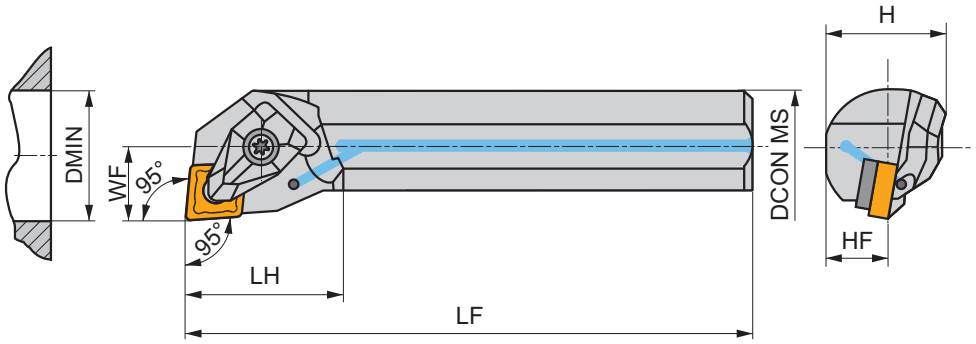
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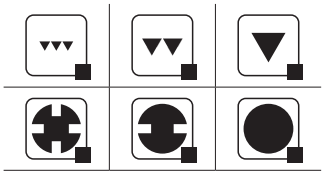


CN.. Uç için Çift Sıkmalı 95° Açılı Delik Kateri

Çift sıkmalı 95° Sağ/Sol içten su vermeli delik kateri. Negatif CN.. uçlarla Kenar ve pah tornalama ile iç konik ve çap tornalama için uygundur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	HF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)		kg		
R	A25T-DCLNR 09	25	32	17	23	11.5	300	31.0	-11	-6	✓	0.98	GI133	DC09
	A25T-DCLNR 12	25	32	17	23	11.5	300	31.0	-12	-6	✓	0.98	GI043	DCI12
	A32T-DCLNR 12	32	40	22	30	15	300	30.0	-10	-6	✓	1.68	GI043	DCI12
	A40T-DCLNR 12	40	50	27	37	18.5	300	32.0	-15	-6	✓	2.56	GI043	DC12
L	A25T-DCLNL 09	25	32	17	23	11.5	300	31.0	-11	-6	✓	0.99	GI133	DC09
	A25T-DCLNL 12	25	32	17	23	11.5	300	31.0	-12	-6	✓	0.98	GI043	DCI12
	A32T-DCLNL 12	32	40	22	30	15	300	30.0	-10	-6	✓	1.68	GI043	DCI12
	A40T-DCLNL 12	40	50	27	37	18.5	300	32.0	-15	-6	✓	2.55	GI043	DC12

GI043	CN.. 1204..
GI133	CN.. 0903..

		Nm			
DC09	DCS 09	1.7	DCS 236-04	US 2004-T09P	FLAG T09P
DC12	DCS 12	3.9	DCS 234-01	US 2002-T15P	FLAG T15P/3,5
DCI12	DCS 12	3.9	DCS 236-03	US 2002-T15P	FLAG T15P/3,5

PCLN(RL) INT

P M K N S H

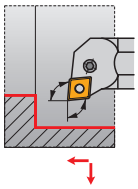
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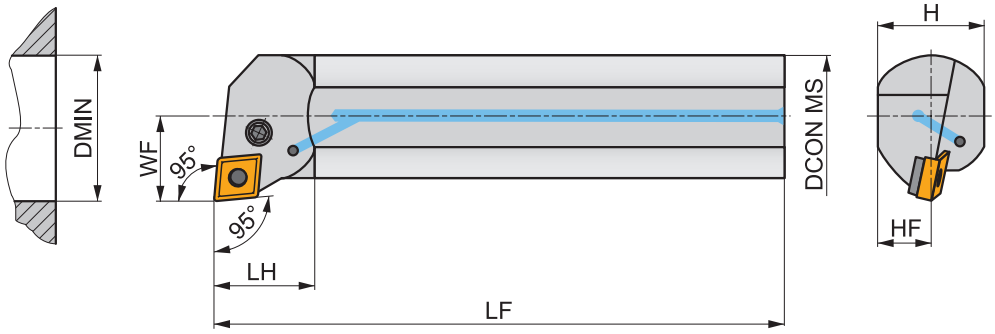
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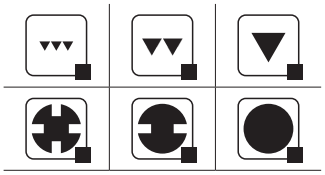


CN.. Uç için Kollu 95° Açılı Delik Kateri

İç çap Sağ/Sol levye kilitli delik işleme barası, içten soğutma mevcut, CN.. uçlar için 95° kesme açısı. Kenar ve pah tornalama ile iç konik ve çap tornalama için. Gövde uzun takım ömrü için işlem görmüştür.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)		kg		
R	A16M-PCLNR 09	16	20	11	15	–	150	-14	-4	✓	0.22	GI133	PC05
	A20Q-PCLNR 09	20	25	13	18	18	180	-13.5	-5	✓	0.33	GI133	PC05
	A25R-PCLNR 12	25	31	17	23	–	200	-14	-4	–	0.70	GI043	PC06
	A32S-PCLNR 12	32	39	22	30	–	250	-12	-4	✓	1.40	GI043	PC07
	A40T-PCLNR 12	40	48	27	37	–	300	-12	-4	✓	2.40	GI043	PC01
	A40T-PCLNR 16	40	48	27	37	–	300	-12	-4	✓	2.65	GI050	PC02
	A50U-PCLNR 16	50	63	35	47	48.5	350	-12	-6	✓	5.20	GI050	PC02
	A60V-PCLNR 16	60	80	43	57	–	400	-12	-4	✓	8.70	GI050	PC02
	A50U-PCLNR 19	50	63	35	47	48.5	350	-12	-6	✓	5.20	GI042	PC08
	A60V-PCLNR 19	60	80	43	57	–	400	-11	-6	✓	8.22	GI042	PC08
L	A16M-PCLNL 09	16	20	11	15	–	150	-14	-4	✓	0.20	GI133	PC05
	A20Q-PCLNL 09	20	25	13	18	–	180	-13	-4	–	0.34	GI133	PC05
	A25R-PCLNL 12	25	31	17	23	–	200	-14	-4	✓	0.65	GI043	PC06
	A32S-PCLNL 12	32	39	22	30	–	250	-12	-4	✓	1.40	GI043	PC07
	A40T-PCLNL 12	40	50	27	38	38	300	-12	-6	✓	2.58	GI043	PC01
	A40T-PCLNL 16	40	48	27	37	–	300	-12	-4	✓	2.58	GI050	PC02
	A50U-PCLNL 16	50	61	35	47	–	350	-12	-4	✓	4.95	GI050	PC02
	A60V-PCLNL 16	60	80	43	57	–	400	-12	-4	✓	8.70	GI050	PC02

GI042	CN.. 1906..
GI043	CN.. 1204..
GI050	CN.. 1606..
GI133	CN.. 0903..

									
PC01	PCS 612	CL 012	CS 608	3.0	M 8x1	20.7	TR 12	MT 05	HXK 3
PC02	PCS 616	CL 016	CS 618	3.0	M 8x1	22.5	TR 15	MT 07	HXK 3
PC05	–	CL 005	CS 605	1.4	M 5x1	12	–	–	HXK 2
PC07	PCS 612	CL 312	CS 648	3.0	M 8x1	17	TR 12	MT 05	HXK 3
PC06	–	CL 212	CS 626	2.0	M 6x1	13.4	–	–	HXK 2.5
PC08	PCS 619	CL 219	CS 610	3.5	M 10x1	27.2	TR 29	MT 06	HXK 4

C.-DCLN(RL) INT

P M K N S H

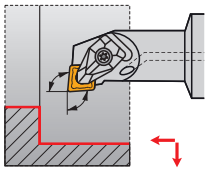
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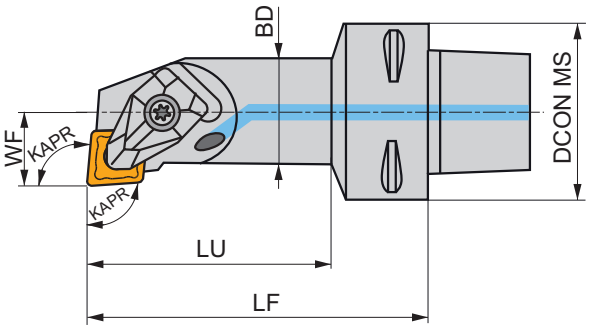
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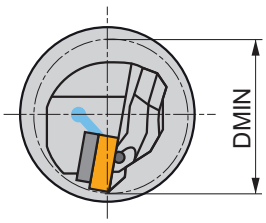


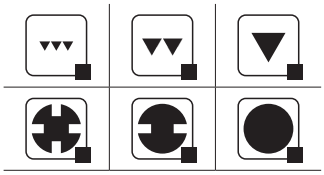
CN.. Uçlar için Çift Sıkmalı 95° Açılı PSC Hızlı Değiştirme Delik Takımı

Çift sıkmalı 95° Sağ/Sol içten su vermeli delik kateri. Negatif CN.. uçlarla birçok çeşit tornalama için uygundur. PSC şaft ölçüleri. Gövde uzun takım ömrü için işlem görmüştür.











	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	LF (mm)	LU (mm)	BD (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg		
R	C4-DCLNR-13080-09	40	25	13	80	57	20	95	-14	-6	✓	0.43	GI133	DC09
R	C4-DCLNR-17090-12	40	32	17	90	68	25	95	-12	-6	✓	0.53	GI043	DCI12
R	C5-DCLNR-17090-12	50	32	17	90	66	25	95	-12	-6	✓	0.72	GI043	DCI12
R	C6-DCLNR-17100-12	63	32	17	100	72	25	95	-12	-6	✓	1.15	GI043	DCI12
R	C6-DCLNR-27140-16	63	50	27	140	114	40	95	-16	-6	✓	1.81	GI050	DC16
L	C4-DCLNL-17090-12	40	32	17	90	68	25	95	-12	-6	✓	0.53	GI043	DCI12
L	C5-DCLNL-17090-12	50	32	17	90	66	25	95	-12	-6	✓	0.72	GI043	DCI12

GI043	CN.. 1204..
GI050	CN.. 1606..
GI133	CN.. 0903..

		Nm				
DC09	DCS 09	1.7	DCS 236-04	US 2004-T09P	FLAG T09P	–
DC16	DCS 16	6.4	DCS 234-03	US 2007-T20P	–	LK T20P
DCI12	DCS 12	3.9	DCS 236-03	US 2002-T15P	FLAG T15P/3,5	–

DDJN(RL) EXT

P M K N S H

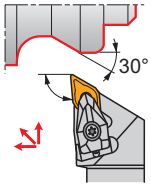
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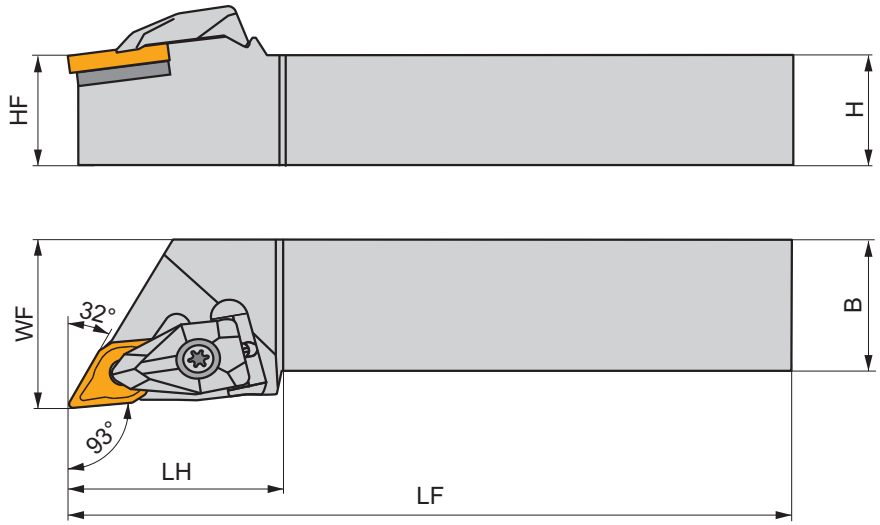
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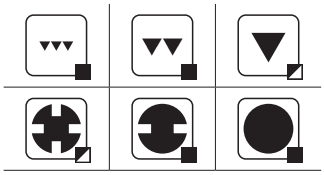


DN.. Uç için Çift Sıkmalı 93° Dış Kateri

Çift sıkmalı 93° Sağ/Sol dış kater. Negatif DN.. 11 veya 16 uçlarla çap, kopya, alın ve pah tornalama için uygundur. 20x20 - 32x32mm şaft ölçüleri. Gövde uzun takım ömrü için işlem görmüştür.









	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg			
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)				
R	DDJNR 2020 K 11	20	20	20	25	125	30.2	-7	-6	0.41	GI046	DD11	–
	DDJNR 2525 M 11	25	25	25	32	150	30.2	-7	-6	0.74	GI046	DD11	–
	DDJNR 2020 K 15	20	20	20	25	125	39.4	-7	-6	0.42	GI044	DD154	AT002
	DDJNR 2525 M 15	25	25	25	32	150	39.4	-7	-6	0.74	GI044	DD154	AT002
	DDJNR 3225 P 15	32	25	32	32	170	39.4	-7	-6	1.07	GI044	DD154	AT002
	DDJNR 3232 P 15	32	32	32	40	170	39.4	-7	-6	1.33	GI044	DD154	AT002
L	DDJNL 2020 K 11	20	20	20	25	125	30.2	-7	-6	0.42	GI046	DD11	–
	DDJNL 2525 M 11	25	25	25	32	150	30.2	-7	-6	0.74	GI046	DD11	–
	DDJNL 2020 K 15	20	20	20	25	125	39.4	-7	-6	0.42	GI044	DD154	AT002
	DDJNL 2525 M 15	25	25	25	32	150	39.4	-7	-6	0.74	GI044	DD154	AT002
	DDJNL 3225 P 15	32	25	32	32	170	39.4	-7	-6	1.01	GI044	DD154	AT002
	DDJNL 3232 P 15	32	32	32	40	170	39.4	-7	-6	1.34	GI044	DD154	AT002

GI044	DN.. 1506..
GI046	DN.. 1104..

DD11	DCS 09	1.7	DDS 267-01	US 2004-T09P	FLAG T09P
DD154	DCS 12	3.9	DDS 266-02	US 2002-T15P	FLAG T15P/3,5

AT002a	DN.. 1504..	–	DDS 266-01
AT002b	CER DN.N 1506..	DCS 12C4	–
AT002c	CER DN.A 1506..	DCS 12C2	–

PDJN(RL) EXT

P M K N S H

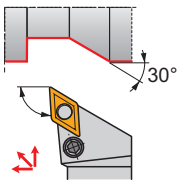
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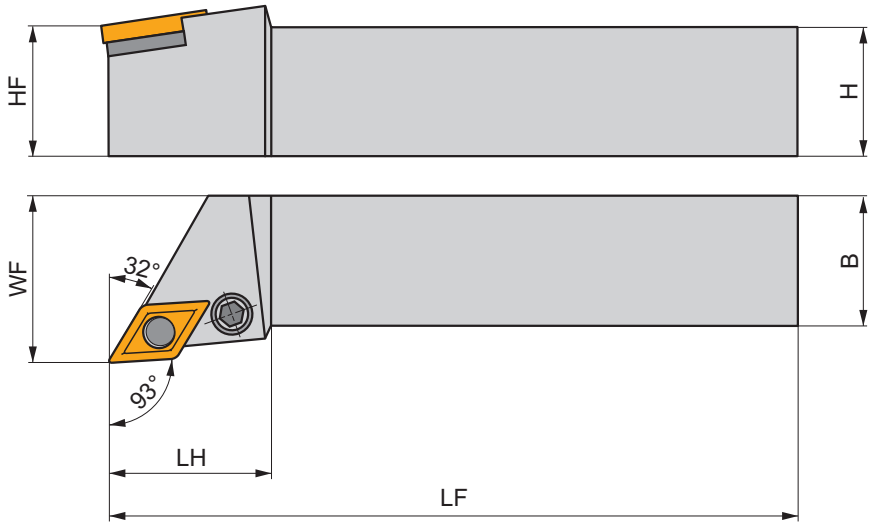
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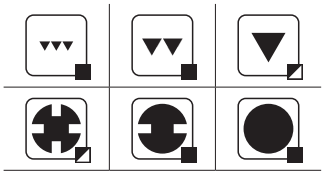


DN.. Uç için Levyeli 93° Açılı Dış Kater

Levyeli, 93° açılı Sağ/Sol dış kater. Negatif DN.. 11 veya 15 uçlarla çap, 30°'ye kadar kopya ve pah tornalamak için uygundur. 20x20'den 32x32mm'ye kadar mevcuttur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	PDJNR 2020 K 11	20	20	20	25	125	28.0	-7	-6	0.40	GI046	PD02
	PDJNR 2525 M 11	25	25	25	32	150	28.0	-7	-6	0.73	GI046	PD02
	PDJNR 2020 K 15	20	20	20	25	125	34.0	-7	-6	0.39	GI044	PD01
	PDJNR 2525 M 15	25	25	25	32	150	34.0	-7	-6	0.73	GI044	PD01
	PDJNR 3225 P 15	32	25	32	32	170	34.0	-7	-6	1.04	GI044	PD01
	PDJNR 3232 P 15	32	32	32	40	170	34.0	-7	-6	1.30	GI044	PD01
L	PDJNL 2020 K 11	20	20	20	25	125	28.0	-7	-6	0.40	GI046	PD02
	PDJNL 2525 M 11	25	25	25	32	150	28.0	-7	-6	0.73	GI046	PD02
	PDJNL 2020 K 15	20	20	20	25	125	40.0	-6	-6	0.42	GI044	PD01
	PDJNL 2525 M 15	25	25	25	32	150	34.0	-7	-6	0.73	GI044	PD01
	PDJNL 3225 P 15	32	25	32	32	170	34.0	-7	-6	0.98	GI044	PD01
	PDJNL 3232 P 15	32	32	32	40	170	34.0	-7	-6	1.30	GI044	PD01

GI044	DN.. 1506..
GI046	DN.. 1104..

				Nm					
PD01	PDS 715	CL 415	CS 638	3.0	M 8x1	21.1	TR 12	MT 05	HXK 3
PD02	PDS 711	CL 009	CS 606	2.0	M 6x1	16.7	TR 09	MT 04	HXK 2.5

PDNN(RL) EXT

P M K N S H

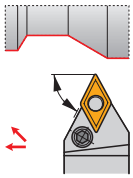
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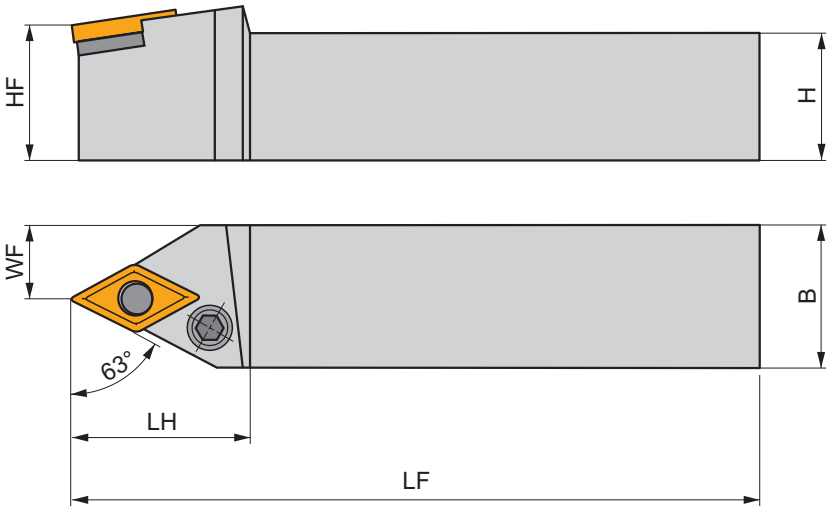
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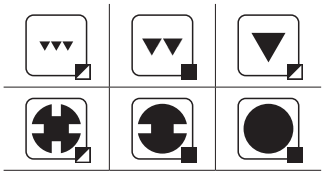


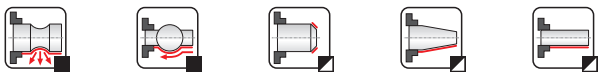
DN.. Uç için Levyeli 63° Açılı Dış Kater

Levyeli, 63° açılı nötr dış kater. Negatif DN.. 15 uçlarla çap, konik, kopya ve pah tornalamak için uygundur. 20x20'den 32x25'e kadar mevcuttur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	**PDNNR 2020 K 11**	20	20	20	10	125	28.0	-6	-6	0.37	GI046	PD02
	PDNNR 2525 M 11	25	25	25	12.5	150	25.0	-6	-6	0.60	GI046	PD02
	PDNNR 2525 M 15	25	25	25	12.5	150	34.0	-6	-6	0.69	GI044	PD01
	PDNNR 3225 P 15	32	25	32	12.5	170	34.0	-6	-6	1.00	GI044	PD01
L	**PDNNL 2020 K 11**	20	20	20	10	125	28.0	-6	-6	0.40	GI046	PD02
	PDNNL 2525 M 11	25	25	25	12.5	150	25.0	-6	-6	0.60	GI046	PD02
	PDNNL 2525 M 15	25	25	25	12.5	150	34.0	-6	-6	0.07	GI044	PD01
	PDNNL 3225 P 15	32	25	32	12.5	170	34.0	-6	-6	1.00	GI044	PD01

GI044	DN.. 1506..
GI046	DN.. 1104..

				Nm					
PD01	PDS 715	CL 415	CS 638	3.0	M 8x1	21.1	TR 12	MT 05	HXK 3
PD02	PDS 711	CL 009	CS 606	2.0	M 6x1	16.7	TR 09	MT 04	HXK 2.5

PDXN(RL) EXT

P M K N S H

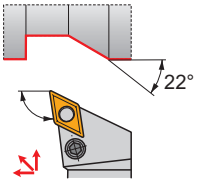
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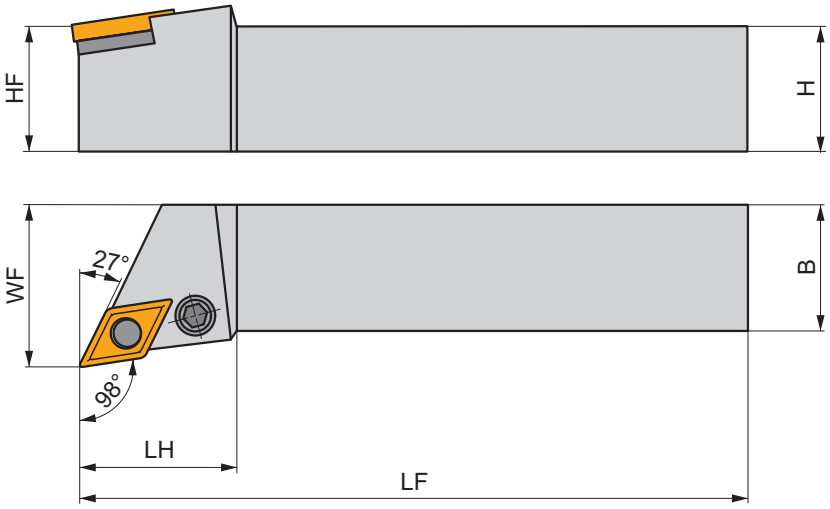
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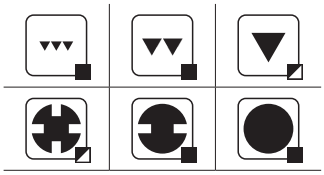


DN.. Uç için Levyeli 98° Açılı Dış Kater

Levyeli, 98° açılı Sağ/Sol dış kater. Negatif DN.. 15 uçlarla çap, 22°'ye kadar kopya, konik ve pah tornalamak için uygundur. 20x20'den 32x25mm'ye kadar mevcuttur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	PDXNR 2020 K 15	20	20	20	25	125	40.0	-6	-6	0.38	GI044	PD01
	PDXNR 2525 M 15	25	25	25	32	150	40.0	-6	-6	0.73	GI044	PD01
	PDXNR 3225 P 15	32	25	32	32	170	34.0	-8	-3	0.80	GI044	PD01
L	PDXNL 2020 K 15	20	20	20	25	125	34.0	-8	-3	0.40	GI044	PD01
	PDXNL 2525 M 15	25	25	25	32	150	34.0	-8	-3	0.71	GI044	PD01
	PDXNL 3225 P 15	32	25	32	32	170	34.0	-8	-3	0.95	GI044	PD01

GI044	DN.. 1506..

PD01	PDS 715	CL 415	CS 638	3.0 Nm	M 8x1	21.1	TR 12	MT 05	HXK 3

C.-DDJN(RL) EXT

P M K N S H

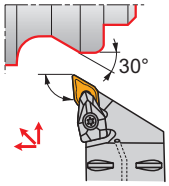
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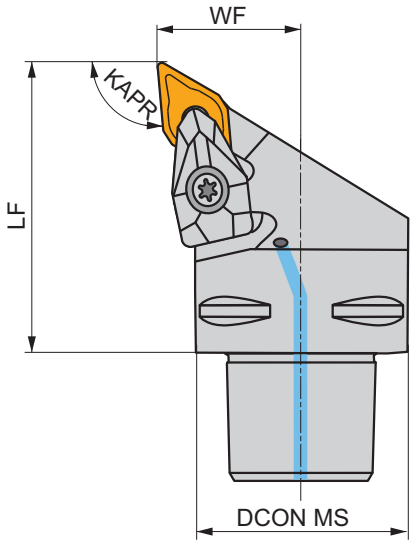
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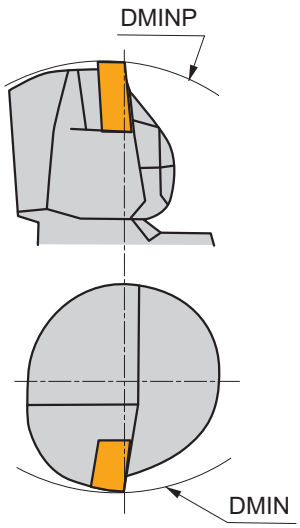


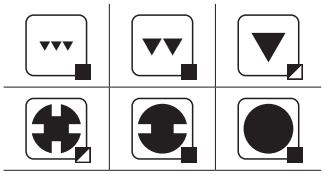
DN.. Uç için Çift Sıkmalı, 93° Açılı Hızlı Değiştirme Dış Takımı

Çift sıkmalı, 93° açılı, içten su vermeli Sağ/Sol dış kater. Negatif DN.. 11 veya 15 uçlarla çap, konik ve pah tornalamak için uygundur. C4 - C6 şaftlı mevcuttur. Tutucu uzun takım ömrü için işlem görmüştür.











	Product	DCON MS (mm)	DMIN (mm)	DMINP (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg			
R	**C4-DDJNR-27050-11**	40	60	140	27	50	93	-7	-6	✓	0.38	GI046	C-DD11	–
	C4-DDJNR-27055-15	40	110	145	27	55	93	-7	-6	✓	0.43	GI044	C-DD154-1	AT002
	C5-DDJNR-35060-15	50	110	165	35	60	93	-7	-6	✓	0.72	GI044	C-DD154-2	AT002
	C6-DDJNR-45065-15	63	110	190	45	65	93	-7	-6	✓	1.18	GI044	C-DD154-3	AT002
L	**C4-DDJNL-27050-11**	40	60	140	27	50	93	-7	-6	✓	0.39	GI046	C-DD11	–
	C4-DDJNL-27055-15	40	110	145	27	55	93	-7	-6	✓	0.43	GI044	C-DD154-1	AT002
	C5-DDJNL-35060-15	50	110	165	35	60	93	-7	-6	✓	0.72	GI044	C-DD154-2	AT002
	C6-DDJNL-45065-15	63	110	190	45	65	93	-7	-6	✓	1.18	GI044	C-DD154-3	AT002

GI044	DN.. 1506..
GI046	DN.. 1104..

		Nm				
C-DD11	DCS 09	1.7	DDS 267-01	US 2004-T09P	FLAG T09P	CN 034-01
C-DD154-1	DCS 12	3.9	DDS 266-02	US 2002-T15P	FLAG T15P/3,5	CN 034-01
C-DD154-2	DCS 12	3.9	DDS 266-02	US 2002-T15P	FLAG T15P/3,5	CN 045-01
C-DD154-3	DCS 12	3.9	DDS 266-02	US 2002-T15P	FLAG T15P/3,5	CN 034-02

AT002a	DN.. 1504..	–	DDS 266-01
AT002b	CER DN.N 1506..	DCS 12C4	–
AT002c	CER DN.A 1506..	DCS 12C2	–
AT002d	CER DN.N 1504..	DCS 12C4	DDS 266-01
AT002e	CER DN.A 1504..	DCS 12C2	DDS 266-01

C.-DDNNN EXT

P M K N S H

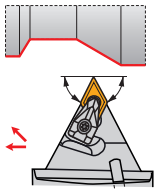
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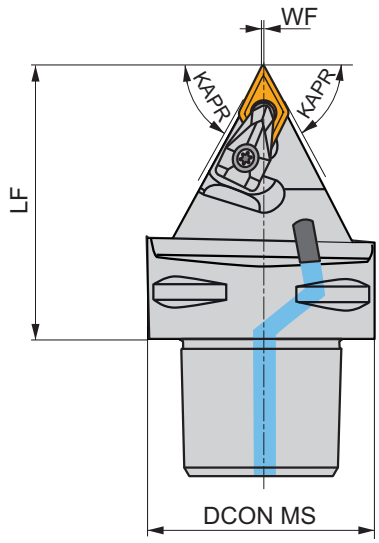
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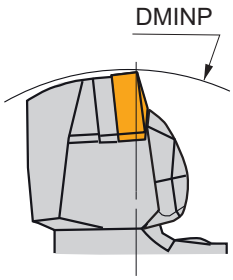


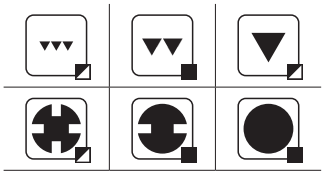
DN.. Uç için Çift Sıkmalı, 62.5° Açılı Hızlı Değiştirme Dış Takımı

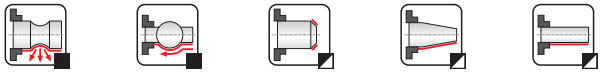
Çift sıkmalı, 62.5° açılı, içten su vermeli Sağ/Sol dış kater. Negatif DN.. 15 uçlarla çap, alın, konik ve pah tornalamak için uygundur. C6 şaftlı mevcuttur. Tutucu uzun takım ömrü için işlem görmüştür.











	Product	DCON MS (mm)	DMINP (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg			
N	**C5-DDNNN-00060-15**	50	165	0.5	60	62.5	-9	-5	✓	0.62	GI044	C-DD154-2	AT002
	C6-DDNNN-00065-15	63	190	0.5	65	62.5	-9	-5	✓	1.06	GI044	C-DD154-2	AT002

GI044	DN.. 1506..

C-DD154-2	DCS 12	3.9 Nm	DDS 266-02	US 2002-T15P	FLAG T15P/3,5	CN 045-01

AT002a	DN.. 1504..	–	DDS 266-01
AT002b	CER DN.N 1506..	DCS 12C4	–
AT002c	CER DN.A 1506..	DCS 12C2	–
AT002d	CER DN.N 1504..	DCS 12C4	DDS 266-01
AT002e	CER DN.A 1504..	DCS 12C2	DDS 266-01

C.-DDUN(RL) EXT

P M K N S H

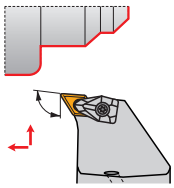
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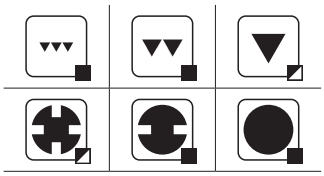
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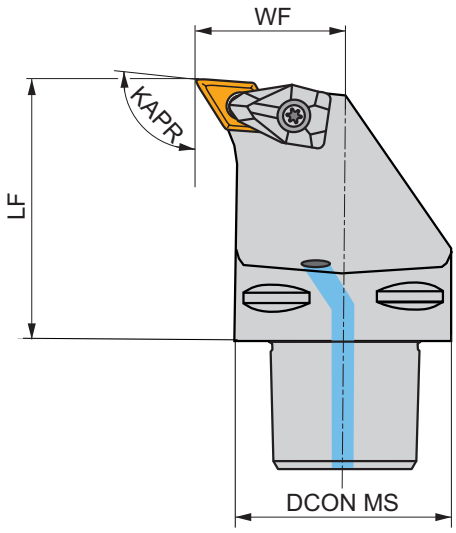


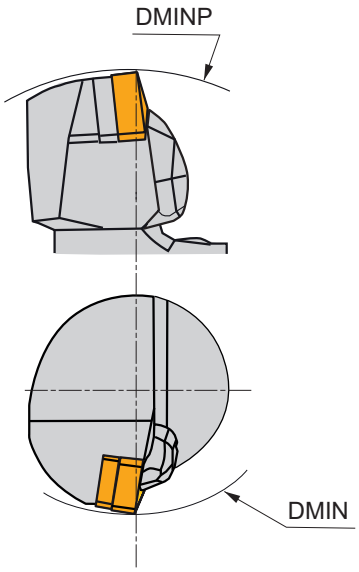
DN.. Uç için Çift Sıkmalı, 93° Açılı (Alın) Hızlı Değiştirme Dış Takımı

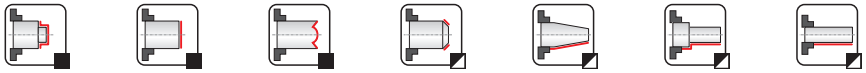
Çift sıkmalı, 93° açılı, içten su vermeli Sağ/Sol dış kater. Negatif DN.. 15 uçlarla çap, alın, konik ve pah tornalamak için uygundur. C4 - C6 şaftlı mevcuttur. Tutucu uzun takım ömrü için işlem görmüştür.











	Product	DCON MS (mm)	DMIN (mm)	DMINP (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg			
R	**C5-DDUNR-35060-15**	50	110	165	35	60	93	-7	-6	✓	0.82	GI044	C-DD154-3	AT002
	C6-DDUNR-45065-15	63	110	190	45	65	93	-7	-6	✓	1.39	GI044	C-DD154-3	AT002
L	**C5-DDUNL-35060-15**	50	110	165	35	60	93	-7	-6	✓	0.82	GI044	C-DD154-3	AT002

GI044	DN.. 1506..

C-DD154-3	DCS 12	3.9	DDS 266-02	US 2002-T15P	FLAG T15P/3,5	CN 034-02

AT002a	DN.. 1504..	–	DDS 266-01
AT002b	CER DN.N 1506..	DCS 12C4	–
AT002c	CER DN.A 1506..	DCS 12C2	–
AT002d	CER DN.N 1504..	DCS 12C4	DDS 266-01
AT002e	CER DN.A 1504..	DCS 12C2	DDS 266-01

DDUN(RL) INT

P M K N S H

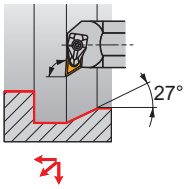
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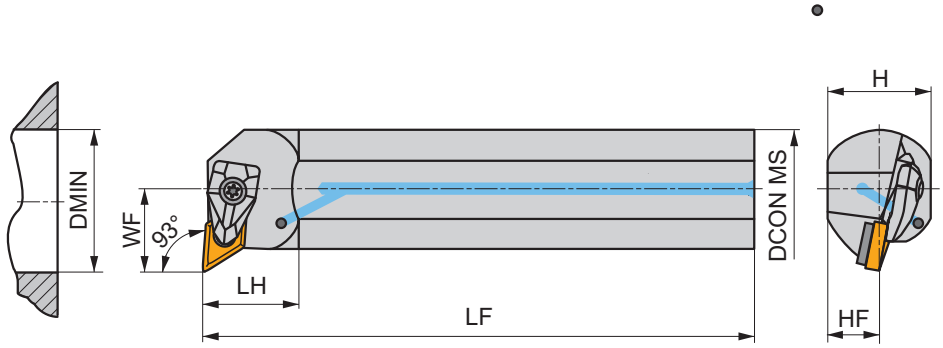
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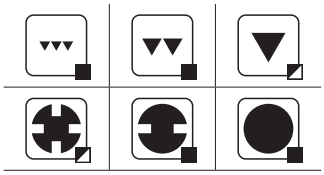


DN.. Uç için Çift Sıkmalı 93° Açılı Delik Kateri

Çift sıkmalı 93° Sağ/Sol içten su vermeli delik kateri. Negatif DN.. uçlarla , birçok uygulama ve 27°'ye kadar kopya tornalama için uygundur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	HF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)		kg			
R	**A25T-DDUNR 11**	25	32	17	23	11.5	300	28.0	-12	-6	✓	0.96	GI046	DD11	–
	A32T-DDUNR 11	32	40	22	30	15	300	30.0	-10	-6	✓	1.68	GI046	DD11	–
	A40T-DDUNR 15	40	50	27	37	18.5	300	36.0	-11	-6	✓	2.58	GI044	DD154	AT002
	A50U-DDUNR 15	50	63	35	47	23.5	350	39.0	-8	-6	✓	5.23	GI044	DD154	AT002
L	**A25T-DDUNL 11**	25	32	17	23	11.5	300	28.0	-12	-6	✓	0.96	GI046	DD11	–
	A32T-DDUNL 11	32	40	22	30	15	300	30.0	-10	-6	✓	1.69	GI046	DD11	–
	A40T-DDUNL 15	40	50	27	37	18.5	300	36.0	-11	-6	✓	2.59	GI044	DD154	AT002
	A50U-DDUNL 15	50	63	35	47	23.5	350	39.0	-8	-6	✓	5.25	GI044	DD154	AT002

GI044	DN.. 1506..
GI046	DN.. 1104..

		Nm			
DD11	DCS 09	1.7	DDS 267-01	US 2004-T09P	FLAG T09P
DD154	DCS 12	3.9	DDS 266-02	US 2002-T15P	FLAG T15P/3,5

AT002a	DN.. 1504..	–	DDS 266-01
AT002b	CER DN.N 1506..	DCS 12C4	–
AT002c	CER DN.A 1506..	DCS 12C2	–

PDUN(RL) INT

P M K N S H

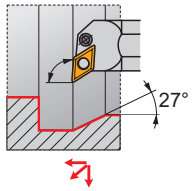
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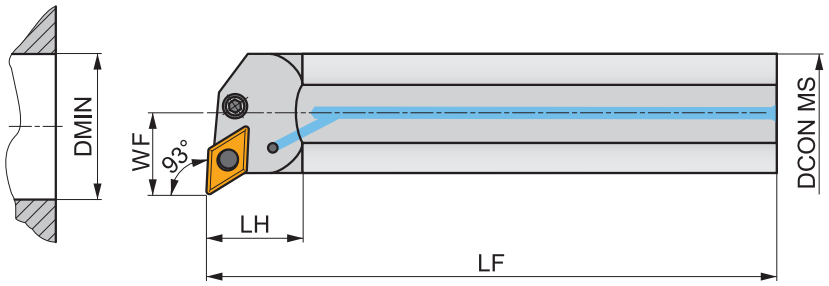
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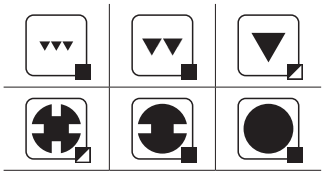


DN.. Uç için Levyeli 93° Açılı Delik Kateri

Levyeli 93° Sağ/Sol içten su vermeli delik kateri. Negatif DN.. uçlarla birçok uygulama ve 27°'ye kadar kopya tornalama için uygundur.Gövde uzun takım ömrü için işlem görmüştür.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)		kg		
R	**A25R-PDUNR 11**	25	31	17	23	–	200	-14	-5	✓	0.70	GI046	PD02
	A32S-PDUNR 11	32	39	22	30	–	250	-14	-5	✓	1.42	GI046	PD02
	A32S-PDUNR 15	32	39	22	30	–	250	-14	-4	✓	1.44	GI097	PD04
	A40T-PDUNR 15	40	48	27	37	–	300	-11	-6	✓	2.40	GI097	PD03
	A50U-PDUNR 15	50	61	35	47	–	350	-14	-4	✓	4.95	GI097	PD03
	A60V-PDUNR 15	60	80	43	57	–	400	-14	-4	✓	8.22	GI097	PD03
L	**A25R-PDUNL 11**	25	31	17	23	–	200	-14	-5	✓	0.70	GI046	PD02
	A32S-PDUNL 11	32	39	22	30	–	250	-14	-5	✓	1.42	GI046	PD02
	A32S-PDUNL 15	32	39	22	30	–	250	-14	-4	✓	1.44	GI097	PD04
	A40T-PDUNL 15	40	48	27	37	–	300	-11	-6	✓	2.56	GI097	PD03
	A60V-PDUNL 15	60	80	43	57	–	400	-14	-4	✓	8.16	GI097	PD03

GI044	DN.. 1506..
GI046	DN.. 1104..

				Nm							
PD02	PDS 711	CL 009	CS 606	2.0	M 6x1	16.7	TR 09	MT 04	HXK 2.5	–	–
PD03	PDS 715	CL 415	CS 638	3.0	M 8x1	21.1	TR 12	MT 05	HXK 3	PDS 725	TR 35
PD04	PDS 715	CL 415	CS 648	3.0	M 8x1	17	TR 12	MT 05	HXK 3	PDS 725	TR 35

C.-DDUN(RL) INT

P M K N S H

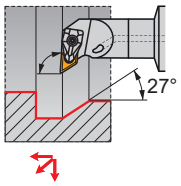
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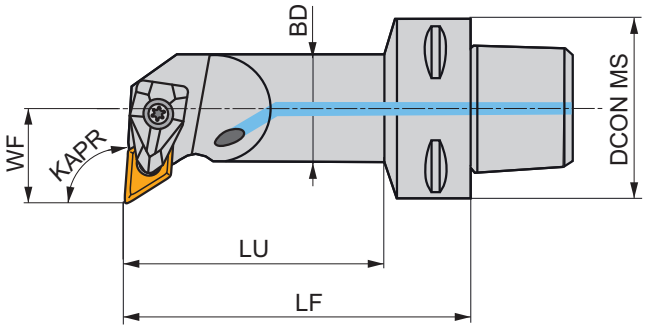
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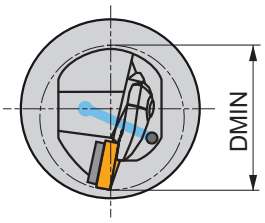


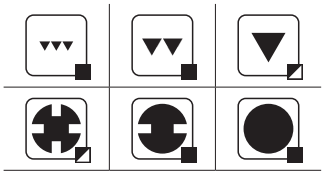
DN.. Uçlar için Çift Sıkmalı 93° Açılı PSC Hızlı Değiştirme Delik Takımı

Çift sıkmalı 93° Sağ/Sol içten su vermeli delik kateri. Negatif DN.. uçlarla ve 27°'ye kadar kopyalama dahil birçok çeşit tornalama için uygundur. Gövde uzun takım ömrü için işlem görmüştür.











	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	LF (mm)	LU (mm)	BD (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg		
R	C4-DDUNR-17090-11	40	32	17	90	68	25	93	-12	-6	✓	0.51	GI046	DD11
L	C4-DDUNL-17090-11	40	32	17	90	68	25	93	-12	-6	✓	0.51	GI046	DD11

GI046	DN.. 1104..

		Nm			
DD11	DCS 09	1.7	DDS 267-01	US 2004-T09P	FLAG T09P

CKJN(RL) EXT

P M K N S H

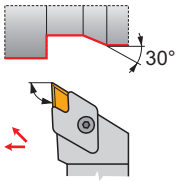
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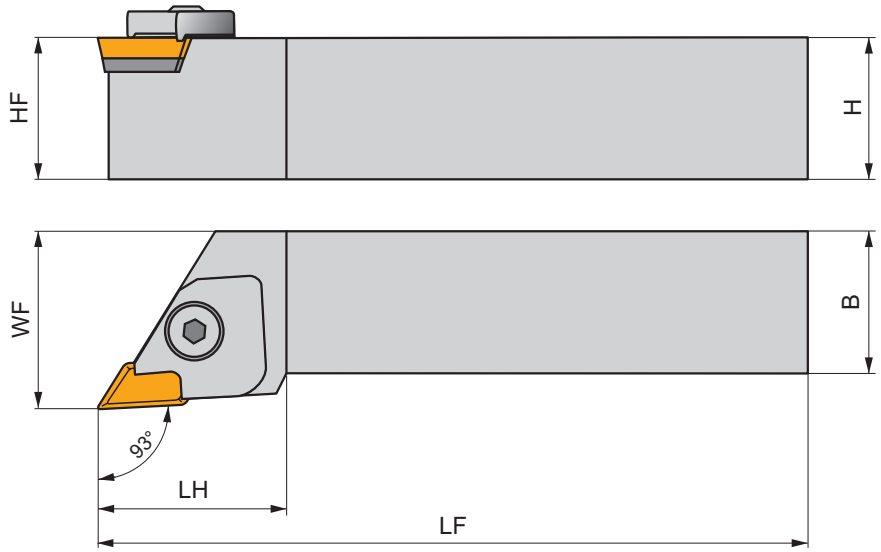
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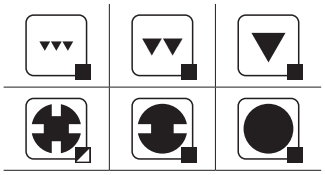


KN.. Uç için Üstten Pabuç Sıkmalı, 93° Açılı Dış Kater

Pabuç sıkmalı Sağ/Sol 93°dış kater. Negatif KN.. 16 uçlarla çap, 30°'ye kadar kopya, konik ve pah tornalama için uygundur. 20x20-32-25mm şaft ölçülerinde bulunur.









	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	**CKJNR 2020 K 16**	20	20	20	30	125	34.0	1	-5	0.40	GI066	R1
	CKJNR 2525 M 16	25	25	25	32	150	34.0	1	-5	0.70	GI066	R
	CKJNR 3225 P 16	32	25	32	32	170	34.0	1	-5	1.06	GI066	R
L	**CKJNL 2020 K 16**	20	20	20	30	125	34.0	1	-5	0.42	GI067	L1
	CKJNL 2525 M 16	25	25	25	32	150	34.0	1	-5	0.74	GI067	L
	CKJNL 3225 P 16	32	25	32	32	170	34.0	1	-5	1.06	GI067	L

GI066	KN.X 1604…R
GI067	KN.X 1604…L

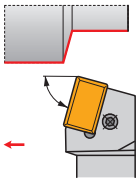
						Nm					
L	KNN 190412L	NT 03	–	UP 26	US 83	6.0	–	–	PR 07	K 23	HXK 4
L1	KNN 190412L	NT 03	–	UP 26	US 83	6.0	–	–	PR 07	K 22	HXK 4
R1	KNN 190412R	NT 03	UP 25	–	US 83	6.0	–	–	PR 07	K 22	HXK 4

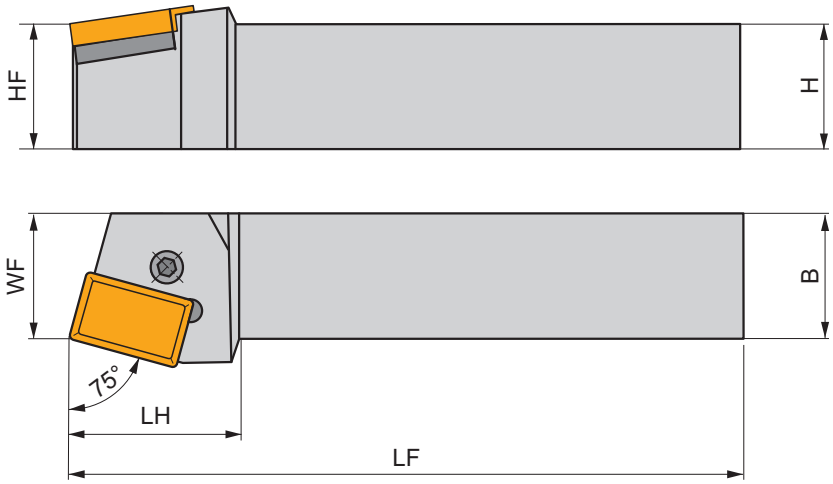
PLBN(RL) EXT

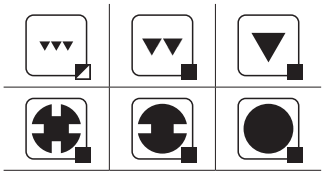


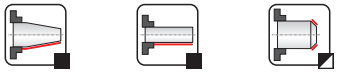
LNUX Uç için Levyeli 75° Açılı Ağır Tornalama Dış Kater

Levyeli, 75° açılı Sağ/Sol dış ağır tornalama kateri. Negatif LN.. 40ve 50 uçlarla çap, konik ve pah tornalamak için uygundur.60x60 kadar mevcuttur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	**PLBNR 6060 V 40-A**	60	60	60	60	400	64.0	-6	-6	13.00	GI102	PL71
	PLBNR 6060 V 50	60	60	60	60	400	70.0	-6	-6	12.75	GI145	PL72
	PLBNR 6060 V 50-2	60	60	60	60	400	70.0	-6	-6	11.60	GI291	PL73
L	**PLBNL 6060 V 40-A**	60	60	60	60	400	64.0	-6	-6	11.14	GI102	PL71
	PLBNL 6060 V 50	60	60	60	60	400	70.0	-6	-6	13.09	GI145	PL72

GI102	LNUX 40....
GI145	LNUX 50....
GI291	LNMX 50....

PL71	LNX 400632	PU 06	PS 12040	8.0	M 12x1	40	NT 08	MT 08	HXK 5	–	–
PL72	LNX 500632	PU 06	PS 12040	8.0	M 12x1	40	NT 08	MT 08	HXK 5	–	–
PL73	LNX 500432P	–	–	–	–	–	–	–	–	UP 1515A-T15P	SDRT15P

KHP-LBN(RL)

P M K

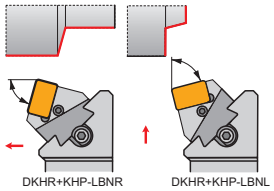
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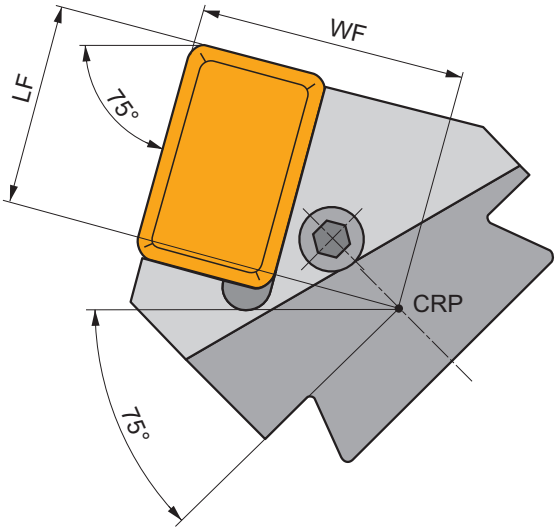
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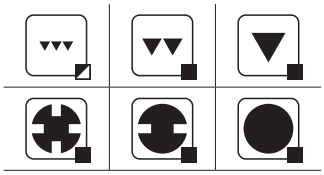


Modüler KHP Levyeli Torna Kartuşu, 75° Kesme Açılı, LNUX Uç için

DKH takım tutucu şaft için kırlangıç bağlantılı, 75° açılı Sağ/Sol levyeli kartuş. LNUX 40 uçlarla çap, alın, konik ve pah tornalamak için uygundur. Tutucu uzun takım ömrü için işlem görmüştür.







	Product	WF (mm)	LF (mm)	LAMS (°)	GAMO (°)	kg		
L	**KHP-LBNR 40-A**	48	36	-6	-6	1.50	GI102	PL71
	KHP-LBNL 40-A	48	36	-6	-6	1.47	GI102	PL71

GI102	LNUX 40....

PL71	LNX 400632	PU 06	PS 12040	8.0 Nm	M 12x1	40	NT 08	MT 08	HXK 5

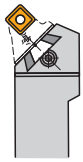
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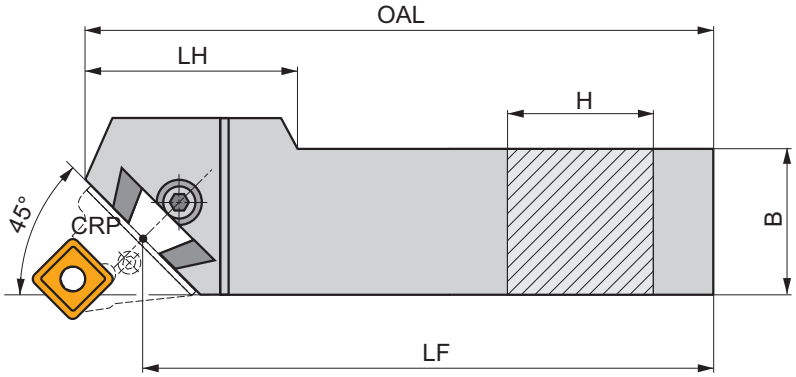
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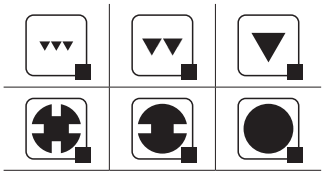


KHP/KHS Ağır Tornalama Kartuşları için Dış Kater Şaftı

KHP/KHS kartuşlar için kırlangıçlı Sağ/Sol takım şaftı. Ağır tornalama için uygundur. 40x50'den 60x80mm'ye kadar mevcut. Gövde uzun takım ömrü için işlem görmüştür.







	Product	H (mm)	B (mm)	LF (mm)	OAL (mm)	LH (mm)	kg		
R	**DKHR 4050 V**	40	50	400	425	100.0	7.10	GI098	DKH10
	DKHR 5060 W	50	60	450	475	110.0	11.30	GI098	DKH10
	DKHR 6080 W-A	60	80	450	485	90.0	19.65	GI098	DKH10
L	**DKHL 4050 V**	40	50	400	425	100.0	7.10	GI098	DKH10
	DKHL 5060 W	50	60	450	475	110.0	11.30	GI098	DKH10
	DKHL 6080 W-A	60	80	450	485	90.0	19.28	GI098	DKH10

GI098	KHP	KHS

DKH10	SR 14	HXK 10

DRSN(RL) EXT

P M K H

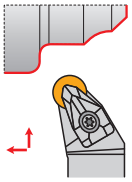
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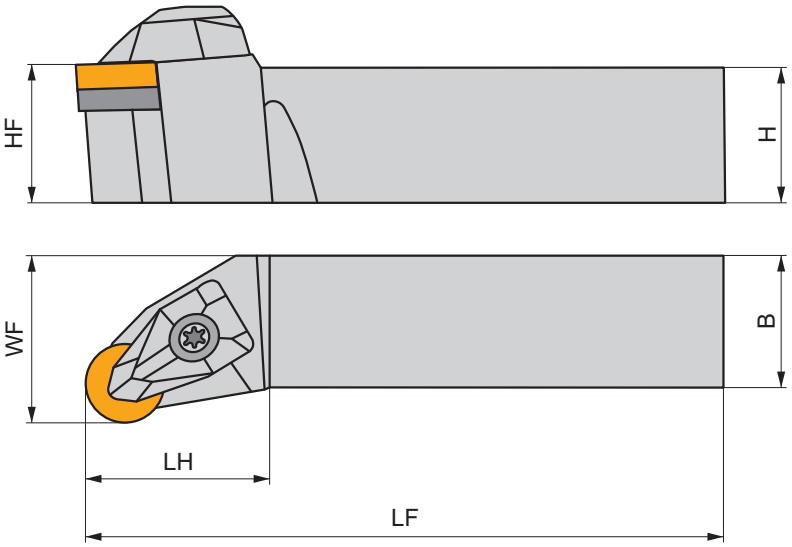
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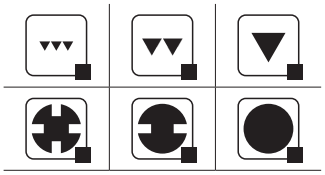


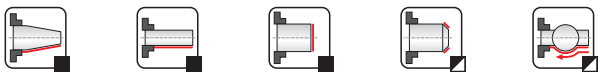
RN.. Uç için Çift Sıkmalı Dış Kateri

Çift sıkmalı Sağ/Sol dış kater. Negatif RN.. 12 uçlarla çap, kopya, konik ve pah tornalama için uygundur.Sadece 25x25mm. Gövde uzun takım ömrü için işlem görmüştür.









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	**DRSNR 2525 M 12**	25	25	25	32	150	31.6	-6	-6	0.74	GI083	DR12
L	**DRSNL 2525 M 12**	25	25	25	32	150	31.6	-6	-6	0.75	GI083	DR12

GI083	RN.. 120400

		Nm			
DR12	DCS 12	3.9	DRS 155-02	US 2002-T15P	FLAG T15P/3,5

PRSN(RL) EXT

P M K H

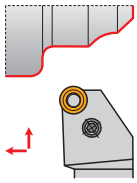
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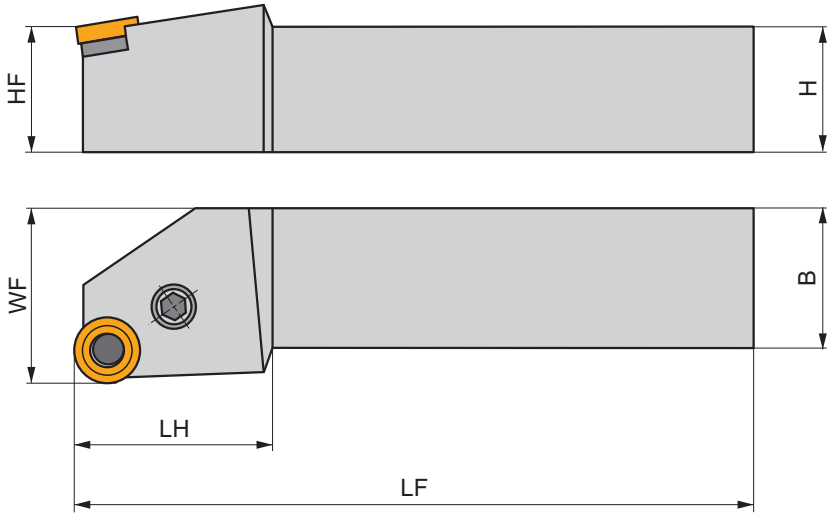
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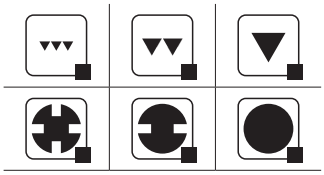


RN.. Uçları için Levyeli Kilit Tutucu

Levyeli, 90° açılı Sağ/Sol dış kater. Negatif RN.. 12, 15 ve 19 uçlarla çap, 90° kopya, konik ve pah tornalamak için uygundur. 25x25'den 40x40mm'ye kadar mevcuttur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	**PRSNR 2525 M 12**	25	25	25	32	150	28.0	-6	-6	0.68	GI083	PR05
	PRSNR 3225 P 15	32	25	32	32	170	34.0	-6	-6	1.00	GI105	PR06
	PRSNR 4040 S 19	40	40	40	50	250	45.0	-6	-6	2.49	GI106	PR07
L	**PRSNL 2525 M 12**	25	25	25	32	150	28.0	-6	-6	0.74	GI083	PR05
	PRSNL 3225 P 15	32	25	32	32	170	34.0	-6	-6	1.00	GI105	PR06
	PRSNL 4040 S 19	40	40	40	50	250	45.0	-6	-6	2.49	GI106	PR07

GI083	RN.. 120400
GI105	RN.. 150600
GI106	RN.. 190600

				Nm					
PR05	PRS 912	CL 012	CS 608	3.0	M 8x1	20.7	TR 12	MT 05	HXK 3
PR06	PRS 915	CL 015	CS 708	3.0	M 8x1	23.5	TR 15	MT 07	HXK 3
PR07	PRS 919	CL 019	CS 610	3.5	M 10x1	27.2	TR 19	MT 06	HXK 4

C.-DRSN(RL) EXT

P M K H

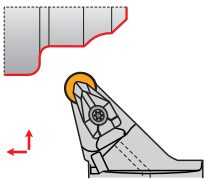
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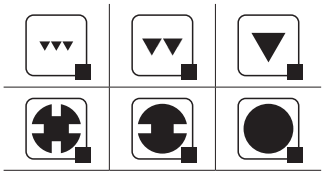
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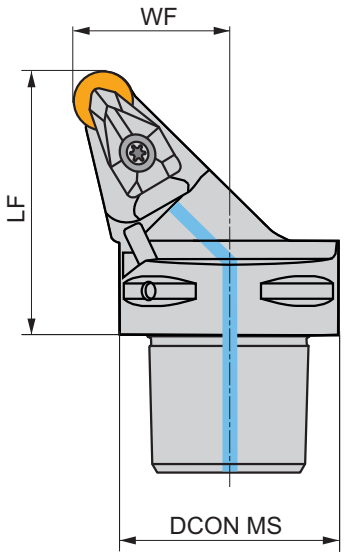


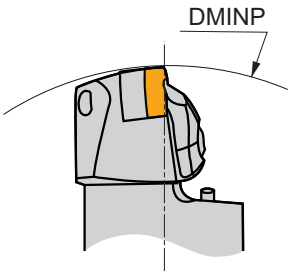
RN.. Uç için Çift Sıkmalı, Hızlı Değiştirme Dış Takımı

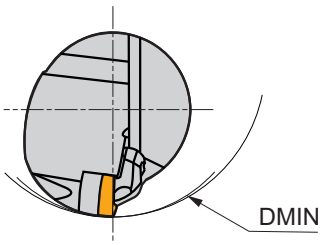
Çift sıkmalı, açılı, içten su vermeli Sağ/Sol dış kater. Negatif RN.. 12 uçlarla çap, alın, konik ve pah tornalamak için uygundur. C6 PSC şaftlı mevcuttur. Tutucu uzun takım ömrü için işlem görmüştür.













	Product	DCON MS (mm)	DMIN (mm)	DMINP (mm)	WF (mm)	LF (mm)	LAMS (°)	GAMO (°)		kg			
R	C6-DRSNR-45065-12	63	110	190	45	65	-6	-6	✓	1.11	GI083	C-DR12	–
L	C6-DRSNL-45065-12	63	110	190	45	65	-6	-6	✓	1.10	GI083	C-DR12	–

GI083	RN.. 120400

C-DR12	DCS 12	3.9 Nm	DRS 155-02	US 2002-T15P	FLAG T15P/3,5	CN 045-01

DSBN(RL) EXT

P M K N S H

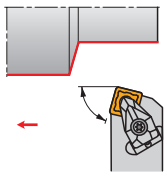
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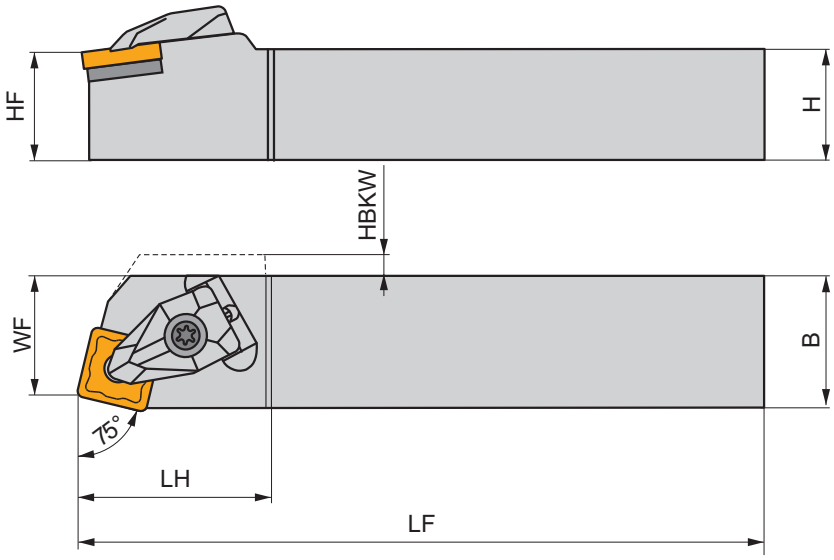
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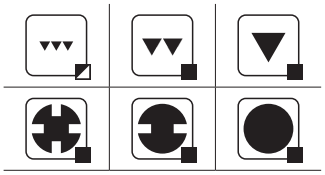


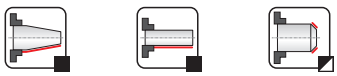
SN.. Uç için Çift Sıkmalı 75° Dış Kateri

Çift sıkmalı 75° Sağ/Sol dış kater. Negatif SN.. 12,15, veya 19 uçlarla çap, kopya, konik ve pah tornalama için uygundur. 20x20 - 40x40mm şaft ölçüleri. Gövde uzun takım ömrü için işlem görmüştür.









	Product	H	B	HF	WF	LF	LH	HBKW	LAMS	GAMO	kg			
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)				
R	**DSBNR 2525 M 12**	25	25	25	22	150	34.3	–	-6	-6	0.74	GI029	DS12	AT003
	DSBNR 2525 M 15	25	25	25	22	150	41.6	2	-6	-6	0.80	GI082	DS15	AT006
	DSBNR 3225 P 15	32	25	32	22	170	41.7	2	-6	-6	1.07	GI082	DS15	AT006
	DSBNR 3232 P 19	32	32	32	27	170	46.4	–	-6	-6	1.38	GI026	DS19	–
	DSBNR 4040 S 19	40	40	40	35	250	46.5	–	-6	-6	3.14	GI026	DS19	–
L	**DSBNL 2525 M 12**	25	25	25	22	150	34.3	–	-6	-6	0.74	GI029	DS12	AT003
	DSBNL 2525 M 15	25	25	25	22	150	41.6	2	-6	-6	0.80	GI082	DS15	AT006
	DSBNL 3225 P 15	32	25	32	22	170	41.7	2	-6	-6	1.12	GI082	DS15	AT006
	DSBNL 4040 S 19	40	40	40	35	250	46.5	–	-6	-6	3.18	GI026	DS19	–

GI029	SN.. 1204..
GI082	SN.. 1506..
GI026	SN.. 1906..

		Nm				
DS12	DCS 12	3.9	DSS 425-01	US 2002-T15P	FLAG T15P/3,5	–
DS15	DCS 16	6.4	DSS 425-03	US 2007-T20P	–	LK T20P
DS19	DCS 19	6.4	DSS 425-04	US 2007-T20P	–	LK T20P

AT003a	SN.. 1207..	–	DSS 425-02
AT006a	SN.. 1507..	–	DSS 425-05
AT003b	CER SN.N 1204..	DCS 12C4	–
AT003c	CER SN.A 1204..	DCS 12C2	–
AT006b	CER CN.N 1606..	DCS 16C4	–
AT006c	CER CN.A 1606..	DCS 16C2	–

DSDNN EXT

P M K N S H

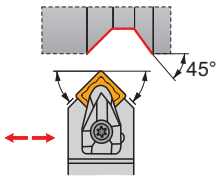
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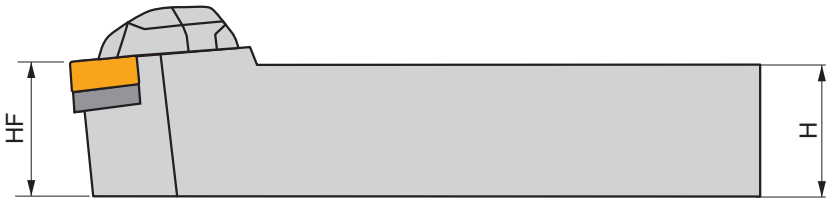
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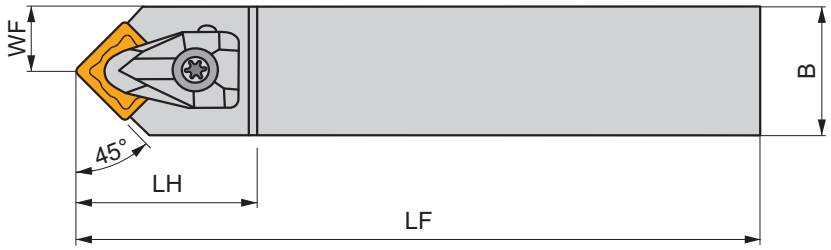


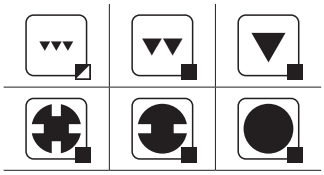
SN.. Uç için 45° Açılı Çift Sıkmalı Dış Kater

Çift sıkmalı, 45° açılı nötr dış kater. Negatif SN.. 12, 15, 19 veya 25 uçlarla çap, alın, konik ve pah tornalamak için uygundur. 25x25'ten 40x40'a kadar mevcuttur. Tutucu uzun takım ömrü için işlem görmüştür.











	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg			
N	**DSDNN 2525 M 12**	25	25	25	12.8	150	36.5	-6	-6	0.74	GI029	DS12	AT003
	DSDNN 2525 M 15	25	25	25	12.8	150	44.8	-6	-6	0.76	GI082	DS15	AT006
	DSDNN 3232 P 19	32	32	32	16.5	170	49.5	-6	-6	1.35	GI026	DS19	–
	DSDNN 4040 S 25	40	40	40	21	250	57.2	-6	-6	3.13	GI027	DS25	–

GI029	SN.. 1204..
GI082	SN.. 1506..
GI026	SN.. 1906..
GI027	SN.. 2507..

		Nm				
DS12	DCS 12	3.9	DSS 425-01	US 2002-T15P	FLAG T15P/3,5	–
DS15	DCS 16	6.4	DSS 425-03	US 2007-T20P	–	LK T20P
DS19	DCS 19	6.4	DSS 425-04	US 2007-T20P	–	LK T20P
DS25	DCS 25	9.5	DSS 425-07	US 2008-T25P	–	LK T25P

AT003a	SN.. 1207..	–	DSS 425-02
AT006a	SN.. 1507..	–	DSS 425-05
AT003b	CER SN.N 1204..	DCS 12C4	–
AT003c	CER SN.A 1204..	DCS 12C2	–
AT006b	CER CN.N 1606..	DCS 16C4	–
AT006c	CER CN.A 1606..	DCS 16C2	–

DSKN(RL) EXT

P M K N S H

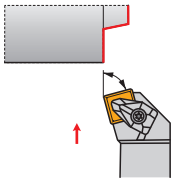
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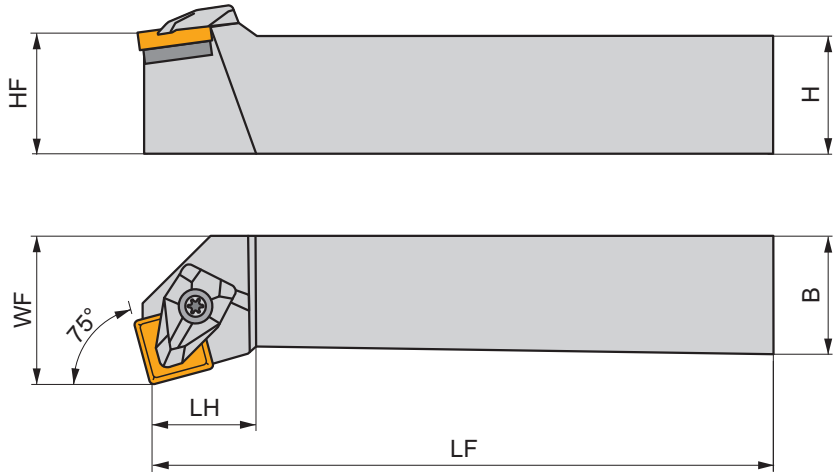
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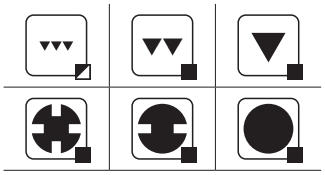


SN.. Uç için Çift Sıkmalı 75° (Alın) Dış Kateri

Çift sıkmalı 75° Sağ/Sol dış kater. Negatif SN.. 12,15, veya 19 uçlarla alın, ve pah tornalama için uygundur. 25x25 - 32x32mm şaft ölçüleri. Gövde uzun takım ömrü için işlem görmüştür.









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg			
R	**DSKNR 2525 M 12**	25	25	25	32	150	23.6	-6	-6	0.77	GI029	DS12	AT003
	DSKNR 3232 P 19	32	32	32	40	170	32.1	-6	-6	1.46	GI026	DS19	–
L	**DSKNL 2525 M 12**	25	25	25	32	150	23.6	-6	-6	0.79	GI029	DS12	AT003
	DSKNL 3232 P 19	32	32	32	40	170	32.1	-6	-6	1.46	GI026	DS19	–

GI029	SN.. 1204..
GI026	SN.. 1906..

		Nm				
DS12	DCS 12	3.9	DSS 425-01	US 2002-T15P	FLAG T15P/3,5	–
DS19	DCS 19	6.4	DSS 425-04	US 2007-T20P	–	LK T20P

AT003a	SN.. 1207..	–	DSS 425-02
AT003b	CER SN.N 1204..	DCS 12C4	–
AT003c	CER SN.A 1204..	DCS 12C2	–

DSSN(RL) EXT

P M K N S H

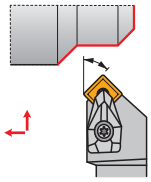
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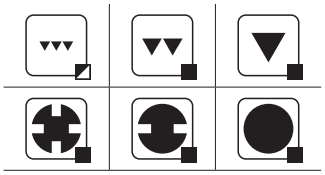
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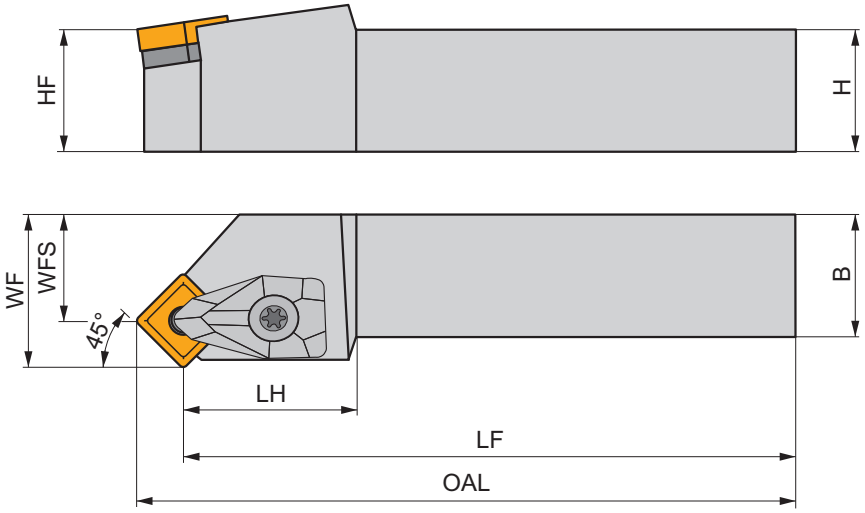


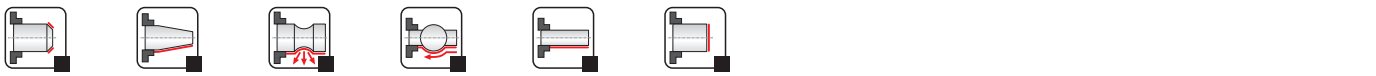
SN.. Uç için Çift Sıkmalı 45° Dış Kateri

Çift sıkmalı 45° Sağ/Sol dış kater. Negatif SN.. 12,15, veya 19 uçlarla çap, alın, kopya, konik ve pah tornalama için uygundur. 20x20 - 40x40mm şaft ölçüleri. Gövde uzun takım ömrü için işlem görmüştür.









	Product	H	B	HF	WF	WFS	LF	OAL	LH	LAMS	GAMO	kg			
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)				
R	**DSSNR 2020 K 12**	20	20	20	25	16.7	125	133.3	27.5	0	-8	0.45	GI029	DS12	AT003
	DSSNR 2525 M 12	25	25	25	32	23.7	150	158.3	27.5	0	-8	0.80	GI029	DS12	AT003
	DSSNR 2525 M 15	25	25	25	32	21.8	150	160.2	32.0	0	-8	0.83	GI082	DS15	AT006
	DSSNR 3225 P 15	32	25	32	32	21.8	170	180.2	34.9	0	-8	1.16	GI082	DS15	AT006
	DSSNR 3232 P 19	32	32	32	40	27.5	170	182.5	37.0	0	-8	1.48	GI026	DS19	–
L	**DSSNL 2525 M 12**	25	25	25	32	23.7	150	158.3	27.5	0	-8	0.19	GI029	DS12	AT003
	DSSNL 2525 M 15	25	25	25	32	21.8	150	160.2	32.0	0	-8	0.83	GI082	DS15	AT006
	DSSNL 3225 P 15	32	25	32	32	21.8	170	180.2	34.9	0	-8	1.16	GI082	DS15	AT006
	DSSNL 3232 P 19	32	32	32	40	27.5	170	182.5	37.0	0	-8	1.48	GI026	DS19	–
	DSSNL 4040 S 19	40	40	40	50	37.5	250	262.5	37.7	0	-8	3.27	GI026	DS19	–

GI029	SN.. 1204..
GI082	SN.. 1506..
GI026	SN.. 1906..

		Nm				
DS12	DCS 12	3.9	DSS 425-01	US 2002-T15P	FLAG T15P/3,5	–
DS15	DCS 16	6.4	DSS 425-03	US 2007-T20P	–	LK T20P
DS19	DCS 19	6.4	DSS 425-04	US 2007-T20P	–	LK T20P

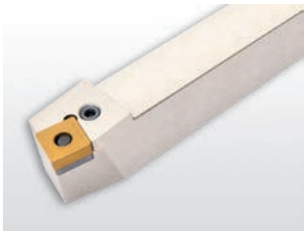
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AT006a	SN.. 1507..	–	DSS 425-05
AT003b	CER SN.N 1204..	DCS 12C4	–
AT003c	CER SN.A 1204..	DCS 12C2	–
AT006b	CER CN.N 1606..	DCS 16C4	–
AT006c	CER CN.A 1606..	DCS 16C2	–

PSBN(RL) EXT

P M K N S H

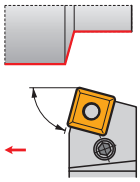
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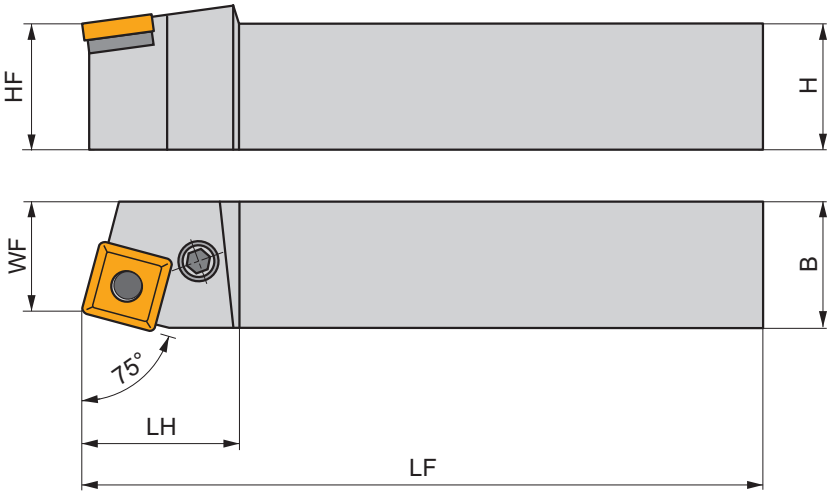
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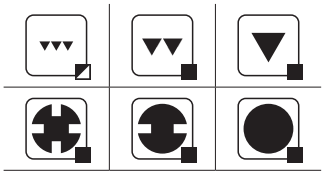


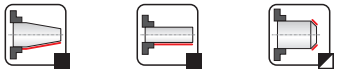
SN.. Uç için Levyeli 75° Açılı Dış Kater

Levyeli, 75° açılı Sağ/Sol dış kater. Negatif SN.. 12, 15, 19 veya 25 uçlarla çap, konik ve pah tornalamak için uygundur. 20x20'den 50x50'ye kadar mevcuttur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	PSBNR 2020 K 12	20	20	20	17	125	36.0	-6	-6	0.42	GI029	PS01
	PSBNR 2525 M 12	25	25	25	22	150	28.0	-6	-6	0.74	GI029	PS01
	PSBNR 3232 P 15	32	32	32	27	170	34.0	-6	-6	1.33	GI082	PS04
	PSBNR 3232 P 19	32	32	32	27	170	42.0	-6	-6	1.30	GI026	PS02
	PSBNR 4040 S 19	40	40	40	35	250	48.0	-6	-6	3.10	GI026	PS02
	PSBNR 4040 S 25	40	40	40	35	250	48.0	-6	-6	2.85	GI027	PS03
	PSBNR 4040 S 2509	40	40	40	35	250	48.0	-6	-6	2.50	GI040	PS03
	PSBNR 4040 S 2512	40	40	40	35	250	48.0	-6	-6	3.00	GI162	PS05
	PSBNR 5050 T 2512	50	50	50	43	300	50.0	-6	-6	5.78	GI162	PS05
	PSBNR 5050 T 25	50	50	50	43	300	50.0	-6	-6	5.76	GI027	PS03
	PSBNR 5050 T 2509	50	50	50	43	300	50.0	-6	-6	5.50	GI040	PS03
L	PSBNL 2020 K 12	20	20	20	17	125	28.0	-6	-6	0.40	GI029	PS01
	PSBNL 2525 M 12	25	25	25	22	150	28.0	-6	-6	0.73	GI029	PS01
	PSBNL 3232 P 15	32	32	32	27	170	34.0	-6	-6	1.33	GI082	PS04
	PSBNL 4040 S 2512	40	40	40	35	250	48.0	-6	-6	3.11	GI162	PS05
	PSBNL 5050 T 2512	50	50	50	43	300	50.0	-6	-6	5.76	GI162	PS05
	PSBNL 3232 P 19	32	32	32	27	170	42.0	-6	-6	1.33	GI026	PS02
	PSBNL 4040 S 19	40	40	40	35	250	48.0	-6	-6	3.09	GI026	PS02
	PSBNL 4040 S 25	40	40	40	35	250	48.0	-6	-6	3.06	GI027	PS03
	PSBNL 4040 S 2509	40	40	40	35	250	50.0	-6	-6	2.50	GI040	PS03
	PSBNL 5050 T 25	50	50	50	43	300	50.0	-6	-6	5.84	GI027	PS03
	PSBNL 5050 T 2509	50	50	50	43	300	50.0	-6	-6	5.80	GI040	PS03

GI029	SN.. 1204..
GI082	SN.. 1506..

GI026	SN.. 1906..
GI027	SN.. 2507..
GI040	SN.. 2509..
GI162	SN.. 2512..

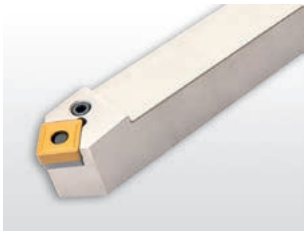
PS01	PSS 512	CL 012	CS 608	3.0	M 8x1	20.7	TR 12	MT 05	HXK 3
PS02	PSS 519	CL 019	CS 610	3.5	M 10x1	27.2	TR 19	MT 06	HXK 4
PS03	PSS 525	CL 025	CS 612	4.0	M 12x1	36	TR 25	MT 08	HXK 5
PS04	PSS 515	CL 016	CS 618	3.0	M 8x1	22.5	TR 15	MT 07	HXK 3
PS05	SNU 250624	PU 10-N	PS 12040	8.0	M 12x1	40	NT 08	MT 08	HXK 5

PSDNN EXT

P M K N S H

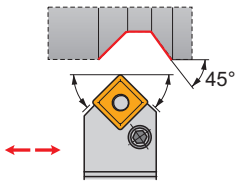
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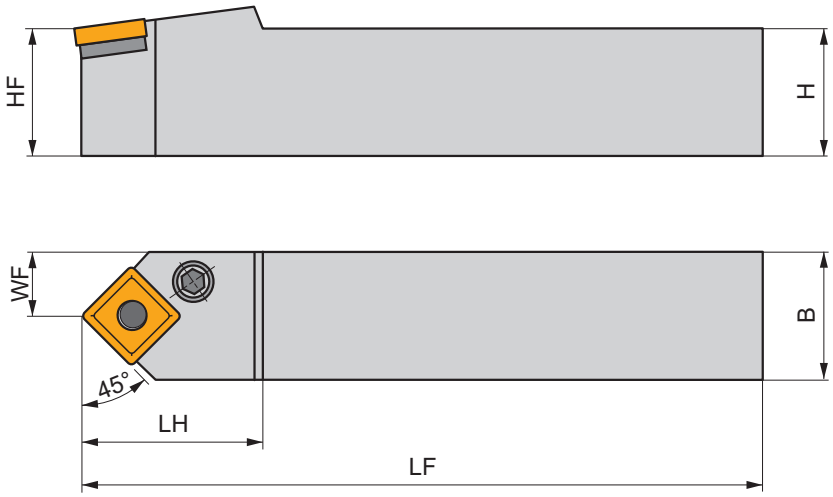
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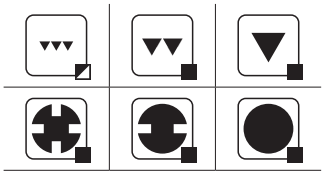


SN.. Uç için Levyeli 45° Açılı Dış Kater

Levyeli, 45° açılı nötr dış kater. Negatif SN.. 12, 15, 19 veya 25 uçlarla çap, alın, konik ve pah tornalamak için uygundur. 20x20'den 50x50'ye kadar mevcuttur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
N	**PSDNN 2020 K 12**	20	20	20	10	125	28.0	-5	-5	0.39	GI029	PS01
	PSDNN 2525 M 12	25	25	25	12.5	150	28.0	-5	-5	0.68	GI029	PS01
	PSDNN 3232 P 15	32	32	32	16	170	34.0	-5	-5	1.30	GI082	PS04
	PSDNN 3232 P 19	32	32	32	16	170	42.0	-5	-5	1.25	GI026	PS02
	PSDNN 4040 S 19	40	40	40	20	250	42.0	-5	-5	3.03	GI026	PS02
	PSDNN 4040 S 25	40	40	40	20	250	48.0	-5	-5	3.02	GI027	PS03
	PSDNN 5050 T 25	50	50	50	25	300	50.0	-5	-5	5.65	GI027	PS03

GI029	SN.. 1204..
GI082	SN.. 1506..
GI026	SN.. 1906..
GI027	SN.. 2507..

				Nm					
PS01	PSS 512	CL 012	CS 608	3.0	M 8x1	20.7	TR 12	MT 05	HXK 3
PS02	PSS 519	CL 019	CS 610	3.5	M 10x1	27.2	TR 19	MT 06	HXK 4
PS03	PSS 525	CL 025	CS 612	4.0	M 12x1	36	TR 25	MT 08	HXK 5
PS04	PSS 515	CL 016	CS 618	3.0	M 8x1	22.5	TR 15	MT 07	HXK 3

PSKN(RL) EXT

P M K N S H

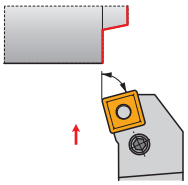
PRAMET

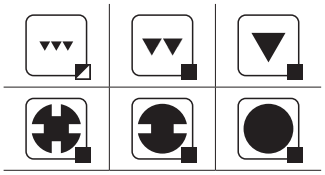
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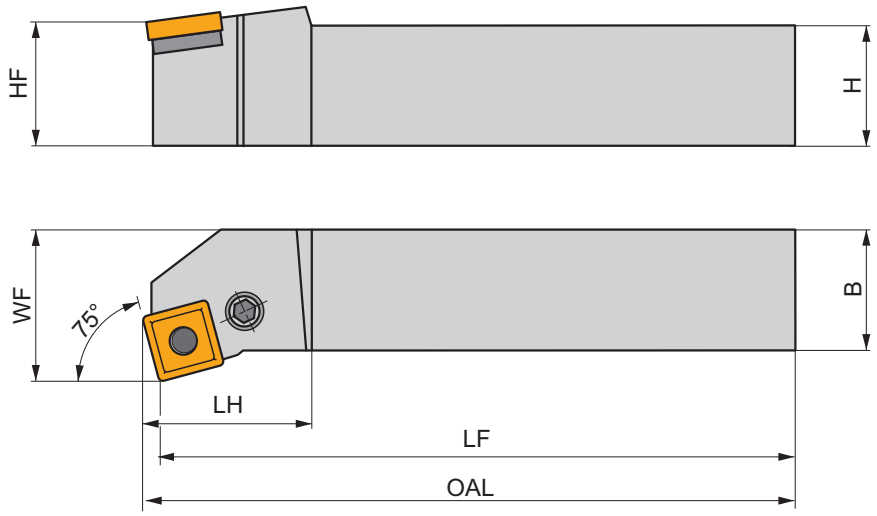


SN.. Uç için Levyeli 75° Açılı (Alın) Dış Kater

Levyeli, 75° açılı Sağ/Sol dış kater. Negatif SN.. 12, 15, 19 veya 25 uçlarla alın ve pah tornalamak için uygundur. 20x20'den 50x50'ye kadar mevcuttur. Gövde uzun takım ömrü için işlem görmüştür.











	Product	H	B	HF	WF	LF	OAL	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	PSKNR 2020 K 12	20	20	20	25	125	128.1	28.0	-6	-6	0.42	GI029	PS01
	PSKNR 2525 M 12	25	25	25	32	150	153.1	28.0	-6	-6	0.76	GI029	PS01
	PSKNR 3232 P 19	32	32	32	40	170	174.6	45.0	-6	-6	1.40	GI026	PS02
	PSKNR 4040 S 19	40	40	40	50	250	254.6	45.0	-6	-6	3.23	GI026	PS02
	PSKNR 4040 S 25	40	40	40	50	250	256.5	50.0	-6	-6	3.28	GI027	PS03
	PSKNR 3232 P 15	32	32	32	40	170	173.9	42.0	-6	-6	1.40	GI082	PS04
	PSKNR 5050 T 25	50	50	50	60	300	306.5	50.0	-6	-6	6.05	GI027	PS03
	PSKNR 5050 T 2509	50	50	50	60	300	306.5	50.0	-6	-6	6.20	GI040	PS03
L	PSKNL 2020 K 12	20	20	20	25	125	128.1	28.0	-6	-6	0.42	GI029	PS01
	PSKNL 2525 M 12	25	25	25	32	150	153.1	28.0	-6	-6	0.79	GI029	PS01
	PSKNL 3232 P 15	32	32	32	40	170	173.9	42.0	-6	-6	1.05	GI082	PS04
	PSKNL 3232 P 19	32	32	32	40	170	174.6	42.0	-6	-6	1.41	GI026	PS02
	PSKNL 4040 S 19	40	40	40	50	250	254.6	45.0	-6	-6	3.26	GI026	PS02
	PSKNL 4040 S 25	40	40	40	50	250	256.5	50.0	-6	-6	3.28	GI027	PS03
	PSKNL 5050 T 25	50	50	50	60	300	306.5	50.0	-6	-6	6.00	GI027	PS03
	PSKNL 5050 T 2509	50	50	50	60	300	306.5	50.0	-6	-6	6.20	GI040	PS03

GI029	SN.. 1204..
GI082	SN.. 1506..
GI026	SN.. 1906..
GI027	SN.. 2507..
GI040	SN.. 2509..

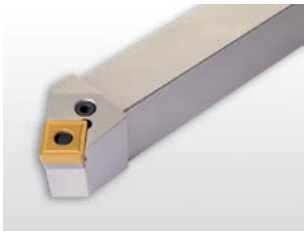
									
PS01	PSS 512	CL 012	CS 608	3.0	M 8x1	20.7	TR 12	MT 05	HXK 3
PS02	PSS 519	CL 019	CS 610	3.5	M 10x1	27.2	TR 19	MT 06	HXK 4
PS03	PSS 525	CL 025	CS 612	4.0	M 12x1	36	TR 25	MT 08	HXK 5
PS04	PSS 515	CL 016	CS 618	3.0	M 8x1	22.5	TR 15	MT 07	HXK 3

PSSN(RL) EXT

P M K N S H

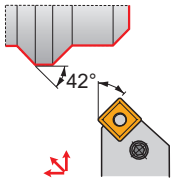
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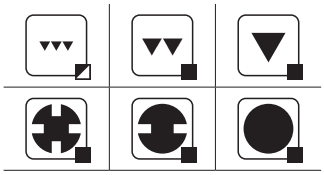
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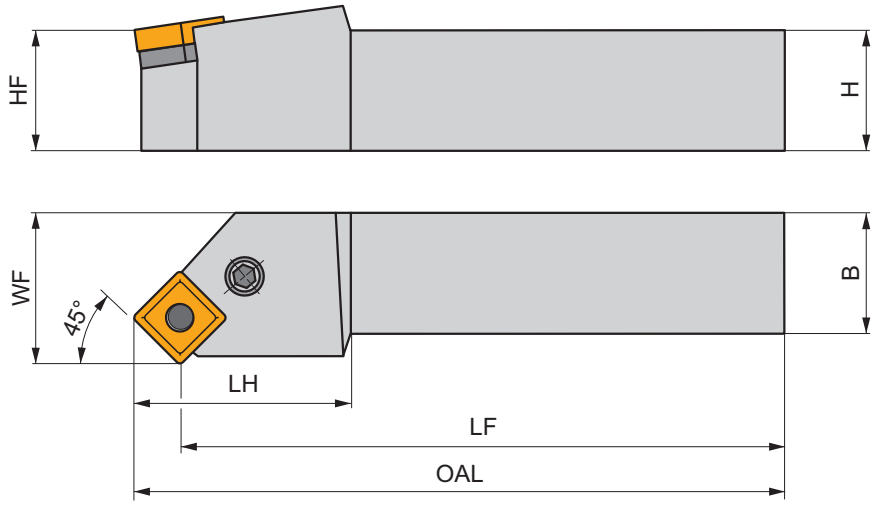


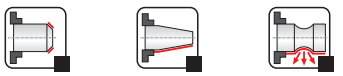
SN.. Uç için Levyeli 45° Açılı Dış Kater

Levyeli, 45° açılı Sağ/Sol dış kater. Negatif SN.. 12, 15, 19 veya 25 uçlarla çap, kopya, konik ve pah tornalamak için uygundur. 20x20'den 50x50'ye kadar mevcuttur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	H	B	HF	WF	LF	OAL	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	PSSNR 2020 K 12	20	20	20	25	125	133.3	28.0	0	-8	0.42	GI029	PS01
	PSSNR 2525 M 12	25	25	25	32	150	158.3	28.0	0	-8	0.75	GI029	PS01
	PSSNR 3225 P 15	32	25	32	32	170	180.2	42.0	0	-8	1.11	GI082	PS04
	PSSNR 3232 P 19	32	32	32	40	170	182.5	45.0	0	-8	1.42	GI026	PS02
	PSSNR 5050 T 25	50	50	50	60	300	316	50.0	0	-8	6.00	GI027	PS03
	PSSNR 4040 S 19	40	40	40	50	250	262.5	45.0	0	-8	3.18	GI026	PS02
	PSSNR 5050 T 2509	50	50	50	60	300	316	50.0	0	-8	6.05	GI040	PS03
L	PSSNL 2020 K 12	20	20	20	25	125	133.3	28.0	0	-8	0.41	GI029	PS01
	PSSNL 2525 M 12	25	25	25	32	150	158.3	28.0	0	-8	0.76	GI029	PS01
	PSSNL 3225 P 15	32	25	32	32	170	180.2	42.0	0	-8	1.13	GI082	PS04
	PSSNL 3232 P 19	32	32	32	40	170	182.5	45.0	0	-8	1.43	GI026	PS02
	PSSNL 4040 S 19	40	40	40	50	250	262.5	45.0	0	-8	3.16	GI026	PS02
	PSSNL 5050 T 25	50	50	50	60	300	316	50.0	0	-8	6.00	GI027	PS03
	PSSNL 5050 T 2509	50	50	50	60	300	316	50.0	0	-8	5.98	GI040	PS03

GI029	SN.. 1204..
GI082	SN.. 1506..
GI026	SN.. 1906..
GI027	SN.. 2507..
GI040	SN.. 2509..

				Nm					
PS01	PSS 512	CL 012	CS 608	3.0	M 8x1	20.7	TR 12	MT 05	HXK 3
PS02	PSS 519	CL 019	CS 610	3.5	M 10x1	27.2	TR 19	MT 06	HXK 4
PS03	PSS 525	CL 025	CS 612	4.0	M 12x1	36	TR 25	MT 08	HXK 5
PS04	PSS 515	CL 016	CS 618	3.0	M 8x1	22.5	TR 15	MT 07	HXK 3

C.-DSDNN EXT

P M K N S H

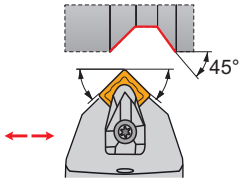
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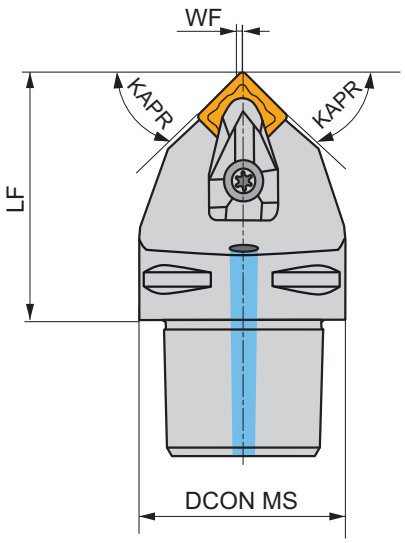
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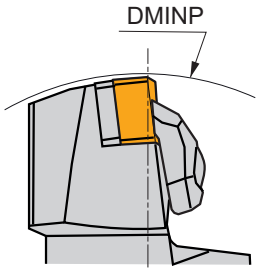


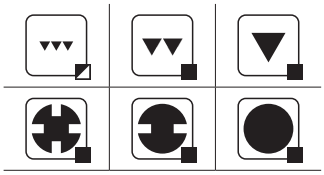
SN.. Uç için 45° Açılı PSC Hızlı Değiştirmeli Dış Kater

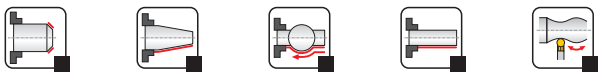
Çift sıkmalı, 45° açılı, içten su vermeli nötr dış kater. Negatif SN.. 12 veya 19 uçlarla çap, alın, konik ve pah tornalamak için uygundur. C4'ten C6'ya kadar PSC şaftlı mevcuttur. Tutucu uzun takım ömrü için işlem görmüştür.











	Product	DCON MS (mm)	DMINP (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg			
N	**C4-DSDNN-00050-12**	40	140	0.3	50	45	-6	-6	✓	0.39	GI029	C-DS12-2	AT003
	C5-DSDNN-00060-12	50	165	0.3	60	45	-6	-6	✓	0.69	GI029	C-DS12-2	AT003
	C6-DSDNN-00070-19	63	195	0.5	70	45	-6	-6	✓	1.28	GI026	C-DS19	–

GI029	SN.. 1204..
GI026	SN.. 1906..

		Nm					
C-DS12-2	DCS 12	3.9	DSS 425-01	US 2002-T15P	FLAG T15P/3,5	–	CN 045-01
C-DS19	DCS 19	6.4	DSS 425-04	US 2007-T20P	–	LK T20P	CN 045-01

AT003a	SN.. 1207..	–	DSS 425-02
AT003b	CER SN.N 1204..	DCS 12C4	–
AT003c	CER SN.A 1204..	DCS 12C2	–

C.-DSKN(RL) EXT

P M K N S H

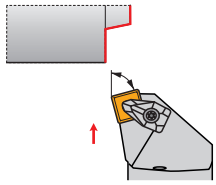
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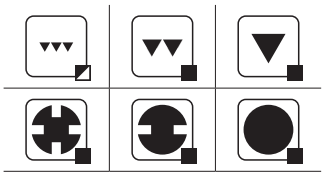
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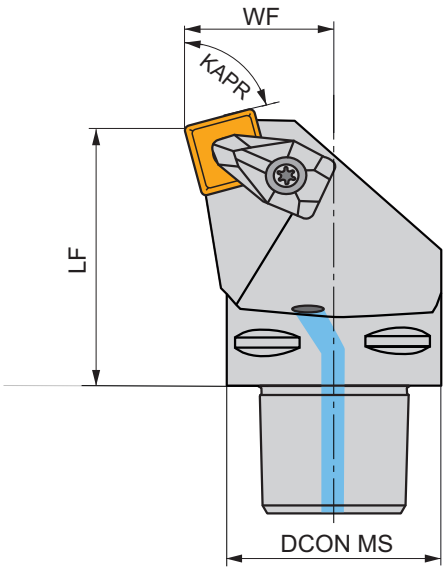


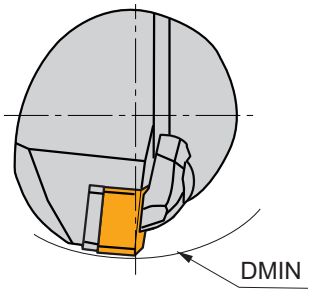
SN.. Uç için Çift Sıkmalı, 75° Açılı (Alın) Hızlı Değiştirme Dış Takımı

Çift sıkmalı, 75° açılı, içten su vermeli Sağ/Sol dış kater. Negatif SN.. 12 uçlarla alın ve pah tornalamak için uygundur. C4 şaftlı mevcuttur. Tutucu uzun takım ömrü için işlem görmüştür.











	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg			
R	C4-DSKNR-27050-12	40	110	27	50	75	-6	-6	✓	0.46	GI029	C-DS12-1	AT003
L	C4-DSKNL-27050-12	40	110	27	50	75	-6	-6	✓	0.46	GI029	C-DS12-1	AT003

GI029	SN.. 1204..

C-DS12-1	DCS 12	3.9	DSS 425-01	US 2002-T15P	FLAG T15P/3,5	CN 034-01

AT003a	SN.. 1207..	–	DSS 425-02
AT003b	CER SN.N 1204..	DCS 12C4	–
AT003c	CER SN.A 1204..	DCS 12C2	–

C.-DSRN(RL) EXT

P M K N S H

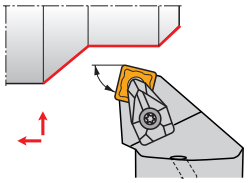
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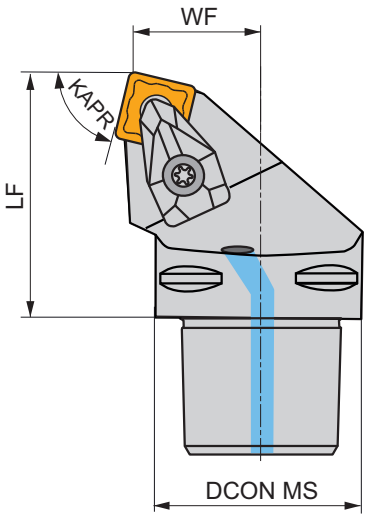
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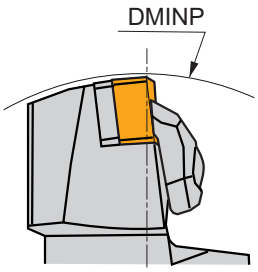


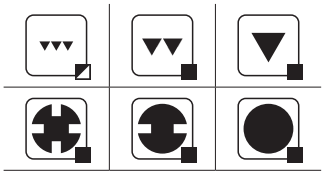
SN.. Uç için Çift Sıkmalı, 75° Açılı Hızlı Değiştirme Dış Takımı

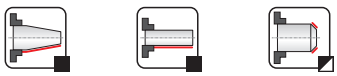
Çift sıkmalı, 75° açılı, içten su vermeli Sağ/Sol dış kater. Negatif SN.. 12 veya 19 uçlarla çap, alın, konik ve pah tornalamak için uygundur. C4 - C6 şaftlı mevcuttur. Tutucu uzun takım ömrü için işlem görmüştür.











	Product	DCON MS (mm)	DMINP (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg			
R	C4-DSRNR-22050-12	40	140	22	50	75	-6	-6	✓	0.40	GI029	C-DS12-1	AT003
	C6-DSRNR-35065-19	63	190	35	65	75	-6	-6	✓	1.30	GI026	C-DS19	–
L	C4-DSRNL-22050-12	40	140	22	50	75	-6	-6	✓	0.41	GI029	C-DS12-1	AT003
	C6-DSRNL-35065-19	63	190	35	65	75	-6	-6	✓	1.30	GI026	C-DS19	–

GI029	SN.. 1204..
GI026	SN.. 1906..

		Nm					
C-DS12-1	DCS 12	3.9	DSS 425-01	US 2002-T15P	FLAG T15P/3,5	–	CN 034-01
C-DS19	DCS 19	6.4	DSS 425-04	US 2007-T20P	–	LK T20P	CN 045-01

AT003a	SN.. 1207..	–	DSS 425-02
AT003b	CER SN.N 1204..	DCS 12C4	–
AT003c	CER SN.A 1204..	DCS 12C2	–

C.-DSSN(RL) EXT

P M K N S H

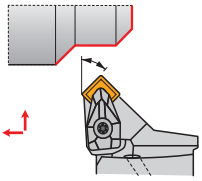
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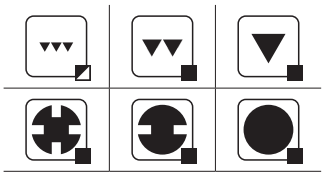
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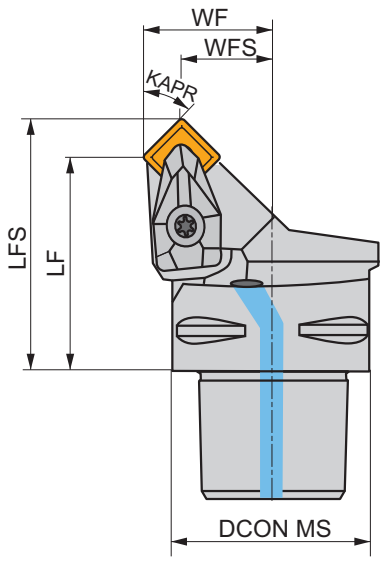


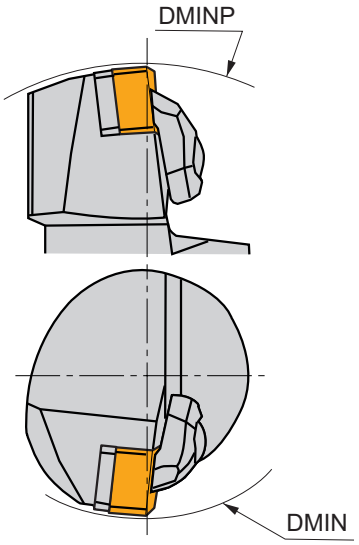
SN.. Uç için Çift Sıkmalı, 45° Açılı Hızlı Değiştirme Dış Takımı

Çift sıkmalı, 45° açılı, içten su vermeli Sağ/Sol dış kater. Negatif SN.. 12 uçlarla çap, alın, konik ve pah tornalamak için uygundur. C4 ve C5 PSC şaftlı mevcuttur. Tutucu uzun takım ömrü için işlem görmüştür.
















	Product	DCON MS (mm)	DMIN (mm)	DMINP (mm)	WF (mm)	WFS (mm)	LF (mm)	LFS (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg			
R	C4-DSSNR-27042-12	40	110	140	27	18.7	42	50.3	45	0	-8	✓	0.38	GI029	C-DS12-1	AT003
	C5-DSSNR-35052-12	50	110	165	35	26.7	52	60.3	45	0	-8	✓	0.68	GI029	C-DS12-3	AT003
L	C4-DSSNL-27042-12	40	110	140	27	18.7	42	50.3	45	0	-8	✓	0.36	GI029	C-DS12-1	AT003
	C5-DSSNL-35052-12	50	110	165	35	26.7	52	60.3	45	0	-8	✓	0.69	GI029	C-DS12-3	AT003

GI029	SN.. 1204..

		Nm				
C-DS12-1	DCS 12	3.9	DSS 425-01	US 2002-T15P	FLAG T15P/3,5	CN 034-01
C-DS12-3	DCS 12	3.9	DSS 425-01	US 2002-T15P	FLAG T15P/3,5	CN 034-02

AT003a	SN.. 1207..	–	DSS 425-02
AT003b	CER SN.N 1204..	DCS 12C4	–
AT003c	CER SN.A 1204..	DCS 12C2	–

KHP-SBN(RL)

P M K

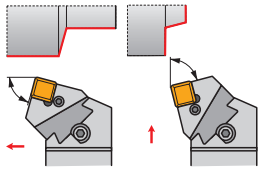
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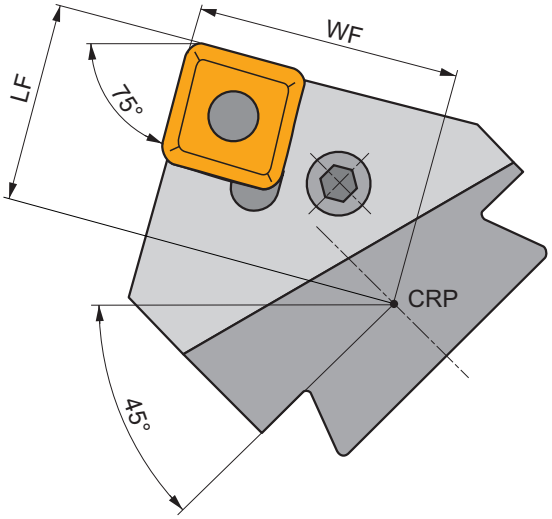
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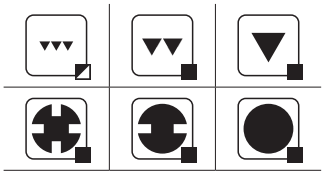


Modüler KHP Levyeli Torna Kartuşu, 75° Kesme Açılı, SN.. Uç için

DKH takım tutucu şaft için kırlangıç bağlantılı, 75° açılı Sağ/Sol levyeli kartuş. Negatif SN.. 19 veya 25 uçlarla çap, alın, konik ve pah tornalamak için uygundur. Tutucu uzun takım ömrü için işlem görmüştür.









	Product	WF (mm)	LF (mm)	LAMS (°)	GAMO (°)	kg		
R	**KHP-SBNR 19**	47	36	-6	-6	1.51	GI026	PS50
	KHP-SBNR 25	47	36	-6	-6	1.47	GI027	PS60
	KHP-SBNR 2509	47	36	-6	-6	1.45	GI040	PS70
L	**KHP-SBNL 19**	47	36	-6	-6	1.92	GI026	PS50
	KHP-SBNL 25	47	36	-6	-6	1.48	GI027	PS60
	KHP-SBNL 2509	47	36	-6	-6	1.46	GI040	PS70

GI026	SN.. 1906..
GI027	SN.. 2507..
GI040	SN.. 2509..

				Nm					
PS50	SNU 190416	PU 05	US 38	8.0	M 10x1	29	NT 06	MT 06	HXK 5
PS60	SNU 250624	PU 06	US 39	8.0	M 10x1	33	NT 08	MT 08	HXK 5
PS70	SNU 250624	PU 06	US 47	8.0	M 12x1	36	NT 08	MT 08	HXK 5

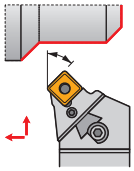
KHP-SSN(RL)

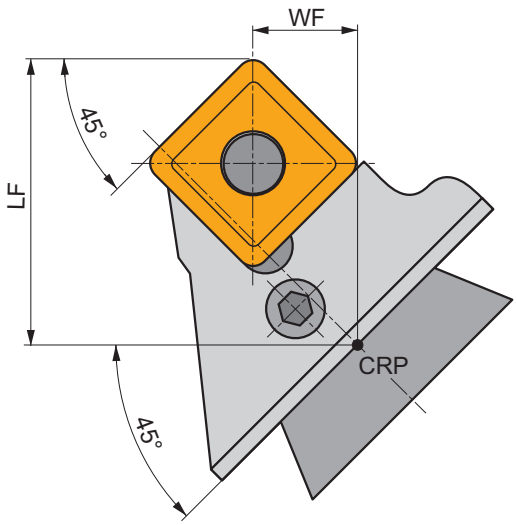
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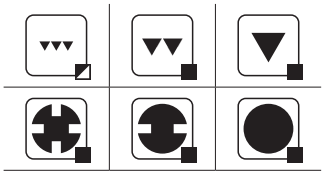
Modüler KHP Levyeli Torna Kartuşu, 45° Kesme Açılı, SN.. Uç için

DKH takım tutucu şaft için kırlangıç bağlantılı, 45° açılı Sağ/Sol levyeli kartuş. Negatif SN.. 19 veya 25 uçlarla çap, alın, konik ve pah tornalamak için uygundur. Tutucu uzun takım ömrü için işlem görmüştür.









	Product	WF (mm)	LF (mm)	LAMS (°)	GAMO (°)	kg		
R	KHP-SSNR 25	15	45	-6	-6	0.98	GI027	PS60
L	KHP-SSNL 25	15	45	-6	-6	1.30	GI027	PS60

GI027	SN.. 2507..

PS60	SNU 250624	PU 06	US 39	8.0 Nm	M 10x1	33	NT 08	MT 08	HXK 5

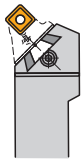
DKH(RL)

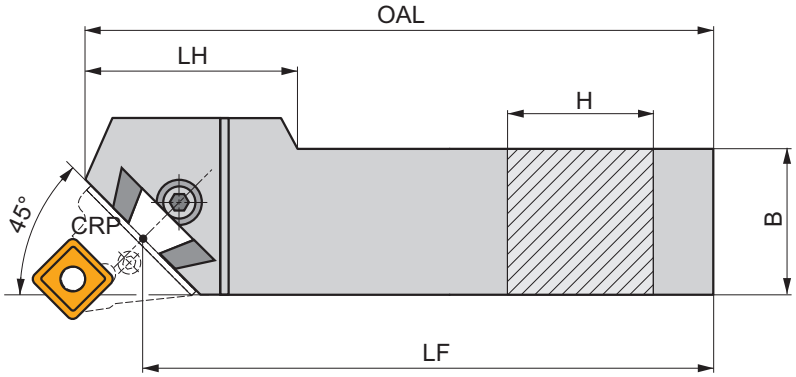
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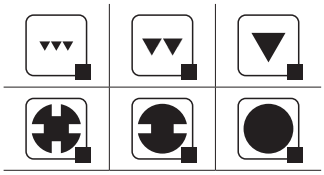


KHP/KHS Ağır Tornalama Kartuşları için Dış Kater Şaftı

KHP/KHS kartuşlar için kırlangıçlı Sağ/Sol takım şaftı. Ağır tornalama için uygundur. 40x50'den 60x80mm'ye kadar mevcut. Gövde uzun takım ömrü için işlem görmüştür.







	Product	H (mm)	B (mm)	LF (mm)	OAL (mm)	LH (mm)	kg		
R	**DKHR 4050 V**	40	50	400	425	100.0	7.10	GI098	DKH10
	DKHR 5060 W	50	60	450	475	110.0	11.30	GI098	DKH10
	DKHR 6080 W-A	60	80	450	485	90.0	19.65	GI098	DKH10
L	**DKHL 4050 V**	40	50	400	425	100.0	7.10	GI098	DKH10
	DKHL 5060 W	50	60	450	475	110.0	11.30	GI098	DKH10
	DKHL 6080 W-A	60	80	450	485	90.0	19.28	GI098	DKH10

GI098	KHP	KHS

DKH10	SR 14	HXK 10

PSKN(RL) INT

P M K N S H

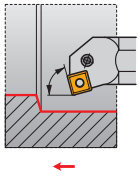
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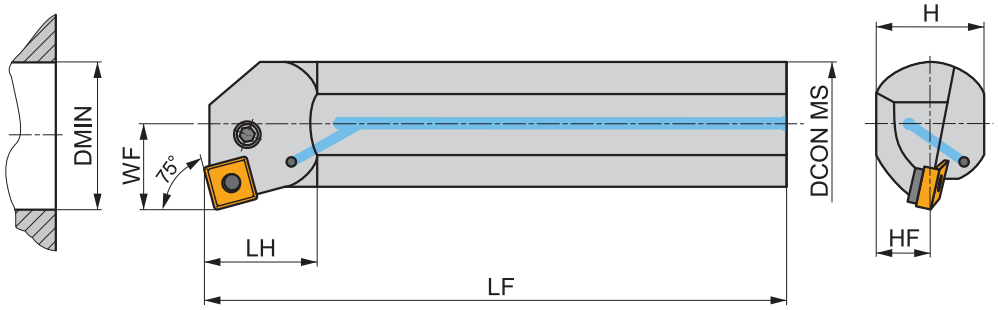
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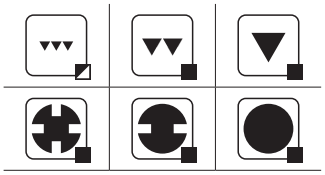


SN.. Uçlar için 75° Kesme Açılı İçten Kollu Kilitli Delik Barası

Levyeli 75° Sağ/Sol içten su vermeli delik kateri. Negatif SN..uçlarla kenar ve pah tornalama ile iç konik ve çap tornalama için uygundur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)		kg		
R	A32S-PSKNR 12	32	39	22	30	–	250	-10	-6	✓	1.45	GI029	PS06
	A40T-PSKNR 15	40	48	27	37	–	300	-11	-6	✓	2.90	GI082	PS04
	A50U-PSKNR 15	50	61	35	47	–	350	-11	-6	✓	5.20	GI082	PS04
	A50U-PSKNR 19	50	63	35	47	48.5	350	-12	-6	✓	5.20	GI026	PS07
L	A50U-PSKNL 15	50	61	35	47	–	350	-11	-6	✓	5.20	GI082	PS04

GI029	SN.. 1204..
GI082	SN.. 1506..
GI026	SN.. 1906..

				Nm					
PS04	PSS 515	CL 016	CS 618	3.0	M 8x1	22.5	TR 15	MT 07	HXK 3
PS06	PSS 512	CL 312	CS 648	3.0	M 8x1	17	TR 12	MT 05	HXK 3
PS07	PSS 519	CL 219	CS 710	3.5	M 10x1	30.4	TR 29	MT 06	HXK 4

DTFN(RL) EXT

P M K N S H

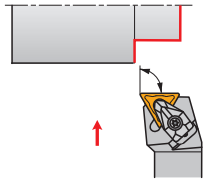
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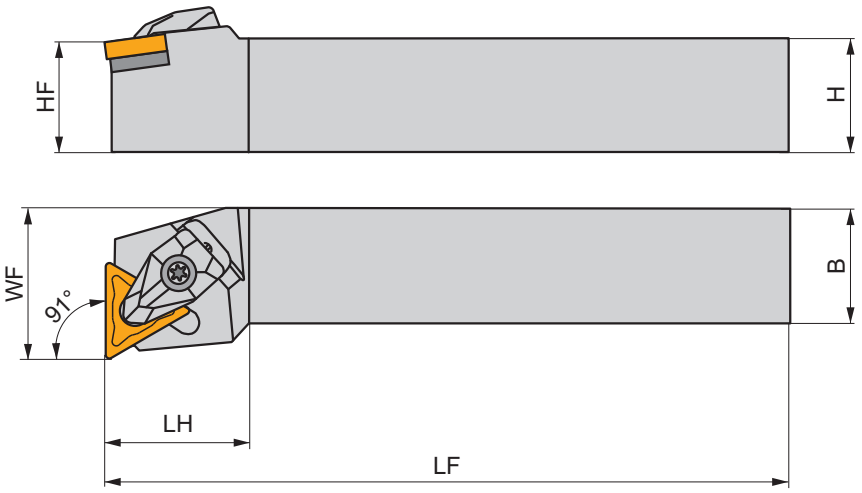
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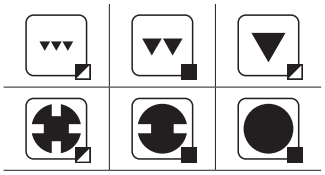


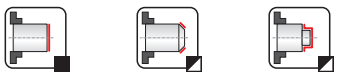
TN.. Uç için Çift Sıkmalı 91° (Alın) Dış Kateri

Çift sıkmalı 91° Sağ/Sol dış kater. Negatif TN.. 16 veya 22 uçlarla alın, ve pah tornalama için uygundur. 20x20 and 25x25mm şaft ölçüleri. Gövde uzun takım ömrü için işlem görmüştür.









	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	**DTFNR 2020 K 16**	20	20	20	25	125	23.6	-6	-6	0.43	GI024	DT16
	DTFNR 2525 M 16	25	25	25	32	150	23.6	-6	-6	0.77	GI024	DT16
	DTFNR 2525 M 22	25	25	25	32	150	30.5	-6	-6	0.79	GI025	DT22
L	**DTFNL 2020 K 16**	20	20	20	25	125	23.6	-6	-6	0.43	GI024	DT16
	DTFNL 2525 M 16	25	25	25	32	150	23.6	-6	-6	0.76	GI024	DT16

GI024	TN.. 1604..
GI025	TN.. 2204..

		Nm			
DT16	DCS 09	1.7	DTS 315-02	US 2004-T09P	FLAG T09P
DT22	DCS 12	3.9	DTS 315-04	US 2002-T15P	FLAG T15P/3,5

DTGN(RL) EXT

P M K N S H

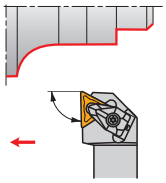
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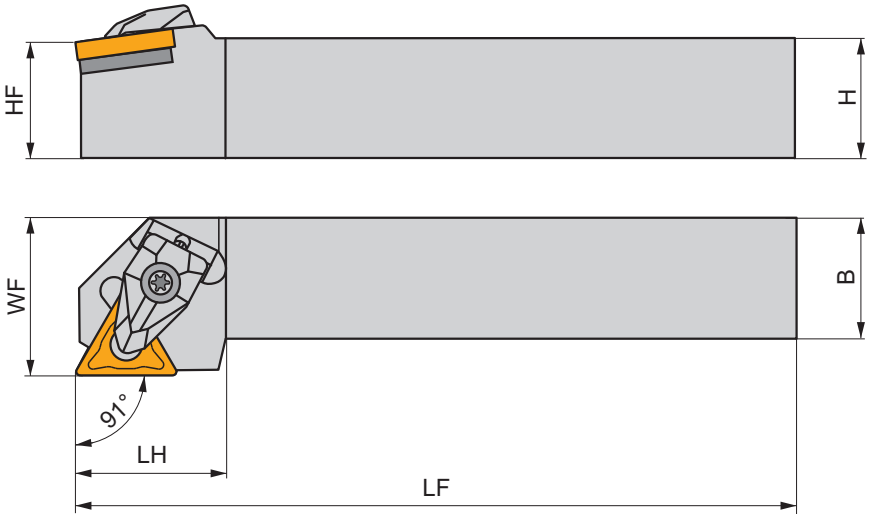
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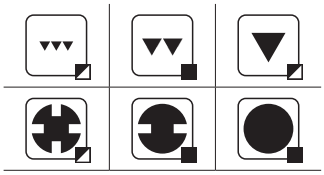


TN.. Uç için Çift Sıkmalı 91° Dış Kateri

Çift sıkmalı 91° Sağ/Sol dış kater. Negatif TN.. 16 veya 22 uçlarla çap, kopya, konik ve pah tornalama için uygundur. 20x20 - 40x40mm şaft ölçüleri. Gövde uzun takım ömrü için işlem görmüştür.









	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	DTGNR 2020 K 16	20	20	20	25	125	25.4	-6	-6	0.42	GI024	DT16
	DTGNR 2525 M 16	25	25	25	32	150	24.6	-6	-6	0.76	GI024	DT16
	DTGNR 2525 M 22	25	25	25	32	150	32.1	-6	-6	0.81	GI025	DT22
	DTGNR 3232 P 22	32	32	32	40	170	33.1	-6	-6	1.41	GI025	DT22
L	DTGNL 2020 K 16	20	20	20	25	125	25.4	-6	-6	0.44	GI024	DT16
	DTGNL 2525 M 16	25	25	25	32	150	24.6	-6	-6	0.78	GI024	DT16
	DTGNL 2525 M 22	25	25	25	32	150	32.1	-6	-6	0.78	GI025	DT22

GI024	TN.. 1604..
GI025	TN.. 2204..

		Nm			
DT16	DCS 09	1.7	DTS 315-02	US 2004-T09P	FLAG T09P
DT22	DCS 12	3.9	DTS 315-04	US 2002-T15P	FLAG T15P/3,5

MTJN(RL) EXT

P M K N S H

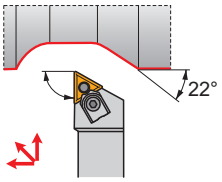
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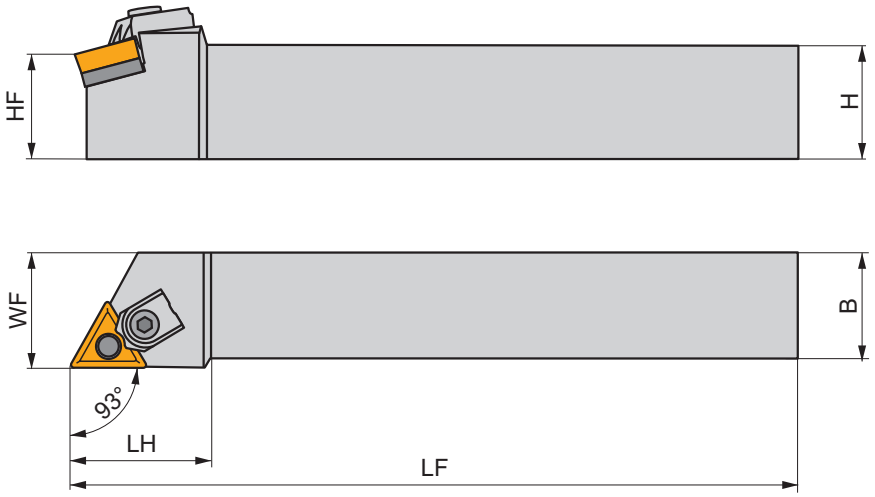
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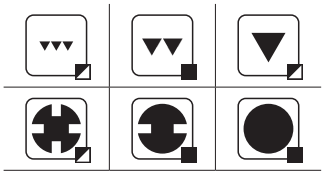


WN.. Uç için Pabuçlu 93° Açılı Dış Kater

Pabuçlu, 93° açılı Sağ/Sol dış kater. Negatif TN.. 16 veya 22 uçlarla çap, 22°'ye kadar kopya, konik ve pah tornalamak için uygundur. 20x20'den 32x32mm'ye kadar mevcuttur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	MTJNR 2020 K 16	20	20	20	25	125	34.0	-6	-6	0.42	GI024	MT16
	MTJNR 2525 M 16	25	25	25	32	150	34.0	-6	-6	0.76	GI024	MT16
	MTJNR 3232 P 22	32	32	32	40	175	42.0	-6	-6	1.37	GI025	MT22
L	MTJNL 2020 K 16	20	20	20	25	125	34.0	-6	-6	0.43	GI024	MT16
	MTJNL 2525 M 16	25	25	25	32	150	34.0	-6	-6	0.75	GI024	MT16
	MTJNL 3232 P 22	32	32	32	40	175	42.0	-6	-6	1.37	GI025	MT22

GI024	TN.. 1604..
GI025	TN.. 2204..

		Nm				
MT16	UE 16	3.0	MTN 160312	UC 52	HS 93	HXK 5
MT22	UE 22	5.0	MTN 220612	UC 61	HS 94	HXK 5

PTFN(RL) EXT

P M K N S H

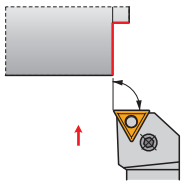
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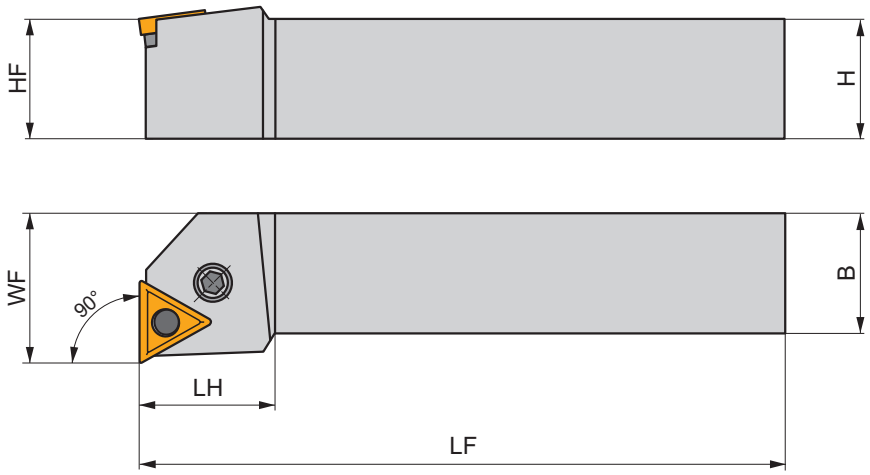
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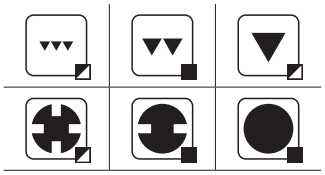


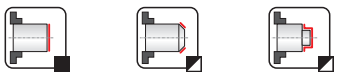
SN.. Uç için Levyeli 90° Açılı (Alın) Dış Kater

Levyeli, 90° açılı Sağ/Sol dış kater. Negatif TN 16, 22 veya 27 uçlarla alın ve pah tornalamak için uygundur. 16x16'dan 40x40mm'ye kadar mevcuttur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	PTFNR 2020 K 16	20	20	20	25	125	22.0	-6	-6	0.41	GI024	PT01
	PTFNR 2525 M 16	25	25	25	32	150	28.0	-6	-6	0.75	GI024	PT01
	PTFNR 3225 P 22	32	25	32	32	170	36.0	-6	-6	1.05	GI025	PT02
	PTFNR 4040 S 27	40	40	40	50	250	45.0	-6	-6	3.22	GI077	PT03
L	PTFNL 2525 M 22	25	25	25	32	150	28.0	-6	-6	0.70	GI025	PT02
	PTFNL 3225 P 22	32	25	32	32	170	36.0	-6	-6	1.14	GI025	PT02
	PTFNL 4040 S 27	40	40	40	50	250	45.0	-6	-6	3.16	GI077	PT03

GI024	TN.. 1604..
GI025	TN.. 2204..
GI077	TN.. 2706..

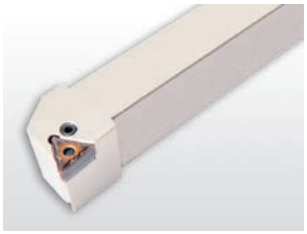
				Nm					
PT01	PTS 416	CL 009	CS 606	2.0	M 6x1	16.7	TR 09	MT 04	HXK 2.5
PT02	PTS 422	CL 012	CS 608	3.0	M 8x1	20.7	TR 12	MT 05	HXK 3
PT03	PTS 427	CL 015	CS 708	3.0	M 8x1	23.5	TR 15	MT 07	HXK 3

PTGN(RL) EXT

P M K N S H

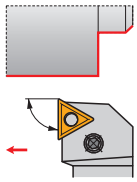
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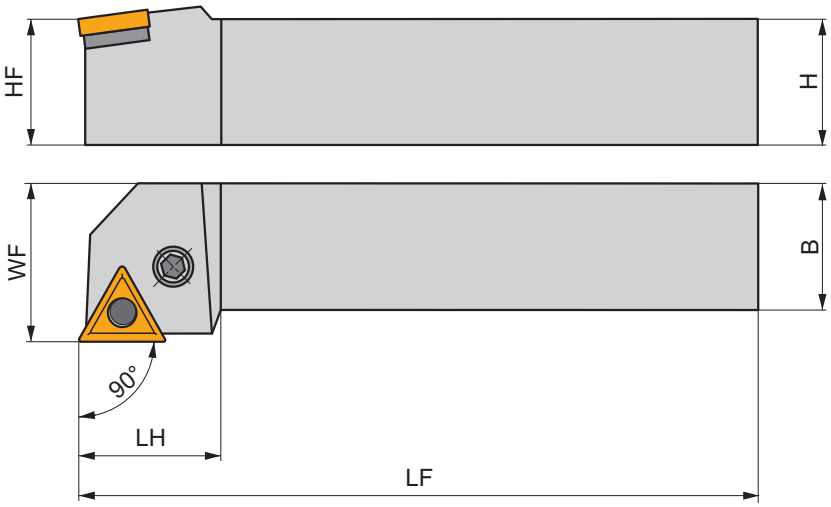
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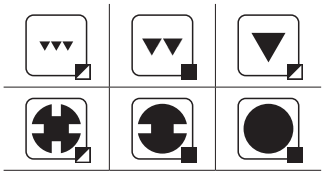


SN.. Uç için Levyeli 90° Açılı Dış Kater

Levyeli, 90° açılı Sağ/Sol dış kater. Negatif TN 16, 22 veya 27 uçlarla çap, konik ve pah tornalamak için uygundur. 16x16'dan 40x40mm'ye kadar mevcuttur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	PTGNR 1616 H 16	16	16	16	20	100	22.0	-6	-6	0.20	GI024	PT01
	PTGNR 2020 K 16	20	20	20	25	125	22.0	-6	-6	0.40	GI024	PT01
	PTGNR 2525 M 16	25	25	25	32	150	28.0	-6	-6	0.73	GI024	PT01
	PTGNR 2525 M 22	25	25	25	32	150	28.0	-6	-6	0.76	GI025	PT02
	PTGNR 3232 P 22	32	32	32	40	170	28.0	-6	-6	1.35	GI025	PT02
	PTGNR 4040 S 27	40	40	40	50	250	45.0	-6	-6	3.15	GI077	PT03
L	PTGNL 1616 H 16	16	16	16	20	100	22.0	-6	-6	0.21	GI024	PT01
	PTGNL 2020 K 16	20	20	20	25	125	22.0	-6	-6	0.40	GI024	PT01
	PTGNL 2525 M 16	25	25	25	32	150	28.0	-6	-6	0.76	GI024	PT01
	PTGNL 2525 M 22	25	25	25	32	150	28.0	-6	-6	0.76	GI025	PT02
	PTGNL 3232 P 22	32	32	32	40	170	28.0	-6	-6	1.34	GI025	PT02
	PTGNL 4040 S 27	40	40	40	50	250	45.0	-6	-6	3.14	GI077	PT03

GI024	TN.. 1604..
GI025	TN.. 2204..
GI077	TN.. 2706..

				Nm					
PT01	PTS 416	CL 009	CS 606	2.0	M 6x1	16.7	TR 09	MT 04	HXK 2.5
PT02	PTS 422	CL 012	CS 608	3.0	M 8x1	20.7	TR 12	MT 05	HXK 3
PT03	PTS 427	CL 015	CS 708	3.0	M 8x1	23.5	TR 15	MT 07	HXK 3

PTTN(RL) EXT

P M K N S H

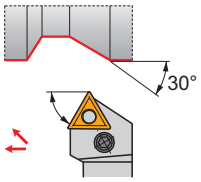
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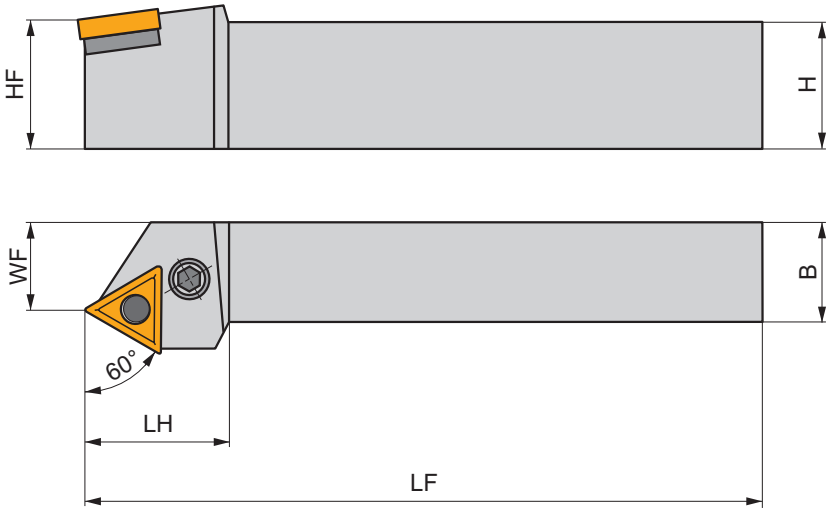
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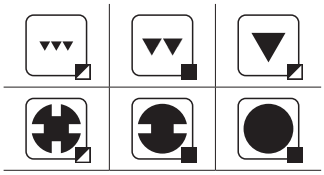


TN.. Uç için Levyeli 60° Açılı Dış Kater

Levyeli, 60° açılı Sağ/Sol dış kater. Negatif TN.. 16 ve 22 uçlarla çap, 30°'ye kadar kopya, konik ve pah tornalamak için uygundur. 20x20'den 32x25'e kadar mevcuttur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	PTTNR 2020 K 16	20	20	20	17	125	28.0	-6	-6	0.43	GI024	PT01
	PTTNR 2525 M 16	25	25	25	22	150	28.0	-6	-6	0.63	GI024	PT01
	PTTNR 2525 M 22	25	25	25	22	150	34.0	-6	-6	0.73	GI025	PT02
	PTTNR 3225 P 22	32	25	32	22	170	34.0	-6	-6	1.07	GI025	PT02
L	PTTNL 2020 K 16	20	20	20	17	125	28.0	-6	-6	0.38	GI024	PT01
	PTTNL 3225 P 22	32	25	32	22	170	34.0	-6	-6	1.04	GI025	PT02

GI024	TN.. 1604..
GI025	TN.. 2204..

				Nm					
PT01	PTS 416	CL 009	CS 606	2.0	M 6x1	16.7	TR 09	MT 04	HXK 2.5
PT02	PTS 422	CL 012	CS 608	3.0	M 8x1	20.7	TR 12	MT 05	HXK 3

C.-DTJN(RL) EXT

P M K N S H

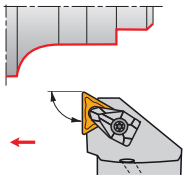
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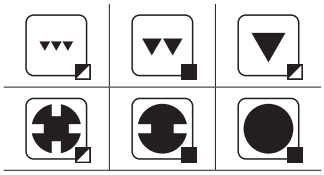
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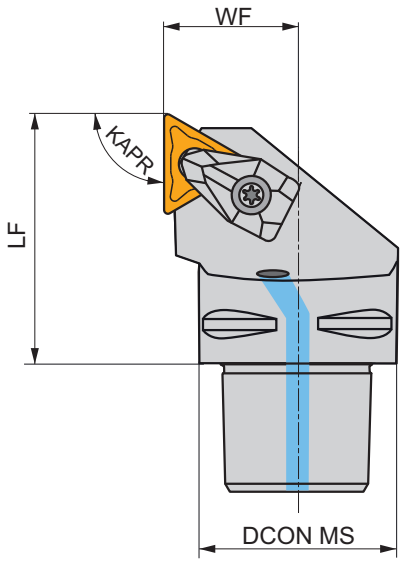


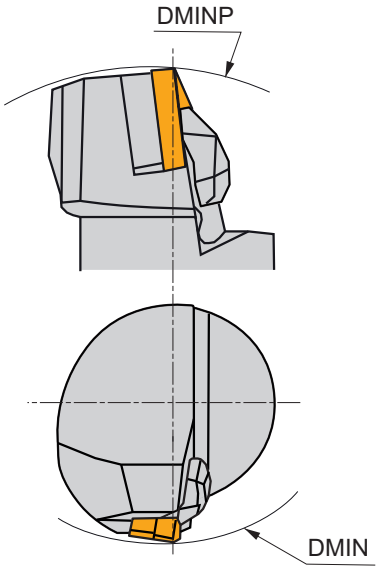
TN.. Uç için Çift Sıkmalı, 93° Açılı Hızlı Değiştirme Dış Takımı

Çift sıkmalı, 93° açılı, içten su vermeli Sağ/Sol dış kater. Negatif TN.. 16 uçlarla çap, alın, konik ve pah tornalamak için uygundur. C4 ve C5 PSC şaftlı mevcuttur. Tutucu uzun takım ömrü için işlem görmüştür.











	Product	DCON MS (mm)	DMIN (mm)	DMINP (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg		
R	C4-DTJNR-27050-16	40	110	140	27	50	93	-6	-6	✓	0.43	GI024	C-DT16
	C5-DTJNR-35060-16	50	110	165	35	60	93	-6	-6	✓	0.79	GI024	C-DT16
L	C4-DTJNL-27050-16	40	110	140	27	50	93	-6	-6	✓	0.43	GI024	C-DT16
	C5-DTJNL-35060-16	50	110	165	35	60	93	-6	-6	✓	0.79	GI024	C-DT16

GI024	TN.. 1604..

C-DT16	DCS 09	1.7	DTS 315-02	US 2004-T09P	FLAG T09P	CN 045-01

DTFN(RL) INT

P M K N S H

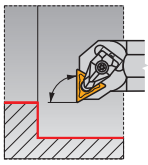
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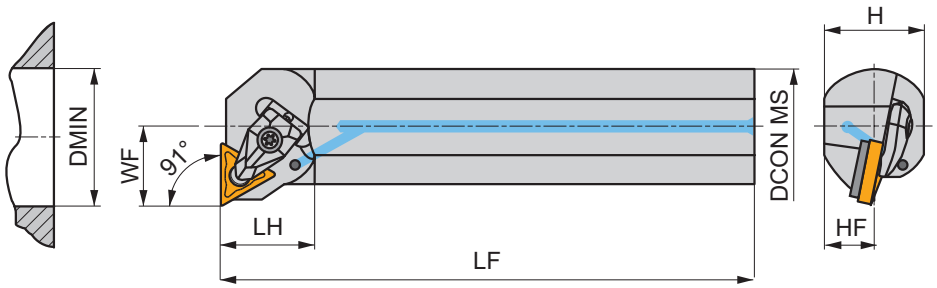
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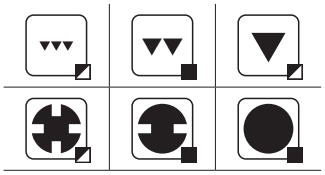


TN.. Uç için Çift Sıkmalı 91° Açılı Delik Kateri

Çift sıkmalı 91° Sağ/Sol içten su vermeli delik kateri. Negatif TN.. uçlarla Kenar ve pah tornalama ile iç konik ve çap tornalama için uygundur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	HF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)		kg		
R	A25T-DTFNR 16	25	32	17	23	11.5	300	32.0	-12	-6	✓	0.96	GI024	DTI16
	A32T-DTFNR 16	32	40	22	30	15	300	33.0	-10	-6	✓	1.67	GI024	DTI16
	A40T-DTFNR 22	40	50	27	37	18.5	300	36.0	-13	-6	✓	2.58	GI025	DT22
L	A25T-DTFNL 16	25	32	17	23	11.5	300	32.0	-12	-6	✓	0.96	GI024	DTI16
	A32T-DTFNL 16	32	40	22	30	15	300	33.0	-10	-6	✓	1.67	GI024	DTI16
	A40T-DTFNL 22	40	50	27	37	18.5	300	36.0	-13	-6	✓	2.58	GI025	DT22

GI024	TN.. 1604..
GI025	TN.. 2204..

		Nm			
DT22	DCS 12	3.9	DTS 315-04	US 2002-T15P	FLAG T15P/3,5
DTI16	DCS 09	1.7	DTS 316-01	US 2004-T09P	FLAG T09P

PTFN(RL) INT

P M K N S H

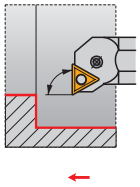
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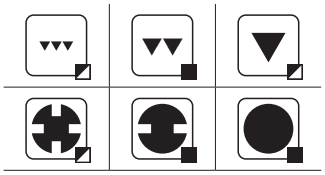
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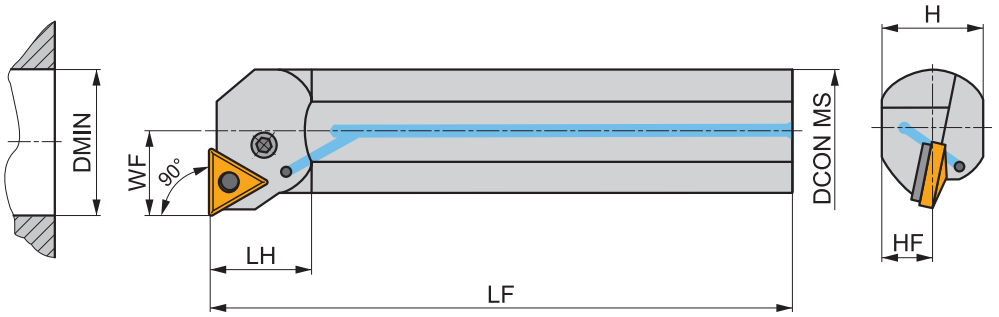


TN.. Uçlar için 90° Kesme Açılı İçten Kollu Kilit Tutucu

Vida sıkmalı Sağ/Sol 95° içten su vermeli karbür delik kateri. Pozitif EP.. uçlarla Kenar ve pah tornalama ile iç konik ve çap tornalama için uygundur. Gövde uzun takım ömrü için işlem görmüştür. Tutucu İşleme Derinliği > 3xD









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)		kg		
R	**A25R-PTFNR 16**	25	31	17	23	–	200	-13	-6	–	0.71	GI024	PT04
	A32S-PTFNR 16	32	39	22	30	–	250	-12	-6	✓	1.45	GI024	PT01
L	**A25R-PTFNL 16**	25	31	17	23	–	200	-13	-6	–	0.71	GI024	PT04

GI024	TN.. 1604..

				Nm					
PT01	PTS 416	CL 009	CS 606	2.0	M 6x1	16.7	TR 09	MT 04	HXK 2.5
PT04	–	CL 216	CS 605	1.4	M 5x1	12	–	–	HXK 2

C.-DTFN(RL) INT

P M K N S H

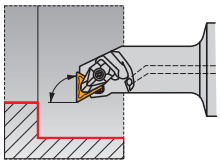
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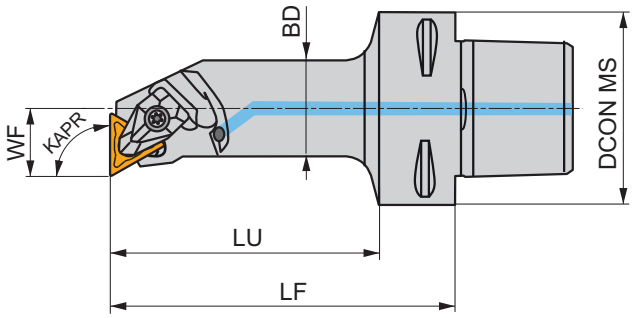
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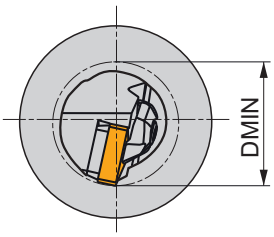


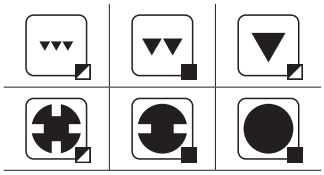
TN.. Uçlar için Çift Sıkmalı 91° Açılı PSC Hızlı Değiştirme Delik Takımı

Çift sıkmalı 91° Sağ/Sol içten su vermeli delik kateri. Negatif TN.. uçlarla birçok çeşit tornalama için uygundur. PSC şaft . Gövde uzun takım ömrü için işlem görmüştür.











	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	LF (mm)	LU (mm)	BD (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg		
R	C4-DTFNR-17090-16	40	32	17	90	68	25	91	-12	-6	✓	0.51	GI024	DTI16

GI024	TN.. 1604..

DTI16	DCS 09	1.7	DTS 316-01	US 2004-T09P	FLAG T09P

DVJN(RL) EXT

P M K N S H

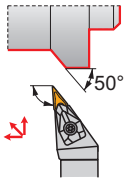
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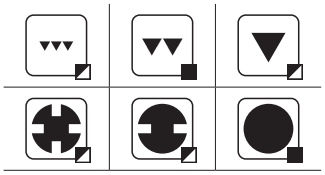
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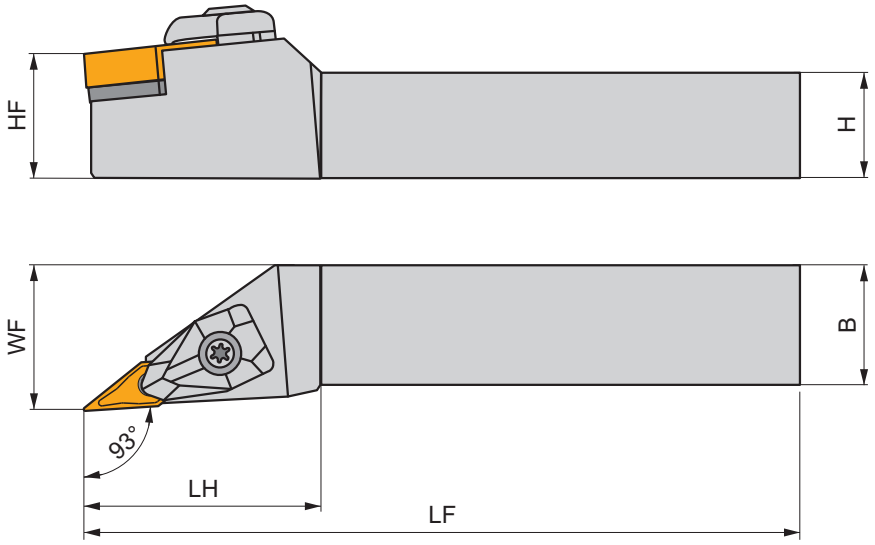


VN.. Uç için Çift Sıkmalı 93° Dış Kateri

Çift sıkmalı 93° Sağ/Sol dış kater. Negatif VN.. 16 uçlarla çap, kopya, konik ve pah tornalama için uygundur. 20x20 - 32x32mm şaft ölçüleri. Gövde uzun takım ömrü için işlem görmüştür.









	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	DVJNR 2020 K 16	20	20	20	25	125	46.4	-13	-4	0.43	GI048	DV16
	DVJNR 2525 M 16	25	25	25	32	150	46.4	-13	-4	0.74	GI048	DV16
	DVJNR 3225 P 16	32	25	32	32	170	46.4	-13	-4	1.05	GI048	DV16
L	DVJNL 2020 K 16	20	20	20	25	125	46.4	-13	-4	0.43	GI048	DV16
	DVJNL 2525 M 16	25	25	25	32	150	46.4	-13	-4	0.75	GI048	DV16
	DVJNL 3225 P 16	32	25	32	32	170	46.4	-13	-4	1.06	GI048	DV16

GI048	VN.. 1604..

DV16	DCS 16V	3.0	DVS 269-01	US 2009-T15P	FLAG T15P/3,5

DVPN(RL) EXT

P M K N S H

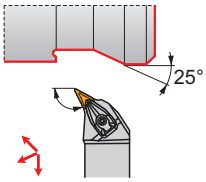
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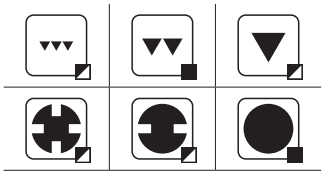
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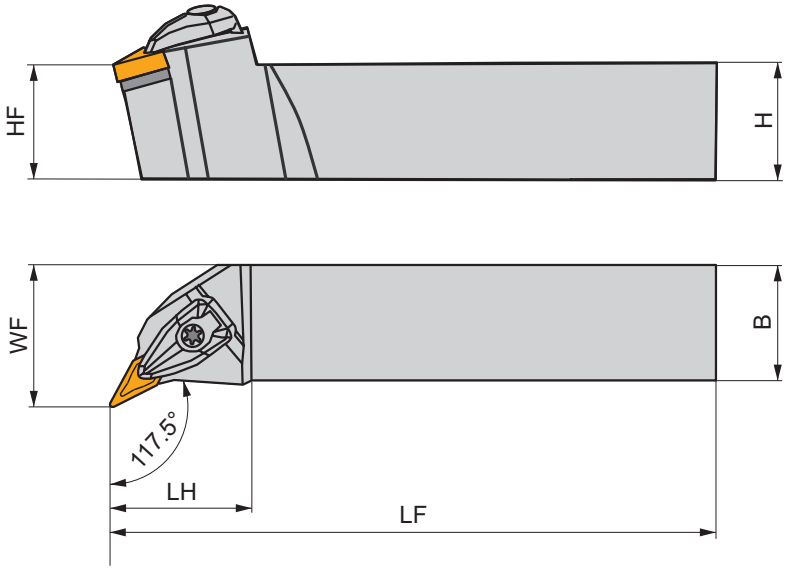


VN.. Uç için Çift Sıkmalı 117.5° Dış Kateri

Çift sıkmalı 117.5° Sağ/Sol dış kater. Negatif VN.. 16 uçlarla çap, kopya, konik ve pah tornalama için uygundur. 25x25 - 32x25mm şaft ölçüleri. Gövde uzun takım ömrü için işlem görmüştür.









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	DVPNR 2525 M 16	25	25	25	32	150	39.2	-13	-4	0.75	GI048	DV16
L	DVPNL 2525 M 16	25	25	25	32	150	39.2	-13	-4	0.74	GI048	DV16

GI048	VN.. 1604..

DV16	DCS 16V	3.0 Nm	DVS 269-01	US 2009-T15P	FLAG T15P/3,5

MVJN(RL) EXT

P M K N S H

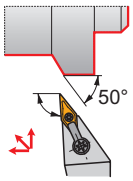
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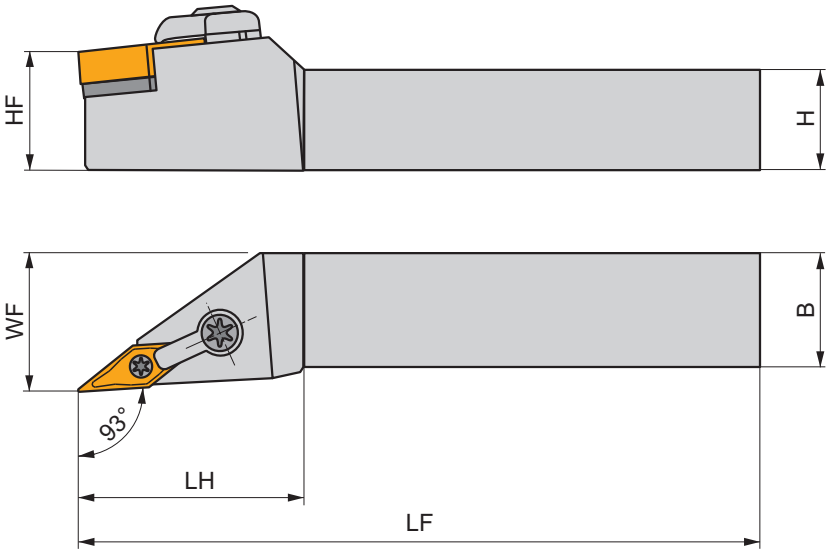
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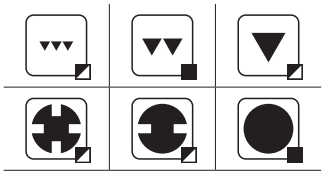


VN.. Uç için Pabuçlu 93° Açılı Dış Kater

Pabuçlu, 93° açılı Sağ/Sol dış kater. Negatif VN.. 16 uçlarla çap, 50°'ye kadar kopya, konik ve pah tornalamak için uygundur. 20x20'den 32x25mm'ye kadar mevcuttur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	MVJNR 2020 K 16-A	20	20	20	25	125	41.0	-4.5	-13.5	0.40	GI048	MV2
	MVJNR 2525 M 16-A	25	25	25	32	150	41.0	-4.5	-13.5	0.70	GI048	MV2
	MVJNR 3225 P 16-A	32	25	32	32	170	41.0	-4.5	-13.5	0.98	GI048	MV2
L	MVJNL 2020 K 16-A	20	20	20	25	125	41.0	-4.5	-13.5	0.40	GI048	MV2
	MVJNL 2525 M 16-A	25	25	25	32	150	41.0	-4.5	-13.5	0.70	GI048	MV2
	MVJNL 3225 P 16-A	32	25	32	32	170	41.0	-4.5	-13.5	0.99	GI048	MV2

GI048	VN.. 1604..

				Nm		Nm	
MV2	UPC 22	MVN 160316	UP 0909-T09P	2.0	PS 6026-T09P	2.0	FLAG T09P

C.-DVJN(RL) EXT

P M K N S H

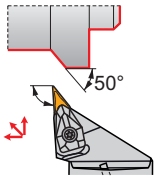
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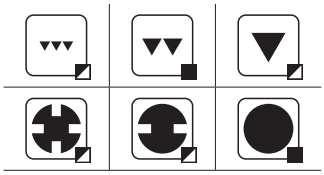
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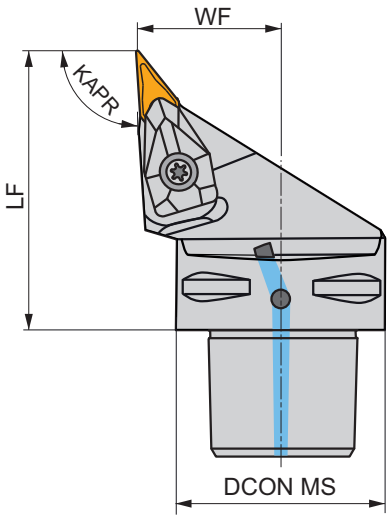


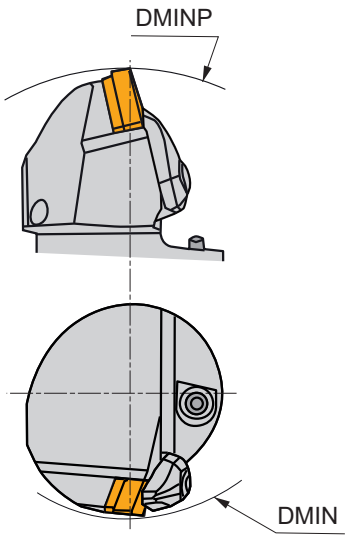
VN.. Uç için Çift Sıkmalı, 93° Açılı Hızlı Değiştirme Dış Takımı

Çift sıkmalı, 93° açılı, içten su vermeli Sağ/Sol dış kater. Negatif VN.. 16 uçlarla çap, alın, konik ve pah tornalamak için uygundur. C4 - C6 şaftlı mevcuttur. Tutucu uzun takım ömrü için işlem görmüştür.











	Product	DCON MS (mm)	DMIN (mm)	DMINP (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg		
R	C4-DVJNR-27062-16	40	60	152	27	62	93	-13	-4	✓	0.45	GI048	C-DV16-1
	C5-DVJNR-35065-16	50	65	170	35	65	93	-13	-4	✓	0.47	GI048	C-DV16-2
	C6-DVJNR-45065-16	63	81	190	45	65	93	-13	-4	✓	1.13	GI048	C-DV16-2
L	C4-DVJNL-27062-16	40	60	152	27	62	93	-13	-4	✓	0.45	GI048	C-DV16-1
	C5-DVJNL-35065-16	50	65	170	35	65	93	-13	-4	✓	0.71	GI048	C-DV16-2
	C6-DVJNL-45065-16	63	81	190	45	65	93	-13	-4	✓	1.13	GI048	C-DV16-2

GI048	VN.. 1604..

		Nm				
C-DV16-1	DCS 16V	3.0	DVS 269-01	US 2009-T15P	FLAG T15P/3,5	CN 034-01
C-DV16-2	DCS 16V	3.0	DVS 269-01	US 2009-T15P	FLAG T15P/3,5	CN 034-02

DVUN(RL) INT

P M K N S H

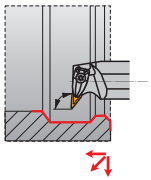
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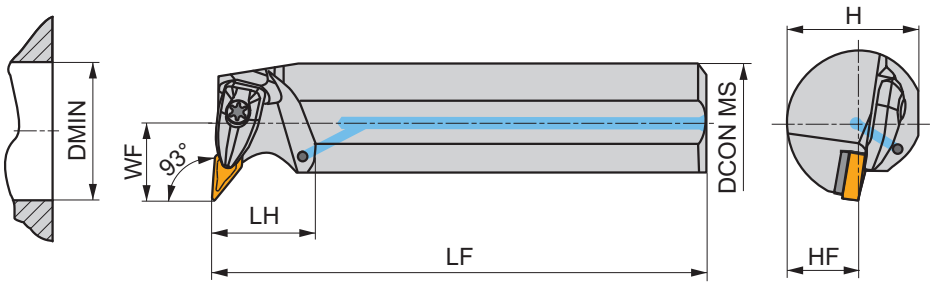
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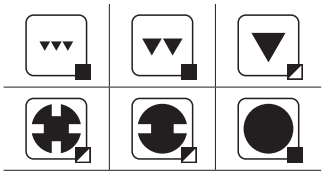


VN.. Uç için Çift Sıkmalı 93° Açılı Delik Kateri

Çift sıkmalı 93° Sağ/Sol içten su vermeli delik kateri. Negatif VN.. uçlarla Kenar ve pah tornalama ile iç konik ve çap tornalama için uygundur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	HF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)		kg		
R	A40T-DVUNR 16	40	50	27	37	18.5	300	36.0	-9	-6	✓	2.59	GI048	DV16
L	A40T-DVUNL 16	40	50	27	37	18.5	300	36.0	-9	-6	✓	2.58	GI048	DV16

GI048	VN.. 1604..

DV16	DCS 16V	3.0 Nm	DVS 269-01	US 2009-T15P	FLAG T15P/3,5

DWLN(RL) EXT

P M K N S H

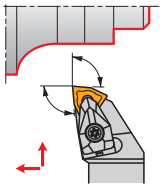
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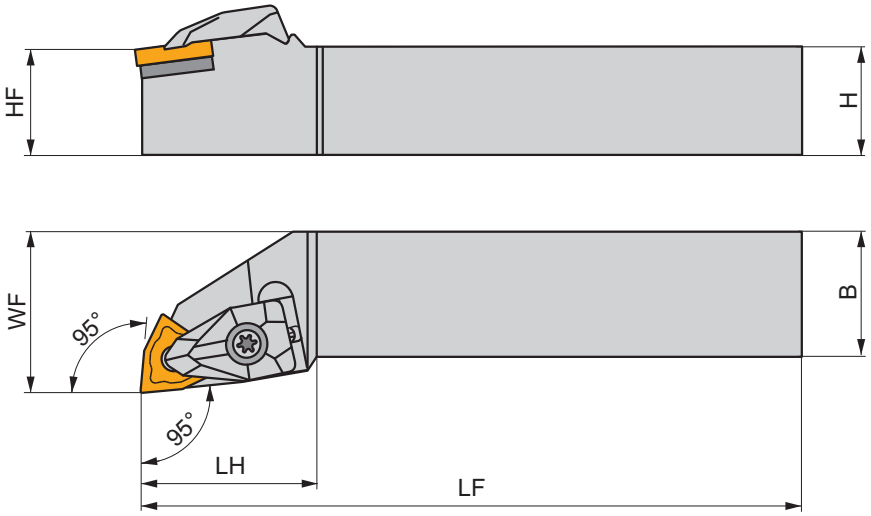
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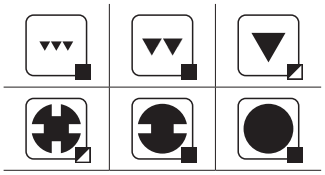


WN.. Uç için Çift Sıkmalı, 95° Açılı Dış Kater

Çift sıkmalı, 95° açılı, içten su vermeli Sağ/Sol dış kater. Negatif WN.. 06 - 13 uçlarla çap, alın, konik ve pah tornalamak için uygundur.16x16 - 40x40mm şaftlı mevcuttur. Tutucu uzun takım ömrü için işlem görmüştür.









	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg			
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)				
R	DWLNR 1616 H 06	16	16	16	20	100	26.4	-6	-6	0.22	GI028	DW06	–
	DWLNR 2020 K 06	20	20	20	25	125	27.1	-6	-6	0.41	GI028	DW06	–
	DWLNR 2525 M 06	25	25	25	32	150	27.1	-6	-6	0.75	GI028	DW06	–
	DWLNR 2020 K 08	20	20	20	25	125	34.3	-6	-6	0.43	GI072	DW08	AT004
	DWLNR 2525 M 08	25	25	25	32	150	35.0	-6	-6	0.75	GI072	DW08	AT004
	DWLNR 3225 P 08	32	25	32	32	170	35.0	-6	-6	1.01	GI072	DW08	AT004
	DWLNR 3225 P 10	32	25	32	32	170	38.0	-6	-6	1.06	GI166	DW10	–
	DWLNR 3232 P 13	32	32	32	40	170	40.0	-6	-6	1.40	GI167	DW13	–
	DWLNR 4040 S 13	40	40	40	50	250	41.0	-6	-6	3.19	GI167	DW13	–
L	DWLNL 1616 H 06	16	16	16	20	100	26.4	-6	-6	0.22	GI028	DW06	–
	DWLNL 2020 K 06	20	20	20	25	125	27.1	-6	-6	0.41	GI028	DW06	–
	DWLNL 2525 M 06	25	25	25	32	150	27.1	-6	-6	0.76	GI028	DW06	–
	DWLNL 2020 K 08	20	20	20	25	125	34.3	-6	-6	0.43	GI072	DW08	AT004
	DWLNL 2525 M 08	25	25	25	32	150	35.0	-6	-6	0.74	GI072	DW08	AT004
	DWLNL 3225 P 08	32	25	32	32	170	35.0	-6	-6	1.10	GI072	DW08	AT004
	DWLNL 3225 P 10	32	25	32	32	170	38.0	-6	-6	1.14	GI166	DW10	–
	DWLNL 3232 P 13	32	32	32	40	170	40.0	-6	-6	1.43	GI167	DW13	–
	DWLNL 4040 S 13	40	40	40	50	250	41.0	-6	-6	3.17	GI167	DW13	–

GI028	WN.. 0604..
GI072	WN.. 0804..
GI166	WN.. 1006..
GI167	WN.. 1306..

DW06	DCS 09	1.7	DWS 328-01	US 2004-T09P	FLAG T09P	–
DW08	DCS 12	3.9	DWS 331-12	US 2002-T15P	FLAG T15P/3,5	–
DW10	DCS 16	6.4	DWN 100612	US 5018-T20P	–	LK T20P
DW13	DCS 19	6.4	DWN 130612	US 6013-T20P	–	LK T20P

AT004a	CER WN.N 0804..	DCS 12C4
AT004b	CER WN.A 0804..	DCS 12C2

MWLN(RL) EXT

P M K N S H

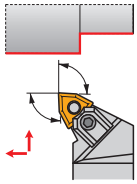
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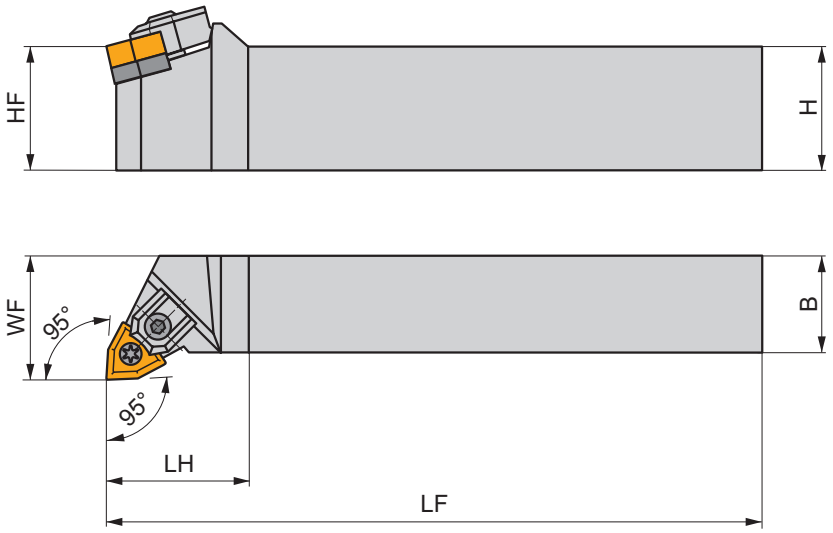
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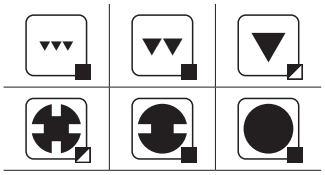


WN.. Uç için Pabuçlu 95° Açılı Dış Kater

Pabuçlu, 95° açılı Sağ/Sol dış kater. Negatif WN.. 08 uçlarla çap, alın, konik ve pah tornalamak için uygundur. 25x25'den 40x40mm'ye kadar mevcuttur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	MWLNR 2525 M 08	25	25	25	32	150	34.0	-6	-6	0.73	GI072	MW02
	MWLNR 3225 P 08	32	25	32	32	170	34.0	-6	-6	1.09	GI072	MW02
	MWLNR 4040 S 08	40	40	40	50	250	45.0	-6	-6	3.14	GI072	MW02
L	MWLNL 2525 M 08	25	25	25	32	150	34.0	-6	-6	0.78	GI072	MW02
	MWLNL 3225 P 08	32	25	32	32	170	34.0	-6	-6	1.02	GI072	MW02
	MWLNL 4040 S 08	40	40	40	50	250	45.0	-6	-6	3.14	GI072	MW02

GI072	WN.. 0804..

MW02	UE 11	4.0 Nm	MWS 433	UC 61	HS 94	HXK 5

PWLN(RL) EXT

P M K N S H

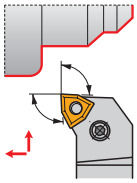
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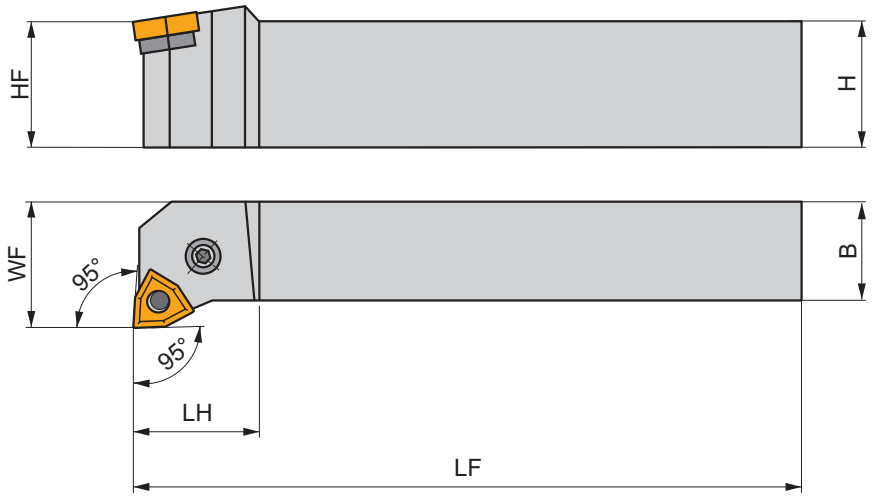
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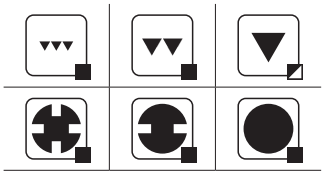


WN.. Uç için Levyeli 95° Açılı Dış Kater

Levyeli, 95° açılı Sağ/Sol dış kater. Negatif WN.. 06 ve 08 uçlarla çap, alın, konik ve pah tornalamak için uygundur. 16x16'dan 32x25mm'ye kadar mevcuttur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	PWLNR 1616 H 0604	16	16	16	20	100	22.0	-6	-6	0.22	GI028	PW01
	PWLNR 2020 K 0604	20	20	20	25	125	22.0	-6	-6	0.40	GI028	PW01
	PWLNR 2525 M 0604	25	25	25	32	150	25.0	-6	-6	0.75	GI028	PW01
	PWLNR 2020 K 08	20	20	20	25	125	28.0	-6	-6	0.41	GI072	PW02
	PWLNR 2525 M 08	25	25	25	32	150	28.0	-6	-6	0.76	GI072	PW02
	PWLNR 3225 P 08	32	25	32	32	170	34.0	-6	-6	1.05	GI072	PW02
L	PWLNL 1616 H 0604	16	16	16	20	100	22.0	-6	-6	0.21	GI028	PW01
	PWLNL 2020 K 0604	20	20	20	25	125	22.0	-6	-6	0.41	GI028	PW01
	PWLNL 2525 M 0604	25	25	25	32	150	25.0	-6	-6	0.75	GI028	PW01
	PWLNL 2020 K 08	20	20	20	25	125	28.0	-6	-6	0.40	GI072	PW02
	PWLNL 2525 M 08	25	25	25	32	150	28.0	-6	-6	0.74	GI072	PW02
	PWLNL 3225 P 08	32	25	32	32	170	34.0	-6	-6	1.05	GI072	PW02

GI028	WN.. 0604..
GI072	WN.. 0804..

PW01	PWS 007	CL 009	CS 606	2.0	M 6x1	16.7	TR 09	MT 04	HXK 2.5
PW02	PWS 008	CL 012	CS 608	3.0	M 8x1	20.7	TR 12	MT 05	HXK 3

C.-DWLN(RL) EXT

P M K N S H

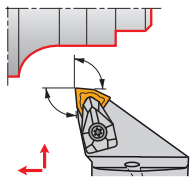
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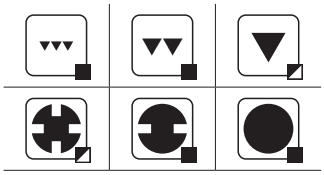
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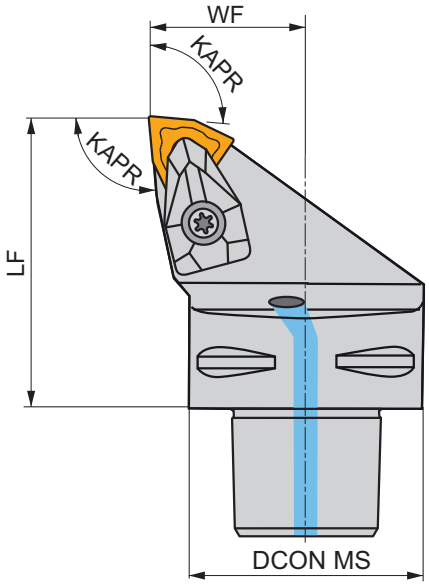


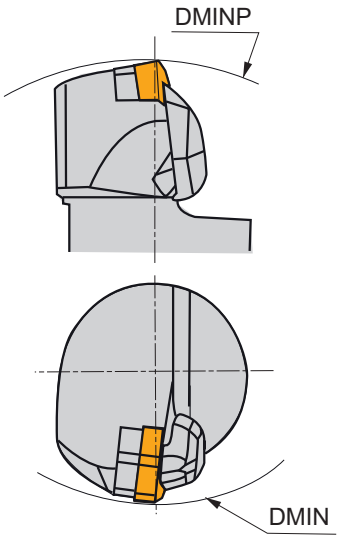
WN.. Uç için Çift Sıkmalı, 95° Açılı Hızlı Değiştirme Dış Takımı

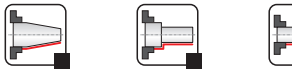
Çift sıkmalı, 95° açılı, içten su vermeli Sağ/Sol dış kater. Negatif WN.. 06 veya 08 uçlarla çap, alın, konik ve pah tornalamak için uygundur. C4 - C6 şaftlı mevcuttur. Tutucu uzun takım ömrü için işlem görmüştür.











	Product	DCON MS (mm)	DMIN (mm)	DMINP (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg			
R	C4-DWLNR-27050-06	40	60	140	27	50	95	-6	-6	✓	0.42	GI028	C-DW06	–
	C4-DWLNR-27050-08	40	110	140	27	50	95	-6	-6	✓	0.42	GI072	C-DW08-1	AT004
	C5-DWLNR-35060-08	50	110	165	35	60	95	-6	-6	✓	0.74	GI072	C-DW08-2	AT004
	C6-DWLNR-45065-08	63	110	190	45	65	95	-6	-6	✓	1.34	GI072	C-DW08-2	AT004
L	C4-DWLNL-27050-06	40	60	140	27	50	95	-6	-6	✓	0.43	GI028	C-DW06	–
	C4-DWLNL-27050-08	40	110	140	27	50	95	-6	-6	✓	0.42	GI072	C-DW08-1	AT004
	C5-DWLNL-35060-08	50	110	165	35	60	95	-6	-6	✓	0.76	GI072	C-DW08-2	AT004
	C6-DWLNL-45065-08	63	110	190	45	65	95	-6	-6	✓	1.34	GI072	C-DW08-2	AT004

GI028	WN.. 0604..
GI072	WN.. 0804..

		Nm				
C-DW06	DCS 09	1.7	DWS 328-01	US 2004-T09P	FLAG T09P	CN 034-01
C-DW08-1	DCS 12	3.9	DWS 331-12	US 2002-T15P	FLAG T15P/3,5	CN 034-01
C-DW08-2	DCS 12	3.9	DWS 331-12	US 2002-T15P	FLAG T15P/3,5	CN 045-01

AT004a	CER WN.N 0804..	DCS 12C4
AT004b	CER WN.A 0804..	DCS 12C2

DWLN(RL) INT

P M K N S H

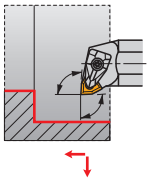
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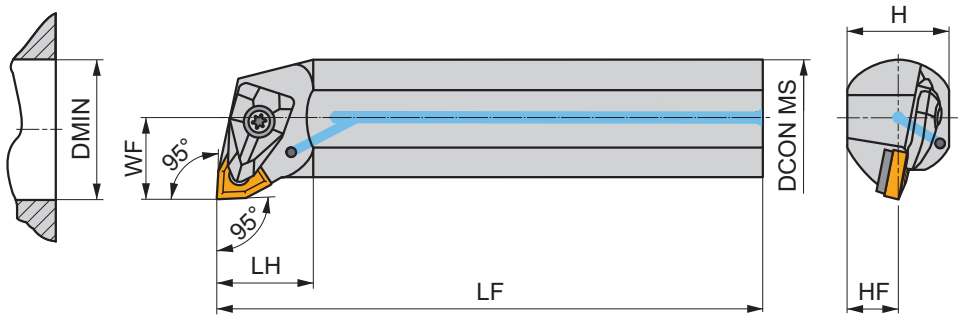
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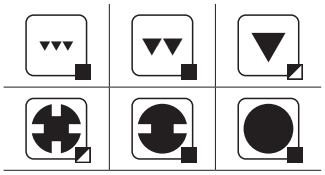


WN.. Uç için Çift Sıkmalı 95° Açılı Delik Kateri

Çift sıkmalı 95° Sağ/Sol içten su vermeli delik kateri. Negatif WN.. uçlarla. Kenar ve pah tornalama ile iç konik ve çap tornalama için. Gövde uzun takım ömrü için işlem görmüştür.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	HF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)		kg		
R	A25T-DWLNR 06	25	32	17	23	11.5	300	31.0	-14	-6	✓	0.97	GI028	DW06
	A25T-DWLNR 08	25	33	17	23	11.5	300	31.0	-12	-6	✓	0.98	GI072	DWI08
	A32T-DWLNR 08	32	40	22	30	15	300	33.0	-10	-6	✓	1.70	GI072	DWI08
	A40T-DWLNR 08	40	50	27	37	18.5	300	36.0	-13	-6	✓	2.59	GI072	DW08
	A50U-DWLNR 08	50	63	35	47	23.5	350	39.0	-11	-6	✓	5.24	GI072	DW08
L	A25T-DWLNL 06	25	32	17	23	11.5	300	31.0	-14	-6	✓	0.97	GI028	DW06
	A25T-DWLNL 08	25	33	17	23	11.5	300	31.0	-12	-6	✓	0.98	GI072	DWI08
	A32T-DWLNL 08	32	40	22	30	15	300	33.0	-10	-6	✓	1.70	GI072	DWI08
	A40T-DWLNL 08	40	50	27	37	18.5	300	36.0	-13	-6	✓	2.59	GI072	DW08
	A50U-DWLNL 08	50	63	35	47	23.5	350	39.0	-11	-6	✓	5.25	GI072	DW08

GI028	WN.. 0604..
GI072	WN.. 0804..

		Nm			
DW06	DCS 09	1.7	DWS 328-01	US 2004-T09P	FLAG T09P
DW08	DCS 12	3.9	DWS 331-12	US 2002-T15P	FLAG T15P/3,5
DWI08	DCS 12	3.9	DWS 328-02	US 2002-T15P	FLAG T15P/3,5

PWLN(RL) INT

P M K N S H

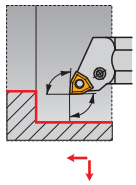
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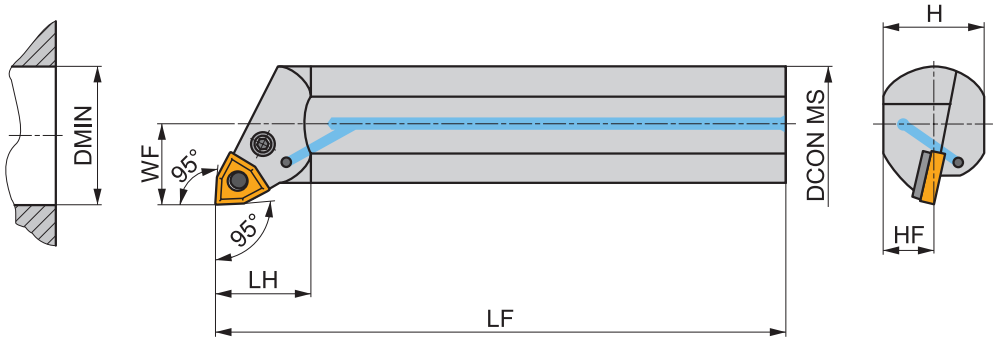
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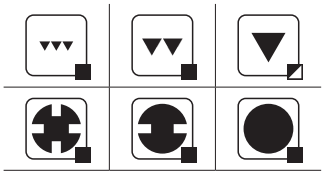


WN.. Uçlar için 95° Kesme Açılı İçten Kollu Kilitli Delik Barası

Levyeli 95° Sağ/Sol içten su vermeli delik kateri. Negatif WN.. uçlarla, Kenar ve pah tornalama ile iç konik ve çap tornalama için uygundu. Gövde uzun takım ömrü için işlem görmüştür.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)		kg		
R	A16M-PWLNR 0604	16	20	11	15	–	150	-18	-4	✓	0.24	GI028	PT04
	A20Q-PWLNR 0604	20	27	13	18	–	180	-18	-4	✓	0.36	GI028	PT04
	A25R-PWLNR 0604	25	31	17	23	–	200	-14	-4	✓	0.72	GI028	PW01
	A32S-PWLNR 0604	32	39	22	30	–	250	-12	-4	✓	1.30	GI028	PW01
	A25R-PWLNR 08	25	31	17	23	–	200	-14	-4	✓	0.66	GI072	PC06
	A32S-PWLNR 08	32	39	22	30	–	250	-12	-4	✓	1.46	GI072	PW02
	A40T-PWLNR 08	40	48	27	37	–	300	-12	-4	✓	2.40	GI072	PW02
	A50U-PWLNR 08	50	61	35	47	–	350	-12	-4	✓	4.88	GI072	PW02
	A60V-PWLNR 08	60	80	43	57	–	400	-12	-4	–	8.10	GI072	PW02
L	A16M-PWLNL 0604	16	20	11	15	–	150	-18	-4	✓	0.22	GI028	PT04
	A20Q-PWLNL 0604	20	27	13	18	–	180	-18	-4	✓	0.36	GI028	PT04
	A25R-PWLNL 0604	25	31	17	23	–	200	-14	-4	✓	0.71	GI028	PW01
	A25R-PWLNL 08	25	31	17	23	–	200	-14	-4	✓	0.71	GI072	PC06
	A32S-PWLNL 08	32	39	22	30	–	250	-12	-4	✓	1.43	GI072	PW02
	A40T-PWLNL 08	40	48	27	37	–	300	-12	-4	–	2.70	GI072	PW02
	A50U-PWLNL 08	50	61	35	47	–	350	-12	-4	✓	4.88	GI072	PW02

GI028	WN.. 0604..
GI072	WN.. 0804..

				Nm					
PW01	PWS 007	CL 009	CS 606	2.0	M 6x1	16.7	TR 09	MT 04	HXK 2.5
PW02	PWS 008	CL 012	CS 608	3.0	M 8x1	20.7	TR 12	MT 05	HXK 3
PT04	–	CL 216	CS 605	1.4	M 5x1	12	–	–	HXK 2
PC06	–	CL 212	CS 626	2.0	M 6x1	13.4	–	–	HXK 2.5

C.-DWLN(RL) INT

P M K N S H

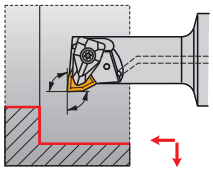
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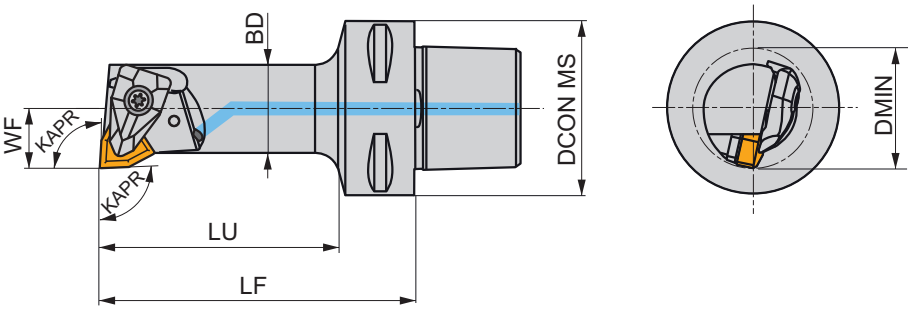
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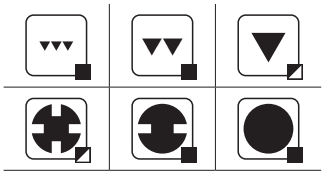


WN.. Uçlar için Çift Sıkmalı 95° Açılı PSC Hızlı Değiştirme Delik Takımı

Çift sıkmalı 95° Sağ/Sol içten su vermeli delik kateri. Negatif WN.. uçlarla Kenar ve pah tornalama ile iç konik ve çap tornalama için uygundur. Çokgen şaft ölçüleri. Gövde uzun takım ömrü için işlem görmüştür.







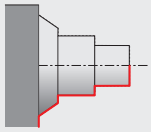


	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	LF (mm)	LU (mm)	BD (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg		
R	C4-DWLNR-13075-06	40	27	13	75	52	20	95	-17	-6	✓	0.42	GI028	DW06
	C4-DWLNR-17090-08	40	33	17	90	68	25	95	-12	-6	✓	0.53	GI072	DWI08
L	C4-DWLNL-13075-06	40	27	13	75	52	20	95	-17	-6	✓	0.42	GI028	DW06
	C4-DWLNL-17090-08	40	33	17	90	68	25	95	-12	-6	✓	0.53	GI072	DWI08

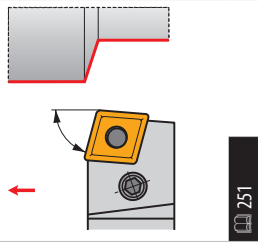
GI028	WN.. 0604..
GI072	WN.. 0804..

		Nm			
DW06	DCS 09	1.7	DWS 328-01	US 2004-T09P	FLAG T09P
DWI08	DCS 12	3.9	DWS 328-02	US 2002-T15P	FLAG T15P/3,5

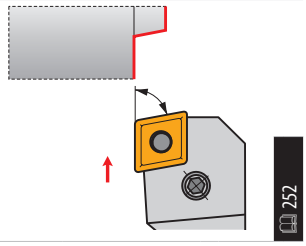
ISO TORNALAMA - DIŞ
KISA VE STABİL PARÇALAR (Negatif uçlar)



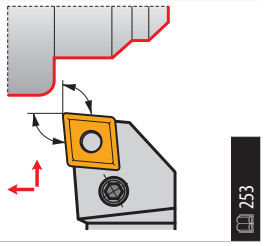
PCBN(RL) EXT 75°
CN..



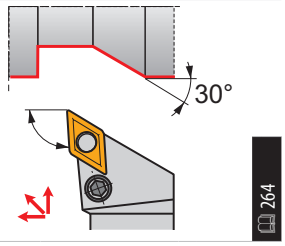
PCKN(RL) EXT 75°
CN..



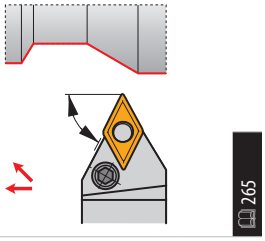
PCLN(RL) EXT 95°
CN..



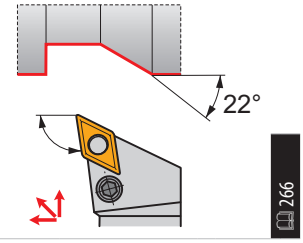
PDJN(RL) EXT 93°
DN..



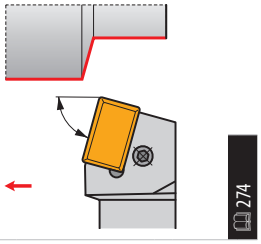
PDNN(RL) EXT 62°30´
DN..



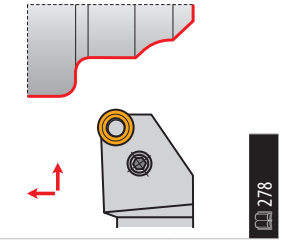
PDXN(RL) EXT 98°
DN..



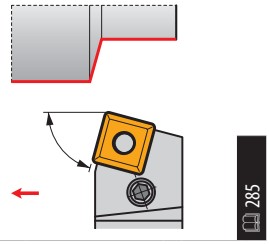
PLBN(RL) EXT 75°
LN..



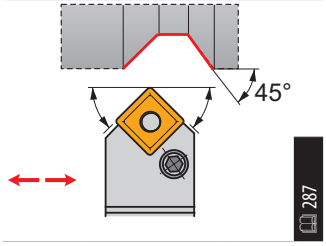
PRSN(RL) EXT
RN..



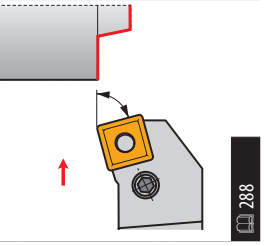
PSBN(RL) EXT 75°
SN..



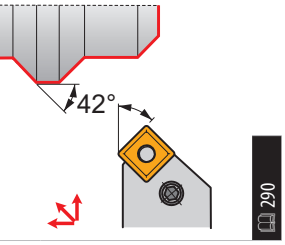
PSDNN EXT 45°
SN..



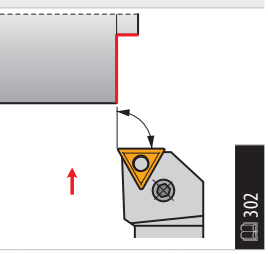
PSKN(RL) EXT 75°
SN..



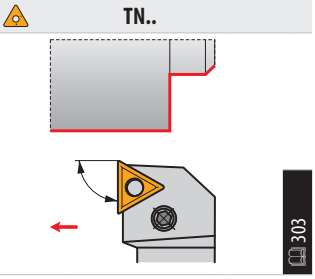
PSSN(RL) EXT 45°
SN..



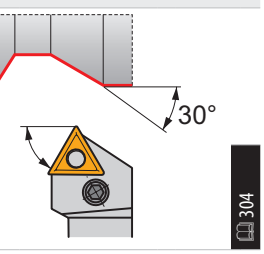
PTFN(RL) EXT 90°
TN..



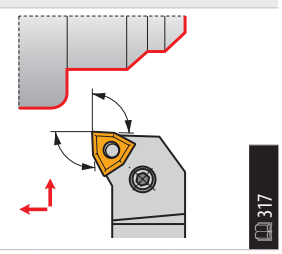
PTGN(RL) EXT 90°
TN..



PTTN(RL) EXT 60°
TN..



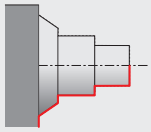
PWLN(RL) EXT 95°
WN..



D SIKMA TIPI

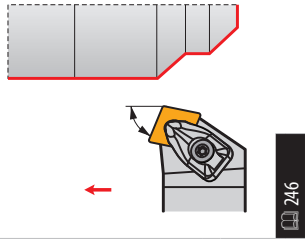
ISO TORNALAMA - DIŞ

KISA VE STABİL PARÇALAR (Negatif uçlar)



DCBN(RL) EXT 75°

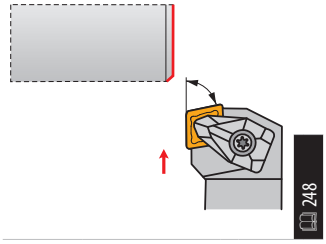
CN..



246

DCKN(RL) EXT 75°

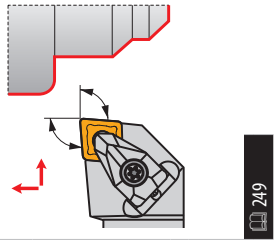
CN..



248

DCLN(RL) EXT 95°

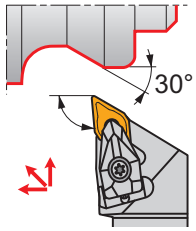
CN..



249

DDJN(RL) EXT 93°

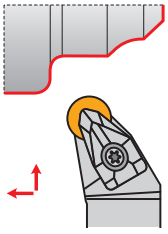
DN..



263

DRSN(RL) EXT

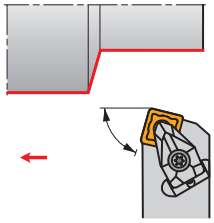
RN..



277

DSBN(RL) EXT 45°

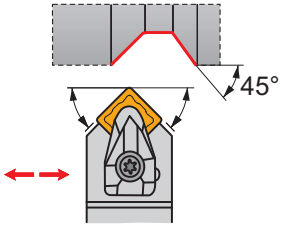
SN..



280

DSDNN EXT 45°

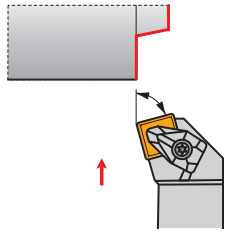
SN..



281

DSKN(RL) EXT 75°

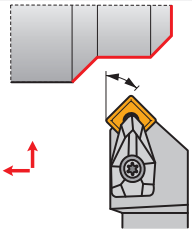
SN..



282

DSSN(RL) EXT 45°

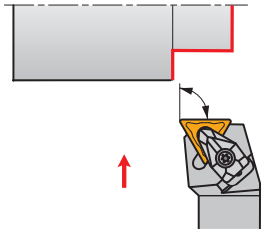
SN..



283

DTFN(RL) EXT 90°

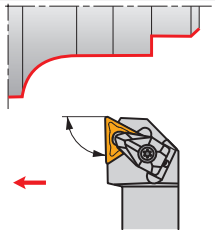
TN..



299

DTGN(RL) EXT 90°

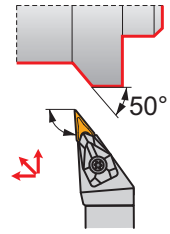
TN..



300

DVJN(RL) EXT 93°

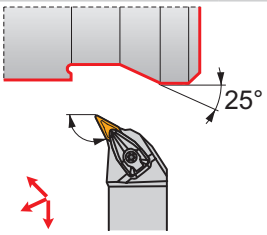
VN..



309

DVPN(RL) EXT 62°30′

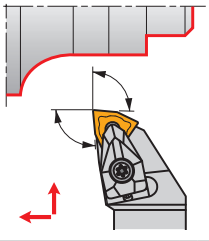
VN..



310

DWLN(RL) EXT 95°

WN..

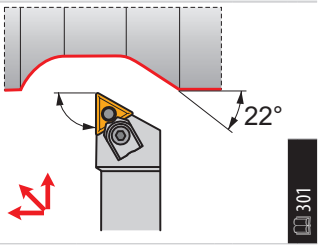


314

M SIKMA TIPI

MTJN(RL) EXT 93°

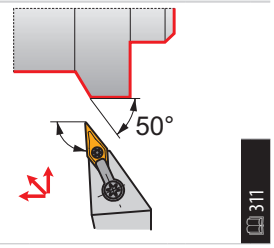
TN..



301

MVJN(RL) EXT 93°

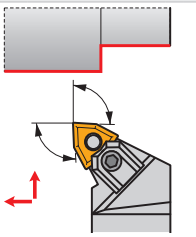
VN..



311

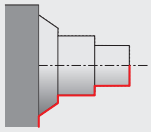
MWLN(RL) EXT 95°

WN..

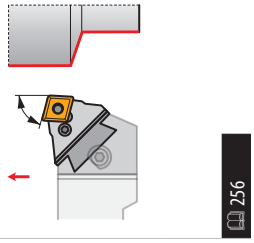


316

ISO TORNALAMA - AĞIR KABA - DIŞ
KAFA (KH)

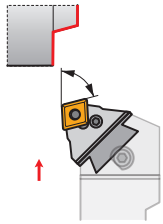


KHP-CBNR 75°
CN..



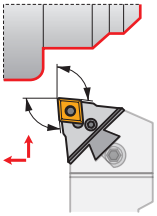
256

KHP-CBNL 75°
CN..



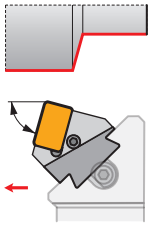
256

KHP-CLNR/L 95°
CN..



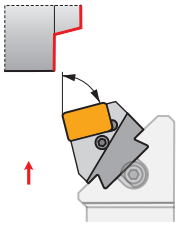
257

KHP-LBNR 75°
LN..



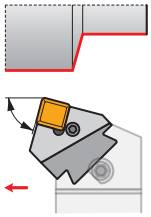
275

KHP-LBNL 75°
LN..



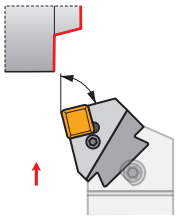
275

KHP-SBNR 75°
SN..



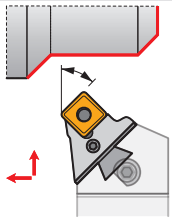
295

KHP-SBNL 75°
SN..



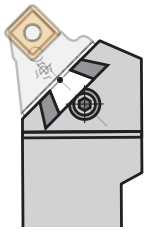
295

KHP-SSNR/L 45°
SN..



296

DKH(RL)



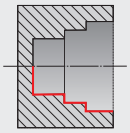
258, 276, 297

P SIKMA TIPI

TAKIMLAR - REHBER

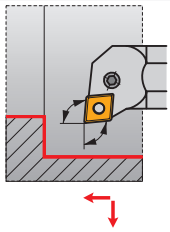
ISO TORNALAMA - İÇ

KISA VE STABİL PARÇALAR (Negatif uçlar)



PCLN(RL) INT 95°

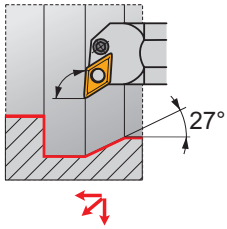
CN..



260

PDUN(RL) INT 93°

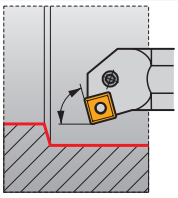
DN..



271

PSKN(RL) INT 93°

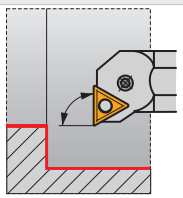
SN..



298

PTFN(RL) INT 90°

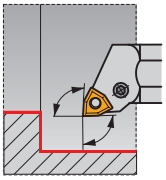
TN..



307

PWLN(RL) INT 95°

WN..



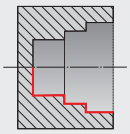
320

D SIKMA TIPI

TAKIMLAR - REHBER

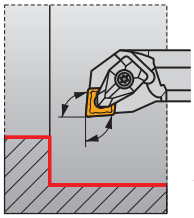
ISO TORNALAMA - İÇ

KISA VE STABİL PARÇALAR (Negatif uçlar)



DCLN(RL) INT 95°

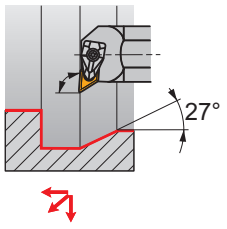
CN..



259

DDUN(RL) INT 93°

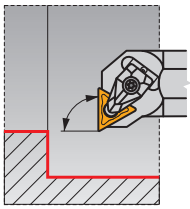
DN..



270

DTFN(RL) INT 90°

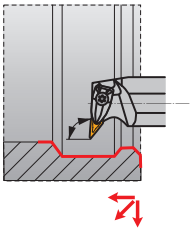
TN..



306

DVUN(RL) INT

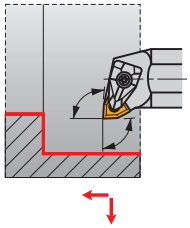
VN..



313

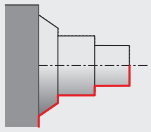
DWLN(RL) INT 95°

WN..

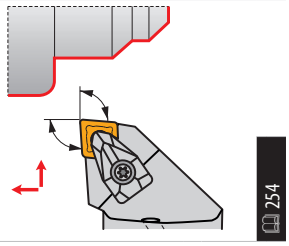


319

ISO TORNALAMA - DIŞ PSC
KISA VE STABİL PARÇALAR (Negatif uçlar)

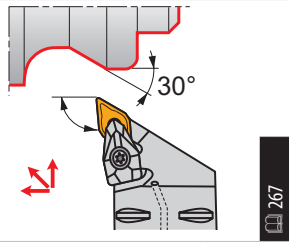


C.-DCLN(RL) EXT 95°
CN..



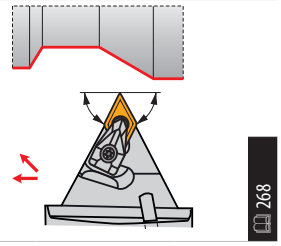
254

C.-DDJN(RL) EXT 93°
DN..



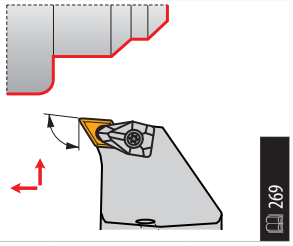
267

C.-DDNNN EXT 62.5°
DN..



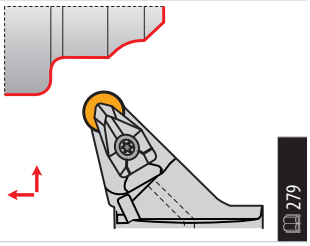
268

C.-DDUN(RL) EXT 93°
DN..



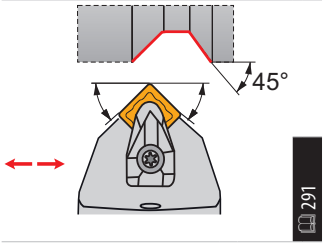
269

C.-DRSN(RL) EXT
RN..



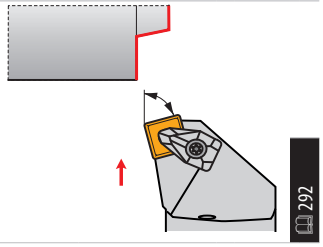
279

C.-DSDNN EXT 45°
SN..



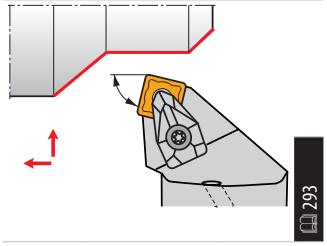
291

C.-DSKN(RL) EXT 75°
SN..



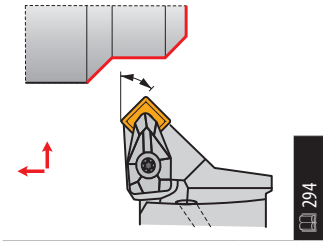
292

C.-DSRN(RL) EXT 75°
SN..



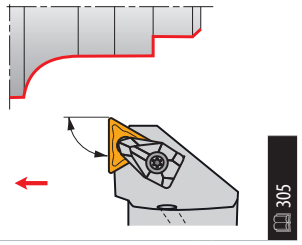
293

C.-DSSN(RL) EXT 45°
SN..



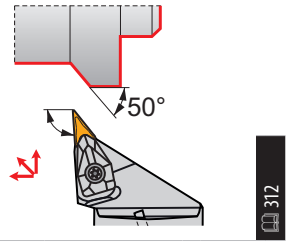
294

C.-DTJN(RL) EXT 93°
TN..



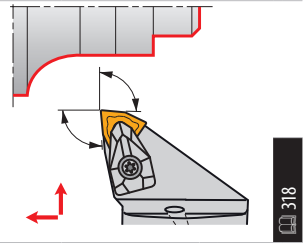
305

C.-DVJN(RL) EXT 93°
VN..



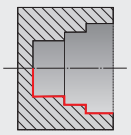
312

C.-DWLN(RL) EXT 95°
WN..

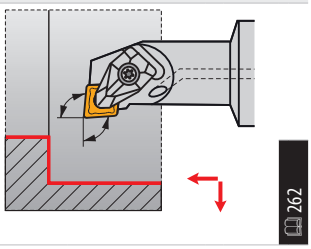


318

ISO TORNALAMA - İÇ PSC
KISA VE STABİL PARÇALAR (Negatif uçlar)

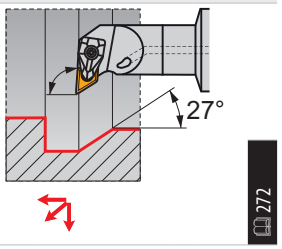


C.-DCLN(RL) INT 95°
CN..



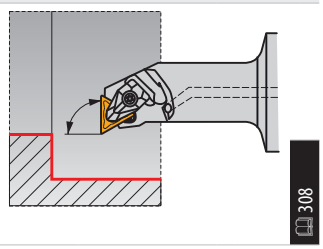
262

C.-DDUN(RL) INT 93°
DN..



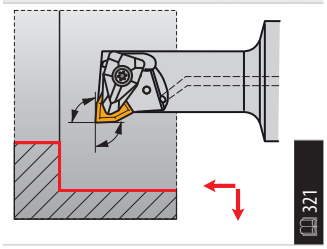
272

C.-DTFN(RL) INT 91°
TN..



308

C.-DWLN(RL) INT 95°
WN..



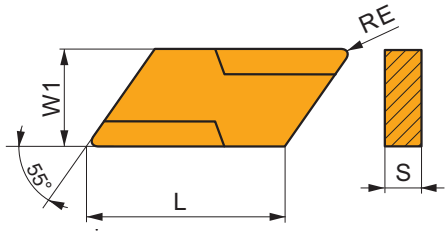
321



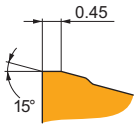
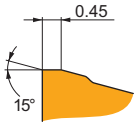
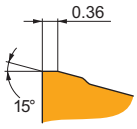
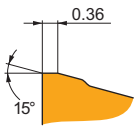
DIĞER KARBÜR VE SERMET UÇLAR

KNUX

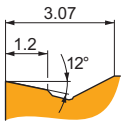
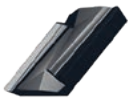
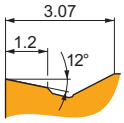
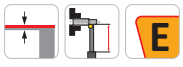
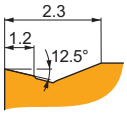
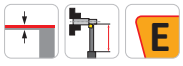
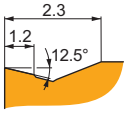
	W1	L	S
	(mm)	(mm)	(mm)
1604	9.525	19.50	4.76



Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
																				
L-22 sol kesme yönlü geometri, finişten yarı kaba işlemeye kadar, darbesiz kesimler için.																				
KNUX 160405L-22:T5315	●	0.5	◪ 190	0.25	2.7	–	–	–	◪ 180	0.25	2.7	–	–	–	–	–	–	–	–	–
KNUX 160405L-22:T7325	●	0.5	◪ 130	0.25	2.7	◪ 100	0.25	2.7	–	–	–	–	–	–	–	–	–	–	–	–
KNUX 160405L-22:T7335	●	0.5	◪ 125	0.25	2.7	◪ 95	0.25	2.7	–	–	–	–	–	–	–	–	–	–	–	–
KNUX 160405L-22:T9325	●	0.5	■ 155	0.25	2.7	◪ 90	0.25	2.7	◪ 145	0.25	2.7	–	–	–	–	–	–	–	–	–
KNUX 160405L-22:T9335	●	0.5	■ 135	0.25	2.7	◪ 80	0.25	2.7	–	–	–	–	–	–	–	–	–	–	–	–
KNUX 160410L-22:T9335	⬌	1.0	■ 155	0.32	2.7	◪ 90	0.29	2.7	–	–	–	–	–	–	–	–	–	–	–	–
																				
R-22 sağ kesme yönlü geometri, finişten yarı kaba işlemeye kadar, darbesiz kesimler için.																				
KNUX 160405R-22:T5315	●	0.5	◪ 190	0.25	2.7	–	–	–	◪ 180	0.25	2.7	–	–	–	–	–	–	–	–	–
KNUX 160405R-22:T7325	●	0.5	◪ 130	0.25	2.7	◪ 100	0.25	2.7	–	–	–	–	–	–	–	–	–	–	–	–
KNUX 160405R-22:T7335	●	0.5	◪ 125	0.25	2.7	◪ 95	0.25	2.7	–	–	–	–	–	–	–	–	–	–	–	–
KNUX 160405R-22:T9325	●	0.5	■ 155	0.25	2.7	◪ 90	0.25	2.7	◪ 145	0.25	2.7	–	–	–	–	–	–	–	–	–
KNUX 160405R-22:T9335	●	0.5	■ 135	0.25	2.7	◪ 80	0.25	2.7	–	–	–	–	–	–	–	–	–	–	–	–
KNUX 160410R-22:T9335	⬌	1.0	■ 155	0.32	2.7	◪ 90	0.29	2.7	–	–	–	–	–	–	–	–	–	–	–	–
																				
L-32 sol kesme yönlü geometri, finişten yarı kaba işlemeye kadar, darbesiz kesimler için.																				
KNUX 160405L-32:T5315	●	0.5	◪ 190	0.25	2.7	–	–	–	◪ 180	0.25	2.7	–	–	–	–	–	–	–	–	–
KNUX 160405L-32:T7325	●	0.5	◪ 130	0.25	2.7	◪ 100	0.25	2.7	–	–	–	–	–	–	–	–	–	–	–	–
KNUX 160405L-32:T7335	●	0.5	◪ 125	0.25	2.7	◪ 95	0.25	2.7	–	–	–	–	–	–	–	–	–	–	–	–
KNUX 160405L-32:T9325	●	0.5	■ 155	0.25	2.7	◪ 90	0.25	2.7	◪ 145	0.25	2.7	–	–	–	–	–	–	–	–	–
KNUX 160405L-32:T9335	●	0.5	■ 135	0.25	2.7	◪ 80	0.25	2.7	–	–	–	–	–	–	–	–	–	–	–	–
KNUX 160410L-32:T9325	●	1.0	■ 175	0.32	2.7	◪ 105	0.29	2.7	◪ 165	0.32	2.7	–	–	–	–	–	–	–	–	–
KNUX 160410L-32:T9335	●	1.0	■ 155	0.32	2.7	◪ 90	0.29	2.7	–	–	–	–	–	–	–	–	–	–	–	–
																				
R-32 sağ kesme yönlü geometri, finişten yarı kaba işlemeye kadar, darbesiz kesimler için.																				
KNUX 160405R-32:T5315	●	0.5	◪ 190	0.25	2.7	–	–	–	◪ 180	0.25	2.7	–	–	–	–	–	–	–	–	–
KNUX 160405R-32:T7325	●	0.5	◪ 130	0.25	2.7	◪ 100	0.25	2.7	–	–	–	–	–	–	–	–	–	–	–	–
KNUX 160405R-32:T7335	●	0.5	◪ 125	0.25	2.7	◪ 95	0.25	2.7	–	–	–	–	–	–	–	–	–	–	–	–
KNUX 160405R-32:T9325	●	0.5	■ 155	0.25	2.7	◪ 90	0.25	2.7	◪ 145	0.25	2.7	–	–	–	–	–	–	–	–	–
KNUX 160405R-32:T9335	●	0.5	■ 135	0.25	2.7	◪ 80	0.25	2.7	–	–	–	–	–	–	–	–	–	–	–	–
KNUX 160410R-32:T9325	●	1.0	■ 175	0.32	2.7	◪ 105	0.29	2.7	◪ 165	0.32	2.7	–	–	–	–	–	–	–	–	–
KNUX 160410R-32:T9335	●	1.0	■ 155	0.32	2.7	◪ 90	0.29	2.7	–	–	–	–	–	–	–	–	–	–	–	–

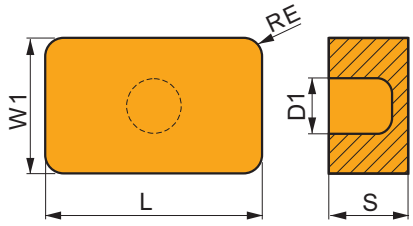
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
   **ER-72** geometri, sağ kesme yönlü tasarım, ince ve finiş işlemeye kadar, ve darbesiz kesim için ugun.																			
KNUX 160405ER-72:T5315	●	0.5	250	0.20	2.0	–	–	–	235	0.20	2.0	–	–	–	–	–	–	–	–	–
KNUX 160405ER-72:T9325	●	0.5	215	0.20	2.0	125	0.18	2.0	200	0.20	2.0	–	–	–	45	0.16	1.6	–	–	–
KNUX 160405ER-72:T9335	●	0.5	185	0.20	2.0	110	0.18	2.0	–	–	–	–	–	–	40	0.16	1.6	–	–	–
   **EL-72** geometri, sol kesme yönlü tasarım, ince ve finiş işlemeye kadar, ve darbesiz kesim için ugun.																			
KNUX 160405EL-72:T5315	●	0.5	250	0.20	2.0	–	–	–	235	0.20	2.0	–	–	–	–	–	–	–	–	–
KNUX 160405EL-72:T9325	●	0.5	215	0.20	2.0	125	0.18	2.0	200	0.20	2.0	–	–	–	45	0.16	1.6	–	–	–
KNUX 160405EL-72:T9335	●	0.5	185	0.20	2.0	110	0.18	2.0	–	–	–	–	–	–	40	0.16	1.6	–	–	–
   **ER-73** geometri, sağ kesme yönlü tasarım, finiş ve yarı kaba işlemeye kadar, ve darbesiz kesim için ugun.																			
KNUX 160405SR-73:6640	●	0.5	150	0.25	3.0	90	0.23	3.0	140	0.25	3.0	–	–	–	–	–	–	–	–	–
KNUX 160410SR-73:6640	⬢	1.0	150	0.40	3.0	90	0.36	3.0	140	0.40	3.0	–	–	–	–	–	–	–	–	–
KNUX 160410SR-73:T5315	●	1.0	235	0.40	3.0	–	–	–	220	0.40	3.0	–	–	–	–	–	–	–	–	–
   **EL-73** geometri, sol kesme yönlü tasarım, finiş ve yarı kaba işlemeye kadar, ve darbesiz kesim için ugun.																			
KNUX 160405SL-73:6640	●	0.5	150	0.25	3.0	90	0.23	3.0	140	0.25	3.0	–	–	–	–	–	–	–	–	–
KNUX 160410SL-73:6640	⬢	1.0	150	0.40	3.0	90	0.36	3.0	140	0.40	3.0	–	–	–	–	–	–	–	–	–

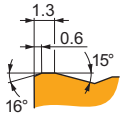
LNUX 40, LN.X 50

PRAMET

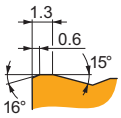
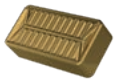
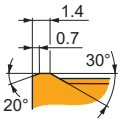
	W1 (mm)	D1 (mm)	L (mm)	S (mm)
40-1	25.200	9.30	40.00	14.00
50-1	25.400	9.30	50.80	14.00
5014	25.400	6.35	50.80	14.00



Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
   **LN.X** ağır kaba işleme ve darbesizden darbeli kesmeye kadar uygun.																			
LNUX 40-1129003:6630	⬢	3.2	45	1.35	25.0	–	–	–	40	1.35	25.0	–	–	–	–	–	–	–	–	–
LNUX 40-1129003:T9325	⬢	3.2	55	1.35	25.0	–	–	–	50	1.35	25.0	–	–	–	–	–	–	–	–	–
LNUX 40-1129003:T9335	⬢	3.2	40	1.35	25.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

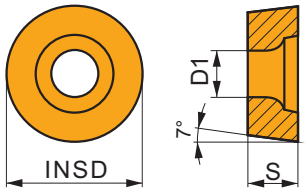
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
LN.X ağır kaba işleme ve darbesizden darbeli kesmeye kadar uygun.																			
LNUX 50-1275000:6630	3.2	45	1.35	25.0	–	–	–	40	1.35	25.0	–	–	–	–	–	–	–	–	–
LNUX 50-1275000:T9325	3.2	55	1.35	25.0	–	–	–	50	1.35	25.0	–	–	–	–	–	–	–	–	–
 																			
LN.X ağır kaba işleme, darbesizden ağır darbeli kesmeye kadar uygun.																			
LNMX 501432E:T9335	3.2	45	1.50	25.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

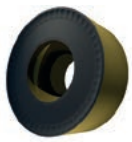
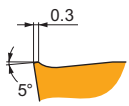
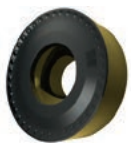
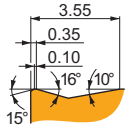
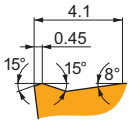
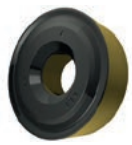
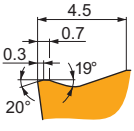
RCMT

PRAMET

	INSD (mm)	D1 (mm)	S (mm)
1606	16.000	5.50	6.35
2006	20.000	6.50	6.35
2507	25.000	8.60	7.94
3009	30.000	10.00	9.53

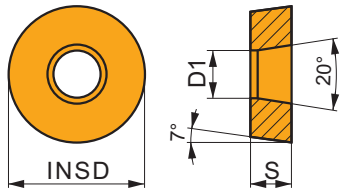


Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

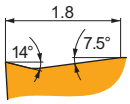
Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
37 geometri yarı kabadan ağır kaba işlemeye kadar, ve darbesizden darbeli kesime kadar uygun.																			
RCMT 1606MOS-37:T9325	–	145	0.60	3.0	–	–	–	135	0.60	3.0	–	–	–	–	–	–	–	–	–
RCMT 1606MOS-37:T9415	–	200	0.60	3.0	–	–	–	190	0.60	3.0	–	–	–	–	–	–	–	–	–
 																			
371 geometri yarı kabadan ağır kaba işlemeye kadar, ve darbesizden darbeli kesime kadar uygun.																			
RCMT 2006MOS-371:T9325	–	125	0.80	3.0	–	–	–	115	0.80	3.0	–	–	–	–	–	–	–	–	–
RCMT 2006MOS-371:T9415	–	185	0.80	3.0	–	–	–	175	0.80	3.0	–	–	–	–	–	–	–	–	–
 																			
372 geometri yarı kabadan ağır kaba işlemeye kadar, ve darbesizden darbeli kesime kadar uygun.																			
RCMT 2507MOS-372:T9325	–	90	0.80	3.0	–	–	–	85	0.80	3.0	–	–	–	–	–	–	–	–	–
 																			
RR4 ağır kaba işleme için geometrisi ve sürekli ila ağır kesintili kesimler.																			
RCMT 3009MO-RR4:T9310	–	90	1.10	4.0	–	–	–	85	1.10	4.0	–	–	–	–	–	–	–	–	–
RCMT 3009MO-RR4:T9315	–	85	1.10	4.0	–	–	–	80	1.10	4.0	–	–	–	–	–	–	–	–	–
RCMT 3009MO-RR4:T9415	–	95	1.10	4.0	–	–	–	90	1.10	4.0	–	–	–	–	–	–	–	–	–

RCMX

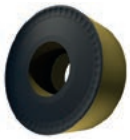
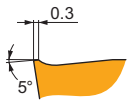
	INSD (mm)	D1 (mm)	S (mm)
1003	10.000	3.60	3.18
1204	12.000	4.20	4.76
1606	16.000	5.20	6.35
2006	20.000	6.50	6.35
2507	25.000	7.20	7.94
3209	32.000	9.50	9.53



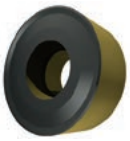
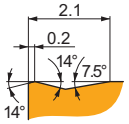
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
RCMX 1003MOS-31:T9325	–	165	0.50	2.0	95	0.45	2.0	155	0.50	2.0	–	–	–	–	–	–	–	–	–

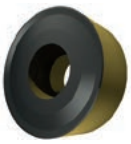
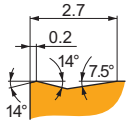
31 geometri finişten yarı kaba işlemeye kadar, ve darbesizden darbeli kesime kadar uygun.

 																			
RCMX 1606MOS-37:T9325	–	145	0.60	3.0	–	–	–	135	0.60	3.0	–	–	–	–	–	–	–	–	–
RCMX 1606MOS-37:T9415	–	200	0.60	3.0	–	–	–	190	0.60	3.0	–	–	–	–	–	–	–	–	–
RCMX 2006MOS-37:6630	–	135	0.60	3.0	–	–	–	125	0.60	3.0	–	–	–	–	–	–	–	–	–
RCMX 2507MOS-37:6630	–	90	0.60	3.0	–	–	–	85	0.60	3.0	–	–	–	–	–	–	–	–	–

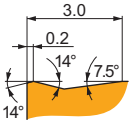
37 geometri yarı kabadan ağır kaba işlemeye kadar, ve darbesizden darbeli kesime kadar uygun.

 																			
RCMX 1204MOS-321:T9325	–	120	1.00	3.0	–	–	–	110	1.00	3.0	–	–	–	–	–	–	–	–	–
RCMX 1204MOS-321:T9415	–	170	1.00	3.0	–	–	–	160	1.00	3.0	–	–	–	–	–	–	–	–	–

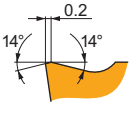
321 geometri yarı kabadan ağır kaba işlemeye kadar, ve darbesizden darbeli kesime kadar uygun.

 																			
RCMX 1606MOS-331:6630	–	100	1.20	3.5	–	–	–	95	1.20	3.5	–	–	–	–	–	–	–	–	–
RCMX 1606MOS-331:T9325	–	105	1.20	3.5	–	–	–	95	1.20	3.5	–	–	–	–	–	–	–	–	–
RCMX 1606MOS-331:T9335	–	110	0.80	3.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
RCMX 1606MOS-331:T9415	–	155	1.20	3.5	–	–	–	145	1.20	3.5	–	–	–	–	–	–	–	–	–

331 geometri yarı kabadan ağır kaba işlemeye kadar, ve darbesizden darbeli kesime kadar uygun.

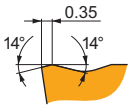
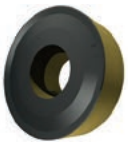
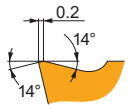
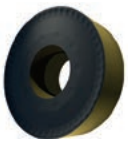
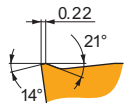
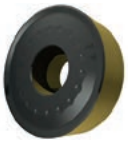
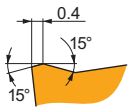
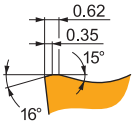
 																			
RCMX 2006MOS-341:6630	–	105	1.00	3.5	–	–	–	95	1.00	3.5	–	–	–	–	–	–	–	–	–
RCMX 2006MOS-341:6640	–	90	1.00	3.5	–	–	–	85	1.00	3.5	–	–	–	–	–	–	–	–	–

341 geometri yarı kabadan ağır kaba işlemeye kadar, ve darbesizden darbeli kesime kadar uygun.

 																			
RCMX 2507MOS-351:6630	–	70	1.00	3.5	–	–	–	65	1.00	3.5	–	–	–	–	–	–	–	–	–
RCMX 2507MOS-351:6640	–	60	1.00	3.5	–	–	–	55	1.00	3.5	–	–	–	–	–	–	–	–	–

351 geometri yarı kabadan ağır kaba işlemeye kadar, ve darbesizden darbeli kesime kadar uygun.

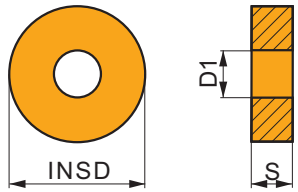
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P			M			K			N			S			H		
			vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)
																				
361 geometri kabadan ağır kaba işlemeye kadar, ve darbesizden darbeli kesime kadar uygun.																				
RCMX 3209M0S-361:6640		–	50	1.40	4.5	–	–	–	45	1.40	4.5	–	–	–	–	–	–	–	–	–
																				
RF1 geometri, finişten yarı kaba işlemeye kadar, ve darbesizden darbeli kesime kadar uygun.																				
RCMX 2006M0-RF1:T5305		–	105	0.80	3.5	–	–	–	95	0.80	3.5	–	–	–	–	–	–	–	–	–
RCMX 2006M0-RF1:T9310		–	105	0.80	3.5	–	–	–	95	0.80	3.5	–	–	–	–	–	–	–	–	–
RCMX 2006M0-RF1:T9315		–	100	0.80	3.5	–	–	–	95	0.80	3.5	–	–	–	–	–	–	–	–	–
RCMX 2006M0-RF1:T9325		–	90	0.80	3.5	–	–	–	85	0.80	3.5	–	–	–	–	–	–	–	–	–
RCMX 2006M0-RF1:T9335		–	110	0.80	3.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
RCMX 2006M0-RF1:T9415		–	105	0.80	3.5	–	–	–	95	0.80	3.5	–	–	–	–	–	–	–	–	–
RCMX 2507M0-RF1:T8345		–	45	1.00	3.5	–	–	–	40	1.00	3.5	–	–	–	–	–	–	–	–	–
RCMX 2507M0-RF1:T9310		–	95	1.00	3.5	–	–	–	90	1.00	3.5	–	–	–	–	–	–	–	–	–
RCMX 2507M0-RF1:T9325		–	80	1.00	3.5	–	–	–	75	1.00	3.5	–	–	–	–	–	–	–	–	–
RCMX 2507M0-RF1:T9335		–	65	1.00	3.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
RCMX 2507M0-RF1:T9415		–	100	1.00	3.5	–	–	–	95	1.00	3.5	–	–	–	–	–	–	–	–	–
																				
RM1 geometri, finişten kaba işlemeye kadar, ve darbesizden darbeli kesime kadar uygun.																				
RCMX 2006M0-RM1:T9310		–	95	1.00	3.5	–	–	–	90	1.00	3.5	–	–	–	–	–	–	–	–	–
RCMX 2006M0-RM1:T9315		–	90	1.00	3.5	–	–	–	85	1.00	3.5	–	–	–	–	–	–	–	–	–
RCMX 2006M0-RM1:T9325		–	80	1.00	3.5	–	–	–	75	1.00	3.5	–	–	–	–	–	–	–	–	–
RCMX 2006M0-RM1:T9335		–	125	0.60	3.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
RCMX 2006M0-RM1:T9415		–	100	1.00	3.5	–	–	–	95	1.00	3.5	–	–	–	–	–	–	–	–	–
RCMX 2507M0-RM1:T9310		–	95	1.00	3.5	–	–	–	90	1.00	3.5	–	–	–	–	–	–	–	–	–
RCMX 2507M0-RM1:T9315		–	90	1.00	3.5	–	–	–	85	1.00	3.5	–	–	–	–	–	–	–	–	–
RCMX 2507M0-RM1:T9325		–	80	1.00	3.5	–	–	–	75	1.00	3.5	–	–	–	–	–	–	–	–	–
RCMX 2507M0-RM1:T9335		–	80	0.60	3.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
RCMX 2507M0-RM1:T9415		–	100	1.00	3.5	–	–	–	95	1.00	3.5	–	–	–	–	–	–	–	–	–
																				
RM2 geometri, yarı kabadan kaba işlemeye kadar, ve darbesizden darbeli kesime kadar uygun.																				
RCMX 2507M0-RM2:T9310		–	90	1.10	3.5	–	–	–	85	1.10	3.5	–	–	–	–	–	–	–	–	–
RCMX 2507M0-RM2:T9325		–	75	1.10	3.5	–	–	–	70	1.10	3.5	–	–	–	–	–	–	–	–	–
RCMX 2507M0-RM2:T9415		–	95	1.10	3.5	–	–	–	90	1.10	3.5	–	–	–	–	–	–	–	–	–
RCMX 3209M0-RM2:T5315		–	95	1.00	4.5	–	–	–	90	1.00	4.5	–	–	–	–	–	–	–	–	–
RCMX 3209M0-RM2:T9310		–	90	1.00	4.5	–	–	–	85	1.00	4.5	–	–	–	–	–	–	–	–	–
RCMX 3209M0-RM2:T9315		–	85	1.00	4.5	–	–	–	80	1.00	4.5	–	–	–	–	–	–	–	–	–
RCMX 3209M0-RM2:T9325		–	75	1.00	4.5	–	–	–	70	1.00	4.5	–	–	–	–	–	–	–	–	–
RCMX 3209M0-RM2:T9335		–	55	1.40	4.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
RCMX 3209M0-RM2:T9415		–	95	1.00	4.5	–	–	–	90	1.00	4.5	–	–	–	–	–	–	–	–	–
																				
RR2 geometri, ağır kaba işleme, ve darbesizden darbeli kesime kadar uygun.																				
RCMX 3209M0-RR2:T9315		–	60	1.40	4.5	–	–	–	55	1.40	4.5	–	–	–	–	–	–	10	0.70	2.0
RCMX 3209M0-RR2:T9415		–	70	1.40	4.5	–	–	–	65	1.40	4.5	–	–	–	–	–	–	10	0.70	2.0

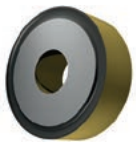
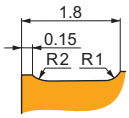
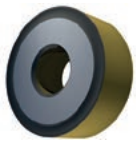
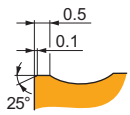
RNMG

PRAMET

	INSD (mm)	D1 (mm)	S (mm)
1204	12.700	5.16	4.76
1506	15.875	6.35	6.35
1906	19.050	7.94	6.35
2509	25.400	9.12	9.53



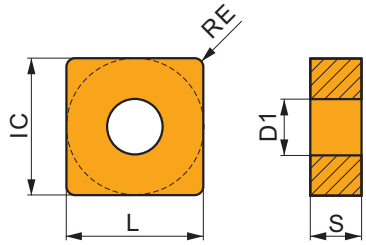
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
08 geometri yarı kabadan ağır kaba işlemeye kadar, ve darbesizden darbeli kesime kadar uygun.																				
RNMG 120400E-08:T5305	●	–	195	0.70	3.0	–	–	–	185	0.70	3.0	–	–	–	–	–	–	35	0.35	0.8
RNMG 120400E-08:T9325	●	–	135	0.70	3.0	–	–	–	125	0.70	3.0	–	–	–	–	–	–	–	–	–
RNMG 120400E-08:T9415	●	–	190	0.70	3.0	–	–	–	180	0.70	3.0	–	–	–	–	–	–	35	0.35	0.8
RNMG 150600E-08:T5305	●	–	195	0.70	3.0	–	–	–	185	0.70	3.0	–	–	–	–	–	–	35	0.35	1.0
RNMG 150600E-08:T9325	✱	–	205	0.70	3.0	–	–	–	190	0.70	3.0	–	–	–	–	–	–	–	–	–
RNMG 150600E-08:T9415	●	–	190	0.70	3.0	–	–	–	180	0.70	3.0	–	–	–	–	–	–	35	0.35	1.0
RNMG 190600E-08:T9325	●	–	135	0.70	3.0	–	–	–	125	0.70	3.0	–	–	–	–	–	–	–	–	–
RNMG 190600E-08:T9415	●	–	190	0.70	3.0	–	–	–	180	0.70	3.0	–	–	–	–	–	–	35	0.35	1.3
																				
081 geometri kabadan ağır kaba işlemeye kadar, ve darbesizden darbeli kesime kadar uygun.																				
RNMG 250900E-081:T9325	✱	–	130	0.90	5.0	–	–	–	120	0.90	5.0	–	–	–	–	–	–	–	–	–
RNMG 250900E-081:T9415	●	–	100	0.90	5.0	–	–	–	95	0.90	5.0	–	–	–	–	–	–	20	0.45	1.7

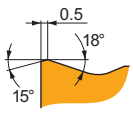
SNMM

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
2507	25.400	9.12	25.40	7.94
2509	25.400	9.12	25.40	9.53



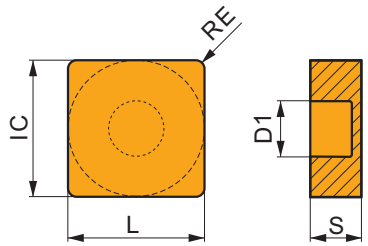
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	Interrupted/ Continuous cut	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
SR geometri, kabadan ağır kaba işlemeye kadar, ve darbesizden darbeli kesime kadar uygun.																				
SNMM 250724S-SR:T9325	✱	2.4	80	1.00	12.0	45	0.90	12.0	75	1.00	12.0	–	–	–	–	–	–	–	–	–
SNMM 250924S-SR:6630	✱	2.4	65	1.00	14.0	35	0.90	14.0	60	1.00	14.0	–	–	–	–	–	–	–	–	–
SNMM 250924S-SR:T9335	✱	2.4	65	1.00	14.0	35	0.90	14.0	–	–	–	–	–	–	–	–	–	–	–	–

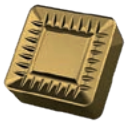
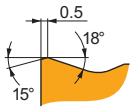
SNMX

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
2512	25.400	9.17	25.40	12.00



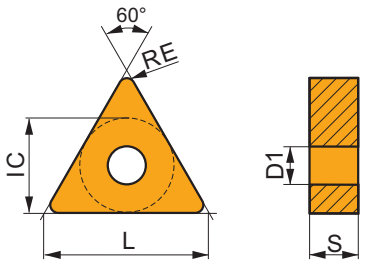
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
SR geometri, kabadan ağır kaba işlemeye kadar, ve darbesizden darbeli kesime kadar uygun.																			
SNMX 251224S-SR:6630	2.4	65	1.00	14.0	35	0.90	14.0	60	1.00	14.0	–	–	–	–	–	–	–	–	–
SNMX 251224S-SR:T8345	2.4	45	1.00	14.0	25	0.90	14.0	40	1.00	14.0	–	–	–	–	–	–	–	–	–
SNMX 251224S-SR:T9325	2.4	80	1.00	14.0	45	0.90	14.0	75	1.00	14.0	–	–	–	–	–	–	–	–	–
SNMX 251224S-SR:T9335	2.4	65	1.00	14.0	35	0.90	14.0	–	–	–	–	–	–	–	–	–	–	–	–

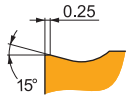
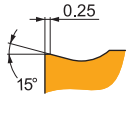
TNMM

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
2204	12.700	5.16	22.00	4.76



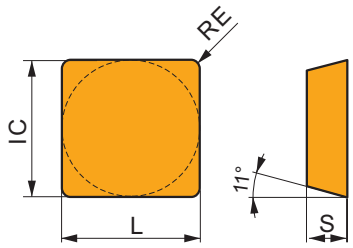
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
ER geometri, sağ kesme yönlü tasarım, orta ve yarı kaba işlemeye kadar, ve darbesiz kesim için ugun.																			
TNMM 220412ER:T9335	1.2	190	0.35	2.1	110	0.32	2.1	–	–	–	–	–	–	40	0.25	1.7	–	–	–
 																			
EL geometri, sol kesme yönlü tasarım, orta ve yarı kaba işlemeye kadar, ve darbesiz kesim için ugun.																			
TNMM 220412EL:T9335	1.2	190	0.35	2.1	110	0.32	2.1	–	–	–	–	–	–	40	0.25	1.7	–	–	–

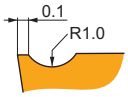
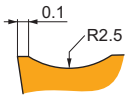
SPMR

PRAMET

	IC (mm)	L (mm)	S (mm)
0903	9.525	9.53	3.18
1203	12.700	12.70	3.18



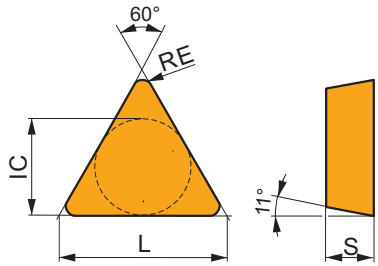
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
46 geometri inceden finiş işlemeye kadar, ve darbesizden darbeli kesime kadar uygun.																			
SPMR 090304E-46:T9325	0.4	215	0.15	1.0	125	0.15	1.0	200	0.15	1.0	–	–	–	–	–	–	–	–	–
SPMR 090308E-46:T9325	0.8	255	0.15	1.0	150	0.15	1.0	240	0.15	1.0	–	–	–	–	–	–	–	–	–
 																			
48 geometri finişten yarı kaba işlemeye kadar, ve darbesizden darbeli kesime kadar uygun.																			
SPMR 120304E-48:T9325	0.4	170	0.22	2.2	100	0.22	2.2	160	0.22	2.2	–	–	–	–	–	–	–	–	–
SPMR 120304E-48:T9335	0.4	145	0.22	2.2	85	0.22	2.2	–	–	–	–	–	–	–	–	–	–	–	–
SPMR 120308E-48:6640	0.8	160	0.22	2.2	95	0.22	2.2	150	0.22	2.2	–	–	–	–	–	–	–	–	–
SPMR 120308E-48:T9325	0.8	205	0.22	2.2	120	0.22	2.2	190	0.22	2.2	–	–	–	–	–	–	–	–	–
SPMR 120308E-48:T9335	0.8	175	0.22	2.2	105	0.22	2.2	–	–	–	–	–	–	–	–	–	–	–	–
SPMR 120312E-48:T9325	1.2	215	0.22	2.2	125	0.22	2.2	200	0.22	2.2	–	–	–	–	–	–	–	–	–

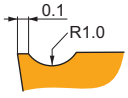
TPMR

PRAMET

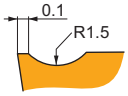
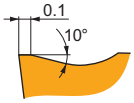
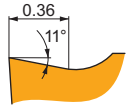
	IC (mm)	L (mm)	S (mm)
1103	6.350	11.00	3.18
1603	9.525	16.50	3.18



Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
46 geometri inceden finiş işlemeye kadar, ve darbesizden darbeli kesime kadar uygun.																			
TPMR 110304E-46:6640	0.4	140	0.15	1.0	80	0.14	1.0	130	0.15	1.0	–	–	–	–	–	–	–	–	–
TPMR 110304E-46:T9325	0.4	175	0.15	1.0	105	0.15	1.0	165	0.15	1.0	–	–	–	–	–	–	–	–	–
TPMR 110304E-46:T9335	0.4	150	0.15	1.0	90	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–
TPMR 110308E-46:6640	0.8	170	0.15	1.0	100	0.14	1.0	160	0.15	1.0	–	–	–	–	–	–	–	–	–
TPMR 110308E-46:T9325	0.8	205	0.15	1.0	120	0.15	1.0	190	0.15	1.0	–	–	–	–	–	–	–	–	–
TPMR 110308E-46:T9335	0.8	180	0.15	1.0	105	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–

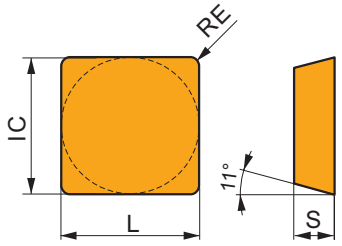
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
47 geometri finişten yarı kaba işlemeye kadar, ve darbesizden darbeli kesime kadar uygun.																			
TPMR 160304E-47:6640	0.4	120	0.20	1.5	70	0.18	1.5	110	0.20	1.5	–	–	–	–	–	–	–	–	–
TPMR 160304E-47:T9325	0.4	150	0.20	1.5	90	0.18	1.5	140	0.20	1.5	–	–	–	–	–	–	–	–	–
TPMR 160304E-47:T9335	0.4	125	0.20	1.5	75	0.18	1.5	–	–	–	–	–	–	–	–	–	–	–	–
TPMR 160308E-47:6640	0.8	140	0.20	1.5	80	0.18	1.5	130	0.20	1.5	–	–	–	–	–	–	–	–	–
TPMR 160308E-47:T9325	0.8	175	0.20	1.5	105	0.18	1.5	165	0.20	1.5	–	–	–	–	–	–	–	–	–
TPMR 160308E-47:T9335	0.8	150	0.20	1.5	90	0.18	1.5	–	–	–	–	–	–	–	–	–	–	–	–
TPMR 160312E-47:T9325	1.2	185	0.20	1.5	110	0.18	1.5	175	0.20	1.5	–	–	–	–	–	–	–	–	–
TPMR 160312E-47:T9335	1.2	160	0.20	1.5	95	0.18	1.5	–	–	–	–	–	–	–	–	–	–	–	–
 																			
61 geometri orta kesme hızları ve talaş derinliklerinde finiş işleme, ve darbesizden darbeli kesime kadar uygun.																			
TPMR 160308E-61:T9325	0.8	135	0.35	1.8	80	0.32	1.8	125	0.35	1.8	–	–	–	–	–	–	–	–	–
TPMR 160308E-61:T9335	0.8	120	0.35	1.8	70	0.32	1.8	–	–	–	–	–	–	–	–	–	–	–	–
 																			
PF2 geometri, inceden finiş işlemeye kadar, ve darbesiz kesim için uygun.																			
TPMR 110304-PF2:TT010	0.4	255	0.10	0.5	150	0.10	0.5	–	–	–	–	–	–	–	–	–	–	–	–
TPMR 160304-PF2:TT010	0.4	255	0.10	0.5	150	0.10	0.5	–	–	–	–	–	–	–	–	–	–	–	–

SPUN-IT

PRAMET

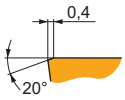
	IC (mm)	L (mm)	M (mm)	S (mm)
1203	12.700	12.70	2.3	3.18
1504	15.875	15.88	2.8	4.76
1904	19.050	19.05	3.5	4.76
2506	25.400	25.40	4.4	6.35



Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
SPUN ince finişten yarı kaba işlemeye kadar ve darbesizden hafif darbeli kesmeye kadar uygun.																			
SPUN 120308:6640	0.8	180	0.15	4.0	–	–	–	170	0.15	4.0	–	–	–	–	–	–	–	–	–
SPUN 120312:6640	1.2	190	0.15	4.0	–	–	–	180	0.15	4.0	–	–	–	–	–	–	–	–	–
SPUN 150408:6640	0.8	155	0.20	5.0	–	–	–	145	0.20	5.0	–	–	–	–	–	–	–	–	–

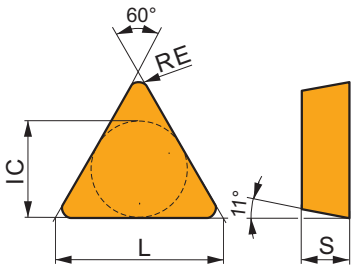
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 		**SPUN** ince finişten yarı kaba işlemeye kadar ve darbesizden hafif darbeli kesmeye kadar uygun.																	
SPUN 150412:6640	1.2	165	0.20	5.0	–	–	–	155	0.20	5.0	–	–	–	–	–	–	–	–	–
SPUN 190408:6640	0.8	150	0.20	6.0	–	–	–	140	0.20	6.0	–	–	–	–	–	–	–	–	–
SPUN 190412:6640	1.2	160	0.20	6.0	–	–	–	150	0.20	6.0	–	–	–	–	–	–	–	–	–
SPUN 190416:6640	1.6	165	0.20	6.0	–	–	–	155	0.20	6.0	–	–	–	–	–	–	–	–	–
 		**SPUN..S** ince finişten yarı kaba işlemeye kadar ve darbesizden hafif darbeli kesmeye kadar uygun.																	
SPUN 250620S:6640	2.0	80	0.40	12.0	–	–	–	75	0.40	12.0	–	–	–	–	–	–	–	–	–

TPUN-IT

PRAMET

	IC (mm)	L (mm)	S (mm)
1103	6.350	11.00	3.18
1603	9.525	16.50	3.18
2204	12.700	22.00	4.76
2706	15.875	27.50	6.35
3306	19.050	33.00	6.35



Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 		**TPUN** ince finişten yarı kaba işlemeye kadar ve darbesizden hafif darbeli kesmeye kadar uygun.																	
TPUN 110304:6640	0.4	135	0.10	1.2	–	–	–	125	0.10	1.2	–	–	–	–	–	–	–	–	–
TPUN 110308:6640	0.8	125	0.18	1.2	–	–	–	115	0.18	1.2	–	–	–	–	–	–	–	–	–
TPUN 160304:6640	0.4	135	0.10	1.5	–	–	–	125	0.10	1.5	–	–	–	–	–	–	–	–	–
TPUN 160308:6640	0.8	125	0.18	1.5	–	–	–	115	0.18	1.5	–	–	–	–	–	–	–	–	–
TPUN 160312:6640	1.2	125	0.20	1.5	–	–	–	115	0.20	1.5	–	–	–	–	–	–	–	–	–
TPUN 220408:6640	0.8	120	0.18	2.0	–	–	–	110	0.18	2.0	–	–	–	–	–	–	–	–	–
TPUN 220412:6640	1.2	120	0.20	2.0	–	–	–	110	0.20	2.0	–	–	–	–	–	–	–	–	–
 		**TPUN..S** ince finişten yarı kaba işlemeye kadar ve darbesizden hafif darbeli kesmeye kadar uygun.																	
TPUN 270616S:6640	1.6	65	0.30	5.0	–	–	–	60	0.30	5.0	–	–	–	–	–	–	–	–	–
TPUN 330620S:6640	2.0	65	0.30	5.0	–	–	–	60	0.30	5.0	–	–	–	–	–	–	–	–	–

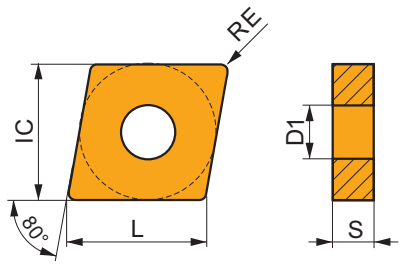


İLERI MALZEME UÇLARI

CNGA CER

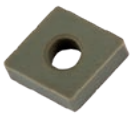
PRAMET

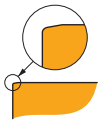
	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1204	12.700	5.16	12.90	4.76



Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
CNGA 120404 T02020:TC100	●	0.4	–	–	–	–	–	–	■ 590	0.10	2.0	–	–	–	–	–	–	–	–	–
CNGA 120408 T01020:TC100	●	0.8	–	–	–	–	–	–	■ 550	0.20	2.0	–	–	–	–	–	–	–	–	–
CNGA 120412 T01020:TC100	●	1.2	–	–	–	–	–	–	■ 540	0.25	2.0	–	–	–	–	–	–	–	–	–





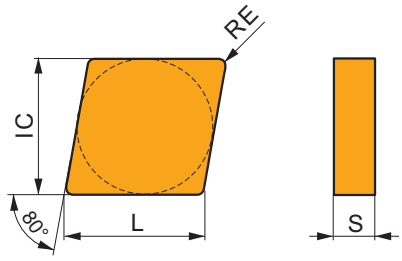
HSC T

CER yüksek hızlı işleme ve darbesiz kesme için.

CNGN CER

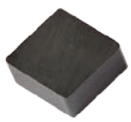
PRAMET

	IC	L	S
	(mm)	(mm)	(mm)
1204	12.700	12.90	4.76
1207	12.700	12.90	7.94



Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
CNGN 120408 T01020:TC100	●	0.8	–	–	–	–	–	–	■ 550	0.20	2.0	–	–	–	–	–	–	–	–	–
CNGN 120708 T01020:TC100	●	0.8	–	–	–	–	–	–	■ 550	0.20	2.0	–	–	–	–	–	–	–	–	–
CNGN 120712 T01020:TC100	●	1.2	–	–	–	–	–	–	■ 540	0.25	2.0	–	–	–	–	–	–	–	–	–





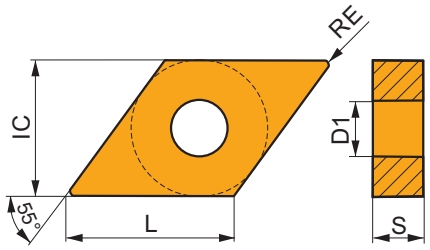
HSC T

CER yüksek hızlı işleme ve darbesiz kesme için.

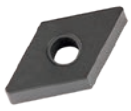
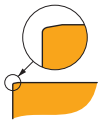
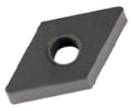
DNGA CER

PRAMET

	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1504	12.700	5.16	15.50	4.76



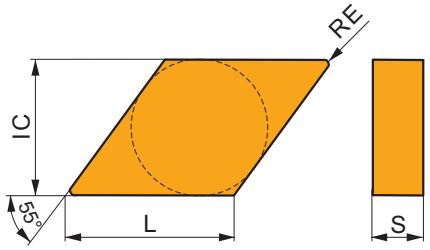
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
			HSC S																	
CER yüksek hızlı işleme ve darbesiz kesme için.																				
DNGA 150408 S02020:TC100	●	0.8	–	–	–	–	–	–	■	450	0.20	1.5	–	–	–	–	–	–	–	–	–
			HSC T																	
CER yüksek hızlı işleme ve darbesiz kesme için.																				
DNGA 150404 T01020:TC100	●	0.4	–	–	–	–	–	–	■	475	0.10	1.5	–	–	–	–	–	–	–	–	–
DNGA 150408 T00520:TC100	●	0.8	–	–	–	–	–	–	■	450	0.20	1.5	–	–	–	–	–	–	–	–	–

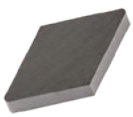
DNGN CER

PRAMET

	IC	L	S
	(mm)	(mm)	(mm)
1504	12.700	15.50	4.76



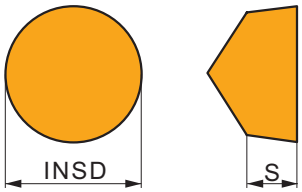
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
			HSC T																	
CER yüksek hızlı işleme ve darbesiz kesme için.																				
DNGN 150408 T01020:TC100	●	0.8	–	–	–	–	–	–	■	450	0.20	1.5	–	–	–	–	–	–	–	–	–

RCGX CER

PRAMET

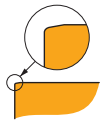
	INSD (mm)	S (mm)
0606	6.350	6.35
0907	9.525	7.94
1207	12.700	7.94



Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
RCGX 060600 K15015:TC100	●	–	–	–	–	–	–	–	■ 365	0.30	0.8	–	–	–	–	–	–	–	–	–
RCGX 090700 K15015:TC100	●	–	–	–	–	–	–	–	■ 410	0.20	1.2	–	–	–	–	–	–	–	–	–
RCGX 120700 K15015:TC100	●	–	–	–	–	–	–	–	■ 405	0.20	1.5	–	–	–	–	–	–	–	–	–





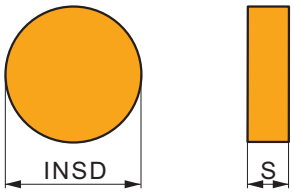
HSC K

CER yüksek hızlı işleme ve darbesiz kesme için.

RNGN CER

PRAMET

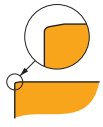
	INSD (mm)	S (mm)
0903	9.525	3.18
1204	12.700	4.76
1207	12.700	7.94



Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
RNGN 090300 T01020:TC100	●	–	–	–	–	–	–	–	■ 460	0.20	1.2	–	–	–	–	–	–	–	–	–
RNGN 120400 T01020:TC100	●	–	–	–	–	–	–	–	■ 455	0.20	1.5	–	–	–	–	–	–	–	–	–
RNGN 120700 T01020:TC100	●	–	–	–	–	–	–	–	■ 455	0.20	1.5	–	–	–	–	–	–	–	–	–
RNGN 120700 T15015:TC100	●	–	–	–	–	–	–	–	■ 455	0.20	1.5	–	–	–	–	–	–	–	–	–





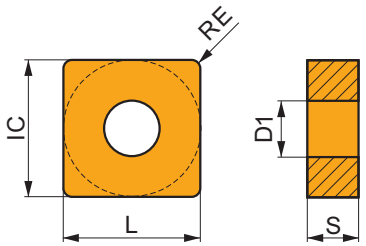
HSC T

CER yüksek hızlı işleme ve darbesiz kesme için.

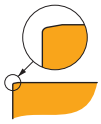
SNGA CER

PRAMET

	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1204	12.700	5.16	12.70	4.76



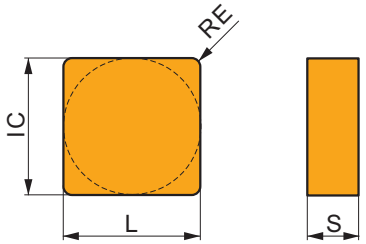
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
																				
CER yüksek hızlı işleme ve darbesiz kesme için.																				
SNGA 120408 T01025:TC100	●	0.8	–	–	–	–	–	–	■ 575	0.20	2.0	–	–	–	–	–	–	–	–	–
SNGA 120412 T01020:TC100	●	1.2	–	–	–	–	–	–	■ 565	0.25	2.0	–	–	–	–	–	–	–	–	–

SNGN CER

PRAMET

	IC	L	S
	(mm)	(mm)	(mm)
0903	9.525	9.53	3.18
1204	12.700	12.70	4.76
1207	12.700	12.70	7.94



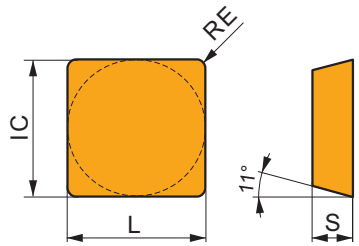
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
																				
CER yüksek hızlı işleme ve darbesiz kesme için.																				
SNGN 090308 T01020:TC100	●	0.8	–	–	–	–	–	–	■ 580	0.20	1.8	–	–	–	–	–	–	–	–	–
SNGN 090312 T01020:TC100	●	1.2	–	–	–	–	–	–	■ 565	0.25	1.8	–	–	–	–	–	–	–	–	–
SNGN 120404 T01020:TC100	●	0.4	–	–	–	–	–	–	■ 620	0.10	2.0	–	–	–	–	–	–	–	–	–
SNGN 120408 T01020:TC100	●	0.8	–	–	–	–	–	–	■ 575	0.20	2.0	–	–	–	–	–	–	–	–	–
SNGN 120708 T01020:TC100	●	0.8	–	–	–	–	–	–	■ 575	0.20	2.0	–	–	–	–	–	–	–	–	–
SNGN 120712 T01020:TC100	●	1.2	–	–	–	–	–	–	■ 565	0.25	2.0	–	–	–	–	–	–	–	–	–

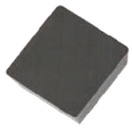
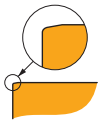
SPGN CER

PRAMET

	IC	L	S
	(mm)	(mm)	(mm)
1203	12.700	12.70	3.18



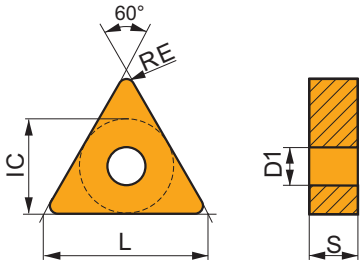
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
																				
CER yüksek hızlı işleme ve darbesiz kesme için.																				
SPGN 120308 T01020:TC100	●	0.8	–	–	–	–	–	–	■ 530	0.20	1.5	–	–	–	–	–	–	–	–	–

TNGA CER

PRAMET

	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1604	9.525	3.81	16.50	4.76



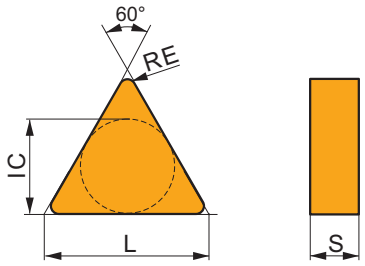
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
																				
CER yüksek hızlı işleme ve darbesiz kesme için.																				
TNGA 160408 T01020:TC100	●	0.8	–	–	–	–	–	–	■ 475	0.20	1.5	–	–	–	–	–	–	–	–	–
TNGA 160412 T01020:TC100	●	1.2	–	–	–	–	–	–	■ 500	0.20	1.5	–	–	–	–	–	–	–	–	–

TNGN CER

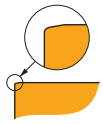
PRAMET

	IC (mm)	L (mm)	S (mm)
1604	9.525	16.50	4.76
1607	9.525	16.50	7.94



Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
TNGN 160408 T01020:TC100	●	0.8	–	–	–	–	–	–	■ 475	0.20	1.5	–	–	–	–	–	–	–	–	–
TNGN 160412 T01020:TC100	●	1.2	–	–	–	–	–	–	■ 500	0.20	1.5	–	–	–	–	–	–	–	–	–
TNGN 160708 T02020:TC100	●	0.8	–	–	–	–	–	–	■ 475	0.20	1.5	–	–	–	–	–	–	–	–	–

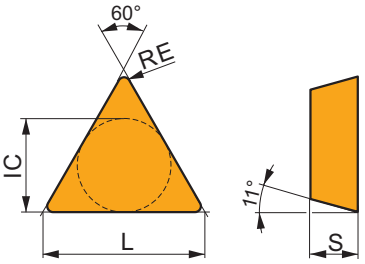
HSC T

CER yüksek hızlı işleme ve darbesiz kesme için.

TPGN CER

PRAMET

	IC (mm)	L (mm)	S (mm)
1103	6.350	11.00	3.18
1603	9.525	16.50	3.18



Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
TPGN 110304 T01020:TC100	●	0.4	–	–	–	–	–	–	■ 460	0.10	1.5	–	–	–	–	–	–	–	–	–
TPGN 110308 T01020:TC100	●	0.8	–	–	–	–	–	–	■ 425	0.20	1.5	–	–	–	–	–	–	–	–	–
TPGN 160304 T01020:TC100	●	0.4	–	–	–	–	–	–	■ 460	0.10	1.5	–	–	–	–	–	–	–	–	–
TPGN 160308 T01020:TC100	●	0.8	–	–	–	–	–	–	■ 425	0.20	1.5	–	–	–	–	–	–	–	–	–
TPGN 160312 T01020:TC100	●	1.2	–	–	–	–	–	–	■ 450	0.20	1.5	–	–	–	–	–	–	–	–	–

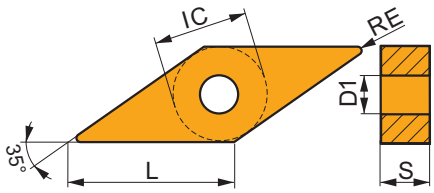



HSC T

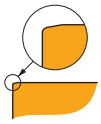
CER yüksek hızlı işleme ve darbesiz kesme için.

VNGA CER

	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1604	9.525	3.81	16.60	4.76

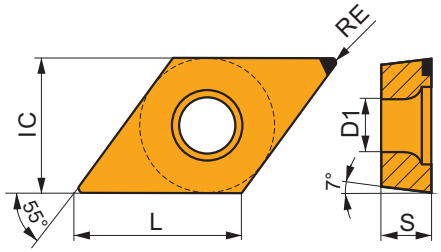


Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

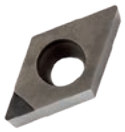
Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
																				
CER yüksek hızlı işleme ve darbesiz kesme için.																				
VNGA 160404 T01020:TC100	●	0.4	–	–	–	–	–	–	■ 425	0.10	1.0	–	–	–	–	–	–	–	–	–
VNGA 160408 T01020:TC100	●	0.8	–	–	–	–	–	–	■ 395	0.20	1.0	–	–	–	–	–	–	–	–	–

DCMW PCD

	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
11T3	9.525	4.40	11.60	3.97

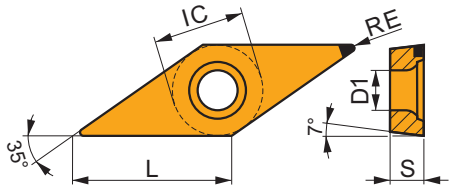


Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
																				
PCD finiş işleme, yüksek hızlı ve stabil kesme şartları için.																				
DCMW 11T304FN:PD1	●	0.4	–	–	–	–	–	–	–	–	–	■ 1035	0.12	0.5	–	–	–	–	–	–
DCMW 11T308FN:PD1	●	0.8	–	–	–	–	–	–	–	–	–	■ 1200	0.12	1.0	–	–	–	–	–	–

VCMW PCD

	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1604	9.525	4.40	16.60	4.76

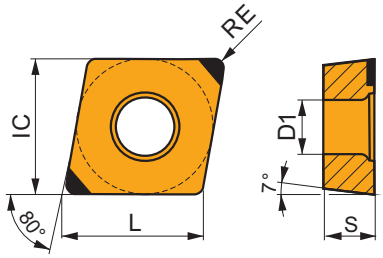


Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

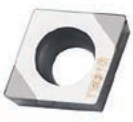
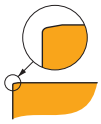
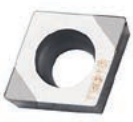
Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
			HSC F																	
PCD lehimli, finişten orta kaba işlemeye kadar, yüksek hızlar ve stabil şartlar için uygun.																				
VCMW 160404FN:PD1	●	0.4	–	–	–	–	–	–	–	–	–	■ 900	0.12	0.5	–	–	–	–	–	–
VCMW 160408FN:PD1	●	0.8	–	–	–	–	–	–	–	–	–	■ 1050	0.12	1.0	–	–	–	–	–	–

CCGW CBN

	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
0602	6.350	2.80	6.50	2.38
09T3	9.525	4.50	9.70	3.97



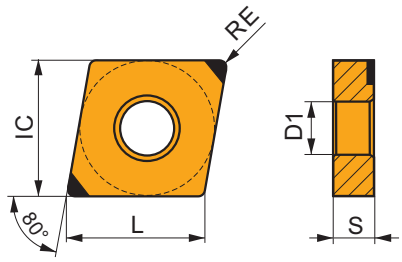
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
			HSC E																	
CBN finiş işleme için.																				
CCGW 060204E-B:TB310	●	0.4	–	–	–	–	–	–	◪ 460	0.10	0.4	–	–	–	◪ 120	0.07	0.3	■ 95	0.07	0.3
CCGW 09T304E-B:TB310	●	0.4	–	–	–	–	–	–	◪ 460	0.10	0.4	–	–	–	◪ 120	0.07	0.3	■ 95	0.07	0.3
			HSC S																	
CBN finiş işleme için.																				
CCGW 060204S01020B:TB310	●	0.4	–	–	–	–	–	–	◪ 460	0.10	0.4	–	–	–	◪ 120	0.07	0.3	■ 95	0.07	0.3
CCGW 09T304S01020B:TB310	●	0.4	–	–	–	–	–	–	◪ 460	0.10	0.4	–	–	–	◪ 120	0.07	0.3	■ 95	0.07	0.3

CNGA CBN

PRAMET

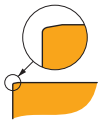
	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1204	12.700	5.16	12.90	4.76



Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
CNGA 120404S01020B:TB310	●	0.4	–	–	–	–	–	–	510	0.10	0.4	–	–	–	135	0.07	0.3	105	0.07	0.3
CNGA 120408S01020B:TB310	●	0.8	–	–	–	–	–	–	530	0.15	0.6	–	–	–	140	0.11	0.5	110	0.08	0.7





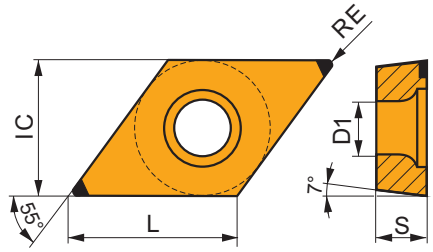
HSC S

CBN finiş işleme ve darbesiz kesme için.

DCGW CBN

PRAMET

	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
11T3	9.525	4.50	11.60	3.97



Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
DCGW 11T304S01020B:TB310	●	0.4	–	–	–	–	–	–	370	0.10	0.4	–	–	–	95	0.07	0.3	75	0.07	0.3
DCGW 11T308S01020B:TB310	●	0.8	–	–	–	–	–	–	380	0.15	0.6	–	–	–	100	0.11	0.5	80	0.08	0.7



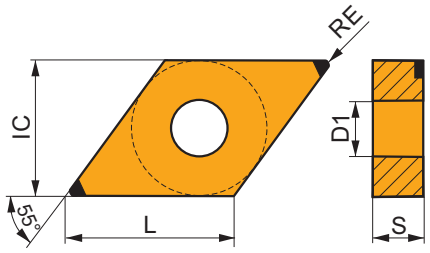


HSC S

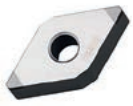
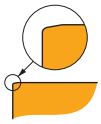
CBN finiş işleme için.

DNGA CBN

	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1506	12.700	5.16	15.50	6.35

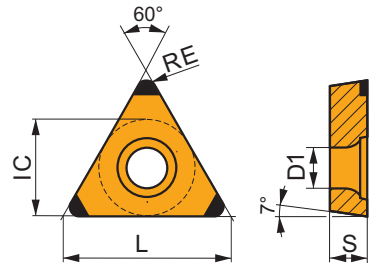


Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
			HSC		S															
			CBN finiş işleme ve darbesiz kesme için.																	
DNGA 150608S01020B:TB310	●	0.8	–	–	–	–	–	–	◪ 420	0.15	0.6	–	–	–	◪ 110	0.11	0.5	■ 85	0.08	0.7

TCGW CBN

	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1102	6.350	2.90	11.00	2.38



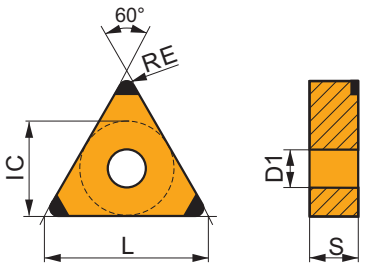
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
			HSC		E															
			CBN finiş işleme ve darbesiz kesme için.																	
TCGW 110204E-C:TB310	●	0.4	–	–	–	–	–	–	◪ 390	0.10	0.4	–	–	–	◪ 100	0.07	0.3	■ 80	0.07	0.3
			HSC		S															
			CBN finiş işleme ve darbesiz kesme için.																	
TCGW 110204S01020C:TB310	●	0.4	–	–	–	–	–	–	◪ 390	0.10	0.4	–	–	–	◪ 100	0.07	0.3	■ 80	0.07	0.3
TCGW 110208S01020C:TB310	●	0.8	–	–	–	–	–	–	◪ 400	0.15	0.6	–	–	–	◪ 105	0.11	0.5	■ 85	0.08	0.7

TNGA CBN

PRAMET

	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1604	9.525	3.81	16.50	4.76



Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

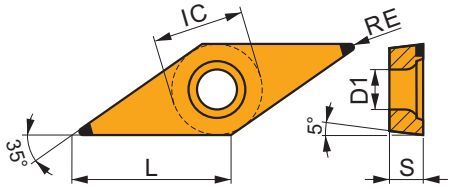
Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
																				
TNGA 160408S01020C:TB310	●	0.8	–	–	–	–	–	–	◪ 450	0.15	0.6	–	–	–	◪ 115	0.11	0.5	■ 95	0.08	0.7

CBN finiş işleme ve darbesiz kesme için.

VBGW CBN

PRAMET

	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1604	9.525	4.50	16.00	4.76



Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

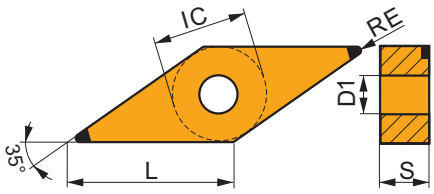
Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
																				
VBGW 160404S01020B:TB310	●	0.4	–	–	–	–	–	–	◪ 340	0.10	0.4	–	–	–	◪ 90	0.07	0.3	■ 70	0.07	0.3
VBGW 160408S01020B:TB310	●	0.8	–	–	–	–	–	–	◪ 350	0.15	0.6	–	–	–	◪ 90	0.11	0.5	■ 70	0.08	0.7

CBN finiş işleme ve darbesiz kesme için.

VNGA CBN

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.00	4.76



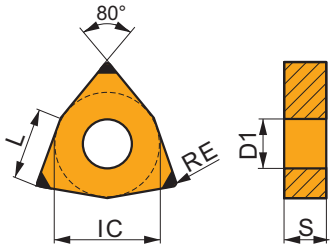
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
			 **CBN** finiş işleme ve darbesiz kesme için.																	
VNGA 160404S01020B:TB310	●	0.4	–	–	–	–	–	–	360	0.10	0.4	–	–	–	95	0.07	0.3	75	0.07	0.3
VNGA 160408S01020B:TB310	●	0.8	–	–	–	–	–	–	370	0.15	0.6	–	–	–	95	0.11	0.5	75	0.08	0.7

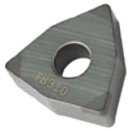
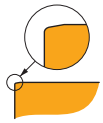
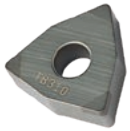
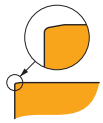
WNGA CBN

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0804	12.700	5.16	8.70	4.76



Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
			 **CBN** finiş işleme ve darbesiz kesme için.																	
WNGA 080408S01020C:TB310	●	0.8	–	–	–	–	–	–	530	0.15	0.6	–	–	–	140	0.11	0.5	110	0.08	0.7
			 **CBN** finiş işleme ve darbesiz kesme için.																	
WNGA080408S01020WC:TB310	–	0.8	–	–	–	–	–	–	530	0.15	0.6	–	–	–	140	0.11	0.5	110	0.08	0.7



KESME VE KANAL AÇMA

GL – DIŞ ÇAP TAKIMLAR KILAVUZU

KESİCİ UÇ YUVASI	GL1	GL2	GL3	GL4	GL5	GL6	
NEW **GLAF(RL)EXT** 20×20 / 25×25		CDX 20 mm	CDX 20 – 40 mm	CDX 20 – 32 mm	CDX 24 – 32 mm	CDX 24 – 32 mm	
NEW **GLAF(RL)EXT-S** 12×12 / 16×16		CDX 12 – 16 mm	CDX 12 – 16 mm	CDX 16 mm			
GLSF(RL)EXT 20×20 / 25×25	CDX 16 mm **NEW**	CDX 20 – 24 mm	CDX 20 – 32 mm	CDX 20 – 32 mm	CDX 20 – 32 mm	CDX 20 – 32 mm	
GLSF(RL)EXT-S 12×12 / 16×16	CDX 12 – 16 mm **NEW**	CDX 12 – 16 mm	CDX 12 – 16 mm	CDX 16 mm			
GLSF(RL)EXT-G 20×20 / 32×32 **NEW**		CDX 10 mm	CDX 10 – 20 mm	CDX 12 – 24 mm	CDX 12 – 32 mm	CDX 12 – 32 mm	
Kesme genişliği (mm) CW	1.5	2	3 (2.5)	4	5	6	8
NEW **Derin kesme** (tek taraflı kesici uç)			TEK TARAFLI KESİCİ UÇ PM 1 PR	TEK TARAFLI KESİCİ UÇ PM 1 PR			
Kesme (boru / dolu çubuk)	**NEW** PM	PM 1 PR	CW = 2.5 / 3 PM 1 PR	PM 1 PR	PM 1 PR	PM 1 PR	
Kanal Açma (derin / sığ)		PR GM	PR GM	PR GM	PR GM	GM	**NEW** GM
Tornalama (boyuna)		GM	GM	GM	GM	GM	**NEW** GM
Profil işleme (çok eksenli)		MM	MM	MM	MM	MM	

GLAF(RL) EXT

P M K N S H

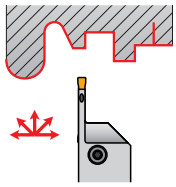
PRAMET

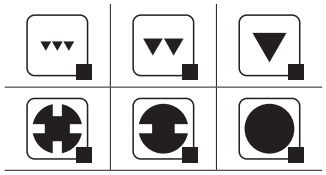
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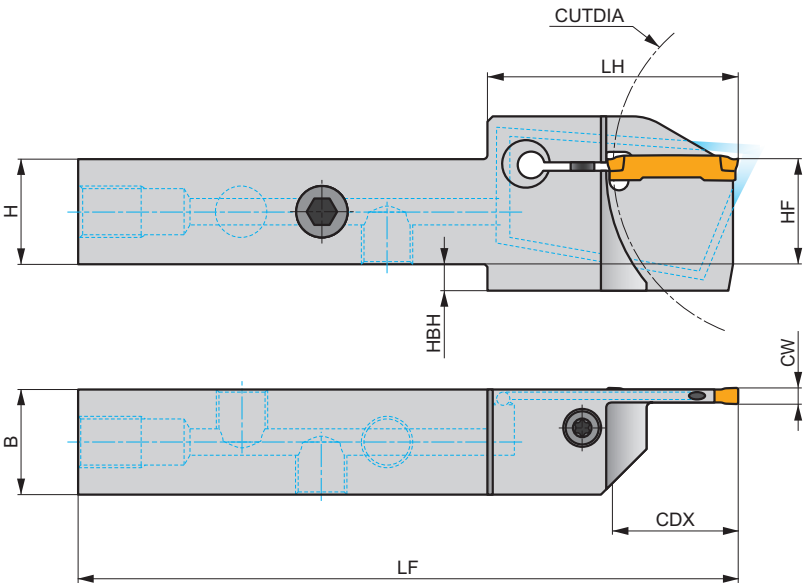


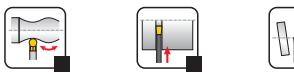
GL Kesici uçlar için içten kesme sıvılı Kanal Açma ve Kesme takımı

GL kesici uçlar için içten kesme sıvılı Sağ/Sol kesme yönlü dış çap takım tutucu. Radyal kanal açma, kesme, tornalama ve profil işleme uygulamaları için uygundur. Gövde tasarımı, uzun takım ömrü ve düşük titreşim için güçlendirilmiştir. Gövde uzun takım ömrü için işlem görmüştür.









	Product	HF (mm)	HBH (mm)	H (mm)	B (mm)	LF (mm)	LH (mm)	CW (mm)	CDX (mm)	CUTDIA (mm)		kg			
R	GL2-A2020KFR-20-80	20	5	20	20	125	43.5	2.00	20	80	✓	0.33	GI334	GL11	CC01
	GL2-A2525MFR-20-80	25	–	25	25	150	43.5	2.00	20	80	✓	0.65	GI334	GL11	CC01
	GL3-A2020KFR-20-80	20	5	20	20	125	43.5	3.00	20	80	✓	0.33	GI335	GL11	CC01
	GL3-A2020KFR-24-80	20	5	20	20	125	47.5	3.00	24	80	✓	0.32	GI335	GL11	CC01
	GL3-A2525MFR-20-80	25	–	25	25	150	43.5	3.00	20	80	✓	0.66	GI335	GL11	CC01
	GL3-A2525PFR-32-80	25	5	25	25	170	55.5	3.00	32	80	✓	0.73	GI335	GL11	CC01
	GL3-A2525PFR-40-100	25	7	25	25	170	63.5	3.00	40	100	✓	0.70	GI335	GL11	CC01
	GL4-A2020KFR-20-80	20	5	20	20	125	43.6	4.00	20	80	✓	0.38	GI336	GL11	CC01
	GL4-A2020KFR-24-80	20	5	20	20	125	47.6	4.00	24	80	✓	0.37	GI336	GL11	CC01
	GL4-A2525MFR-20-80	25	–	25	25	150	43.6	4.00	20	80	✓	0.58	GI336	GL11	CC01
	GL4-A2525PFR-32-80	25	5	25	25	170	55.6	4.00	32	80	✓	0.67	GI336	GL11	CC01
	GL5-A2020KFR-24-80	20	5	20	20	125	47.6	5.00	24	80	✓	0.32	GI337	GL11	CC01
	GL5-A2525PFR-32-100	25	5	25	25	170	55.6	5.00	32	100	✓	0.67	GI337	GL11	CC01
	GL6-A2020KFR-24-80	20	5	20	20	125	47.6	6.00	24	80	✓	0.37	GI338	GL11	CC01
	GL6-A2525PFR-32-100	25	5	25	25	170	55.6	6.00	32	100	✓	0.68	GI338	GL11	CC01
L	GL2-A2020KFL-20-80	20	5	20	20	125	43.5	2.00	20	80	✓	0.33	GI334	GL11	CC01
	GL2-A2525MFL-20-80	25	–	25	25	150	43.5	2.00	20	80	✓	0.66	GI334	GL11	CC01
	GL3-A2020KFL-20-80	20	5	20	20	125	43.5	3.00	20	80	✓	0.33	GI335	GL11	CC01
	GL3-A2020KFL-24-80	20	5	20	20	125	47.5	3.00	24	80	✓	0.36	GI335	GL11	CC01
	GL3-A2525MFL-20-80	25	–	25	25	150	43.5	3.00	20	80	✓	0.65	GI335	GL11	CC01
	GL3-A2525PFL-32-80	25	5	25	25	170	55.5	3.00	32	80	✓	0.67	GI335	GL11	CC01
	GL3-A2525PFL-40-100	25	7	25	25	170	63.5	3.00	40	100	✓	0.70	GI335	GL11	CC01
	GL4-A2020KFL-20-80	20	5	20	20	125	43.6	4.00	20	80	✓	0.33	GI336	GL11	CC01
	GL4-A2020KFL-24-80	20	5	20	20	125	47.6	4.00	24	80	✓	0.37	GI336	GL11	CC01
	GL4-A2525MFL-20-80	25	–	25	25	150	43.6	4.00	20	80	✓	0.65	GI336	GL11	CC01
	GL4-A2525PFL-32-80	25	5	25	25	170	55.6	4.00	32	80	✓	0.73	GI336	GL11	CC01
	GL5-A2020KFL-24-80	20	5	20	20	125	47.6	5.00	24	80	✓	0.32	GI337	GL11	CC01

	Product	HF (mm)	HBH (mm)	H (mm)	B (mm)	LF (mm)	LH (mm)	CW (mm)	CDX (mm)	CUTDIA (mm)		kg			
L	**GL5-A2525PFL-32-100**	25	5	25	25	170	55.6	5.00	32	100	✓	0.67	GI337	GL11	CC01
	GL6-A2020KFL-24-80	20	5	20	20	125	47.6	6.00	24	80	✓	0.33	GI338	GL11	CC01
	GL6-A2525PFL-32-100	25	5	25	25	170	55.6	6.00	32	100	✓	0.68	GI338	GL11	CC01

GI334	GL2..	–
GI335	GL3..	–
GI336	GL4..	–
GI337	GL5..	–
GI338	GL6-D600..	GL6-D800..

İşlenmiş çap için kesme derinliklerini sayfa 364'te bulabilirsiniz.

GL11	US 5018-T20P	5.0	M 5	18.2	LK T20P

CC01	CHP-P1/8	G1/8"	HXK 4

Kesme sıvısı aksesuarları için sayfa 366'e bakınız.

GLAF(RL) EXT-S

P M K N S H

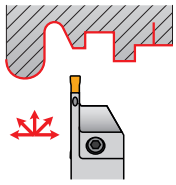
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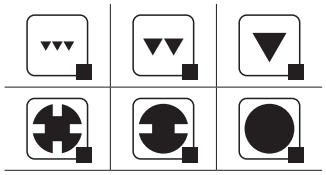
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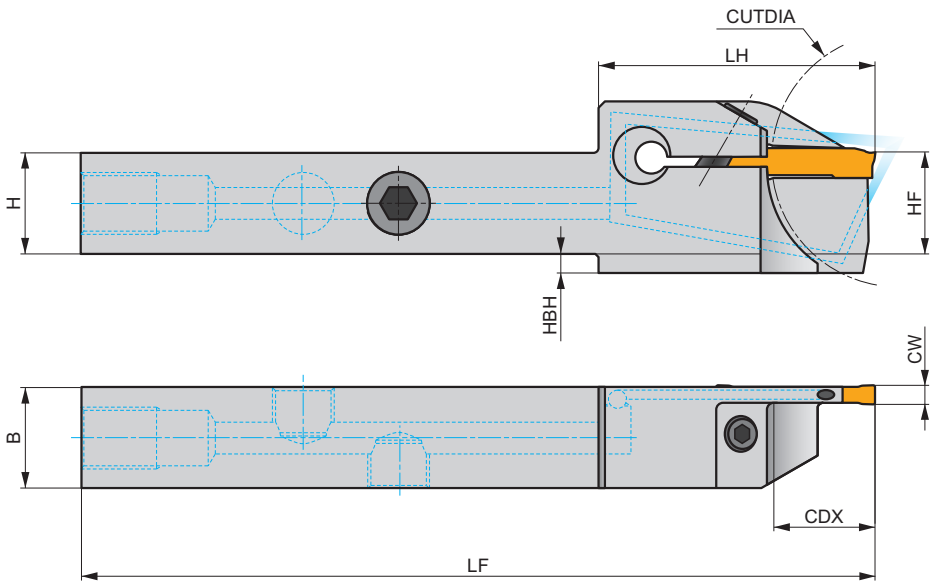


GL Kesici uçlar için içten kesme sıvılı Kanal Açma takımı, Kayar otomat tezgahları için

GL kesici uçlar için içten kesme sıvılı Sağ/Sol kesme yönlü dış çap takım tutucu, kayar otomat tezgahları için tasarlanmıştır, kesici uç bağlama mekanizmasına kolay erişime izin verir. Radyal kanal açma, kesme, tornalama ve profil işleme uygulamaları için uygundur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	HF (mm)	HBH (mm)	H (mm)	B (mm)	LF (mm)	LH (mm)	CW (mm)	CDX (mm)	CUTDIA (mm)		kg			
R	GL2-A1212HFR-12-40	12	3	12	12	100	33.0	2.00	12	40	✓	0.12	GI334	GL13	CC02
	GL2-A1616KFR-16-45	16	3	16	16	125	43.5	2.00	16	45	✓	0.21	GI334	GL12	CC01
	GL3-A1212HFR-12-40	12	3	12	12	100	33.0	3.00	12	40	✓	0.12	GI335	GL13	CC02
	GL3-A1616KFR-16-45	16	3	16	16	125	43.5	3.00	16	45	✓	0.21	GI335	GL12	CC01
	GL4-A1616KFR-16-45	16	4	16	16	125	43.6	4.00	16	45	✓	0.21	GI336	GL12	CC01
L	GL2-A1212HFL-12-40	12	3	12	12	100	33.0	2.00	12	40	✓	0.11	GI334	GL13	CC02
	GL2-A1616KFL-16-45	16	3	16	16	125	43.5	2.00	16	45	✓	0.27	GI334	GL12	CC01
	GL3-A1212HFL-12-40	12	3	12	12	100	33.0	3.00	12	40	✓	0.12	GI335	GL13	CC02
	GL3-A1616KFL-16-45	16	3	16	16	125	43.5	3.00	16	45	✓	0.25	GI335	GL12	CC01
	GL4-A1616KFL-16-45	16	4	16	16	125	43.6	4.00	16	45	✓	0.21	GI336	GL12	CC01

GI334	GL2..
GI335	GL3..
GI336	GL4..

İşlenmiş çap için kesme derinliklerini sayfa 364'te bulabilirsiniz.

		Nm			
GL12	HS 0516	5.0	M 5	16	HXK 4
GL13	HS 0412	5.0	M 4	12	HXK 3

CC01	CHP-P1/8	–	G1/8"	HXK 4	–	–
CC02	–	CHP-P6	M6	HXK 3	CHP-G06	CHP-R1/8-6

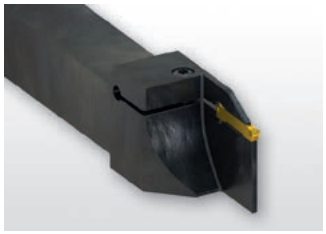
Kesme sıvısı aksesuarları için sayfa 366'e bakınız.

GLSF(RL) EXT

P M K N S H

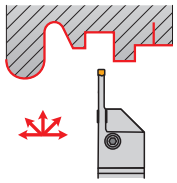
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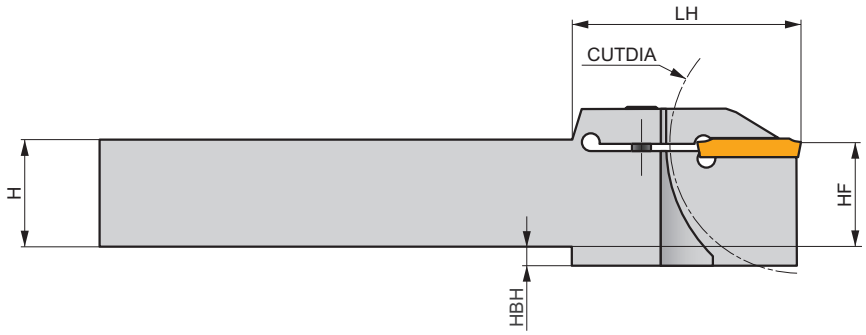
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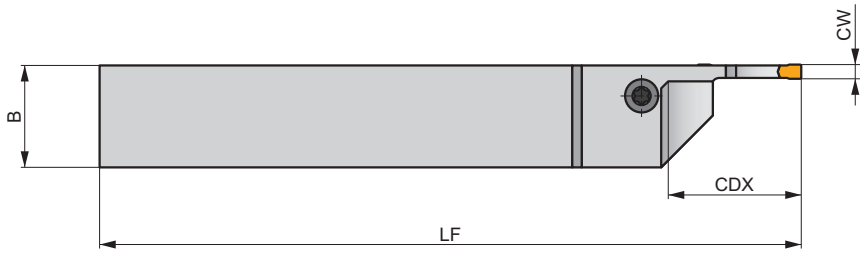


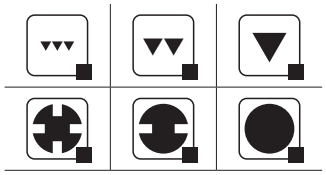
GL Kesici uçlar için Kanal Açma ve Kesme takımı

GL kesici uçlar için Sağ/Sol kesme yönlü dış çap takım tutucu. Radyal kanal açma, kesme, tornalama ve profil işleme uygulamaları için uygundur. Gövde tasarımı, uzun takım ömrü ve düşük titreşim için güçlendirilmiştir. Gövde uzun takım ömrü için işlem görmüştür.











	Product	HF (mm)	HBH (mm)	H (mm)	B (mm)	LF (mm)	LH (mm)	CW (mm)	CDX (mm)	CUTDIA (mm)	kg		
R	GL1-S2020KFR-16-60	20	–	20	20	125	34.2	1.50	16	60	0.35	GI333	GL11
	GL2-S2020KFR-20-80	20	–	20	20	125	43.5	2.00	20	80	0.38	GI334	GL11
	GL2-S2020KFR-24-80	20	5	20	20	125	48.5	2.00	24	80	0.38	GI334	GL11
	GL2-S2525MFR-20-80	25	–	25	25	150	43.5	2.00	20	80	0.70	GI334	GL11
	GL2-S2525MFR-24-80	25	–	25	25	150	47.5	2.00	24	80	0.68	GI334	GL11
	GL3-S2020KFR-20-80	20	–	20	20	125	43.5	3.00	20	80	0.38	GI335	GL11
	GL3-S2020KFR-24-80	20	5	20	20	125	47.5	3.00	24	80	0.36	GI335	GL11
	GL3-S2525MFR-20-80	25	–	25	25	150	43.5	3.00	20	80	0.70	GI335	GL11
	GL3-S2525MFR-24-80	25	–	25	25	150	47.5	3.00	24	80	0.65	GI335	GL11
	GL3-S2525PFR-32-80	25	5	25	25	170	55.5	3.00	32	80	0.78	GI335	GL11
	GL4-S2020KFR-20-80	20	–	20	20	125	43.5	4.00	20	80	0.38	GI336	GL11
	GL4-S2020KFR-24-80	20	5	20	20	125	47.5	4.00	24	80	0.37	GI336	GL11
	GL4-S2525MFR-20-80	25	–	25	25	150	43.5	4.00	20	80	0.68	GI336	GL11
	GL4-S2525MFR-24-80	25	–	25	25	150	47.5	4.00	24	80	0.69	GI336	GL11
	GL4-S2525PFR-32-80	25	5	25	25	170	55.5	4.00	32	80	0.78	GI336	GL11
	GL5-S2020KFR-20-80	20	–	20	20	125	43.5	5.00	20	80	0.38	GI337	GL11
	GL5-S2525MFR-20-80	25	–	25	25	150	43.5	5.00	20	80	0.68	GI337	GL11
	GL5-S2525PFR-32-100	25	5	25	25	170	55.5	5.00	32	100	0.78	GI337	GL11
	GL6-S2020KFR-20-80	20	–	20	20	125	43.5	6.00	20	80	0.39	GI338-1	GL11
	GL6-S2525MFR-20-80	25	–	25	25	150	43.5	6.00	20	80	0.68	GI338-1	GL11
	GL6-S2525PFR-32-100	25	5	25	25	170	55.5	6.00	32	100	0.75	GI338	GL11
L	GL1-S2020KFL-16-60	20	–	20	20	125	34.2	1.50	16	60	0.35	GI333	GL11
	GL2-S2020KFL-20-80	20	–	20	20	125	43.5	2.00	20	80	0.38	GI334	GL11
	GL2-S2020KFL-24-80	20	5	20	20	125	47.5	2.00	24	80	0.39	GI334	GL11
	GL2-S2525MFL-20-80	25	–	25	25	150	43.5	2.00	20	80	0.70	GI334	GL11
	GL2-S2525MFL-24-80	25	–	25	25	150	47.5	2.00	24	80	0.64	GI334	GL11
	GL3-S2020KFL-20-80	20	–	20	20	125	43.5	3.00	20	80	0.38	GI335	GL11

	Product	HF (mm)	HBH (mm)	H (mm)	B (mm)	LF (mm)	LH (mm)	CW (mm)	CDX (mm)	CUTDIA (mm)	kg		
L	**GL3-S2020KFL-24-80**	20	5	20	20	125	47.5	3.00	24	80	0.39	GI335	GL11
	GL3-S2525MFL-20-80	25	–	25	25	150	43.5	3.00	20	80	0.68	GI335	GL11
	GL3-S2525MFL-24-80	25	–	25	25	150	47.5	3.00	24	80	0.68	GI335	GL11
	GL3-S2525PFL-32-80	25	5	25	25	170	55.5	3.00	32	80	0.78	GI335	GL11
	GL4-S2020KFL-20-80	20	–	20	20	125	43.5	4.00	20	80	0.38	GI336	GL11
	GL4-S2020KFL-24-80	20	5	20	20	125	47.5	4.00	24	80	0.39	GI336	GL11
	GL4-S2525MFL-20-80	25	–	25	25	150	43.5	4.00	20	80	0.68	GI336	GL11
	GL4-S2525MFL-24-80	25	–	25	25	150	47.5	4.00	24	80	0.65	GI336	GL11
	GL4-S2525PFL-32-80	25	5	25	25	170	55.5	4.00	32	80	0.78	GI336	GL11
	GL5-S2020KFL-20-80	20	–	20	20	125	43.5	5.00	20	80	0.38	GI337	GL11
	GL5-S2525MFL-20-80	25	–	25	25	150	43.5	5.00	20	80	0.71	GI337	GL11
	GL5-S2525PFL-32-100	25	5	25	25	170	55.5	5.00	32	100	0.78	GI337	GL11
	GL6-S2020KFL-20-80	20	–	20	20	125	43.5	6.00	20	80	0.39	GI338-1	GL11
	GL6-S2525MFL-20-80	25	–	25	25	150	43.5	6.00	20	80	0.71	GI338-1	GL11
	GL6-S2525PFL-32-100	25	5	25	25	170	55.5	6.00	32	100	0.75	GI338	GL11

GI333	GL1..	–
GI334	GL2..	–
GI335	GL3..	–
GI336	GL4..	–
GI337	GL5..	–
GI338	GL6-D600..	GL6-D800..
GI338-1	GL6-D600..	–

İşlenmiş çap için kesme derinliklerini sayfa 364'te bulabilirsiniz.

		Nm			
GL11	US 5018-T20P	5.0	M 5	18.2	LK T20P

GLSF(RL) EXT-S

P M K N S H

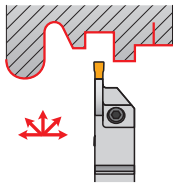
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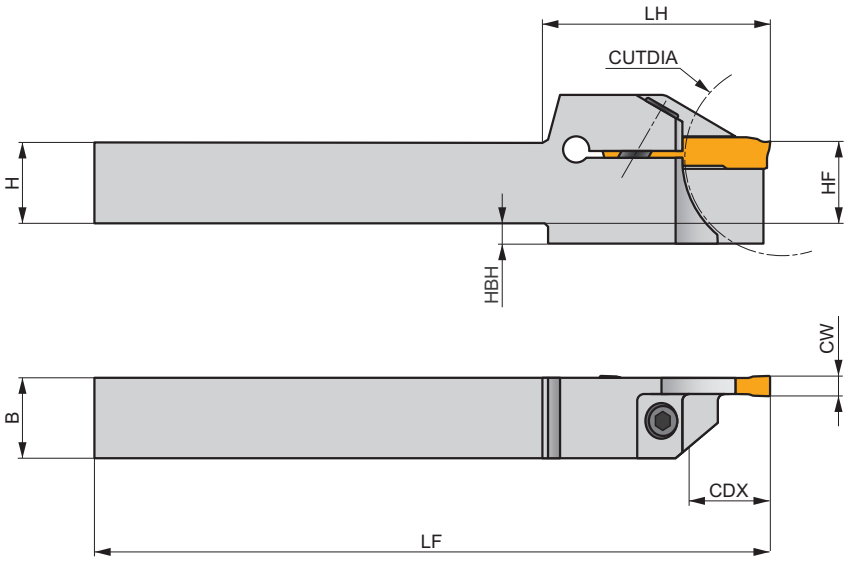
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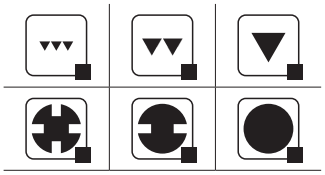


GL Kesici uçlar için Kanal Açma ve Kesme takımı, Kayar otomat tezgahları için

GL kesici uçlar için Sağ/Sol kesme yönlü dış çap takım tutucu, kayar otomat tezgahları için tasarlanmıştır, kesici uç bağlama mekanizmasına kolay erişime izin verir. Radyal kanal açma, kesme, tornalama ve profil işleme uygulamaları için uygundur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	HF (mm)	HBH (mm)	H (mm)	B (mm)	LF (mm)	LH (mm)	CW (mm)	CDX (mm)	CUTDIA (mm)	kg		
R	GL1-S1212HFR-12-40	12	–	12	12	100	30.2	1.50	12	40	0.10	GI333	GL13
	GL1-S1616KFR-16-45	16	–	16	16	125	34.2	1.50	16	45	0.23	GI333	GL12
	GL2-S1212HFR-12-40	12	3	12	12	100	33.0	2.00	12	40	0.14	GI334	GL13
	GL2-S1616KFR-16-45	16	3	16	16	125	39.5	2.00	16	45	0.23	GI334	GL12
	GL3-S1212HFR-12-40	12	3	12	12	100	33.0	3.00	12	40	0.11	GI335	GL13
	GL3-S1616KFR-16-45	16	3	16	16	125	39.5	3.00	16	45	0.23	GI335	GL12
	GL4-S1616KFR-16-45	16	4	16	16	125	39.5	4.00	16	45	0.28	GI336	GL12
L	GL1-S1212HFL-12-40	12	–	12	12	100	30.2	1.50	12	40	0.10	GI333	GL13
	GL1-S1616KFL-16-45	16	–	16	16	125	34.2	1.50	16	45	0.23	GI333	GL12
	GL2-S1212HFL-12-40	12	3	12	12	100	33.0	2.00	12	40	0.11	GI334	GL13
	GL2-S1616KFL-16-45	16	3	16	16	125	39.5	2.00	16	45	0.23	GI334	GL12
	GL3-S1212HFL-12-40	12	3	12	12	100	33.0	3.00	12	40	0.11	GI335	GL13
	GL3-S1616KFL-16-45	16	3	16	16	125	39.5	3.00	16	45	0.23	GI335	GL12
	GL4-S1616KFL-16-45	16	4	16	16	125	39.5	4.00	16	45	0.24	GI336	GL12

GI333	GL1..
GI334	GL2..
GI335	GL3..
GI336	GL4..

İşlenmiş çap için kesme derinliklerini sayfa 364'te bulabilirsiniz.

		Nm			
GL12	HS 0516	5.0	M 5	16	HXK 4
GL13	HS 0412	5.0	M 4	12	HXK 3

GLSF(RL) EXT-G

P M K N S H

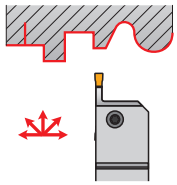
PRAMET

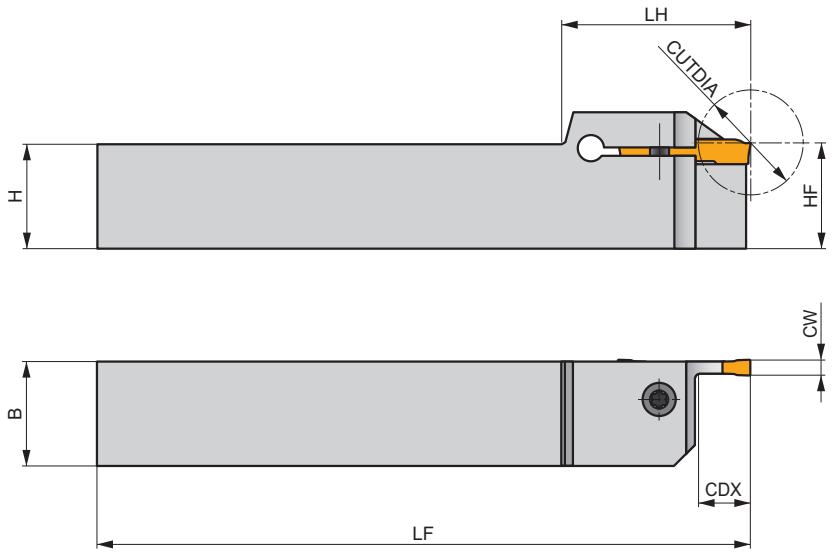
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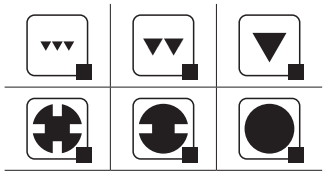


GL Kesici uçlar için Kanal Açma ve Tornalama takımı

GL kesici uçlar için Sağ/Sol kesme yönlü dış çap takım tutucu. Boyuna tornalama ve profil işleme uygulamaları için çok uygundur, kanal açma ve kesme için de kullanılabilir. Gövde uzun takım ömrü için işlem görmüştür.









	Product	HF (mm)	H (mm)	B (mm)	LF (mm)	LH (mm)	CW (mm)	CDX (mm)	CUTDIA (mm)	kg		
R	GL2-S2020KFR-10	20	20	20	125	36.0	2.00	10	20	0.38	GI334	GL11
	GL2-S2525MFR-10	25	25	25	150	36.0	2.00	10	20	0.69	GI334	GL11
	GL3-S2020KFR-10	20	20	20	125	36.0	3.00	10	20	0.39	GI335	GL11
	GL3-S2525MFR-10	25	25	25	150	36.0	3.00	10	20	0.73	GI335	GL11
	GL3-S3232MFR-20	32	32	32	150	46.0	3.00	20	40	1.12	GI335	GL15
	GL4-S2020KFR-12	20	20	20	125	36.0	4.00	12	24	0.37	GI336	GL11
	GL4-S2525MFR-12	25	25	25	150	36.0	4.00	12	24	0.69	GI336	GL11
	GL4-S3232MFR-24	32	32	32	150	50.0	4.00	24	48	1.04	GI336	GL15
	GL5-S2020KFR-12	20	20	20	125	36.0	5.00	12	24	0.36	GI337	GL11
	GL5-S2525MFR-12	25	25	25	150	36.0	5.00	12	24	0.72	GI337	GL11
	GL5-S3232PFR-32	32	32	32	170	58.0	5.00	32	64	1.21	GI337	GL15
	GL6-S2020KFR-12	20	20	20	125	36.0	6.00	12	24	0.36	GI338-1	GL11
	GL6-S2525MFR-12	25	25	25	150	36.0	6.00	12	24	0.68	GI338-1	GL11
	GL6-S3232PFR-32	32	32	32	170	58.0	6.00	32	64	1.22	GI338	GL15
L	GL2-S2020KFL-10	20	20	20	125	36.0	2.00	10	20	0.37	GI334	GL11
	GL2-S2525MFL-10	25	25	25	150	36.0	2.00	10	20	0.70	GI334	GL11
	GL3-S2020KFL-10	20	20	20	125	36.0	3.00	10	20	0.36	GI335	GL11
	GL3-S2525MFL-10	25	25	25	150	36.0	3.00	10	20	0.70	GI335	GL11
	GL3-S3232MFL-20	32	32	32	150	46.0	3.00	20	40	1.12	GI335	GL15
	GL4-S2020KFL-12	20	20	20	125	36.0	4.00	12	24	0.37	GI336	GL11
	GL4-S2525MFL-12	25	25	25	150	36.0	4.00	12	24	0.69	GI336	GL11
	GL4-S3232MFL-24	32	32	32	150	50.0	4.00	24	48	1.04	GI336	GL15
	GL5-S2020KFL-12	20	20	20	125	36.0	5.00	12	24	0.36	GI337	GL11
	GL5-S2525MFL-12	25	25	25	150	36.0	5.00	12	24	0.72	GI337	GL11
	GL5-S3232PFL-32	32	32	32	170	58.0	5.00	32	64	1.15	GI337	GL15
	GL6-S2020KFL-12	20	20	20	125	36.0	6.00	12	24	0.36	GI338-1	GL11
	GL6-S2525MFL-12	25	25	25	150	36.0	6.00	12	24	0.72	GI338-1	GL11

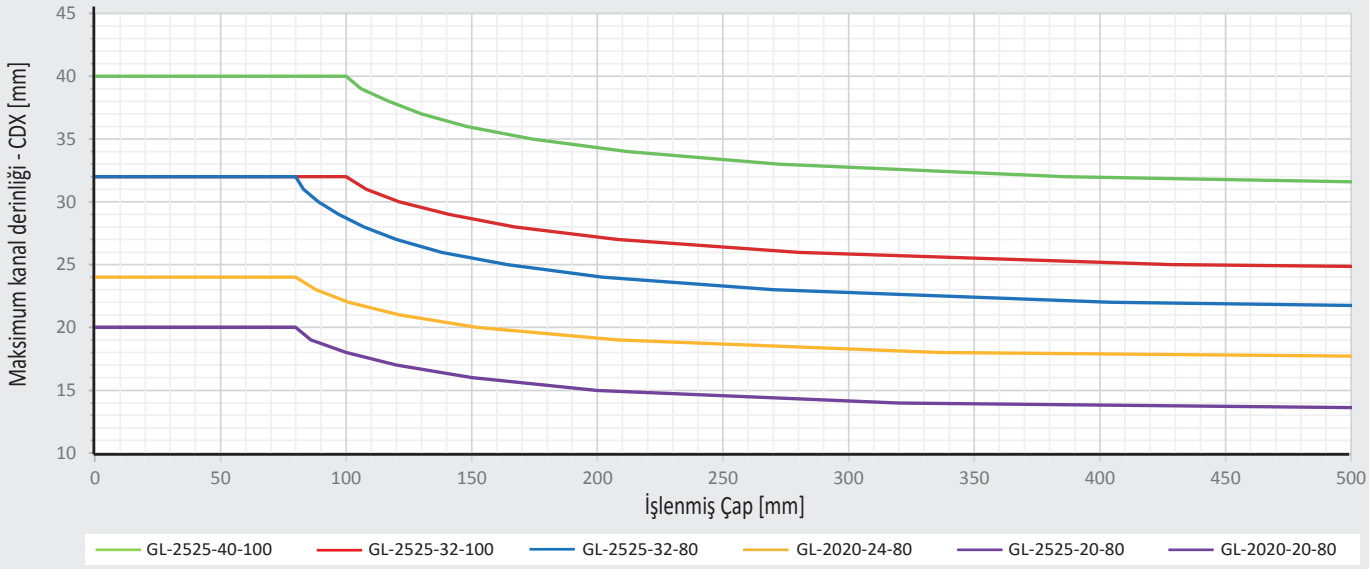
	Product	HF (mm)	H (mm)	B (mm)	LF (mm)	LH (mm)	CW (mm)	CDX (mm)	CUTDIA (mm)	kg		
L	**GL6-S3232PFL-32**	32	32	32	170	58.0	6.00	32	64	1.15	GI338	GL15

GI334	GL2..	–
GI335	GL3..	–
GI336	GL4..	–
GI337	GL5..	–
GI338	GL6-D600..	GL6-D800..
GI338-1	GL6-D600..	–

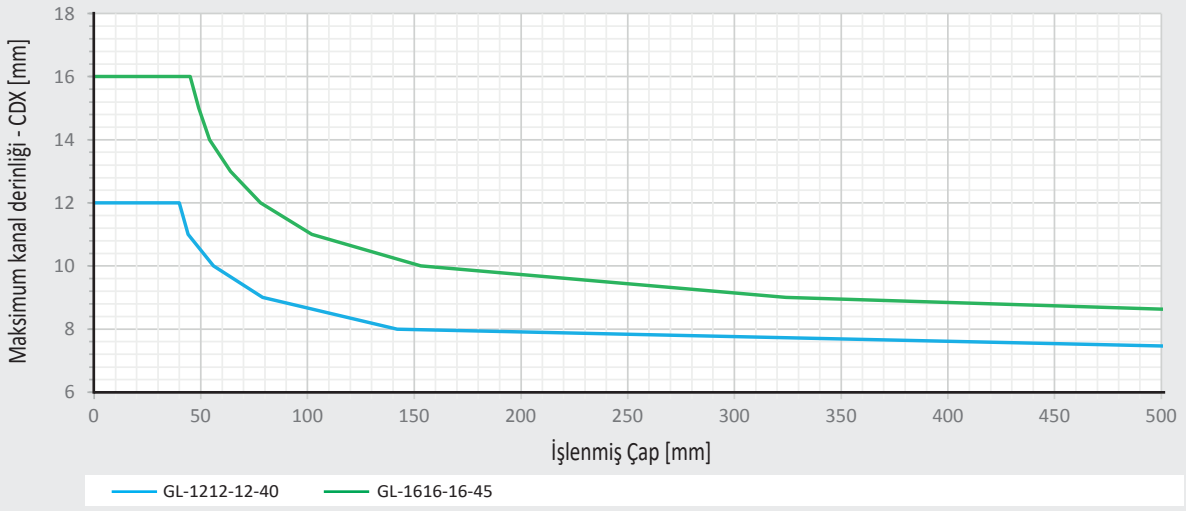
		Nm			
GL11	US 5018-T20P	5.0	M 5	18.2	LK T20P
GL15	SR 88026-T30P	5.0	M8	26	LK T30P

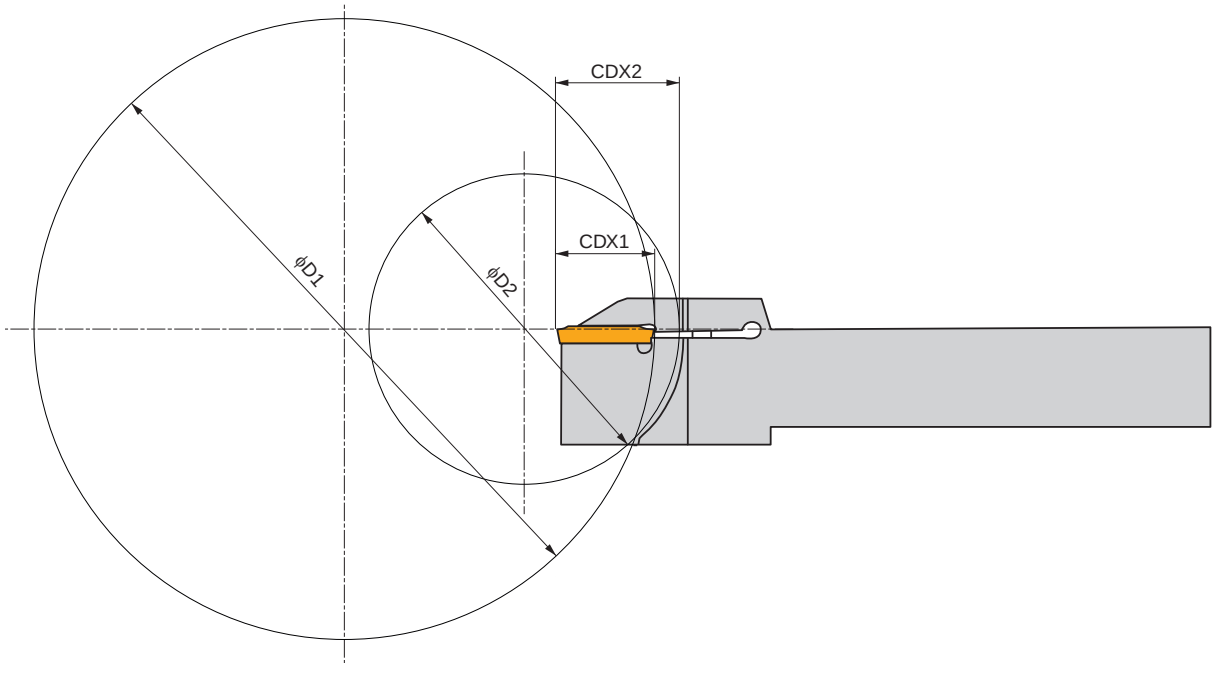
İŞLENMİŞ ÇAPA GÖRE KESME DERİNLİKLERİ

GLAF(RL) EXT



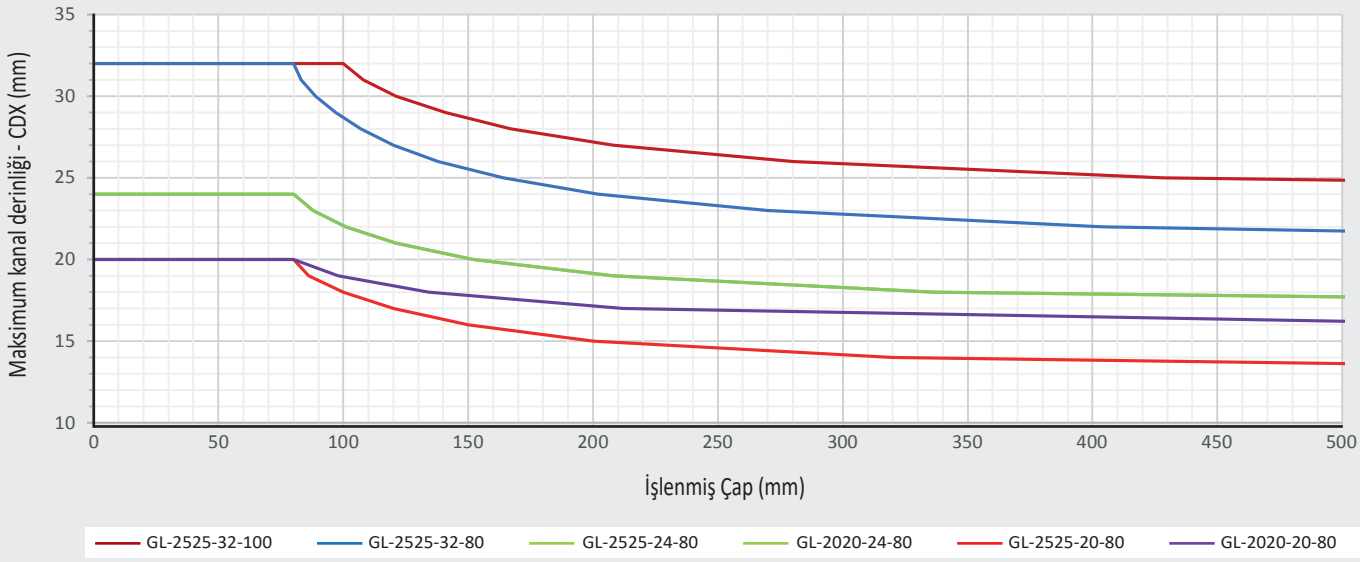
GLAF(RL) EXT-S



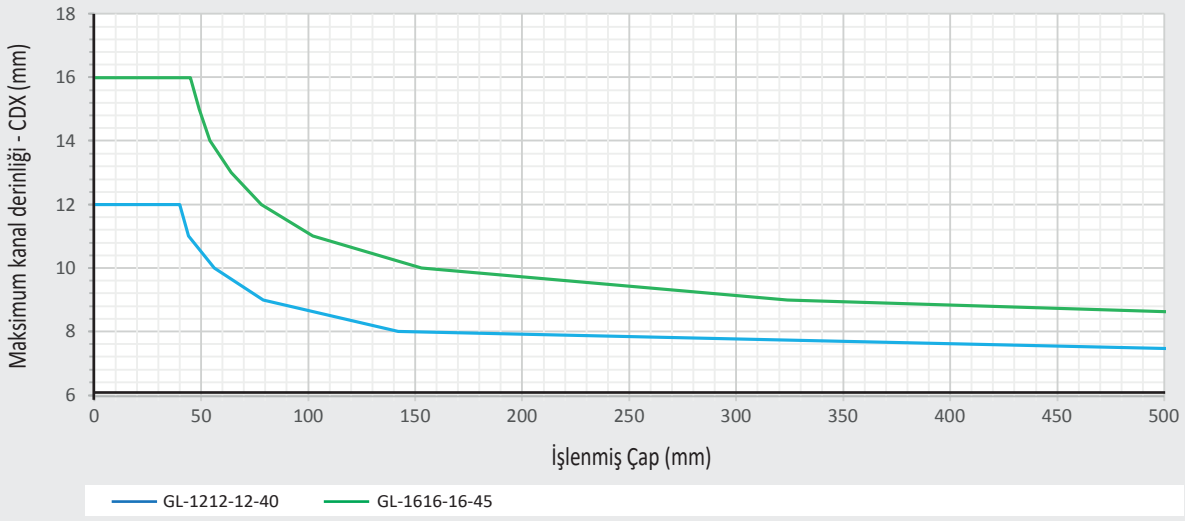


İŞLENMİŞ ÇAPA GÖRE KESME DERİNLİKLERİ

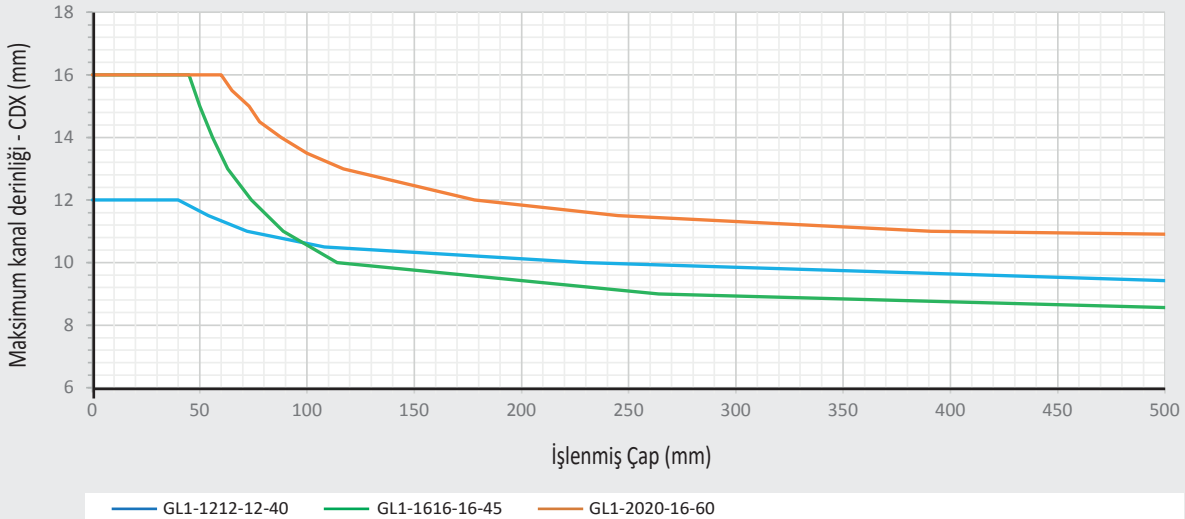
GLSF (RL) EXT



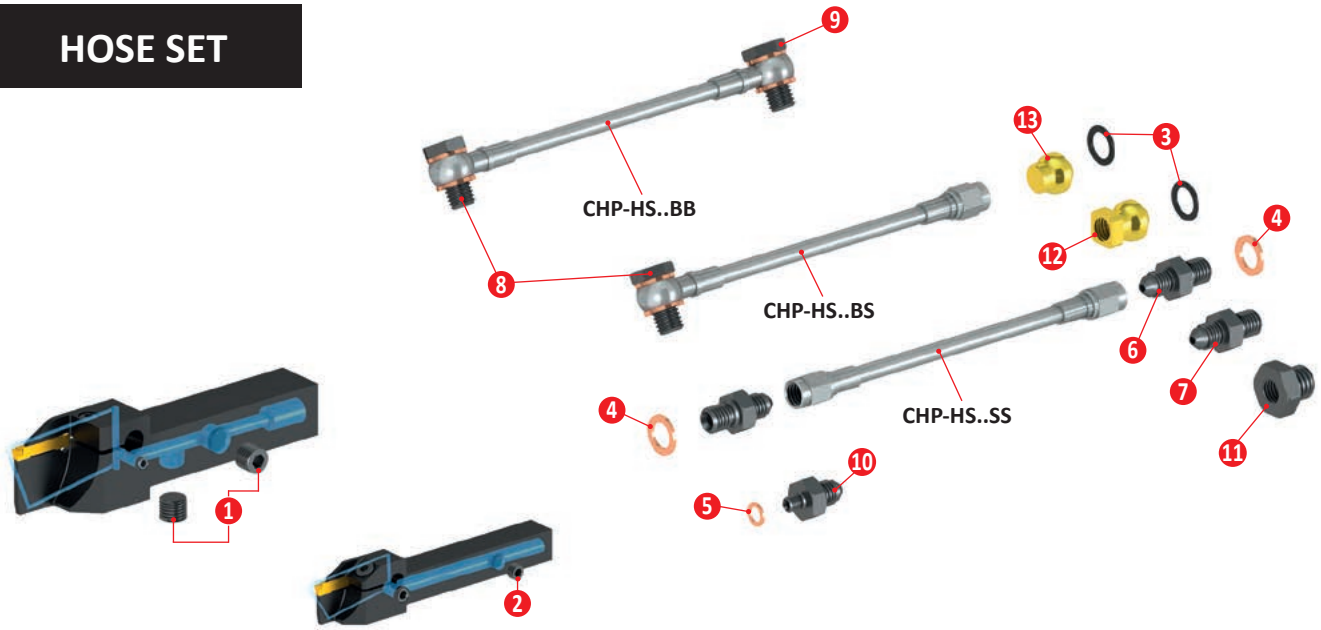
GLSF (RL) EXT-S

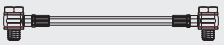


GL1



HOSE SET



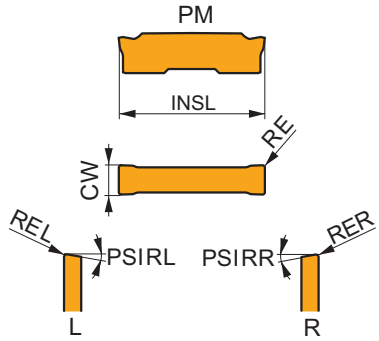
				uzunluk			
				150 mm	CHP-HS150 SS	CHP-HS150 BS	CHP-HS150 BB
			İşaret	250 mm	CHP-HS250 SS	CHP-HS250 BS	CHP-HS250 BB
				300 mm	CHP-HS300 SS	CHP-HS300 BS	CHP-HS300 BB
1		Başlıksız Pim G⅛“	CHP-P1/8		1 x	1 x	1 x
2		Başlıksız Pim 6*	CHP-P6		–	–	–
3		O-ring	CHP-010×1		2 x	2 x	2 x
4		Bakır conta	CHP-G10		2 x	3 x	4 x
5		Bakır conta*	CHP-G06		–	–	–
6		Düz konnektör G⅛“	CHP-CS1/8		2 x	1 x	–
7		Düz konnektör M10	CHP-CS10		1 x	–	–
8		Banjo konnektör G⅛“	CHP-CB1/8		–	1 x	2 x
9		Banjo konnektör M10	CHP-CB10		–	1 x	1 x
10		Redüktör G⅛“ - M6*	CHP-R1/8-6		–	–	–
11		Redüktör G¼" - G⅛“	CHP-R1/4-1/8		–	1 x	1 x
12		Kesme sıvısı nozülü G⅛“	CHP-PV1/8-12		1 x	1 x	1 x
13		Kesme sıvısı nozülü başlıksız pimi	CHP-PV14		1 x	1 x	1 x

* 12 × 12 takım şaftı teslimata dahildir

Daha fazla bilgi için kullanma talimatına bakınız
366

GL. D - PM

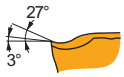
	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
150	1.50	-0.04	0.04	16.5
200	2.00	-0.05	0.05	25.0
250	2.55	-0.05	0.05	25.0
300	3.00	-0.05	0.05	25.0
400	4.00	-0.05	0.05	25.0
500	5.00	-0.05	0.05	25.0
600	6.00	-0.05	0.05	25.0



Kesme hızı (vc), ilerleme (f) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P		M		K		N		S		H		PSIRR	PSIRL
			vc	f	vc	f	vc	f	vc	f	vc	f	vc	f		
		(mm)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(°)	(°)

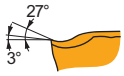




PM geometrisi ile büyük pozitif eğim açısı, kesme için ilk tercih, darbesizden hafif darbeli kesime kadar uygun.

GL1-D150M015-PM:G8330	●	0.1	■	130	0.05	■	75	0.05	◪	120	0.05	◪	390	0.06	◪	30	0.04	–	–	–	–
GL2-D200M02-PM:G8330	●●	0.2	■	130	0.08	■	75	0.07	◪	120	0.08	◪	390	0.10	◪	30	0.06	–	–	–	–
GL2-D200M02-PM:T7325	●	0.2	◪	150	0.08	■	115	0.07	◪	140	0.08		–	–	◪	45	0.06	–	–	–	–
GL3-D250G02-PM:G8330	●●	0.2	■	130	0.10	■	75	0.09	◪	120	0.10	◪	390	0.12	◪	30	0.07	–	–	–	–
GL3-D300M02-PM:G8330	●	0.2	■	130	0.10	■	75	0.09	◪	120	0.10	◪	390	0.12	◪	30	0.07	–	–	–	–
GL3-D300M02-PM:T7325	●	0.2	◪	150	0.10	■	115	0.09	◪	140	0.10		–	–	◪	45	0.07	–	–	–	–
GL4-D400M02-PM:G8330	●●	0.2	■	130	0.12	■	75	0.11	◪	120	0.12	◪	390	0.14	◪	30	0.10	–	–	–	–
GL4-D400M02-PM:T7325	●	0.2	◪	150	0.12	■	115	0.11	◪	140	0.12		–	–	◪	45	0.10	–	–	–	–
GL5-D500M03-PM:G8330	●●	0.3	■	130	0.15	■	75	0.14	◪	120	0.15	◪	390	0.18	◪	30	0.12	–	–	–	–
GL6-D600M03-PM:G8330	●●	0.3	■	130	0.15	■	75	0.14	◪	120	0.15	◪	390	0.18	◪	30	0.12	–	–	–	–

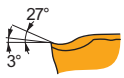




R-PM sağ kesme yönlü geometri ile büyük pozitif eğim açısı, boru kesme için ilk tercih, sürekli kesime uygun.

GL1-D150G015R06-PM:G8330	●	0.1	■	130	0.05	■	75	0.05	◪	120	0.05	◪	390	0.06	◪	30	0.04	–	–	6	–
GL1-D150G015R12-PM:G8330	●	0.1	■	130	0.05	■	75	0.05	◪	120	0.05	◪	390	0.06	◪	30	0.04	–	–	12	–
GL2-D200G02R06-PM:G8330	●	0.2	■	130	0.08	■	75	0.07	◪	120	0.08	◪	390	0.10	◪	30	0.06	–	–	6	–
GL2-D200G02R06-PM:T7325	●	0.2	◪	150	0.08	■	115	0.07	◪	140	0.08		–	–	◪	45	0.06	–	–	6	–
GL2-D200G02R12-PM:G8330	●	0.2	■	130	0.08	■	75	0.07	◪	120	0.08	◪	390	0.10	◪	30	0.06	–	–	12	–
GL3-D300G02R06-PM:G8330	●	0.2	■	130	0.10	■	75	0.09	◪	120	0.10	◪	390	0.12	◪	30	0.07	–	–	6	–
GL3-D300G02R06-PM:T7325	●	0.2	◪	150	0.10	■	115	0.09	◪	140	0.10		–	–	◪	45	0.07	–	–	6	–
GL3-D300G02R12-PM:G8330	●	0.2	■	130	0.10	■	75	0.09	◪	120	0.10	◪	390	0.12	◪	30	0.07	–	–	12	–
GL4-D400G02R06-PM:G8330	●	0.2	■	130	0.12	■	75	0.11	◪	120	0.12	◪	390	0.14	◪	30	0.10	–	–	6	–
GL4-D400G02R06-PM:T7325	●	0.2	◪	150	0.12	■	115	0.11	◪	140	0.12		–	–	◪	45	0.10	–	–	6	–
GL4-D400G02R12-PM:G8330	●	0.2	■	130	0.12	■	75	0.11	◪	120	0.12	◪	390	0.14	◪	30	0.10	–	–	12	–



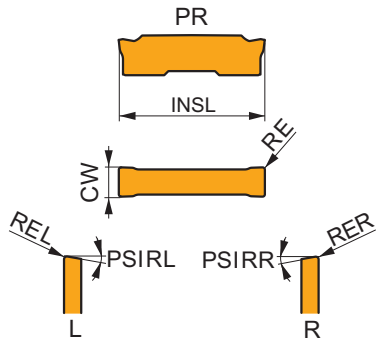


L-PM sol kesme yönlü geometri ile büyük pozitif eğim açısı, boru kesme için ilk tercih, sürekli kesime uygun.

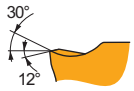
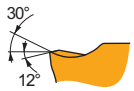
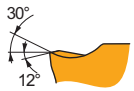
GL1-D150G015L06-PM:G8330	●	0.1	■	130	0.05	■	75	0.05	◪	120	0.05	◪	390	0.06	◪	30	0.04	–	–	–	6
GL1-D150G015L12-PM:G8330	●	0.1	■	130	0.05	■	75	0.05	◪	120	0.05	◪	390	0.06	◪	30	0.04	–	–	–	12
GL2-D200G02L06-PM:G8330	●	0.2	■	130	0.08	■	75	0.07	◪	120	0.08	◪	390	0.10	◪	30	0.06	–	–	–	6
GL2-D200G02L06-PM:T7325	●	0.2	◪	150	0.08	■	115	0.07	◪	140	0.08		–	–	◪	45	0.06	–	–	–	6
GL2-D200G02L12-PM:G8330	●	0.2	■	130	0.08	■	75	0.07	◪	120	0.08	◪	390	0.10	◪	30	0.06	–	–	–	12
GL3-D300G02L06-PM:G8330	●	0.2	■	130	0.10	■	75	0.09	◪	120	0.10	◪	390	0.12	◪	30	0.07	–	–	–	6
GL3-D300G02L06-PM:T7325	●	0.2	◪	150	0.10	■	115	0.09	◪	140	0.10		–	–	◪	45	0.07	–	–	–	6
GL3-D300G02L12-PM:G8330	●	0.2	■	130	0.10	■	75	0.09	◪	120	0.10	◪	390	0.12	◪	30	0.07	–	–	–	12
GL4-D400G02L06-PM:G8330	●	0.2	■	130	0.12	■	75	0.11	◪	120	0.12	◪	390	0.14	◪	30	0.10	–	–	–	6
GL4-D400G02L06-PM:T7325	●	0.2	◪	150	0.12	■	115	0.11	◪	140	0.12		–	–	◪	45	0.10	–	–	–	6
GL4-D400G02L12-PM:G8330	●	0.2	■	130	0.12	■	75	0.11	◪	120	0.12	◪	390	0.14	◪	30	0.10	–	–	–	12

GL. D - PR

	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
200	2.00	-0.05	0.05	25.0
300	3.00	-0.05	0.05	25.0
400	4.00	-0.05	0.05	25.0
500	5.00	-0.05	0.05	25.0
600	6.00	-0.05	0.05	25.0



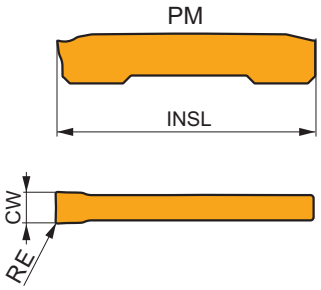
Kesme hızı (vc), ilerleme (f) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE	P		M		K		N		S		H		PSIRR	PSIRL
		vc	f	vc	f	vc	f	vc	f	vc	f	vc	f		
	(mm)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(°)	(°)
 		**PR** geometri ile negatif T bölgesi, zorlu kanal açma ve kesme için ilk tercih, darbesizden darbeli kesime kadar uygun.													
GL2-D200M02-PR:G8330	0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	–	–
GL2-D200M02-PR:T7325	0.2	150	0.10	115	0.09	140	0.10	–	–	–	–	–	–	–	–
GL3-D300M02-PR:G8330	0.2	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	–	–
GL3-D300M02-PR:T7325	0.2	150	0.12	115	0.11	140	0.12	–	–	–	–	–	–	–	–
GL4-D400M02-PR:G8330	0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	–
GL4-D400M02-PR:T7325	0.2	150	0.15	115	0.14	140	0.15	–	–	–	–	–	–	–	–
GL5-D500M04-PR:G8330	0.4	130	0.18	75	0.16	120	0.18	–	–	–	–	–	–	–	–
GL6-D600M04-PR:G8330	0.4	130	0.18	75	0.16	120	0.18	–	–	–	–	–	–	–	–
 		**R-PR** sağ kesme yönlü geometri ile negatif T bölgesi, zorlu bara kesme için ilk tercih, darbesizden darbeli kesime kadar uygun.													
GL2-D200G02R06-PR:G8330	0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	6	–
GL2-D200G02R12-PR:G8330	0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	12	–
GL3-D300G02R06-PR:G8330	0.2	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	6	–
GL3-D300G02R12-PR:G8330	0.2	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	12	–
GL4-D400G02R06-PR:G8330	0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	6	–
GL4-D400G02R12-PR:G8330	0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	12	–
 		**L-PR** sol kesme yönlü geometri ile negatif T bölgesi, zorlu bara kesme için ilk tercih, darbesizden darbeli kesime kadar uygun.													
GL2-D200G02L06-PR:G8330	0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	–	6
GL2-D200G02L12-PR:G8330	0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	–	12
GL3-D300G02L06-PR:G8330	0.2	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	–	6
GL3-D300G02L12-PR:G8330	0.2	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	–	12
GL4-D400G02L06-PR:G8330	0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	6
GL4-D400G02L12-PR:G8330	0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	12

GL. S - PM

PRAMET

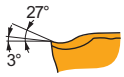
	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
300	3.00	-0.05	0.05	24.5
400	4.00	-0.05	0.05	24.3



Kesme hızı (vc), ilerleme (f) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P		M		K		N		S		H		PSIRR	PSIRL
			vc	f	vc	f	vc	f	vc	f	vc	f	vc	f		
		(mm)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(°)	(°)





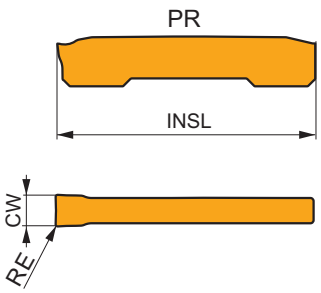
PM geometrisi ile tek taraflı kesici uçta büyük pozitif eğim açısı, derin kesme için ilk tercih ve darbesizden hafif darbeli kesime kadar uygun.

GL3-S300M02-PM:G8330		0.2	■	130	0.10	■	75	0.09	◪	120	0.10	◪	390	0.12	◪	30	0.07	–	–	–	–
GL4-S400M02-PM:G8330		0.2	■	130	0.12	■	75	0.11	◪	120	0.12	◪	390	0.14	◪	30	0.10	–	–	–	–

GL. S - PR

PRAMET

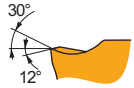
	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
300	3.00	-0.05	0.05	24.5
400	4.00	-0.05	0.05	24.3



Kesme hızı (vc), ilerleme (f) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P		M		K		N		S		H		PSIRR	PSIRL
			vc	f	vc	f	vc	f	vc	f	vc	f	vc	f		
		(mm)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(°)	(°)





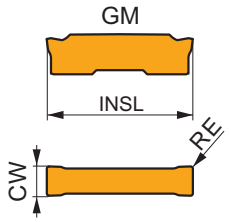
PR geometri ile tek taraflı kesici uçta negatif T bölgesi, zorlu derin kanal açma ve kesme için ilk tercih, darbesizden darbeli kesime kadar uygun.

GL3-S300M02-PR:G8330		0.2	■	130	0.12	◪	75	0.11	■	120	0.12		–	–		–	–	–	–	–	–
GL4-S400M02-PR:G8330		0.2	■	130	0.15	◪	75	0.14	■	120	0.15		–	–		–	–	–	–	–	–

GL. D - GM

PRAMET

	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
200	2.00	-0.05	0.05	25.0
300	3.00	-0.05	0.05	25.0
400	4.00	-0.05	0.05	25.0
500	5.00	-0.05	0.05	25.0
600	6.00	-0.05	0.05	25.0
800	8.00	-0.05	0.05	25.0



Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
GL2-D200M02-GM:G8330		0.2	190	0.10	0.8	110	0.09	0.8	180	0.10	0.8	–	–	–	45	0.08	0.6	–	–	–
GL2-D200M02-GM:T7325	●	0.2	220	0.10	0.8	170	0.09	0.8	205	0.10	0.8	–	–	–	70	0.08	0.6	–	–	–
GL3-D300M02-GM:G8330		0.2	150	0.20	1.0	90	0.18	1.0	140	0.20	1.0	–	–	–	35	0.14	0.8	–	–	–
GL3-D300M02-GM:T7325	●	0.2	175	0.20	1.0	135	0.18	1.0	165	0.20	1.0	–	–	–	55	0.14	0.8	–	–	–
GL3-D300M04-GM:G8330		0.4	160	0.20	1.0	95	0.18	1.0	150	0.20	1.0	–	–	–	40	0.14	0.8	–	–	–
GL3-D300M04-GM:T7325	●	0.4	185	0.20	1.0	140	0.18	1.0	175	0.20	1.0	–	–	–	60	0.14	0.8	–	–	–
GL4-D400M04-GM:G8330		0.4	150	0.25	1.2	90	0.23	1.2	140	0.25	1.2	–	–	–	35	0.18	1.0	–	–	–
GL4-D400M04-GM:T7325	●	0.4	170	0.25	1.2	130	0.23	1.2	160	0.25	1.2	–	–	–	55	0.18	1.0	–	–	–
GL4-D400M08-GM:G8330		0.8	180	0.25	1.2	105	0.23	1.2	170	0.25	1.2	–	–	–	45	0.18	1.0	–	–	–
GL4-D400M08-GM:T7325	●	0.8	200	0.25	1.2	155	0.23	1.2	190	0.25	1.2	–	–	–	65	0.18	1.0	–	–	–
GL5-D500M08-GM:G8330		0.8	170	0.30	1.2	100	0.27	1.2	160	0.30	1.2	–	–	–	40	0.21	1.0	–	–	–
GL5-D500M08-GM:T7325	●	0.8	190	0.30	1.2	145	0.27	1.2	180	0.30	1.2	–	–	–	60	0.21	1.0	–	–	–
GL6-D600M08-GM:G8330		0.8	170	0.30	1.2	100	0.27	1.2	160	0.30	1.2	–	–	–	40	0.21	1.0	–	–	–
GL6-D600M08-GM:T7325	●	0.8	190	0.30	1.2	145	0.27	1.2	180	0.30	1.2	–	–	–	60	0.21	1.0	–	–	–
GL6-D800M08-GM:G8330 [1]		0.8	170	0.30	1.2	100	0.27	1.2	160	0.30	1.2	–	–	–	40	0.21	1.2	–	–	–





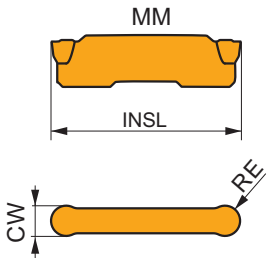
GM çok yönlü geometri, kanal açma ve boyuna tornalama için, darbesizden darbeli kesime kadar uygun.

[1] Yalnızca tutucularda kullanılabilir. ≥ CDX 24 .

GL. D - MM

PRAMET

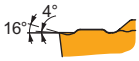
	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
200	2.00	-0.05	0.05	25.0
300	3.00	-0.05	0.05	25.0
400	4.00	-0.05	0.05	25.0
500	5.00	-0.05	0.05	26.0
600	6.00	-0.05	0.05	26.0



Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

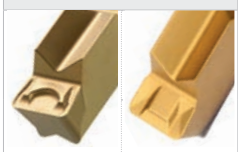
Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
GL2-D200MM0-MM:G8330		1.0	250	0.10	1.0	150	0.09	1.0	235	0.10	1.0	–	–	–	60	0.08	0.8	–	–	–
GL2-D200MM0-MM:T7325	●	1.0	285	0.10	1.0	220	0.09	1.0	270	0.10	1.0	–	–	–	90	0.08	0.8	–	–	–
GL3-D300MM0-MM:G8330		1.5	210	0.20	1.2	125	0.18	1.2	195	0.20	1.2	–	–	–	50	0.14	1.0	–	–	–
GL3-D300MM0-MM:T7325	●	1.5	240	0.20	1.2	185	0.18	1.2	225	0.20	1.2	–	–	–	75	0.14	1.0	–	–	–
GL4-D400MM0-MM:G8330		2.0	220	0.20	1.2	130	0.18	1.2	205	0.20	1.2	–	–	–	55	0.14	1.0	–	–	–
GL4-D400MM0-MM:T7325	●	2.0	250	0.20	1.2	195	0.18	1.2	235	0.20	1.2	–	–	–	80	0.14	1.0	–	–	–
GL5-D500MM0-MM:G8330		2.5	205	0.25	1.2	120	0.23	1.2	190	0.25	1.2	–	–	–	50	0.18	1.0	–	–	–
GL5-D500MM0-MM:T7325	●	2.5	235	0.25	1.2	180	0.23	1.2	220	0.25	1.2	–	–	–	75	0.18	1.0	–	–	–
GL6-D600MM0-MM:G8330		3.0	195	0.30	1.2	115	0.27	1.2	185	0.30	1.2	–	–	–	45	0.21	1.0	–	–	–
GL6-D600MM0-MM:T7325	●	3.0	220	0.30	1.2	170	0.27	1.2	205	0.30	1.2	–	–	–	70	0.21	1.0	–	–	–





MM geometri, kopya profil ve çap tornalama için tam radyüs, darbesizden darbeli kesime kadar uygun.

LCM. – DIŞ ÇAP TAKIMLAR KILAVUZU

KESİCİ UÇ YUVASI	0316	0416	0516	0616	0830
GFI(RL) EXT 16×16 / 32×25					
GFM(RL) EXT 20×20 / 32×25					
Kesme genişliği (mm) CW	3	4	5	6	8
Derin kesme (tek taraflı kesici uç)	 LCMR CM	 LCMR CM			
Kesme (boru / dolu çubuk)	 CM F	 CM F	 CM F	 CM F	 F
Kanal Açma (derin / sığ)	 F M	 F M	 F M	 F M	 F
Tornalama (boyuna)	 F M	 F M	 F M	 F M	 F
Profil işleme (çok eksenli)	 MP	 MP	 MP	 MP	 MP

GFI(RL) EXT

P M K N S H

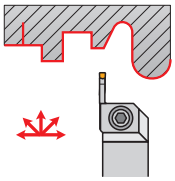
PRAMET

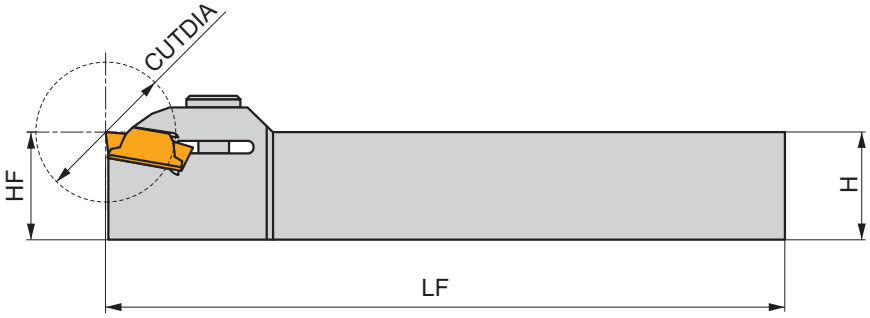
G

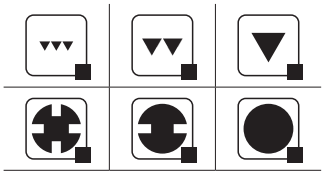


LCM. Uç için V-Kanal Sıkmalı Dış Torna ve Kanal Kateri

LCM uçlar için Sağ/Sol dış kanal kateri. kanal açma profil işleme ve çap tornalama için uygundur. Gövde uzun takım ömrü için işlem görmüştür.











	Product	HF (mm)	H (mm)	B (mm)	LF (mm)	CW (mm)	CUTDIA (mm)	kg		
R	**GFIR 1616 H 03**	16	16	16	100	3.00	18	0.22	GI136	GL03
	GFIR 2020 K 03	20	20	20	125	3.00	18	0.40	GI136	GL04
	GFIR 2525 M 03	25	25	25	150	3.00	18	0.73	GI136	GL05
	GFIR 1616 H 04	16	16	16	100	4.00	24	0.21	GI137	GL03
	GFIR 2020 K 04	20	20	20	125	4.00	24	0.39	GI137	GL04
	GFIR 2525 M 04	25	25	25	150	4.00	24	0.71	GI137	GL05
	GFIR 2020 K 05	20	20	20	125	5.00	28	0.38	GI138	GL04
	GFIR 2525 M 05	25	25	25	150	5.00	28	0.70	GI138	GL05
	GFIR 2020 K 06	20	20	20	125	6.00	28	0.38	GI139	GL04
	GFIR 2525 M 06	25	25	25	150	6.00	28	0.70	GI139	GL05
	GFIR 2525 M 08	25	25	25	150	8.00	48	0.74	GI193	GL09
	GFIR 3225 P 08	32	32	25	170	8.00	48	1.01	GI193	GL09
L	**GFIL 1616 H 03**	16	16	16	100	3.00	18	0.22	GI136	GL03
	GFIL 2020 K 03	20	20	20	125	3.00	18	0.39	GI136	GL04
	GFIL 2525 M 03	25	25	25	150	3.00	18	0.73	GI136	GL05
	GFIL 1616 H 04	16	16	16	100	4.00	24	0.20	GI137	GL03
	GFIL 2020 K 04	20	20	20	125	4.00	24	0.38	GI137	GL04
	GFIL 2525 M 04	25	25	25	150	4.00	24	0.71	GI137	GL05
	GFIL 2020 K 05	20	20	20	125	5.00	28	0.38	GI138	GL04
	GFIL 2525 M 05	25	25	25	150	5.00	28	0.71	GI138	GL05
	GFIL 2020 K 06	20	20	20	125	6.00	28	0.40	GI139	GL04
	GFIL 2525 M 06	25	25	25	150	6.00	28	0.70	GI139	GL05
	GFIL 2525 M 08	25	25	25	150	8.00	48	0.74	GI193	GL09
	GFIL 3225 P 08	32	32	25	170	8.00	48	1.02	GI193	GL09

GI136	LCM. 0316..
GI137	LCM. 0416..
GI138	LCM. 0516..
GI139	LCM. 0616..
GI193	LCM. 0830..

GL03	HS 0616C	6.0	M 6	16	HXK 5
GL04	HS 0620C	6.0	M 6	20	HXK 5
GL05	HS 0625C	6.0	M 6	25	HXK 5
GL09	HSI 1020	8.0	M 10	20	HXK 8

GFM(RL) EXT

P M K N S H

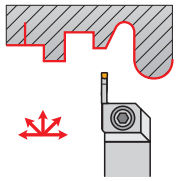
PRAMET

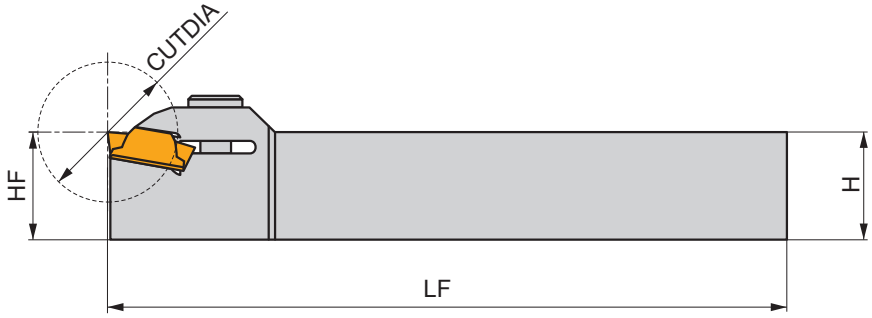
G

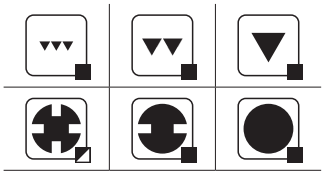


LCM. Uç için V-Kanal Sıkmalı Dış Torna ve Kanal Kateri

LCM. uçlar için Sağ/Sol dış kanal kateri. kanal açma profil işleme ve çap tornalama için uygundur. Gövde uzun takım ömrü için işlem görmüştür.











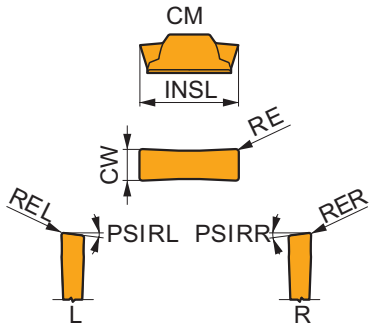
	Product	HF (mm)	H (mm)	B (mm)	LF (mm)	CW (mm)	CUTDIA (mm)	kg		
R	**GFMR 2020 K 0316**	20	20	20	125	3.00	30	0.37	GI136	GL04
	GFMR 2525 M 0316	25	25	25	150	3.00	30	0.68	GI136	GL04
	GFMR 2020 K 0416	20	20	20	125	4.00	40	0.37	GI137	GL04
	GFMR 2525 M 0416	25	25	25	150	4.00	40	0.67	GI137	GL04
	GFMR 2525 M 0516	25	25	25	150	5.00	50	0.65	GI138	GL04
	GFMR 3225 P 0516	32	32	25	170	5.00	50	0.96	GI138	GL04
	GFMR 2525 M 0616	25	25	25	150	6.00	60	0.66	GI139	GL04
	GFMR 3225 P 0616	32	32	25	170	6.00	60	0.95	GI139	GL04
	GFMR 3225 P 0830	32	32	25	170	8.00	80	0.97	GI193	GL10
L	**GFML 2020 K 0316**	20	20	20	125	3.00	30	0.36	GI136	GL04
	GFML 2525 M 0316	25	25	25	150	3.00	30	0.69	GI136	GL04
	GFML 2020 K 0416	20	20	20	125	4.00	40	0.37	GI137	GL04
	GFML 2525 M 0416	25	25	25	150	4.00	40	0.67	GI137	GL04
	GFML 2525 M 0516	25	25	25	150	5.00	50	0.66	GI138	GL04
	GFML 3225 P 0516	32	32	25	170	5.00	50	0.96	GI138	GL04
	GFML 2525 M 0616	25	25	25	150	6.00	60	0.64	GI139	GL04
	GFML 3225 P 0616	32	32	25	170	6.00	60	0.95	GI139	GL04
	GFML 3225 P 0830	32	32	25	170	8.00	80	0.97	GI193	GL10

GI136	LCM. 0316..
GI137	LCM. 0416..
GI138	LCM. 0516..
GI139	LCM. 0616..
GI193	LCM. 0830..

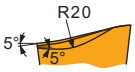
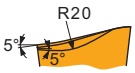
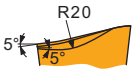
		Nm			
GL04	HS 0620C	6.0	M 6	20	HXK 5
GL10	HSI 1020	8.0	M 10	20	HXK 8

LCMF 16 - CM

	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
0316	3.00	-0.05	0.05	16.4
0416	4.00	-0.05	0.05	16.4
0516	5.00	-0.05	0.05	16.4
0616	6.00	-0.05	0.05	16.4



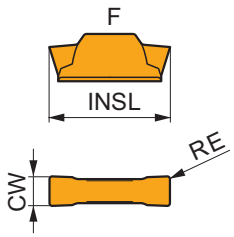
Kesme hızı (vc), ilerleme (f) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P		M		K		N		S		H		PSIRR	PSIRL
			vc	f	vc	f	vc	f	vc	f	vc	f	vc	f		
		(mm)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(°)	(°)
																
CM geometri, kesme ve kanal açma için ilk tercih, darbesizden hafif darbeli kesmeye kadar uygun.																
LCMF 031602-CM:T8330	●	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	–	–
LCMF 031604-CM:T8330	●	0.4	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	–	–
LCMF 041602-CM:T8330	●	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	–	–
LCMF 041604-CM:T8330	●	0.4	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	–	–
LCMF 051604-CM:T8330	●	0.4	130	0.11	75	0.11	120	0.11	–	–	–	–	–	–	–	–
LCMF 061604-CM:T8330	●	0.4	130	0.11	75	0.11	120	0.11	–	–	–	–	–	–	–	–
																
R-CM sol kesme yönlü geometri, kesme için ilk tercih, darbesizden hafif darbeli kesime kadar uygun.																
LCMF 031602R15-CM:T8330[1)]	●	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	15	–
LCMF 031602R6-CM:T8330	●	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	6	–
LCMF 041602R15-CM:T8330[1)]	●	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	15	–
LCMF 041602R6-CM:T8330	●	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	6	–
																
L-CM sol kesme yönlü geometri, kesme için ilk tercih, darbesizden hafif darbeli kesime kadar uygun.																
LCMF 031602L15-CM:T8330[1)]	●	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	–	15
LCMF 031602L6-CM:T8330	●	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	–	6
LCMF 041602L15-CM:T8330[1]	●	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	–	15
LCMF 041602L6-CM:T8330	●	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	–	6

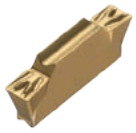
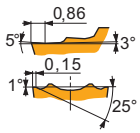
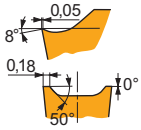
[1)] Toolholders have to be modified.

LCMF 16, LCMF 30 - F

	CW (mm)	CWTOLL (mm)	CWTOLU (mm)	INSL (mm)
0316	3.00	-0.05	0.05	16.4
0416	4.00	-0.05	0.05	16.4
0516	5.00	-0.05	0.05	16.4
0616	6.00	-0.05	0.05	16.4
0830	8.00	-0.05	0.05	30.0



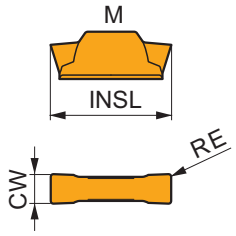
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
F geometri, kesme, kanal açma ve çap tornalama için, ince ve finiş işleme, ve darbesizden hafif darbeli işlemeye kadar uygun.																				
LCMF 031602-F:T8330		0.2	195	0.10	0.3	115	0.09	0.3	185	0.10	0.3	–	–	–	–	–	–	–	–	–
LCMF 031604-F:T8330		0.4	200	0.10	0.5	120	0.09	0.5	190	0.10	0.5	–	–	–	–	–	–	–	–	–
LCMF 041604-F:T8330		0.4	185	0.13	0.5	110	0.12	0.5	175	0.13	0.5	–	–	–	–	–	–	–	–	–
LCMF 041604-F:T9325		0.4	275	0.13	0.5	165	0.12	0.5	260	0.13	0.5	–	–	–	–	–	–	–	–	–
LCMF 041608-F:T8330		0.8	205	0.13	1.0	120	0.12	1.0	190	0.13	1.0	–	–	–	–	–	–	–	–	–
LCMF 041608-F:T9325		0.8	305	0.13	1.0	180	0.12	1.0	285	0.13	1.0	–	–	–	–	–	–	–	–	–
LCMF 051608-F:T8330		0.8	195	0.15	1.0	115	0.14	1.0	185	0.15	1.0	–	–	–	–	–	–	–	–	–
LCMF 051608-F:T9325		0.8	285	0.15	1.0	170	0.14	1.0	270	0.15	1.0	–	–	–	–	–	–	–	–	–
LCMF 061608-F:T8330		0.8	190	0.17	1.0	110	0.15	1.0	180	0.17	1.0	–	–	–	–	–	–	–	–	–
LCMF 061608-F:T9325		0.8	270	0.17	1.0	160	0.15	1.0	255	0.17	1.0	–	–	–	–	–	–	–	–	–
																				
F geometri, kesme, kanal açma ve çap tornalama için, ince ve finiş işleme, ve darbesizden hafif darbeli işlemeye kadar uygun.																				
LCMF 083008-F:T8330		0.8	175	0.25	1.0	105	0.23	1.0	165	0.25	1.0	–	–	–	–	–	–	–	–	–
LCMF 083012-F:T8330		1.2	170	0.25	1.5	100	0.23	1.5	160	0.25	1.5	–	–	–	–	–	–	–	–	–

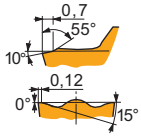
LCMF 16 - M

PRAMET

	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
0316	3.00	-0.05	0.05	16.4
0416	4.00	-0.05	0.05	16.4
0516	5.00	-0.05	0.05	16.4
0616	6.00	-0.05	0.05	16.4



Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

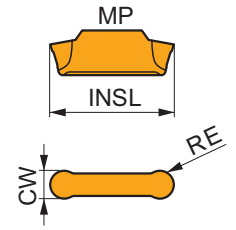
Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
																				
LCMF 031602-M:T8330		0.2	160	0.13	1.0	95	0.12	1.0	150	0.13	1.0	–	–	–	–	–	–	30	0.10	0.7
LCMF 031604-M:T8330		0.4	170	0.13	1.0	100	0.12	1.0	160	0.13	1.0	–	–	–	–	–	–	30	0.10	0.7
LCMF 041604-M:T8330		0.4	155	0.18	1.0	90	0.16	1.0	145	0.18	1.0	–	–	–	–	–	–	30	0.12	0.8
LCMF 041604-M:T9325		0.4	225	0.18	1.0	135	0.16	1.0	210	0.18	1.0	–	–	–	–	–	–	–	–	–
LCMF 041608-M:T8330		0.8	185	0.18	1.0	110	0.16	1.0	175	0.18	1.0	–	–	–	–	–	–	35	0.12	0.8
LCMF 041608-M:T9325		0.8	265	0.18	1.0	155	0.16	1.0	250	0.18	1.0	–	–	–	–	–	–	–	–	–
LCMF 051608-M:T8330		0.8	180	0.20	1.0	105	0.18	1.0	170	0.20	1.0	–	–	–	–	–	–	35	0.13	1.0
LCMF 051608-M:T9325		0.8	255	0.20	1.0	150	0.18	1.0	240	0.20	1.0	–	–	–	–	–	–	–	–	–
LCMF 061608-M:T8330		0.8	175	0.25	1.0	105	0.23	1.0	165	0.25	1.0	–	–	–	–	–	–	35	0.13	1.0
LCMF 061608-M:T9325		0.8	230	0.25	1.0	135	0.23	1.0	215	0.25	1.0	–	–	–	–	–	–	–	–	–

M geometri, kanal açma ve çap tornalama için, darbesizden darbeli kesime kadar uygun.

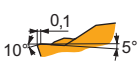
LCMF 16, LCMF 30 - MP

PRAMET

	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
0316	3.00	-0.05	0.05	17.5
0416	4.00	-0.05	0.05	17.6
0516	5.00	-0.05	0.05	18.3
0616	6.00	-0.05	0.05	18.5
0830	8.00	-0.05	0.05	30.9



Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

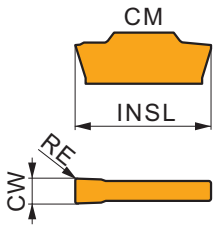
Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
																				
LCMF 0316MO-MP:T8330		1.5	190	0.30	0.8	110	0.27	0.8	180	0.30	0.8	–	–	–	–	–	–	–	–	–
LCMF 0416MO-MP:T8330		2.0	175	0.40	1.0	105	0.36	1.0	165	0.40	1.0	–	–	–	–	–	–	–	–	–
LCMF 0416MO-MP:T9325		2.0	220	0.40	1.0	130	0.36	1.0	205	0.40	1.0	–	–	–	–	–	–	–	–	–
LCMF 0516MO-MP:T8330		2.5	170	0.45	1.0	100	0.41	1.0	160	0.45	1.0	–	–	–	–	–	–	–	–	–
LCMF 0516MO-MP:T9325		2.5	205	0.45	1.0	120	0.41	1.0	190	0.45	1.0	–	–	–	–	–	–	–	–	–
LCMF 0616MO-MP:T8330		3.0	165	0.50	1.0	95	0.45	1.0	155	0.50	1.0	–	–	–	–	–	–	–	–	–
LCMF 0616MO-MP:T9325		3.0	200	0.50	1.0	120	0.45	1.0	190	0.50	1.0	–	–	–	–	–	–	–	–	–
LCMF 0830MO-MP:T8330		4.0	150	0.60	1.2	90	0.54	1.2	140	0.60	1.2	–	–	–	–	–	–	–	–	–

MP geometri, kopya profil ve çap tornalama, ve darbesizden darbeli kesime kadar uygun.

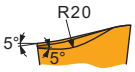
LCMR 16 - CM

PRAMET

	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
0316	3.00	-0.05	0.05	16.4
0416	4.00	-0.05	0.05	16.4



Kesme hızı (vc), ilerleme (f) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

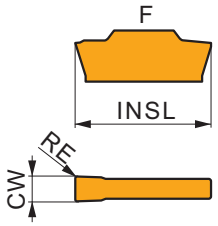
Product	RE	P		M		K		N		S		H		PSIRR	PSIRL
		vc	f	vc	f	vc	f	vc	f	vc	f	vc	f		
	(mm)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(°)	(°)
															
LCMR 031602-CM:T8330	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	–	–
LCMR 041604-CM:T8330	0.4	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	–	–

CM geometri, kesme ve kanal açma için ilk tercih, darbesizden hafif darbeli kesmeye kadar uygun.

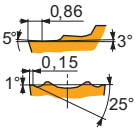
LCMR 16, LCMR 30 - F

PRAMET

	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
0316	3.00	-0.05	0.05	16.4
0416	4.00	-0.05	0.05	16.4
0516	5.00	-0.05	0.05	16.4
0616	6.00	-0.05	0.05	16.4



Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

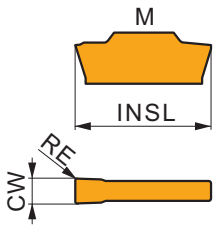
Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
																			
LCMR 031604-F:T8330	0.4	200	0.10	0.5	120	0.09	0.5	190	0.10	0.5	–	–	–	–	–	–	–	–	–
LCMR 041604-F:T8330	0.4	185	0.13	0.5	110	0.12	0.5	175	0.13	0.5	–	–	–	–	–	–	–	–	–
LCMR 051604-F:T8330	0.4	180	0.15	0.5	105	0.14	0.5	170	0.15	0.5	–	–	–	–	–	–	–	–	–
LCMR 061608-F:T8330	0.8	190	0.17	1.0	110	0.15	1.0	180	0.17	1.0	–	–	–	–	–	–	–	–	–

F geometri, kesme, kanal açma ve çap tornalama için, ince ve finiş işleme, ve darbesizden hafif darbeli işlemeye kadar uygun.

LCMR 16 - M

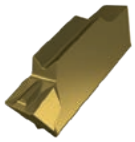
PRAMET

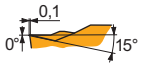
	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
0316	3.00	-0.05	0.05	16.4
0416	4.00	-0.05	0.05	16.4
0516	5.00	-0.05	0.05	16.4
0616	6.00	-0.05	0.05	16.4



Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
LCMR 031604-M:T8330		0.4	170	0.13	1.0	100	0.12	1.0	160	0.13	1.0	–	–	–	–	–	–	30	0.10	0.7
LCMR 041604-M:T8330		0.4	155	0.18	1.0	90	0.16	1.0	145	0.18	1.0	–	–	–	–	–	–	30	0.12	0.8
LCMR 051604-M:T8330		0.4	150	0.20	1.0	90	0.18	1.0	140	0.20	1.0	–	–	–	–	–	–	30	0.13	1.0
LCMR 061608-M:T8330		0.8	175	0.25	1.0	105	0.23	1.0	165	0.25	1.0	–	–	–	–	–	–	35	0.13	1.0





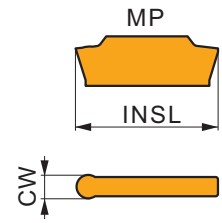
E

M geometri, kanal açma ve çap tornalama için, darbesizden darbeli kesime kadar uygun.

LCMR 16 - MP

PRAMET

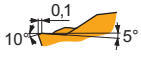
	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
0316	3.00	-0.05	0.05	17.4
0416	4.00	-0.05	0.05	17.5
0516	5.00	-0.05	0.05	18.1
0616	6.00	-0.05	0.05	18.3



Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
LCMR 0316M0-MP:T8330		1.5	190	0.30	0.8	110	0.27	0.8	180	0.30	0.8	–	–	–	–	–	–	–	–	–
LCMR 0416M0-MP:T8330		2.0	175	0.40	1.0	105	0.36	1.0	165	0.40	1.0	–	–	–	–	–	–	–	–	–
LCMR 0516M0-MP:T8330		2.5	170	0.45	1.0	100	0.41	1.0	160	0.45	1.0	–	–	–	–	–	–	–	–	–
LCMR 0616M0-MP:T8330		3.0	165	0.50	1.0	95	0.45	1.0	155	0.50	1.0	–	–	–	–	–	–	–	–	–





U S

MP geometri, kopya profil ve çap tornalama, ve darbesizden darbeli kesime kadar uygun.

KESİCİ UÇ YUVASI	GL1	GL2	GL3	GL4	GL5	GL6	
Lamalar H = 26; 32 mm	CDX 16 mm NEW	CDX 35 – 50 mm	CDX 35 – 50 mm	CDX 50 mm	CDX 60 mm	CDX 60 mm	
NEW MS Lamalar		CDX 24 mm	CDX 24 mm	CDX 24 mm	CDX 24 mm	CDX 24 mm	
Kesme genişliği (mm) CW	1.5	2	3 (2.5)	4	5	6	8
NEW Derin kesme (tek taraflı kesici uç)			TEK TARAFLI KESİCİ UÇ PM 1 PR	TEK TARAFLI KESİCİ UÇ PM 1 PR			
Kesme (boru / dolu çubuk)	NEW PM	PM 1 PR	CW = 2.5 / 3 PM 1 PR	PM 1 PR	PM 1 PR	PM 1 PR	
Kanal Açma (derin / sığ)		PR GM	PR GM	PR GM	PR GM	PR GM	NEW GM



MS-EN

- Modüler Takım Tutucu
- Şaft boyutları:
  20 × 20, 25 × 25, 32 × 32 mm



DU, D

- Takım Tutucu Bloğu
- Şaft boyutları:
  20 × 20, 25 × 23, 25 × 32, 32 × 29, 25 × 30 mm

GLS B

P M K N S H

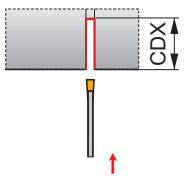
PRAMET

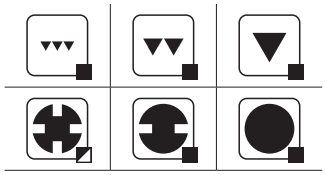
X

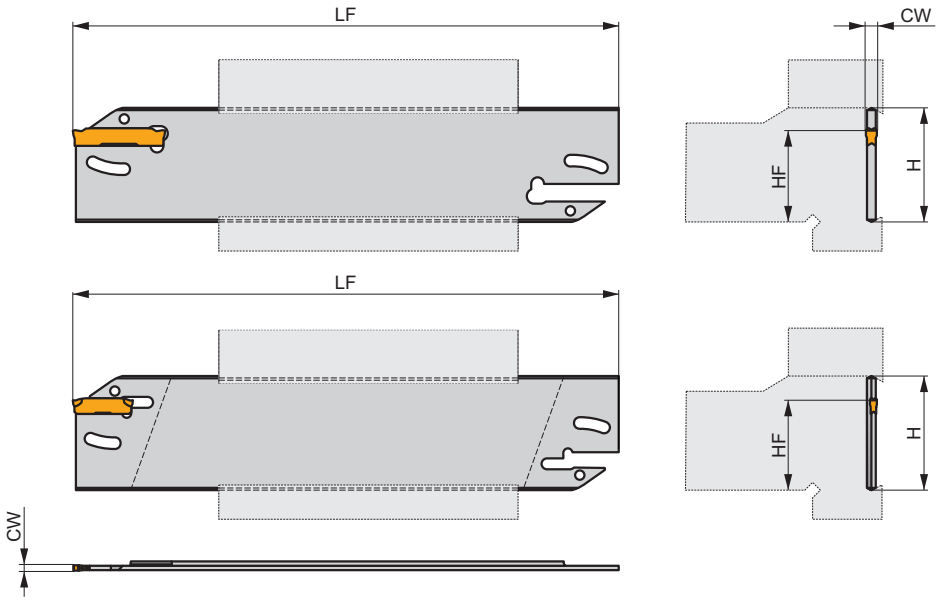


GL kesici uçlar için Çift Taraflı Kanal Açma ve Kesme Laması

GL kesici uçlar için lama, kesme ve kanal açma uygulamalarına uygundur. Spesifik anahtar (pakete dahildir) kesici uç değişimini kolaylaştırır. DU, D takım tutucu bloğuna takılabilir. Gövde uzun takım ömrü için işlem görmüştür.









	Product	HF (mm)	H (mm)	LF (mm)	CW (mm)	CDX (mm)	kg		
R	GL1-S26KBR-16	21.4	26	125	1.50	16	0.05	GI333	KV2
	GL1-S32MBR-16	32	32	150	1.50	16	0.07	GI333	KV2
L	GL1-S26KBL-16	21.4	26	125	1.50	16	0.05	GI333	KV2
	GL1-S32MBL-16	32	32	150	1.50	16	0.07	GI333	KV2
N	GL2-S26KB	21.4	26	125	2.00	35	0.13	GI334	KV2
	GL2-S32MB	25	32	150	2.00	50	0.15	GI334	KV2
	GL3-S26KB	21.4	26	125	3.00	35	0.15	GI335	KV2
	GL3-S32MB	25	32	150	3.00	50	0.15	GI335	KV2
	GL4-S32MB	25	32	150	4.00	50	0.19	GI336	KV2
	GL5-S32MB	25	32	150	5.00	60	0.22	GI337	KV2
	GL6-S32MB	25	32	150	6.00	60	0.25	GI338	KV2

GI333	GL1..	–
GI334	GL2..	–
GI335	GL3..	–
GI336	GL4..	–
GI337	GL5..	–
GI338	GL6-D600..	GL6-D800..

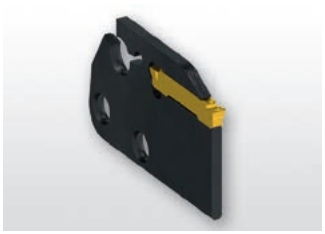
KV2	KV 15x150

GLS BS

P M K N S H

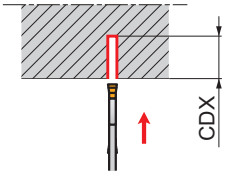
PRAMET

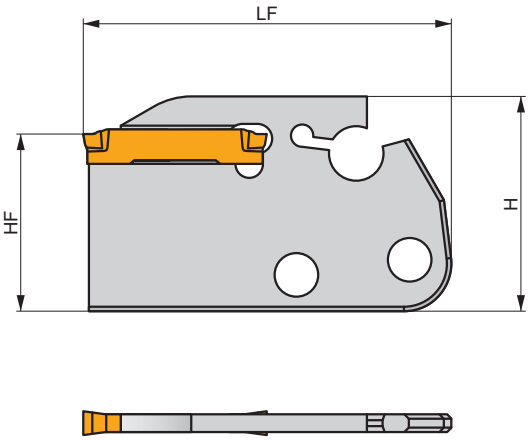
G

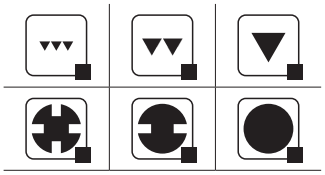


GL Kesici uçlar için Kanal Açma ve Kesme Laması, MS-EN Takım Tutucu için

Modüler takım tutucu MS-EN için Lama, GL kesici uçlar için tasarlanmıştır. Kanal açma ve kesme uygulamaları için uygundur. Lamalar uzun takım ömrü için işlem görmüştür.







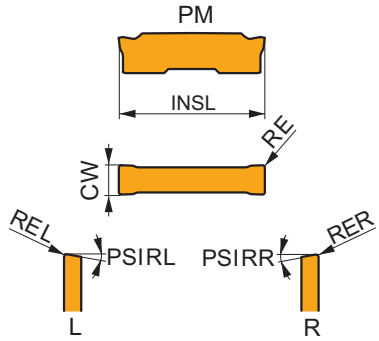


	Product	HF (mm)	H (mm)	LF (mm)	CW (mm)	CDX (mm)	kg	
	GL2-S29CBS	24	29	50	2.00	24	0.01	GI334
	GL3-S29CBS	24	29	50	3.00	24	0.02	GI335
	GL4-S29CBS	24	29	50	4.00	24	0.02	GI336
	GL5-S29CBS	24	29	50	5.00	24	0.03	GI337
	GL6-S29CBS	24	29	50	6.00	24	0.04	GI338

GI334	GL2..	–
GI335	GL3..	–
GI336	GL4..	–
GI337	GL5..	–
GI338	GL6-D600..	GL6-D800..

GL. D - PM

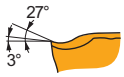
	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
150	1.50	-0.04	0.04	16.5
200	2.00	-0.05	0.05	25.0
250	2.55	-0.05	0.05	25.0
300	3.00	-0.05	0.05	25.0
400	4.00	-0.05	0.05	25.0
500	5.00	-0.05	0.05	25.0
600	6.00	-0.05	0.05	25.0



Kesme hızı (vc), ilerleme (f) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P		M		K		N		S		H		PSIRR	PSIRL
			vc	f	vc	f	vc	f	vc	f	vc	f	vc	f		
		(mm)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(°)	(°)

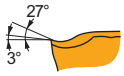




PM geometrisi ile büyük pozitif eğim açısı, kesme için ilk tercih, darbesizden hafif darbeli kesime kadar uygun.

GL1-D150M015-PM:G8330	●	0.1	■	130	0.05	■	75	0.05	◪	120	0.05	◪	390	0.06	◪	30	0.04	–	–	–	–
GL2-D200M02-PM:G8330	●●●	0.2	■	130	0.08	■	75	0.07	◪	120	0.08	◪	390	0.10	◪	30	0.06	–	–	–	–
GL2-D200M02-PM:T7325	●	0.2	◪	150	0.08	■	115	0.07	◪	140	0.08		–	–	◪	45	0.06	–	–	–	–
GL3-D250G02-PM:G8330	●●●	0.2	■	130	0.10	■	75	0.09	◪	120	0.10	◪	390	0.12	◪	30	0.07	–	–	–	–
GL3-D300M02-PM:G8330	●	0.2	■	130	0.10	■	75	0.09	◪	120	0.10	◪	390	0.12	◪	30	0.07	–	–	–	–
GL3-D300M02-PM:T7325	●	0.2	◪	150	0.10	■	115	0.09	◪	140	0.10		–	–	◪	45	0.07	–	–	–	–
GL4-D400M02-PM:G8330	●●●	0.2	■	130	0.12	■	75	0.11	◪	120	0.12	◪	390	0.14	◪	30	0.10	–	–	–	–
GL4-D400M02-PM:T7325	●	0.2	◪	150	0.12	■	115	0.11	◪	140	0.12		–	–	◪	45	0.10	–	–	–	–
GL5-D500M03-PM:G8330	●●●	0.3	■	130	0.15	■	75	0.14	◪	120	0.15	◪	390	0.18	◪	30	0.12	–	–	–	–
GL6-D600M03-PM:G8330	●●●	0.3	■	130	0.15	■	75	0.14	◪	120	0.15	◪	390	0.18	◪	30	0.12	–	–	–	–

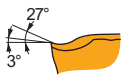




R-PM sağ kesme yönlü geometri ile büyük pozitif eğim açısı, boru kesme için ilk tercih, sürekli kesime uygun.

GL1-D150G015R06-PM:G8330	●	0.1	■	130	0.05	■	75	0.05	◪	120	0.05	◪	390	0.06	◪	30	0.04	–	–	6	–
GL1-D150G015R12-PM:G8330	●	0.1	■	130	0.05	■	75	0.05	◪	120	0.05	◪	390	0.06	◪	30	0.04	–	–	12	–
GL2-D200G02R06-PM:G8330	●	0.2	■	130	0.08	■	75	0.07	◪	120	0.08	◪	390	0.10	◪	30	0.06	–	–	6	–
GL2-D200G02R06-PM:T7325	●	0.2	◪	150	0.08	■	115	0.07	◪	140	0.08		–	–	◪	45	0.06	–	–	6	–
GL2-D200G02R12-PM:G8330	●	0.2	■	130	0.08	■	75	0.07	◪	120	0.08	◪	390	0.10	◪	30	0.06	–	–	12	–
GL3-D300G02R06-PM:G8330	●	0.2	■	130	0.10	■	75	0.09	◪	120	0.10	◪	390	0.12	◪	30	0.07	–	–	6	–
GL3-D300G02R06-PM:T7325	●	0.2	◪	150	0.10	■	115	0.09	◪	140	0.10		–	–	◪	45	0.07	–	–	6	–
GL3-D300G02R12-PM:G8330	●	0.2	■	130	0.10	■	75	0.09	◪	120	0.10	◪	390	0.12	◪	30	0.07	–	–	12	–
GL4-D400G02R06-PM:G8330	●	0.2	■	130	0.12	■	75	0.11	◪	120	0.12	◪	390	0.14	◪	30	0.10	–	–	6	–
GL4-D400G02R06-PM:T7325	●	0.2	◪	150	0.12	■	115	0.11	◪	140	0.12		–	–	◪	45	0.10	–	–	6	–
GL4-D400G02R12-PM:G8330	●	0.2	■	130	0.12	■	75	0.11	◪	120	0.12	◪	390	0.14	◪	30	0.10	–	–	12	–



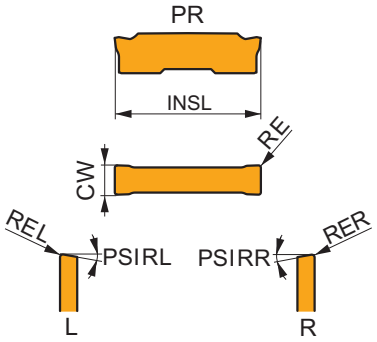


L-PM sol kesme yönlü geometri ile büyük pozitif eğim açısı, boru kesme için ilk tercih, sürekli kesime uygun.

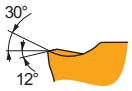
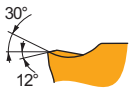
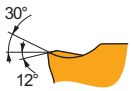
GL1-D150G015L06-PM:G8330	●	0.1	■	130	0.05	■	75	0.05	◪	120	0.05	◪	390	0.06	◪	30	0.04	–	–	–	6
GL1-D150G015L12-PM:G8330	●	0.1	■	130	0.05	■	75	0.05	◪	120	0.05	◪	390	0.06	◪	30	0.04	–	–	–	12
GL2-D200G02L06-PM:G8330	●	0.2	■	130	0.08	■	75	0.07	◪	120	0.08	◪	390	0.10	◪	30	0.06	–	–	–	6
GL2-D200G02L06-PM:T7325	●	0.2	◪	150	0.08	■	115	0.07	◪	140	0.08		–	–	◪	45	0.06	–	–	–	6
GL2-D200G02L12-PM:G8330	●	0.2	■	130	0.08	■	75	0.07	◪	120	0.08	◪	390	0.10	◪	30	0.06	–	–	–	12
GL3-D300G02L06-PM:G8330	●	0.2	■	130	0.10	■	75	0.09	◪	120	0.10	◪	390	0.12	◪	30	0.07	–	–	–	6
GL3-D300G02L06-PM:T7325	●	0.2	◪	150	0.10	■	115	0.09	◪	140	0.10		–	–	◪	45	0.07	–	–	–	6
GL3-D300G02L12-PM:G8330	●	0.2	■	130	0.10	■	75	0.09	◪	120	0.10	◪	390	0.12	◪	30	0.07	–	–	–	12
GL4-D400G02L06-PM:G8330	●	0.2	■	130	0.12	■	75	0.11	◪	120	0.12	◪	390	0.14	◪	30	0.10	–	–	–	6
GL4-D400G02L06-PM:T7325	●	0.2	◪	150	0.12	■	115	0.11	◪	140	0.12		–	–	◪	45	0.10	–	–	–	6
GL4-D400G02L12-PM:G8330	●	0.2	■	130	0.12	■	75	0.11	◪	120	0.12	◪	390	0.14	◪	30	0.10	–	–	–	12

GL. D - PR

	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
200	2.00	-0.05	0.05	25.0
300	3.00	-0.05	0.05	25.0
400	4.00	-0.05	0.05	25.0
500	5.00	-0.05	0.05	25.0
600	6.00	-0.05	0.05	25.0



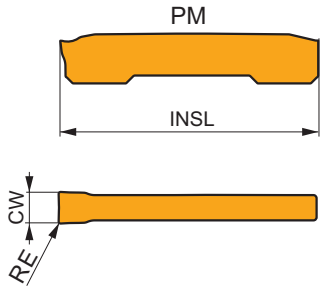
Kesme hızı (vc), ilerleme (f) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P		M		K		N		S		H		PSIRR	PSIRL
			vc	f	vc	f	vc	f	vc	f	vc	f	vc	f		
		(mm)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(°)	(°)
			**PR** geometri ile negatif T bölgesi, zorlu kanal açma ve kesme için ilk tercih, darbesizden darbeli kesime kadar uygun.													
GL2-D200M02-PR:G8330		0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	–	–
GL2-D200M02-PR:T7325		0.2	150	0.10	115	0.09	140	0.10	–	–	–	–	–	–	–	–
GL3-D300M02-PR:G8330		0.2	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	–	–
GL3-D300M02-PR:T7325		0.2	150	0.12	115	0.11	140	0.12	–	–	–	–	–	–	–	–
GL4-D400M02-PR:G8330		0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	–
GL4-D400M02-PR:T7325		0.2	150	0.15	115	0.14	140	0.15	–	–	–	–	–	–	–	–
GL5-D500M04-PR:G8330		0.4	130	0.18	75	0.16	120	0.18	–	–	–	–	–	–	–	–
GL6-D600M04-PR:G8330		0.4	130	0.18	75	0.16	120	0.18	–	–	–	–	–	–	–	–
			**R-PR** sağ kesme yönlü geometri ile negatif T bölgesi, zorlu bara kesme için ilk tercih, darbesizden darbeli kesime kadar uygun.													
GL2-D200G02R06-PR:G8330		0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	6	–
GL2-D200G02R12-PR:G8330		0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	12	–
GL3-D300G02R06-PR:G8330		0.2	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	6	–
GL3-D300G02R12-PR:G8330		0.2	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	12	–
GL4-D400G02R06-PR:G8330		0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	6	–
GL4-D400G02R12-PR:G8330		0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	12	–
			**L-PR** sol kesme yönlü geometri ile negatif T bölgesi, zorlu bara kesme için ilk tercih, darbesizden darbeli kesime kadar uygun.													
GL2-D200G02L06-PR:G8330		0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	–	6
GL2-D200G02L12-PR:G8330		0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	–	12
GL3-D300G02L06-PR:G8330		0.2	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	–	6
GL3-D300G02L12-PR:G8330		0.2	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	–	12
GL4-D400G02L06-PR:G8330		0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	6
GL4-D400G02L12-PR:G8330		0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	12

GL. S - PM

PRAMET

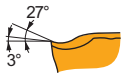
	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
300	3.00	-0.05	0.05	24.5
400	4.00	-0.05	0.05	24.3



Kesme hızı (vc), ilerleme (f) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P		M		K		N		S		H		PSIRR	PSIRL
			vc	f	vc	f	vc	f	vc	f	vc	f	vc	f		
		(mm)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(°)	(°)
GL3-S300M02-PM:G8330		0.2	130	0.10	75	0.09	120	0.10	390	0.12	30	0.07	–	–	–	–
GL4-S400M02-PM:G8330		0.2	130	0.12	75	0.11	120	0.12	390	0.14	30	0.10	–	–	–	–



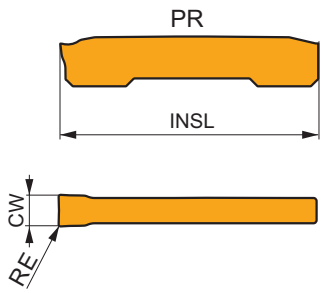


PM geometrisi ile tek taraflı kesici uçta büyük pozitif eğim açısı, derin kesme için ilk tercih ve darbesizden hafif darbeli kesime kadar uygun.

GL. S - PR

PRAMET

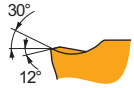
	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
300	3.00	-0.05	0.05	24.5
400	4.00	-0.05	0.05	24.3



Kesme hızı (vc), ilerleme (f) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P		M		K		N		S		H		PSIRR	PSIRL
			vc	f	vc	f	vc	f	vc	f	vc	f	vc	f		
		(mm)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(°)	(°)
GL3-S300M02-PR:G8330		0.2	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	–	–
GL4-S400M02-PR:G8330		0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	–



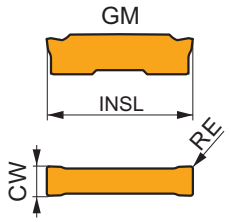


PR geometri ile tek taraflı kesici uçta negatif T bölgesi, zorlu derin kanal açma ve kesme için ilk tercih, darbesizden darbeli kesime kadar uygun.

GL. D - GM

PRAMET

	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
200	2.00	-0.05	0.05	25.0
300	3.00	-0.05	0.05	25.0
400	4.00	-0.05	0.05	25.0
500	5.00	-0.05	0.05	25.0
600	6.00	-0.05	0.05	25.0
800	8.00	-0.05	0.05	25.0



Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
GL2-D200M02-GM:G8330	✱	0.2	190	0.10	0.8	110	0.09	0.8	180	0.10	0.8	–	–	–	45	0.08	0.6	–	–	–
GL2-D200M02-GM:T7325	●	0.2	220	0.10	0.8	170	0.09	0.8	205	0.10	0.8	–	–	–	70	0.08	0.6	–	–	–
GL3-D300M02-GM:G8330	✱	0.2	150	0.20	1.0	90	0.18	1.0	140	0.20	1.0	–	–	–	35	0.14	0.8	–	–	–
GL3-D300M02-GM:T7325	●	0.2	175	0.20	1.0	135	0.18	1.0	165	0.20	1.0	–	–	–	55	0.14	0.8	–	–	–
GL3-D300M04-GM:G8330	✱	0.4	160	0.20	1.0	95	0.18	1.0	150	0.20	1.0	–	–	–	40	0.14	0.8	–	–	–
GL3-D300M04-GM:T7325	●	0.4	185	0.20	1.0	140	0.18	1.0	175	0.20	1.0	–	–	–	60	0.14	0.8	–	–	–
GL4-D400M04-GM:G8330	✱	0.4	150	0.25	1.2	90	0.23	1.2	140	0.25	1.2	–	–	–	35	0.18	1.0	–	–	–
GL4-D400M04-GM:T7325	●	0.4	170	0.25	1.2	130	0.23	1.2	160	0.25	1.2	–	–	–	55	0.18	1.0	–	–	–
GL4-D400M08-GM:G8330	✱	0.8	180	0.25	1.2	105	0.23	1.2	170	0.25	1.2	–	–	–	45	0.18	1.0	–	–	–
GL4-D400M08-GM:T7325	●	0.8	200	0.25	1.2	155	0.23	1.2	190	0.25	1.2	–	–	–	65	0.18	1.0	–	–	–
GL5-D500M08-GM:G8330	✱	0.8	170	0.30	1.2	100	0.27	1.2	160	0.30	1.2	–	–	–	40	0.21	1.0	–	–	–
GL5-D500M08-GM:T7325	●	0.8	190	0.30	1.2	145	0.27	1.2	180	0.30	1.2	–	–	–	60	0.21	1.0	–	–	–
GL6-D600M08-GM:G8330	✱	0.8	170	0.30	1.2	100	0.27	1.2	160	0.30	1.2	–	–	–	40	0.21	1.0	–	–	–
GL6-D600M08-GM:T7325	●	0.8	190	0.30	1.2	145	0.27	1.2	180	0.30	1.2	–	–	–	60	0.21	1.0	–	–	–
GL6-D800M08-GM:G8330 [1]	✱	0.8	170	0.30	1.2	100	0.27	1.2	160	0.30	1.2	–	–	–	40	0.21	1.2	–	–	–





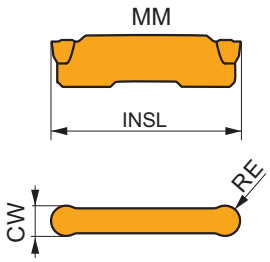
GM çok yönlü geometri, kanal açma ve boyuna tornalama için, darbesizden darbeli kesime kadar uygun.

[1] Yalnızca tutucularda kullanılabilir. ≥ CDX 24 .

GL. D - MM

PRAMET

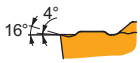
	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
200	2.00	-0.05	0.05	25.0
300	3.00	-0.05	0.05	25.0
400	4.00	-0.05	0.05	25.0
500	5.00	-0.05	0.05	26.0
600	6.00	-0.05	0.05	26.0



Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

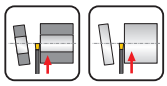
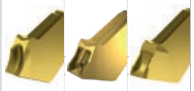
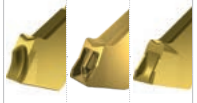
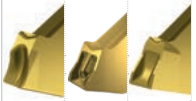
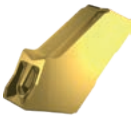
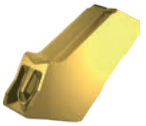
Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
GL2-D200MM0-MM:G8330	✱	1.0	250	0.10	1.0	150	0.09	1.0	235	0.10	1.0	–	–	–	60	0.08	0.8	–	–	–
GL2-D200MM0-MM:T7325	✱	1.0	285	0.10	1.0	220	0.09	1.0	270	0.10	1.0	–	–	–	90	0.08	0.8	–	–	–
GL3-D300MM0-MM:G8330	✱	1.5	210	0.20	1.2	125	0.18	1.2	195	0.20	1.2	–	–	–	50	0.14	1.0	–	–	–
GL3-D300MM0-MM:T7325	✱	1.5	240	0.20	1.2	185	0.18	1.2	225	0.20	1.2	–	–	–	75	0.14	1.0	–	–	–
GL4-D400MM0-MM:G8330	✱	2.0	220	0.20	1.2	130	0.18	1.2	205	0.20	1.2	–	–	–	55	0.14	1.0	–	–	–
GL4-D400MM0-MM:T7325	✱	2.0	250	0.20	1.2	195	0.18	1.2	235	0.20	1.2	–	–	–	80	0.14	1.0	–	–	–
GL5-D500MM0-MM:G8330	✱	2.5	205	0.25	1.2	120	0.23	1.2	190	0.25	1.2	–	–	–	50	0.18	1.0	–	–	–
GL5-D500MM0-MM:T7325	✱	2.5	235	0.25	1.2	180	0.23	1.2	220	0.25	1.2	–	–	–	75	0.18	1.0	–	–	–
GL6-D600MM0-MM:G8330	✱	3.0	195	0.30	1.2	115	0.27	1.2	185	0.30	1.2	–	–	–	45	0.21	1.0	–	–	–
GL6-D600MM0-MM:T7325	✱	3.0	220	0.30	1.2	170	0.27	1.2	205	0.30	1.2	–	–	–	70	0.21	1.0	–	–	–

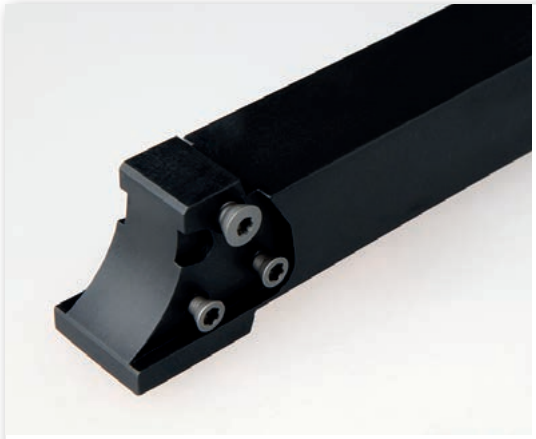




MM geometri, kopya profil ve çap tornalama için tam radyüs, darbesizden darbeli kesime kadar uygun.

LFMX – LAMALAR VE AKSESUARLAR KILAVUZU

KESİCİ UÇ YUVASI	1.60	2.00	3.00	4.00	5.00	6.35
XLCFN B Lamalar H = 26 mm H = 32; 45 mm						
XLCF(NRL) BS MS Lamalar						
Kesme genişliği (mm) CW	1.5 / 1.6	2.0 / 2.2	3.1	4.1	5.1	6.35
Kesme uçları (keskin / T-land ile)						
	F1 F2	F1 F2 M2	F1 F2 M2	F1 F2 M2	F2	F2



MS-EN

- Modüler Takım Tutucu
- Şaft boyutları:
  20 × 20, 25 × 25, 32 × 32 mm



DU, D

- Takım Tutucu Bloğu
- Şaft boyutları:
  20 × 20, 25 × 23, 25 × 32, 32 × 29, 25 × 30 mm

XLCFN B

P M K N S H

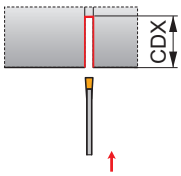
PRAMET

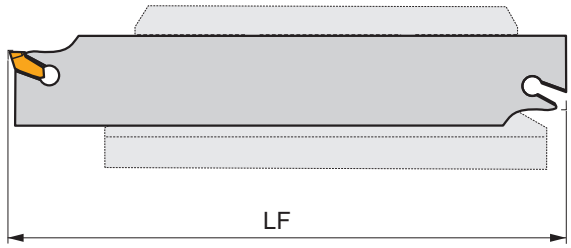
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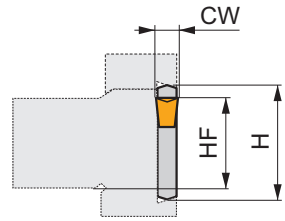


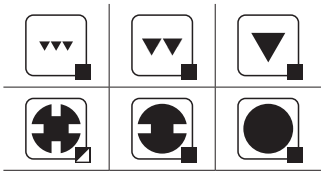
LFMX Uçlar için Çift Taraflı Kesme Laması

Kesme işlemleri için lama. Tek taraflı LFMX uçlar için. DU Pramet baz tutuculara uygundur. Lama uzun takım ömrü için işlem görmüştür.











	Product	HF (mm)	H (mm)	LF (mm)	CW (mm)	CDX (mm)	kg		
N	XLCFN 2601 J 1.60	21.4	26	110	1.50	15	0.06	GI132	KV
	XLCFN 2601 J 2.00	21.4	26	110	2.00	25	0.07	GI061	KV
	XLCFN 2602 J 3.00	21.4	26	110	3.10	37.5	0.08	GI001	KV
	XLCFN 2603 J 4.00	21.4	26	110	4.10	40	0.10	GI002	KV
	XLCFN 3201 M 1.60	25	32	150	1.50	15	0.11	GI132	KV
	XLCFN 3201 M 2.00	25	32	150	2.00	25	0.11	GI061	KV
	XLCFN 3202 M 3.00	25	32	150	3.10	50	0.08	GI001	KV
	XLCFN 3203 M 4.00	25	32	150	4.10	50	0.14	GI002	KV
	XLCFN 3204 M 5.00	25	32	150	5.10	60	0.18	GI004	KV
	XLCFN 3205 M 6.35	25	32	150	6.35	60	0.21	GI005	KV
	XLCFN 4502 S 3.00	32	45	250	3.10	80	0.25	GI001	KV
	XLCFN 4503 S 4.00	32	45	250	4.10	80	0.33	GI002	KV
	XLCFN 4504 S 5.00	32	45	250	5.10	80	0.41	GI004	KV
	XLCFN 4505 S 6.35	32	45	250	6.35	80	0.48	GI005	KV

GI001	LFMX 3.1-.	–
GI002	LFMX 4.1-.	–
GI004	LFMX 5.1-.	–
GI005	LFMX 6.35-.	–
GI061	LFMX 2.0-.	LFMX 2.2-.
GI132	LFMX 1.5-.	LFMX 1.6-.

KV	KV 5x70

XLCF(NRL) BS

P M K N S H

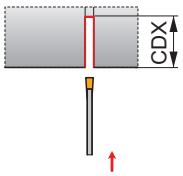
PRAMET

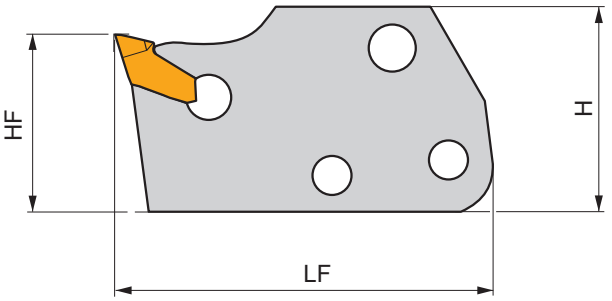
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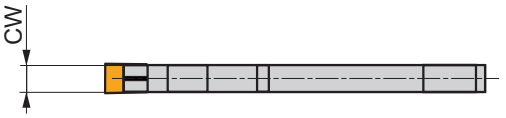


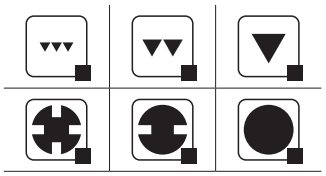
Modüler LFMX Uçlu MS-EN Takım için Radyal Kanal Açma Laması

Tek taraflı LFMX uçlar için modüler kanal açma laması. Aksiyel kanal açma ve kesme (maks. 25mm kesme derinliği) uygulamaları için uygundur. Lamalar uzun takım ömrü için işlem görmüştür.











	Product	HF (mm)	H (mm)	LF (mm)	CW (mm)	CDX (mm)	kg		
R	XLCFR 160115-1.60	12	25	35	1.50	15	0.03	GI132	KV
	XLCFR 160115-2.00	12	25	35	2.00	15	0.01	GI061	KV
	XLCFR 250115-1.60	24	29	40	1.50	15	0.01	GI132	KV
	XLCFR 250115-2.00	24	29	40	2.00	15	0.05	GI061	KV
L	XLCFL 160115-1.60	12	25	35	1.50	15	0.03	GI132	KV
	XLCFL 160115-2.00	12	25	35	2.00	15	0.04	GI061	KV
	XLCFL 250115-1.60	24	29	40	1.50	15	0.04	GI132	KV
	XLCFL 250115-2.00	24	29	40	2.00	15	0.05	GI061	KV
N	XLCFN 160215-3.00	12	25	35	3.10	15	0.01	GI001	KV
	XLCFN 160220-3.00	12	25	40	3.10	20	0.04	GI001	KV
	XLCFN 250215-3.00	24	29	40	3.10	15	0.04	GI001	KV
	XLCFN 250225-3.00	24	29	50	3.10	25	0.02	GI001	KV
	XLCFN 250315-4.00	24	29	40	4.10	15	0.04	GI002	KV
	XLCFN 250325-4.00	24	29	50	4.10	25	0.04	GI002	KV
	XLCFN 250425-5.00	24	29	50	5.10	25	0.04	GI004	KV
	XLCFN 250525-6.35	24	29	50	6.35	25	0.07	GI005	KV

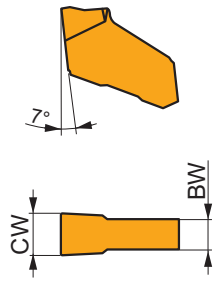
GI001	LFMX 3.1-.	–
GI002	LFMX 4.1-.	–
GI004	LFMX 5.1-.	–
GI005	LFMX 6.35-.	–
GI061	LFMX 2.0-.	LFMX 2.2-.
GI132	LFMX 1.5-.	LFMX 1.6-.

KV	KV 5x70

LFMX - F1

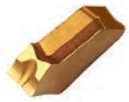
PRAMET

	CW	CWTOLL	CWTOLU	BW
	(mm)	(mm)	(mm)	(mm)
1.5	1.50	-0.03	0.03	1.30
1.6	1.60	-0.03	0.03	1.30
2.0	2.00	-0.03	0.03	1.60
3.1	3.10	-0.04	0.04	2.60
4.1	4.10	-0.04	0.04	3.60



Kesme hızı (vc), ilerleme (f) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P		M		K		N		S		H		PSIRR	PSIRL
			vc	f	vc	f	vc	f	vc	f	vc	f	vc	f		
		(mm)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(°)	(°)





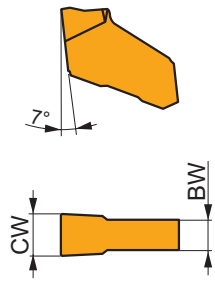
F1 eN-geometri, kesme ve kanal açma için, darbesiz işlemeye uygun.

LFMX 1.5-.16ENF1:T8330	●	0.2	130	0.08	75	0.07	120	0.08	–	–	–	–	–	–	–	–
LFMX 1.6-.16ENF1:T8330	●	0.2	130	0.08	75	0.07	120	0.08	–	–	–	–	–	–	–	–
LFMX 2.0-.16ENF1:T8330	●	0.2	130	0.08	75	0.07	120	0.08	–	–	–	–	–	–	–	–
LFMX 3.1-.20ENF1:T8330	●	0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	–	–
LFMX 4.1-.20ENF1:T8330	●	0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	–	–

LFMX - F2

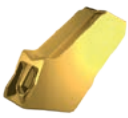
PRAMET

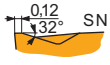
	CW	CWTOLL	CWTOLU	BW
	(mm)	(mm)	(mm)	(mm)
1.6	1.60	-0.03	0.03	1.30
2.0	2.00	-0.03	0.03	1.60
3.1	3.10	-0.04	0.04	2.60
4.1	4.10	-0.04	0.04	3.60
5.1	5.10	-0.04	0.04	4.60
6.35	6.35	-0.04	0.04	5.80



Kesme hızı (vc), ilerleme (f) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P		M		K		N		S		H		PSIRR	PSIRL
			vc	f	vc	f	vc	f	vc	f	vc	f	vc	f		
		(mm)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(°)	(°)

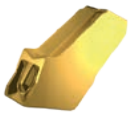
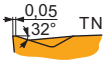




SN-F2 geometri, kesme ve kanal açma, darbesiz kesim için.

LFMX 1.6-.16SNF2:T8330	●	0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	–	–
LFMX 2.0-.16SNF2:6640	●	0.2	150	0.10	90	0.09	140	0.10	–	–	–	–	–	–	–	–
LFMX 2.0-.16SNF2:T8330	●	0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	–	–
LFMX 3.1-.20SNF2:6640	●	0.2	150	0.10	90	0.09	140	0.10	–	–	–	–	–	–	–	–
LFMX 3.1-.20SNF2:T8330	●	0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	–	–
LFMX 4.1-.20SNF2:T8330	●	0.2	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	–	–
LFMX 5.1-.20SNF2:T8330	●	0.2	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	–	–
LFMX 6.35-.20SNF2:T8330	●	0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	–

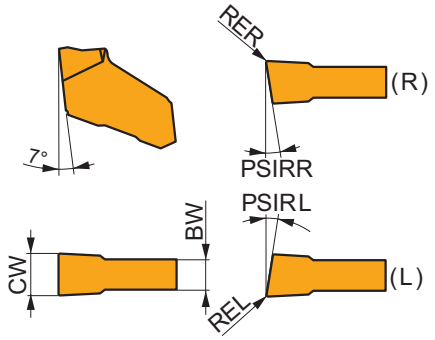
Kesme hızı (vc), ilerleme (f) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P		M		K		N		S		H		PSIRR	PSIRL
			vc	f	vc	f	vc	f	vc	f	vc	f	vc	f		
		(mm)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(°)	(°)
																
TN-F2 geometri, kesme ve kanal açma için, darbesiz kesim.																
LFMX 3.1-.20TNF2:6640	●	0.2	150	0.10	90	0.09	140	0.10	–	–	–	–	–	–	–	–
LFMX 3.1-.20TNF2:T8330	●	0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	–	–
LFMX 4.1-.20TNF2:T8330	●	0.2	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	–	–

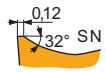
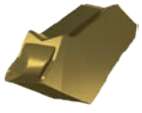
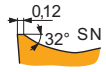
LFMX - M2

PRAMET

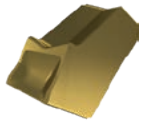
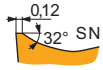
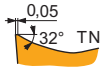
	CW	CWTOLL	CWTOLU	BW
	(mm)	(mm)	(mm)	(mm)
2.0	2.00	-0.03	0.03	1.60
2.2	2.20	-0.03	0.03	1.60
3.1	3.10	-0.04	0.04	2.60
4.1	4.10	-0.04	0.04	3.60
5.1	5.10	-0.04	0.04	4.60
6.35	6.35	-0.04	0.04	5.80



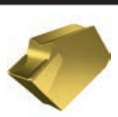
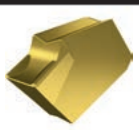
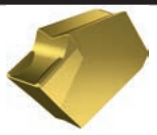
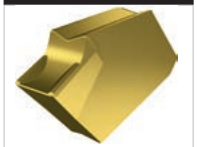
Kesme hızı (vc), ilerleme (f) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P		M		K		N		S		H		PSIRR	PSIRL
			vc	f	vc	f	vc	f	vc	f	vc	f	vc	f		
		(mm)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(°)	(°)
																
SN-M2 geometri, kesme ve kanal açma, darbesiz ve hafif darbeli kesim için.																
LFMX 2.0-.16SNM2:6640	●	0.2	150	0.11	90	0.10	140	0.11	–	–	–	–	–	–	–	–
LFMX 2.0-.16SNM2:T8330	●	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	–	–
LFMX 2.2-.16SNM2:6640	●	0.2	150	0.11	90	0.10	140	0.11	–	–	–	–	–	–	–	–
LFMX 2.2-.16SNM2:T8330	●	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	–	–
LFMX 3.1-.20SNM2:6640	●	0.2	150	0.15	90	0.14	140	0.15	–	–	–	–	–	–	–	–
LFMX 3.1-.20SNM2:T8330	●	0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	–
LFMX 4.1-.20SNM2:6640	●	0.2	150	0.15	90	0.14	140	0.15	–	–	–	–	–	–	–	–
LFMX 4.1-.20SNM2:T8330	●	0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	–
LFMX 5.1-.20SNM2:6640	●	0.2	150	0.20	90	0.18	140	0.20	–	–	–	–	–	–	–	–
LFMX 5.1-.20SNM2:T8330	●	0.2	130	0.20	75	0.18	120	0.20	–	–	–	–	–	–	–	–
LFMX 6.35-.20SNM2:6640	●	0.2	150	0.20	90	0.18	140	0.20	–	–	–	–	–	–	–	–
LFMX 6.35-.20SNM2:T8330	●	0.2	130	0.20	75	0.18	120	0.20	–	–	–	–	–	–	–	–
																
SR-M2 sağ kesme yönlü geometri, kesme, darbesiz ve hafif darbeli kesim için.																
LFMX 2.0-.16SR12M2:T8330	●	0.2	130	0.09	75	0.08	120	0.09	–	–	–	–	–	–	12	–
LFMX 2.0-.16SR6M2:T8330	●	0.2	130	0.09	75	0.08	120	0.09	–	–	–	–	–	–	6	–
LFMX 3.1-.20SR8M2:T8330	●	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	8	–
LFMX 4.1-.20SR8M2:T8330	●	0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	8	–

Kesme hızı (vc), ilerleme (f) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	M vc (m/min)	M f (mm/rev)	K vc (m/min)	K f (mm/rev)	N vc (m/min)	N f (mm/rev)	S vc (m/min)	S f (mm/rev)	H vc (m/min)	H f (mm/rev)	PSIRR (°)	PSIRL (°)
 															
SL-M2 sol kesme yönlü geometri, kesme için, ve darbesizden hafif darbeli kesime kadar uygun.															
LFMX 2.0-.16SL12M2:T8330	0.2	130	0.09	75	0.08	120	0.09	–	–	–	–	–	–	–	12
LFMX 2.0-.16SL6M2:T8330	0.2	130	0.09	75	0.08	120	0.09	–	–	–	–	–	–	–	6
LFMX 3.1-.20SL8M2:T8330	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	–	8
LFMX 4.1-.20SL8M2:T8330	0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	8
 															
TN-M2 geometri, kesme ve kanal açma için, darbesiz ve hafif darbeli kesim.															
LFMX 3.1-.20TNM2:6640	0.2	150	0.15	90	0.14	140	0.15	–	–	–	–	–	–	–	–
LFMX 3.1-.20TNM2:T8330	0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	–
LFMX 4.1-.20TNM2:6640	0.2	150	0.15	90	0.14	140	0.15	–	–	–	–	–	–	–	–
LFMX 4.1-.20TNM2:T8330	0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	–

LFUX – LAMALAR VE AKSESUARLAR KILAVUZU

KESİCİ UÇ YUVASI	03	04	05	06		
XLCFN B LFUX Lamalar H = 26 mm H = 32; 47 mm						
Kesme genişliği (mm) CW	3	4	5			
Kesme uçları						
	LFUX	LFUX	LFUX	LFUX		



DU, D

- Takım Tutucu Bloğu
- Şaft boyutları:
  20 × 20, 25 × 23, 25 × 32, 32 × 29, 25 × 30 mm

XLCFN B LFUX

P M K N S H

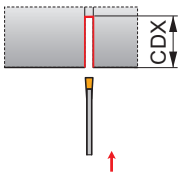
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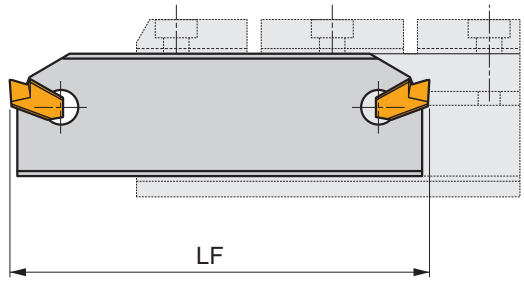
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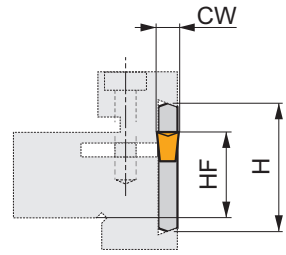


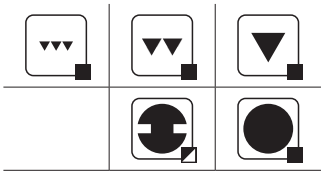
LFUX Uçlar için Çift Taraflı Kesme Laması

Kesme işlemleri için lama. Çift taraflı LFUX uçlar için 26, 32 veya 47mm yüksekliklerinde. DU, D Pramet baz tutuculara uygundur. Lama uzun takım ömrü için işlem görmüştür.













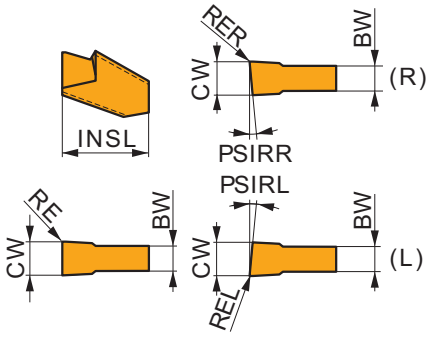
	Product	HF (mm)	H (mm)	LF (mm)	CW (mm)	CDX (mm)	kg		
N	**XLCFN 2603 J 03**	21.4	26	110	3.10	37.5	0.06	GI018	KV
	XLCFN 3202 M 03	25	32	150	3.10	50	0.11	GI018	KV
	XLCFN 3203 M 04	25	32	150	4.10	50	0.15	GI019	KV
	XLCFN 3204 M 05	25	32	150	5.10	60	0.17	GI020	KV
	XLCFN 4704 S 05	38	47	270	5.10	100	0.46	GI020	KV
	XLCFN 4705 S 06	38	47	270	6.10	100	0.50	GI021	KV

GI018	LFUX 0308..
GI019	LFUX 0408..
GI020	LFUX 0508..
GI021	LFUX 0608..

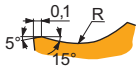
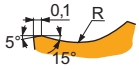
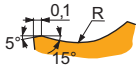
KV	KV 5x70

LFUX

	CW	BW	INSL
	(mm)	(mm)	(mm)
0308	3.00	2.51	11.5
0408	4.00	3.44	11.5
0508	5.00	4.30	11.5
0608	6.00	5.30	11.5



Kesme hızı (vc), ilerleme (f) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

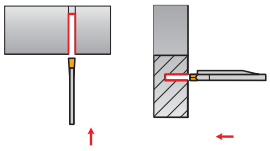
Product	RE	P		M		K		N		S		H		PSIRR	PSIRL
		vc	f	vc	f	vc	f	vc	f	vc	f	vc	f		
	(mm)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(°)	(°)
		**TN** geometri, kesme ve kanal açma için, darbesiz ve hafif darbeli kesim.													
LFUX 030802TN:6640	0.2	150	0.10	–	–	140	0.10	–	–	–	–	–	–	–	–
LFUX 030802TN:T8330	0.2	130	0.10	–	–	120	0.10	–	–	–	–	–	–	–	–
LFUX 040802TN:6640	0.2	150	0.12	–	–	140	0.12	–	–	–	–	–	–	–	–
LFUX 040802TN:T8330	0.2	130	0.12	–	–	120	0.12	–	–	–	–	–	–	–	–
LFUX 050802TN:6640	0.2	150	0.15	–	–	140	0.15	–	–	–	–	–	–	–	–
LFUX 050802TN:T8330	0.2	130	0.15	–	–	120	0.15	–	–	–	–	–	–	–	–
LFUX 060802TN:6640	0.2	150	0.20	–	–	140	0.20	–	–	–	–	–	–	–	–
LFUX 060802TN:T8330	0.2	130	0.20	–	–	120	0.20	–	–	–	–	–	–	–	–
		**TR** geometri, sağ kesme yönlü, kesme için, darbesiz ve hafif darbeli kesim.													
LFUX 030800TR:6640	0.2	150	0.10	–	–	140	0.10	–	–	–	–	–	–	5	–
LFUX 030800TR:T8330	0.2	130	0.10	–	–	120	0.10	–	–	–	–	–	–	5	–
LFUX 040800TR:6640	0.2	150	0.12	–	–	140	0.12	–	–	–	–	–	–	5	–
LFUX 040800TR:T8330	0.2	130	0.12	–	–	120	0.12	–	–	–	–	–	–	5	–
		**TL** sol kesme yönlü geometri, kesme, darbesiz ve hafif darbeli kesim için.													
LFUX 030800TL:6640	0.2	150	0.10	–	–	140	0.10	–	–	–	–	–	–	–	5
LFUX 030800TL:T8330	0.2	130	0.10	–	–	120	0.10	–	–	–	–	–	–	–	5

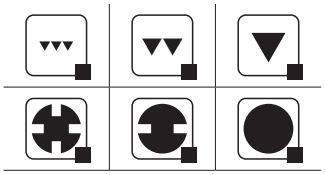
MS-EN

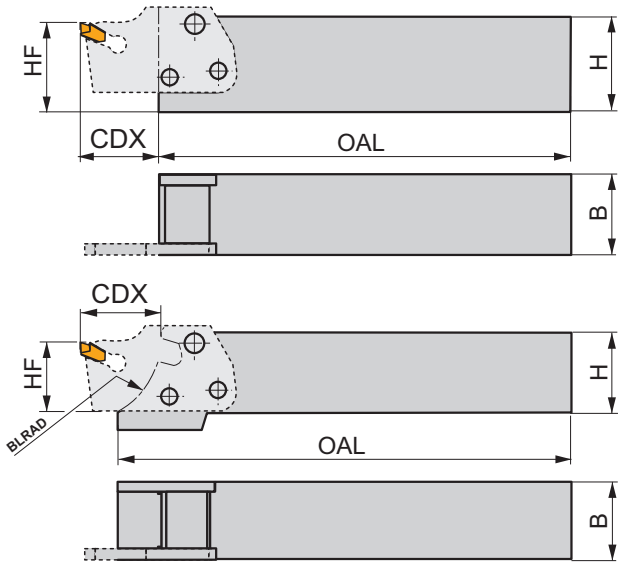


Kanal Açma ve Kesme Lamaları için Modüler Takım Tutucu

BS tipi kanal açma ve kesme lamaları için modüler takım tutucu. Gövde uzun takım ömrü için işlem görmüştür.







	Product	HF (mm)	H (mm)	B (mm)	OAL (mm)	BLRAD (mm)	kg		
	MS-EN-1212 F	12	12	12	75	–	0.12	GI006	ND4
	MS-EN-1616 H	16	16	16	90	–	0.21	GI006	ND4
	MS-EN-2020 K	20	20	20	115	–	0.23	GI003	ND5
	MS-EN-2020 KS	20	20	20	129	25	0.42	GI060	ND5
	MS-EN-2525 M	25	25	25	140	–	0.65	GI003	ND5
	MS-EN-2525 MS	25	25	25	153	25	0.73	GI060	ND5
	MS-EN-3225 P	32	32	25	160	–	0.95	GI003	ND5
	MS-EN-3225 PS	32	32	25	174	25	1.00	GI060	ND5

GI003	XLC.. 25..15...	XLC.. 25..25…	GL.BS	XLXFL 25…
GI006	XLCF. 16..15…	XLCF. 16..20…	–	–
GI060	XLC.. 25..15…	XLC.. 25..25…	GL.BS	–

ND4	US 4011-T15P	3.5	M 4	10.6	–	–	–	–	FLAG T15P
ND5	US 45013-T20P	5.0	M 5	13	US 46017-T20P	5.0	M6	17	FLAG T20P

ND4 =3 x US 4011-T15P; ND5=2 x US 45013-T20P

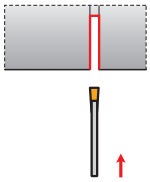
DU, D

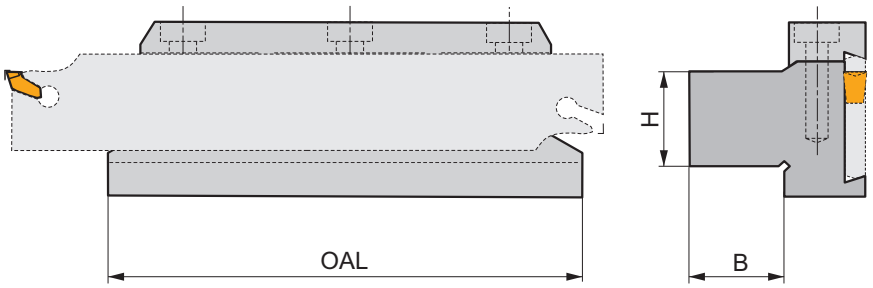
PRAMET

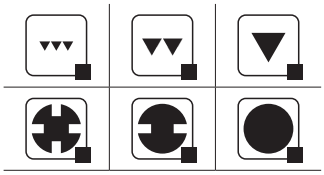


Kanal Açma ve Kesme Lamaları için Takım Tutucu Bloğu

Kanal açma ve kesme lamalarına uygun takım tutucu. Gövde uzun takım ömrü için işlem görmüştür.







	Product	H (mm)	B (mm)	OAL (mm)	kg		
	26-DU 2020	20	20	90	0.76	GI007	ND2
	26-D 2020	20	20	100	0.82	GI007	ND2
	32-DU 2523	25	23	110	1.06	GI008	ND2
	32-DU 2532	25	32	110	1.24	GI008	ND2
	32-D 2530	25	30	115	1.28	GI008	ND2
	32-DU 3229	32	29	110	1.25	GI008	ND2
	45-DU 3229	32	29	110	1.50	GI009	ND7
	45-DU 4036	40	36	110	2.05	GI009	ND7
	47-D 4040	40	40	150	3.84	GI091	ND3

GI007	XLC.N 26..	GL.-S26.B.
GI008	XLC.N 32..	GL.-S32.B.
GI009	XLC.N 45..	–
GI091	XLC.N 47..	–

		Nm			
ND2	HS 0625	6.0	M 6	25	HXK 5
ND3	HS 1030	8.0	M 10	30	HXK 8
ND7	HS 0630	6.0	M 6	30	HXK 5

ALINA KANAL AÇMA TAKIMLARI

KESİCİ UÇ YUVASI	LNMX 3.00	GL3	GL4	GL5	GL6
NEW Alın eksenel, Sağ 20 × 20 / 32 × 32		CDX 12 mm	CDX 20 – 25 mm	CDX 25 mm	CDX 25 – 32 mm
NEW Alın eksenel, Sol 25 × 25 / 32 × 32		CDX 12 mm	CDX 20 – 25 mm	CDX 25 mm	CDX 25 – 32 mm
NEW Alın 90°, Sağ 25 × 25		CDX 15 mm	CDX 20 – 25 mm		
MS Lamalar					
Kesme genişliği (mm) CW	3.1	3	4	5	6 / 8
Alına kanal açma	LFMX	GM	GM	GM	GM / GM
Alın tornalama Alına profil işleme		GM / MM	GM / MM	GM / MM	GM / MM / GM

GLSF L-R AXIAL

P M K N S H

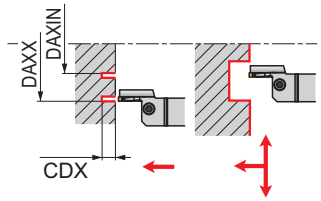
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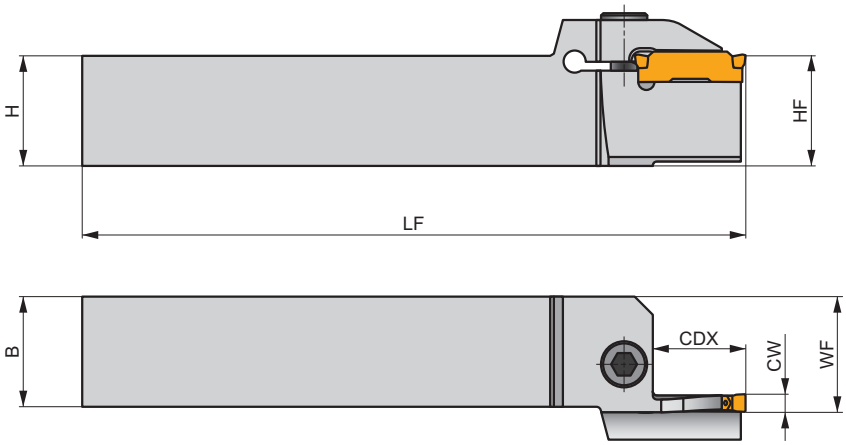
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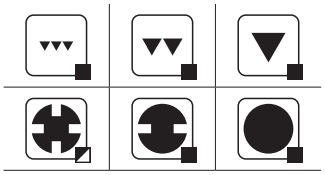


GL kesici uçlar için Eksenel Alına Kanal Açma takımı

GL kesici uçlar için Sol kesme yönlü eksenel alına kanal açma takım tutucu. Alına kanal açma, tornalama ve profil işleme uygulamaları için uygundur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	HF (mm)	H (mm)	B (mm)	WF (mm)	LF (mm)	CW (mm)	CDX (mm)	DAXX (mm)	DAXIN (mm)	kg		
L	GL3-S2525MFL-12-R035027	25	25	25	26	150	3.00	12	35	27	0.69	GI361	GL16
	GL3-S2525MFL-15-R044033	25	25	25	26	150	3.00	15	44	33	0.68	GI361	GL16
	GL3-S2525MFL-15-R055040	25	25	25	26	150	3.00	15	55	40	0.68	GI361	GL16
	GL3-S2525MFL-20-R080051	25	25	25	26	150	3.00	20	80	51	0.65	GI361	GL16
	GL3-S2525MFL-25-R110076	25	25	25	26	150	3.00	25	110	76	0.63	GI361	GL16
	GL4-S2525MFL-20-R065050	25	25	25	26	150	4.00	20	65	50	0.71	GI362	GL16
	GL4-S2525MFL-20-R095060	25	25	25	26	150	4.00	20	95	60	0.65	GI362	GL16
	GL4-S2525MFL-25-R160090	25	25	25	26	150	4.00	25	160	90	0.63	GI362	GL16
	GL4-S2525MFL-25-R400150	25	25	25	25.7	150	4.00	25	400	150	0.63	GI362	GL16
	GL4-S2525MFL-25-R950380	25	25	25	25.7	150	4.00	25	950	380	0.63	GI362	GL16
	GL5-S2525MFL-25-R095060	25	25	25	25.3	150	5.00	25	95	60	0.63	GI363	GL16
	GL5-S2525MFL-25-R200090	25	25	25	25.3	150	5.00	25	200	90	0.63	GI363	GL16
	GL5-S2525MFL-25-R950180	25	25	25	25.3	150	5.00	25	950	180	0.63	GI363	GL16
	GL6-S2525MFL-25-R095060	25	25	25	25.4	150	6.00	25	95	60	0.69	GI364	GL16
	GL6-S2525MFL-25-R200090	25	25	25	25.4	150	6.00	25	200	90	0.64	GI364	GL16
	GL6-S2525MFL-25-R950180	25	25	25	25.4	150	6.00	25	950	180	0.64	GI364	GL16
	GL6-S3232PFL-32-R200090	32	32	32	32.4	170	6.00	32	200	90	1.20	GI364	GL17
	GL6-S3232PFL-32-R950180	32	32	32	32.4	170	6.00	32	950	180	1.20	GI364	GL17

GI361	GL3-GM	GL3-MM
GI362	GL4-GM	GL4-MM
GI363	GL5-GM	GL5-MM
GI364	GL6-GM	GL6-MM

		Nm			
GL16	HS 0620	6.0	M6	20	HXK 5
GL17	HS 0825	8.0	M8	25	HXK 6

GLSF R-L AXIAL

P M K N S H

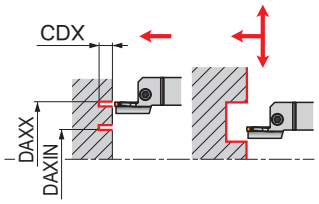
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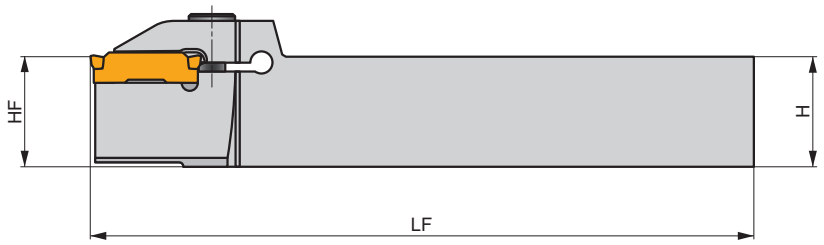
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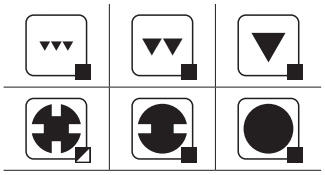
GL kesici uçlar için Eksenel Alına Kanal Açma takımı

GL kesici uçlar için Sağ kesme yönlü eksenel alına kanal açma takım tutucu. Alına kanal açma, tornalama ve profil işleme uygulamaları için uygundur. Gövde uzun takım ömrü için işlem görmüştür.











	Product	HF (mm)	H (mm)	B (mm)	WF (mm)	LF (mm)	CW (mm)	CDX (mm)	DAXX (mm)	DAXIN (mm)	kg		
R	GL3-S2020KFR-12-L035027	20	20	20	20.5	125	3.00	12	35	27	0.40	GI361	GL16
	GL3-S2020KFR-15-L044033	20	20	20	20.5	125	3.00	15	44	33	0.39	GI361	GL16
	GL3-S2020KFR-15-L055040	20	20	20	20.5	125	3.00	15	55	40	0.39	GI361	GL16
	GL3-S2020KFR-20-L080051	20	20	20	20.5	125	3.00	20	80	51	0.38	GI361	GL16
	GL3-S2525MFR-12-L035027	25	25	25	26	150	3.00	12	35	27	0.69	GI361	GL16
	GL3-S2525MFR-15-L044033	25	25	25	26	150	3.00	15	44	33	0.68	GI361	GL16
	GL3-S2525MFR-15-L055040	25	25	25	26	150	3.00	15	55	40	0.68	GI361	GL16
	GL3-S2525MFR-20-L080051	25	25	25	26	150	3.00	20	80	51	0.65	GI361	GL16
	GL3-S2525MFR-25-L110076	25	25	25	26	150	3.00	25	110	76	0.63	GI361	GL16
	GL4-S2525MFR-20-L065050	25	25	25	26	150	4.00	20	65	50	0.66	GI362	GL16
	GL4-S2525MFR-20-L095060	25	25	25	26	150	4.00	20	95	60	0.65	GI362	GL16
	GL4-S2525MFR-25-L160090	25	25	25	26	150	4.00	25	160	90	0.63	GI362	GL16
	GL4-S2525MFR-25-L400150	25	25	25	25.7	150	4.00	25	400	150	0.63	GI362	GL16
	GL4-S2525MFR-25-L950380	25	25	25	25.7	150	4.00	25	950	380	0.63	GI362	GL16
	GL5-S2525MFR-25-L095060	25	25	25	25.3	150	5.00	25	95	60	0.63	GI363	GL16
	GL5-S2525MFR-25-L200090	25	25	25	25.3	150	5.00	25	200	90	0.63	GI363	GL16
	GL5-S2525MFR-25-L950180	25	25	25	25.3	150	5.00	25	950	180	0.63	GI363	GL16
	GL6-S2525MFR-25-L095060	25	25	25	25.4	150	6.00	25	95	60	0.64	GI364	GL16
	GL6-S2525MFR-25-L200090	25	25	25	25.4	150	6.00	25	200	90	0.64	GI364	GL16
	GL6-S2525MFR-25-L950180	25	25	25	25.4	150	6.00	25	950	180	0.64	GI364	GL16
	GL6-S3232PFR-32-L200090	32	32	32	32.4	170	6.00	32	200	90	1.20	GI364	GL17
	GL6-S3232PFR-32-L950180	32	32	32	32.4	170	6.00	32	950	180	1.21	GI364	GL17

GI361	GL3-GM	GL3-MM
GI362	GL4-GM	GL4-MM
GI363	GL5-GM	GL5-MM
GI364	GL6-GM	GL6-MM

GL16	HS 0620	6.0	M6	20	HXK 5
GL17	HS 0825	8.0	M8	25	HXK 6

GLSG R-R AXIAL

P M K N S H

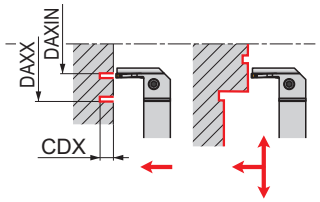
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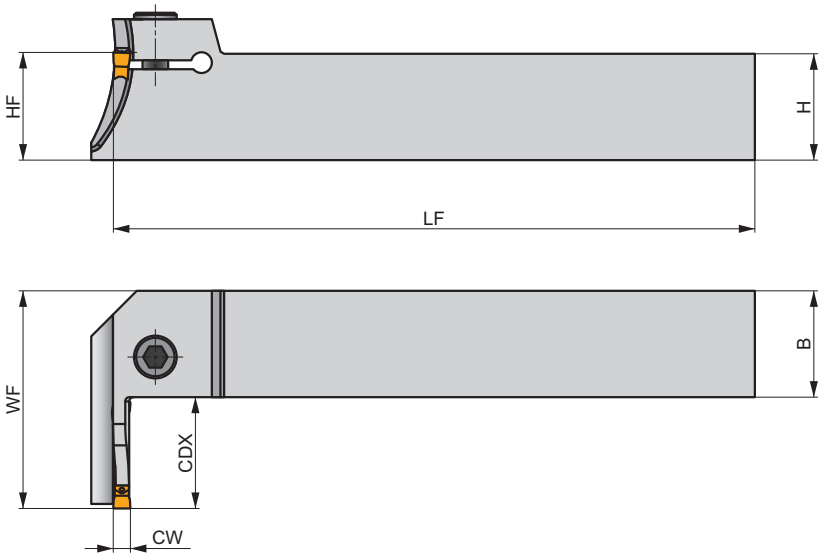
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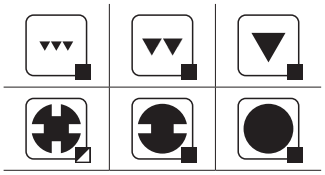


GL kesici uçlar için Radyal Alına Kanal Açma takımı

GL kesici uçlar için Sağ kesme yönlü radyal alına kanal açma takım tutucu. Alına kanal açma, tornalama ve profil işleme uygulamaları için uygundur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	HF (mm)	H (mm)	B (mm)	WF (mm)	LF (mm)	CW (mm)	CDX (mm)	DAXX (mm)	DAXIN (mm)	kg		
R	GL3-S2525MGR-15-R044033	25	25	25	40.9	150	3.00	15	44	33	0.75	GI361	GL16
	GL3-S2525MGR-15-R055040	25	25	25	40.9	150	3.00	15	55	40	0.75	GI361	GL16
	GL3-S2525MGR-20-R080051	25	25	25	45.9	150	3.00	20	80	51	0.75	GI361	GL16
	GL3-S2525MGR-25-R110076	25	25	25	50.9	150	3.00	25	110	76	0.75	GI361	GL16
	GL4-S2525MGR-20-R065050	25	25	25	46	150	4.00	20	65	50	0.77	GI362	GL16
	GL4-S2525MGR-25-R095060	25	25	25	51	150	4.00	25	95	60	0.76	GI362	GL16
	GL4-S2525MGR-25-R160090	25	25	25	51	150	4.00	25	160	90	0.76	GI362	GL16
	GL4-S2525MGR-25-R400150	25	25	25	51	150	4.00	25	400	150	0.75	GI362	GL16

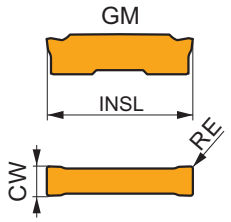
GI361	GL3-GM	GL3-MM
GI362	GL4-GM	GL4-MM

GL16	HS 0620	6.0	M6	20	HXK 5

GL. D - GM

PRAMET

	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
200	2.00	-0.05	0.05	25.0
300	3.00	-0.05	0.05	25.0
400	4.00	-0.05	0.05	25.0
500	5.00	-0.05	0.05	25.0
600	6.00	-0.05	0.05	25.0
800	8.00	-0.05	0.05	25.0



Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
GL2-D200M02-GM:G8330	●	0.2	190	0.10	0.8	110	0.09	0.8	180	0.10	0.8	–	–	–	45	0.08	0.6	–	–	–
GL2-D200M02-GM:T7325	●	0.2	220	0.10	0.8	170	0.09	0.8	205	0.10	0.8	–	–	–	70	0.08	0.6	–	–	–
GL3-D300M02-GM:G8330	●	0.2	150	0.20	1.0	90	0.18	1.0	140	0.20	1.0	–	–	–	35	0.14	0.8	–	–	–
GL3-D300M02-GM:T7325	●	0.2	175	0.20	1.0	135	0.18	1.0	165	0.20	1.0	–	–	–	55	0.14	0.8	–	–	–
GL3-D300M04-GM:G8330	●	0.4	160	0.20	1.0	95	0.18	1.0	150	0.20	1.0	–	–	–	40	0.14	0.8	–	–	–
GL3-D300M04-GM:T7325	●	0.4	185	0.20	1.0	140	0.18	1.0	175	0.20	1.0	–	–	–	60	0.14	0.8	–	–	–
GL4-D400M04-GM:G8330	●	0.4	150	0.25	1.2	90	0.23	1.2	140	0.25	1.2	–	–	–	35	0.18	1.0	–	–	–
GL4-D400M04-GM:T7325	●	0.4	170	0.25	1.2	130	0.23	1.2	160	0.25	1.2	–	–	–	55	0.18	1.0	–	–	–
GL4-D400M08-GM:G8330	●	0.8	180	0.25	1.2	105	0.23	1.2	170	0.25	1.2	–	–	–	45	0.18	1.0	–	–	–
GL4-D400M08-GM:T7325	●	0.8	200	0.25	1.2	155	0.23	1.2	190	0.25	1.2	–	–	–	65	0.18	1.0	–	–	–
GL5-D500M08-GM:G8330	●	0.8	170	0.30	1.2	100	0.27	1.2	160	0.30	1.2	–	–	–	40	0.21	1.0	–	–	–
GL5-D500M08-GM:T7325	●	0.8	190	0.30	1.2	145	0.27	1.2	180	0.30	1.2	–	–	–	60	0.21	1.0	–	–	–
GL6-D600M08-GM:G8330	●	0.8	170	0.30	1.2	100	0.27	1.2	160	0.30	1.2	–	–	–	40	0.21	1.0	–	–	–
GL6-D600M08-GM:T7325	●	0.8	190	0.30	1.2	145	0.27	1.2	180	0.30	1.2	–	–	–	60	0.21	1.0	–	–	–
GL6-D800M08-GM:G8330 [1]	●	0.8	170	0.30	1.2	100	0.27	1.2	160	0.30	1.2	–	–	–	40	0.21	1.2	–	–	–

[1] Yalnızca tutucularda kullanılabilir. ≥ CDX 24



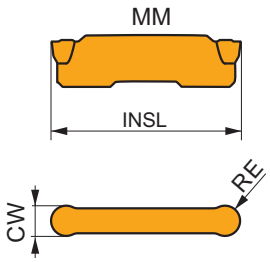


GM çok yönlü geometri, kanal açma ve boyuna tornalama için, darbesizden darbeli kesime kadar uygun.

GL. D - MM

PRAMET

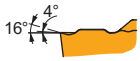
	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
200	2.00	-0.05	0.05	25.0
300	3.00	-0.05	0.05	25.0
400	4.00	-0.05	0.05	25.0
500	5.00	-0.05	0.05	26.0
600	6.00	-0.05	0.05	26.0



Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
GL2-D200MM0-MM:G8330	●	1.0	250	0.10	1.0	150	0.09	1.0	235	0.10	1.0	–	–	–	60	0.08	0.8	–	–	–
GL2-D200MM0-MM:T7325	●	1.0	285	0.10	1.0	220	0.09	1.0	270	0.10	1.0	–	–	–	90	0.08	0.8	–	–	–
GL3-D300MM0-MM:G8330	●	1.5	210	0.20	1.2	125	0.18	1.2	195	0.20	1.2	–	–	–	50	0.14	1.0	–	–	–
GL3-D300MM0-MM:T7325	●	1.5	240	0.20	1.2	185	0.18	1.2	225	0.20	1.2	–	–	–	75	0.14	1.0	–	–	–
GL4-D400MM0-MM:G8330	●	2.0	220	0.20	1.2	130	0.18	1.2	205	0.20	1.2	–	–	–	55	0.14	1.0	–	–	–
GL4-D400MM0-MM:T7325	●	2.0	250	0.20	1.2	195	0.18	1.2	235	0.20	1.2	–	–	–	80	0.14	1.0	–	–	–
GL5-D500MM0-MM:G8330	●	2.5	205	0.25	1.2	120	0.23	1.2	190	0.25	1.2	–	–	–	50	0.18	1.0	–	–	–
GL5-D500MM0-MM:T7325	●	2.5	235	0.25	1.2	180	0.23	1.2	220	0.25	1.2	–	–	–	75	0.18	1.0	–	–	–
GL6-D600MM0-MM:G8330	●	3.0	195	0.30	1.2	115	0.27	1.2	185	0.30	1.2	–	–	–	45	0.21	1.0	–	–	–
GL6-D600MM0-MM:T7325	●	3.0	220	0.30	1.2	170	0.27	1.2	205	0.30	1.2	–	–	–	70	0.21	1.0	–	–	–





MM geometri, kopya profil ve çap tornalama için tam radyüs, darbesizden darbeli kesime kadar uygun.

XLXFL BS AXIAL

P M K N S H

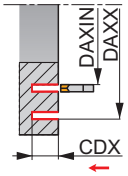
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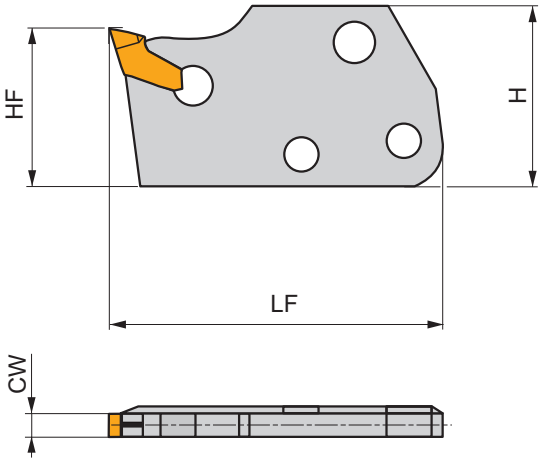
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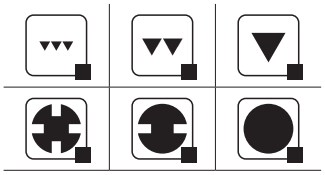


Modüler LFMX Uçlu MS-EN Takım için Aksiyel Kanal Açma Laması

Tek taraflı LFMX 3.1 uçlar için modüler kanal açma laması. Eksenel kanal açma ve kesme (maks. 20mm kesme derinliği) uygulamaları için uygundur. MS-EN tutucu ile kullanılır. Lamalar uzun takım ömrü için işlem görmüştür.











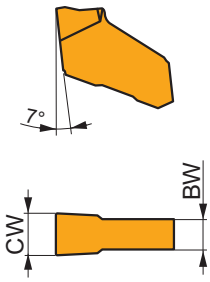
	Product	H (mm)	HF (mm)	LF (mm)	CW (mm)	CDX (mm)	DAXIN (mm)	DAXX (mm)	kg		
L	**XLXFL 250220-3.00-60**	29	24	46	3.10	20	60	85	0.05	GI001	KV
	XLXFL 250220-3.00-80	29	24	46	3.10	20	80	105	0.05	GI001	KV
	XLXFL 250220-3.00-100	29	24	46	3.10	20	100	155	0.03	GI001	KV
	XLXFL 250220-3.00-150	29	24	46	3.10	20	150	280	0.03	GI001	KV

GI001	LFMX 3.1-.

KV	KV 5x70

LFMX - F1

	CW	CWTOLL	CWTOLU	BW
	(mm)	(mm)	(mm)	(mm)
1.5	1.50	-0.03	0.03	1.30
1.6	1.60	-0.03	0.03	1.30
2.0	2.00	-0.03	0.03	1.60
3.1	3.10	-0.04	0.04	2.60
4.1	4.10	-0.04	0.04	3.60



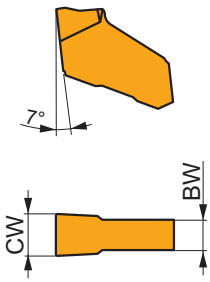
Kesme hızı (vc), ilerleme (f) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE	P		M		K		N		S		H		PSIRR	PSIRL
		vc	f	vc	f	vc	f	vc	f	vc	f	vc	f		
	(mm)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(°)	(°)
															
LFMX 1.5-.16ENF1:T8330	●	0.2	130	0.08	75	0.07	120	0.08	–	–	–	–	–	–	–	–
LFMX 1.6-.16ENF1:T8330	●	0.2	130	0.08	75	0.07	120	0.08	–	–	–	–	–	–	–	–
LFMX 2.0-.16ENF1:T8330	●	0.2	130	0.08	75	0.07	120	0.08	–	–	–	–	–	–	–	–
LFMX 3.1-.20ENF1:T8330	●	0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	–	–
LFMX 4.1-.20ENF1:T8330	●	0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	–	–

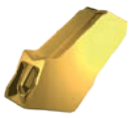
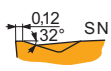
F1 eN-geometri, kesme ve kanal açma için, darbesiz işlemeye uygun.

LFMX - F2

	CW	CWTOLL	CWTOLU	BW
	(mm)	(mm)	(mm)	(mm)
1.6	1.60	-0.03	0.03	1.30
2.0	2.00	-0.03	0.03	1.60
3.1	3.10	-0.04	0.04	2.60
4.1	4.10	-0.04	0.04	3.60
5.1	5.10	-0.04	0.04	4.60
6.35	6.35	-0.04	0.04	5.80

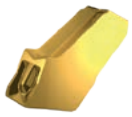


Kesme hızı (vc), ilerleme (f) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE	P		M		K		N		S		H		PSIRR	PSIRL
		vc	f	vc	f	vc	f	vc	f	vc	f	vc	f		
	(mm)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(°)	(°)
															
LFMX 1.6-.16SNF2:T8330	●	0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	–	–
LFMX 2.0-.16SNF2:6640	●	0.2	150	0.10	90	0.09	140	0.10	–	–	–	–	–	–	–	–
LFMX 2.0-.16SNF2:T8330	●	0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	–	–
LFMX 3.1-.20SNF2:6640	●	0.2	150	0.10	90	0.09	140	0.10	–	–	–	–	–	–	–	–
LFMX 3.1-.20SNF2:T8330	●	0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	–	–
LFMX 4.1-.20SNF2:T8330	●	0.2	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	–	–
LFMX 5.1-.20SNF2:T8330	●	0.2	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	–	–
LFMX 6.35-.20SNF2:T8330	●	0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	–

SN-F2 geometri, kesme ve kanal açma, darbesiz kesim için.

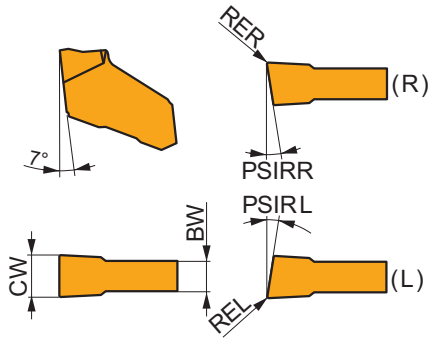
Kesme hızı (vc), ilerleme (f) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P		M		K		N		S		H		PSIRR	PSIRL
			vc	f	vc	f	vc	f	vc	f	vc	f	vc	f		
		(mm)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(°)	(°)
			0,05 32° TN													
			TN-F2 geometri, kesme ve kanal açma için, darbesiz kesim.													
LFMX 3.1-.20TNF2:6640	●	0.2	150	0.10	90	0.09	140	0.10	–	–	–	–	–	–	–	–
LFMX 3.1-.20TNF2:T8330	●	0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	–	–
LFMX 4.1-.20TNF2:T8330	●	0.2	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	–	–

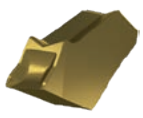
LFMX - M2

PRAMET

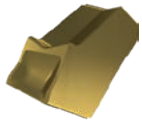
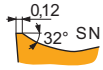
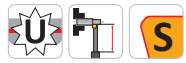
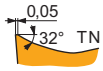
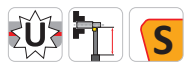
	CW	CWTOLL	CWTOLU	BW
	(mm)	(mm)	(mm)	(mm)
2.0	2.00	-0.03	0.03	1.60
2.2	2.20	-0.03	0.03	1.60
3.1	3.10	-0.04	0.04	2.60
4.1	4.10	-0.04	0.04	3.60
5.1	5.10	-0.04	0.04	4.60
6.35	6.35	-0.04	0.04	5.80



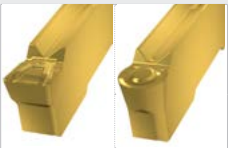
Kesme hızı (vc), ilerleme (f) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P		M		K		N		S		H		PSIRR	PSIRL
			vc	f	vc	f	vc	f	vc	f	vc	f	vc	f		
		(mm)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(°)	(°)
			0,12 32° SN													
			SN-M2 geometri, kesme ve kanal açma, darbesiz ve hafif darbeli kesim için.													
LFMX 2.0-.16SNM2:6640	●	0.2	150	0.11	90	0.10	140	0.11	–	–	–	–	–	–	–	–
LFMX 2.0-.16SNM2:T8330	●	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	–	–
LFMX 2.2-.16SNM2:6640	●	0.2	150	0.11	90	0.10	140	0.11	–	–	–	–	–	–	–	–
LFMX 2.2-.16SNM2:T8330	●	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	–	–
LFMX 3.1-.20SNM2:6640	●	0.2	150	0.15	90	0.14	140	0.15	–	–	–	–	–	–	–	–
LFMX 3.1-.20SNM2:T8330	●	0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	–
LFMX 4.1-.20SNM2:6640	●	0.2	150	0.15	90	0.14	140	0.15	–	–	–	–	–	–	–	–
LFMX 4.1-.20SNM2:T8330	●	0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	–
LFMX 5.1-.20SNM2:6640	●	0.2	150	0.20	90	0.18	140	0.20	–	–	–	–	–	–	–	–
LFMX 5.1-.20SNM2:T8330	●	0.2	130	0.20	75	0.18	120	0.20	–	–	–	–	–	–	–	–
LFMX 6.35-.20SNM2:6640	●	0.2	150	0.20	90	0.18	140	0.20	–	–	–	–	–	–	–	–
LFMX 6.35-.20SNM2:T8330	●	0.2	130	0.20	75	0.18	120	0.20	–	–	–	–	–	–	–	–
			0,12 32° SN													
			SR-M2 sağ kesme yönlü geometri, kesme, darbesiz ve hafif darbeli kesim için.													
LFMX 2.0-.16SR12M2:T8330	●	0.2	130	0.09	75	0.08	120	0.09	–	–	–	–	–	–	12	–
LFMX 2.0-.16SR6M2:T8330	●	0.2	130	0.09	75	0.08	120	0.09	–	–	–	–	–	–	6	–
LFMX 3.1-.20SR8M2:T8330	●	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	8	–
LFMX 4.1-.20SR8M2:T8330	●	0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	8	–

Kesme hızı (vc), ilerleme (f) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P		M		K		N		S		H		PSIRR	PSIRL
			vc	f	vc	f	vc	f	vc	f	vc	f	vc	f		
		(mm)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(°)	(°)
																
SL-M2 sol kesme yönlü geometri, kesme için, ve darbesizden hafif darbeli kesime kadar uygun.																
LFMX 2.0-.16SL12M2:T8330	●	0.2	130	0.09	75	0.08	120	0.09	–	–	–	–	–	–	–	12
LFMX 2.0-.16SL6M2:T8330	●	0.2	130	0.09	75	0.08	120	0.09	–	–	–	–	–	–	–	6
LFMX 3.1-.20SL8M2:T8330	●	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	–	8
LFMX 4.1-.20SL8M2:T8330	●	0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	8
																
TN-M2 geometri, kesme ve kanal açma için, darbesiz ve hafif darbeli kesim.																
LFMX 3.1-.20TNM2:6640	●	0.2	150	0.15	90	0.14	140	0.15	–	–	–	–	–	–	–	–
LFMX 3.1-.20TNM2:T8330	●	0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	–
LFMX 4.1-.20TNM2:6640	●	0.2	150	0.15	90	0.14	140	0.15	–	–	–	–	–	–	–	–
LFMX 4.1-.20TNM2:T8330	●	0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	–

KANAL AÇMA DELİK İŞLEME BARASI

KESİCİ UÇ YUVASI	0313	0413	GL2	GL3	GL4
GG.(RL) INT					
GLAG (RL)INT DCON MS = 25 – 40 mm DMIN = 32 mm					
Kesme genişliği (mm) CW	3	4	2	3	4
Kanal Açma (Delik içi)	 CM F	 CM F	 GM	 GM	 GM
Tornalama / Profil işleme (Delik içi)	 F MP	 F MP	 GM MM	 GM MM	 GM MM

GLAG (RL) INT

P M K N S H

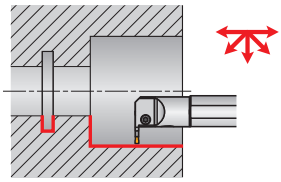
PRAMET

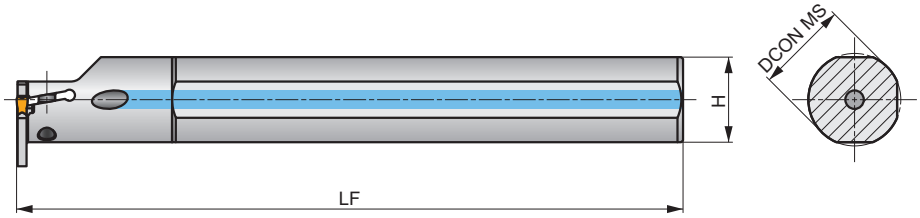
G

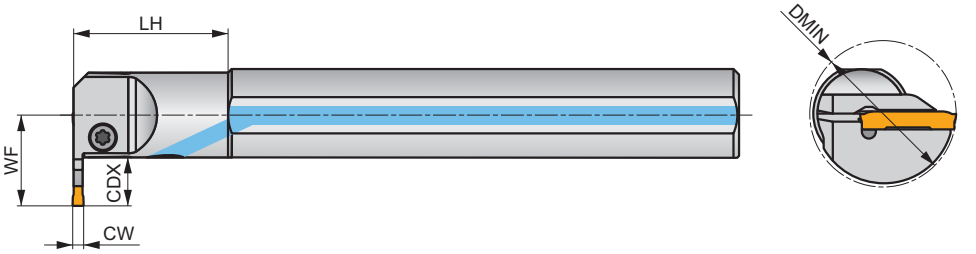


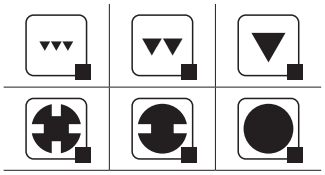
GL kesici uçlar için içten kesme sıvılı Kanal Açma takımı

GL kesici uçlar için içten kesme sıvılı Sağ/Sol kesme yönlü iç çap takım tutucu, güvenlik için güçlendirilmiş yuva ve lama ile tasarlanmıştır. İç çap kanal açma, tornalama ve profil işleme uygulamaları için uygundur. Gövde uzun takım ömrü için işlem görmüştür.











	Product	DCON MS (mm)	H (mm)	WF (mm)	LF (mm)	LH (mm)	CW (mm)	CDX (mm)	DMIN (mm)		kg		
R	GL2-A25QGR-06-32	25	23	18.5	180	41.2	2.00	6	32	✓	0.57	GI360	GL14
	GL2-A25QGR-10-38	25	23	22.5	180	41.2	2.00	10	38	✓	0.57	GI360	GL14
	GL3-A25QGR-06-32	25	23	18.5	180	42.0	3.00	6	32	✓	0.57	GI361	GL14
	GL3-A25QGR-12-38	25	23	24.5	180	42.0	3.00	12	38	✓	0.58	GI361	GL14
	GL4-A25QGR-06-40	25	23	18.6	180	43.0	4.00	6	40	✓	0.58	GI362	GL14
	GL4-A25QGR-12-40 [1]	25	23	24.6	180	43.0	4.00	12	40	✓	0.58	GI365	GL14
	GL2-A32SGR-06-40	32	30	22	250	51.2	2.00	6	40	✓	1.38	GI360	GL14
	GL2-A32SGR-10-45	32	30	26	250	51.2	2.00	10	45	✓	1.30	GI360	GL14
	GL3-A32SGR-06-40	32	30	22	250	52.0	3.00	6	40	✓	1.38	GI361	GL14
	GL3-A32SGR-12-45	32	30	28	250	52.0	3.00	12	45	✓	1.30	GI361	GL14
	GL4-A32SGR-06-40	32	30	22.1	250	53.0	4.00	6	40	✓	1.39	GI362	GL14
	GL4-A32SGR-12-45 [1]	32	30	28.1	250	53.0	4.00	12	45	✓	1.39	GI365	GL14
	GL3-A40TGR-12-54	40	38	32	300	52.0	3.00	12	54	✓	2.69	GI361	GL14
	GL4-A40TGR-12-56 [1]	40	38	32.1	300	53.0	4.00	12	56	✓	2.60	GI365	GL14
	GL4-A40TGR-20-62 [1]	40	38	40.1	300	53.0	4.00	20	62	✓	2.70	GI365	GL14
L	GL2-A25QGL-06-32	25	23	18.5	180	41.2	2.00	6	32	✓	0.57	GI360	GL14
	GL2-A25QGL-10-38	25	23	22.5	180	41.2	2.00	10	38	✓	0.57	GI360	GL14
	GL3-A25QGL-06-32	25	23	18.5	180	42.0	3.00	6	32	✓	0.57	GI361	GL14
	GL3-A25QGL-12-38	25	23	24.5	180	42.0	3.00	12	38	✓	0.58	GI361	GL14
	GL4-A25QGL-06-40	25	23	18.6	180	43.0	4.00	6	40	✓	0.58	GI362	GL14
	GL4-A25QGL-12-40 [1]	25	23	24.6	180	43.0	4.00	12	40	✓	0.58	GI365	GL14
	GL2-A32SGL-06-40	32	30	22	250	51.2	2.00	6	40	✓	1.38	GI360	GL14
	GL2-A32SGL-10-45	32	30	26	250	51.2	2.00	10	45	✓	1.38	GI360	GL14
	GL3-A32SGL-06-40	32	30	22	250	52.0	3.00	6	40	✓	1.30	GI361	GL14
	GL3-A32SGL-12-45	32	30	28	250	52.0	3.00	12	45	✓	1.38	GI361	GL14
	GL4-A32SGL-06-40	32	30	22.1	250	53.0	4.00	6	40	✓	1.39	GI362	GL14
	GL4-A32SGL-12-45 [1]	32	30	28.1	250	53.0	4.00	12	45	✓	1.30	GI365	GL14

	Product	DCON MS (mm)	H (mm)	WF (mm)	LF (mm)	LH (mm)	CW (mm)	CDX (mm)	DMIN (mm)		kg		
L	**GL3-A40TGL-12-54**	40	38	32	300	52.0	3.00	12	54	✓	2.60	GI361	GL14
	GL4-A40TGL-12-56 [1]	40	38	32.1	300	53.0	4.00	12	56	✓	2.70	GI365	GL14
	GL4-A40TGL-20-62 [1]	40	38	40.1	300	53.0	4.00	20	62	✓	2.70	GI365	GL14

[1] MM geometrisi sadece DMIN >= 68 mm olduğunda uygulanabilir.

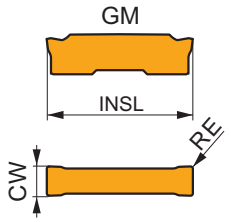
GI360	GL2-GM	GL2-MM
GI361	GL3-GM	GL3-MM
GI362	GL4-GM	GL4-MM

		Nm			
GL14	US 5015-T20P	5.0	M 5	15	LK T20P

GL. D - GM

PRAMET

	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
200	2.00	-0.05	0.05	25.0
300	3.00	-0.05	0.05	25.0
400	4.00	-0.05	0.05	25.0
500	5.00	-0.05	0.05	25.0
600	6.00	-0.05	0.05	25.0
800	8.00	-0.05	0.05	25.0



Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
GL2-D200M02-GM:G8330		0.2	190	0.10	0.8	110	0.09	0.8	180	0.10	0.8	–	–	–	45	0.08	0.6	–	–	–
GL2-D200M02-GM:T7325	●	0.2	220	0.10	0.8	170	0.09	0.8	205	0.10	0.8	–	–	–	70	0.08	0.6	–	–	–
GL3-D300M02-GM:G8330		0.2	150	0.20	1.0	90	0.18	1.0	140	0.20	1.0	–	–	–	35	0.14	0.8	–	–	–
GL3-D300M02-GM:T7325	●	0.2	175	0.20	1.0	135	0.18	1.0	165	0.20	1.0	–	–	–	55	0.14	0.8	–	–	–
GL3-D300M04-GM:G8330		0.4	160	0.20	1.0	95	0.18	1.0	150	0.20	1.0	–	–	–	40	0.14	0.8	–	–	–
GL3-D300M04-GM:T7325	●	0.4	185	0.20	1.0	140	0.18	1.0	175	0.20	1.0	–	–	–	60	0.14	0.8	–	–	–
GL4-D400M04-GM:G8330		0.4	150	0.25	1.2	90	0.23	1.2	140	0.25	1.2	–	–	–	35	0.18	1.0	–	–	–
GL4-D400M04-GM:T7325	●	0.4	170	0.25	1.2	130	0.23	1.2	160	0.25	1.2	–	–	–	55	0.18	1.0	–	–	–
GL4-D400M08-GM:G8330		0.8	180	0.25	1.2	105	0.23	1.2	170	0.25	1.2	–	–	–	45	0.18	1.0	–	–	–
GL4-D400M08-GM:T7325	●	0.8	200	0.25	1.2	155	0.23	1.2	190	0.25	1.2	–	–	–	65	0.18	1.0	–	–	–
GL5-D500M08-GM:G8330		0.8	170	0.30	1.2	100	0.27	1.2	160	0.30	1.2	–	–	–	40	0.21	1.0	–	–	–
GL5-D500M08-GM:T7325	●	0.8	190	0.30	1.2	145	0.27	1.2	180	0.30	1.2	–	–	–	60	0.21	1.0	–	–	–
GL6-D600M08-GM:G8330		0.8	170	0.30	1.2	100	0.27	1.2	160	0.30	1.2	–	–	–	40	0.21	1.0	–	–	–
GL6-D600M08-GM:T7325	●	0.8	190	0.30	1.2	145	0.27	1.2	180	0.30	1.2	–	–	–	60	0.21	1.0	–	–	–
GL6-D800M08-GM:G8330 [1]		0.8	170	0.30	1.2	100	0.27	1.2	160	0.30	1.2	–	–	–	40	0.21	1.2	–	–	–





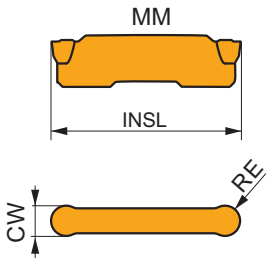
GM çok yönlü geometri, kanal açma ve boyuna tornalama için, darbesizden darbeli kesime kadar uygun.

[1] Yalnızca tutucularda kullanılabilir. ≥ CDX 24

GL. D - MM

PRAMET

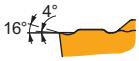
	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
200	2.00	-0.05	0.05	25.0
300	3.00	-0.05	0.05	25.0
400	4.00	-0.05	0.05	25.0
500	5.00	-0.05	0.05	26.0
600	6.00	-0.05	0.05	26.0



Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
GL2-D200MM0-MM:G8330		1.0	250	0.10	1.0	150	0.09	1.0	235	0.10	1.0	–	–	–	60	0.08	0.8	–	–	–
GL2-D200MM0-MM:T7325		1.0	285	0.10	1.0	220	0.09	1.0	270	0.10	1.0	–	–	–	90	0.08	0.8	–	–	–
GL3-D300MM0-MM:G8330		1.5	210	0.20	1.2	125	0.18	1.2	195	0.20	1.2	–	–	–	50	0.14	1.0	–	–	–
GL3-D300MM0-MM:T7325		1.5	240	0.20	1.2	185	0.18	1.2	225	0.20	1.2	–	–	–	75	0.14	1.0	–	–	–
GL4-D400MM0-MM:G8330		2.0	220	0.20	1.2	130	0.18	1.2	205	0.20	1.2	–	–	–	55	0.14	1.0	–	–	–
GL4-D400MM0-MM:T7325		2.0	250	0.20	1.2	195	0.18	1.2	235	0.20	1.2	–	–	–	80	0.14	1.0	–	–	–
GL5-D500MM0-MM:G8330		2.5	205	0.25	1.2	120	0.23	1.2	190	0.25	1.2	–	–	–	50	0.18	1.0	–	–	–
GL5-D500MM0-MM:T7325		2.5	235	0.25	1.2	180	0.23	1.2	220	0.25	1.2	–	–	–	75	0.18	1.0	–	–	–
GL6-D600MM0-MM:G8330		3.0	195	0.30	1.2	115	0.27	1.2	185	0.30	1.2	–	–	–	45	0.21	1.0	–	–	–
GL6-D600MM0-MM:T7325		3.0	220	0.30	1.2	170	0.27	1.2	205	0.30	1.2	–	–	–	70	0.21	1.0	–	–	–





MM geometri, kopya profil ve çap tornalama için tam radyüs, darbesizden darbeli kesime kadar uygun.

GG.(RL) INT

P M K N S H

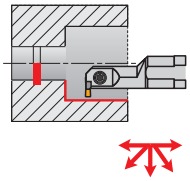
PRAMET

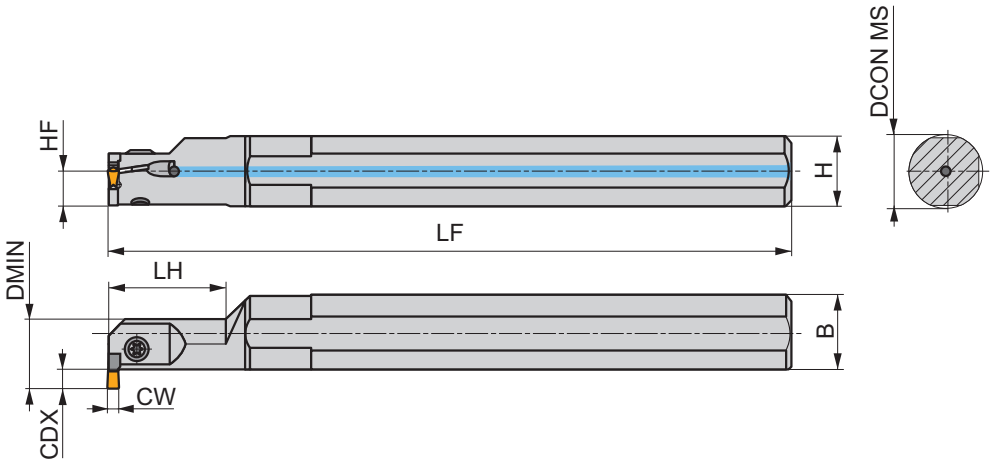
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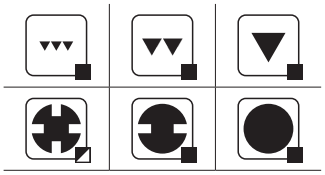


LCM. Uç için Delik Kanal Kateri

LCM uçlar ile kanal açmak için dahili Sağ/Sol kanal açma delik işleme barası. İç kanal açma ve çok yönlü tornalama için uygundur. Daha uzun takım ömrü için gövde bakımı yapılmıştır.









	Product	DCON MS (mm)	HF (mm)	H (mm)	B (mm)	LF (mm)	LH (mm)	CW (mm)	CDX (mm)	DMIN (mm)		kg		
R	A16Q-GGER 0313	16	7.5	15	15.5	180	25.0	3.00	3	16	✓	0.26	GI143	GL06
	A20R-GGFR 0313	20	9	18	19	200	30.0	3.00	4.5	20	✓	0.38	GI143	GL06
	A25S-GGHR 0313	25	11.5	23	24	250	40.0	3.00	6.5	25	✓	0.78	GI143	GL06
	A25S-GGFR 0413	25	11.5	23	24	250	40.0	4.00	6.5	25	✓	0.78	GI170	GL06
L	A16Q-GGEL 0313	16	7.5	15	15.5	180	25.0	3.00	3	16	✓	0.27	GI143	GL06
	A20R-GGFL 0313	20	9	18	19	200	30.0	3.00	4.5	20	✓	0.38	GI143	GL06
	A25S-GGHL 0313	25	11.5	23	24	250	40.0	3.00	6.5	25	✓	0.78	GI143	GL06

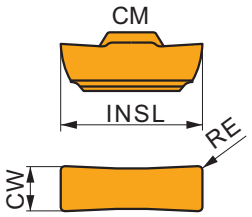
GI143	LCM. 0313..
GI170	LCM. 0413..

		Nm			
GL06	SR 85011-T15P	5.0	M 5	9	FLAG T15P

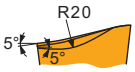
LCMF 13 - CM

PRAMET

	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
0313	3.00	-0.05	0.05	12.6
0413	4.00	-0.05	0.05	12.6



Kesme hızı (vc), ilerleme (f) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

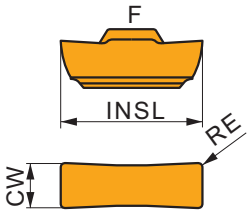
Product	RE	P		M		K		N		S		H		PSIRR	PSIRL
		vc	f	vc	f	vc	f	vc	f	vc	f	vc	f		
	(mm)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(°)	(°)
	 														
LCMF 031304-CM:T8330	0.4	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	–	–
LCMF 041304-CM:T8330	0.4	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	–	–

CM geometri ve kanal açma için ilk tercih.

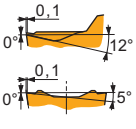
LCMF 13 - F

PRAMET

	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
0313	3.00	-0.05	0.05	12.6
0413	4.00	-0.05	0.05	12.6



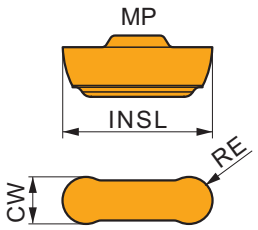
Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
	 																		
LCMF 031302-F:T8330	0.2	195	0.10	0.3	115	0.09	0.3	185	0.10	0.3	–	–	–	–	–	–	–	–	–
LCMF 031304-F:T8330	0.4	185	0.13	0.5	110	0.12	0.5	175	0.13	0.5	–	–	–	–	–	–	–	–	–
LCMF 041304-F:T8330	0.4	185	0.13	0.5	110	0.12	0.5	175	0.13	0.5	–	–	–	–	–	–	–	–	–

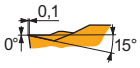
F geometri ve tornalama için ilk tercih.

LCMF 13 - MP

	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
0313	3.00	-0.05	0.05	12.6
0413	4.00	-0.05	0.05	12.6

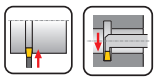
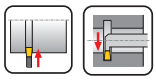


Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
																				
LCMF 0313MO-MP:T8330		1.5	■ 190	0.30	0.8	◪ 110	0.27	0.8	■ 180	0.30	0.8	–	–	–	–	–	–	–	–	–
LCMF 0413MO-MP:T8330		2.0	■ 175	0.40	1.0	◪ 105	0.36	1.0	■ 165	0.40	1.0	–	–	–	–	–	–	–	–	–

MP geometri, kopya profil ve çap tornalama, ince ve finiş işleme için, ve darbesizden darbeli kesime kadar uygun.

O-RING VE SEGMAN KANAL AÇMA

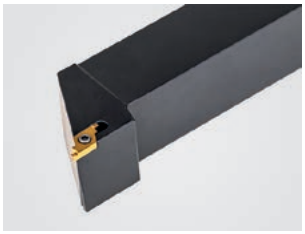
	İÇ		DIŞ			
P61(RL) EXT 16x16 20x20 25x25	R 	L 				
P61(RL) INT DCON MS = 12 – 32 mm DMIN = 16 – 40 mm			R 	L 		
P61S(RL)-1 INT DCON MS = 10 – 12 mm DMIN = 12.5 mm					R 	L 
Segmanlar için kanal açma 	R  **X61** CW = 0,85 – 3,2	L  **X61** CW = 0,85 – 3,2	L  **X61** CW=0,85 – 3,2	R  **X61** CW =0,85 – 3,2	L  **X61-1** CW=0,85 – 2,2	R  **X61-1** CW=0,85 – 2,2
O-ringler için kanal açma 	R  **X61 R** RE = 1 – 1.5	L  **X61 R** RE = 1 – 1.5	L  **X61 R** RE = 1 – 1.5	R  **X61 R** RE = 1 – 1.5	L  **X61 R-1** RE = 0.5 – 1	R  **X61 R-1** RE = 0.5–1

P61(RL) EXT

P M K N S

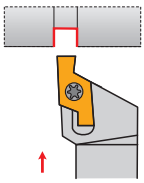
PRAMET

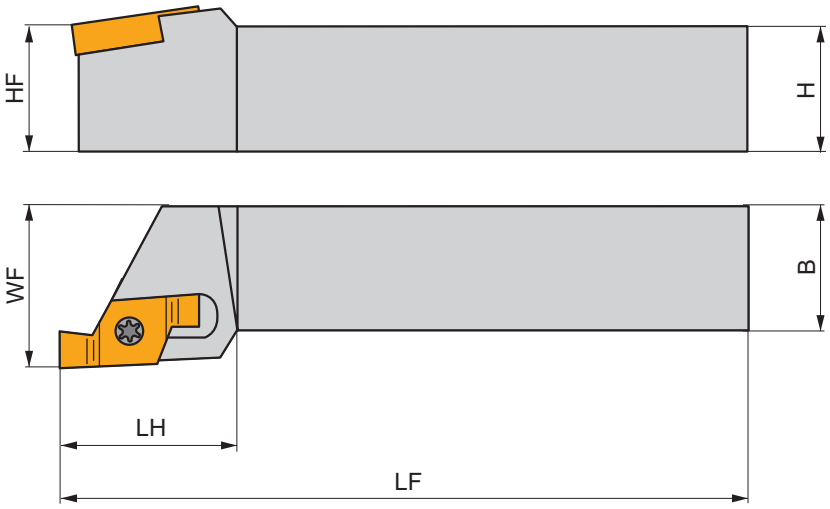
S

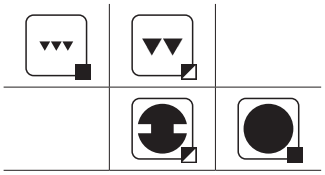


X61 Segman ve O-ring Ucu için Dış Kanal Kateri

Çift taraflı X61 O-ring ve segman uçları için Sağ/Sol radyal dış kanal kateri. Yüksek toleranslı ölçüler için pürüzsüz kesme sağlar. 16x16-25x25 şaft ölçülerinde bulunur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	HF (mm)	H (mm)	B (mm)	WF (mm)	LF (mm)	LH (mm)	kg		
R	P61.SFR-1616H-06	16	16	16	20	100	21.0	0.23	GI332_1	SV11
	P61.SFR-2020K-06	20	20	20	25	125	25.0	0.40	GI332_1	SV11
	P61.SFR-2525M-06	25	25	25	32	150	32.0	0.72	GI332_1	SV11
L	P61.SFL-1616H-06	16	16	16	20	100	21.0	0.22	GI332_2	SV11
	P61.SFL-2020K-06	20	20	20	25	125	25.0	0.41	GI332_2	SV11
	P61.SFL-2525M-06	25	25	25	32	150	32.0	0.73	GI332_2	SV11

GI332_1	X61 0602.. R

		Nm			
SV11	US 2003-T07P	0.8	M 2.5	6.5	FLAG T07P

P61(RL) INT

P M K N S

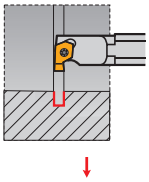
PRAMET

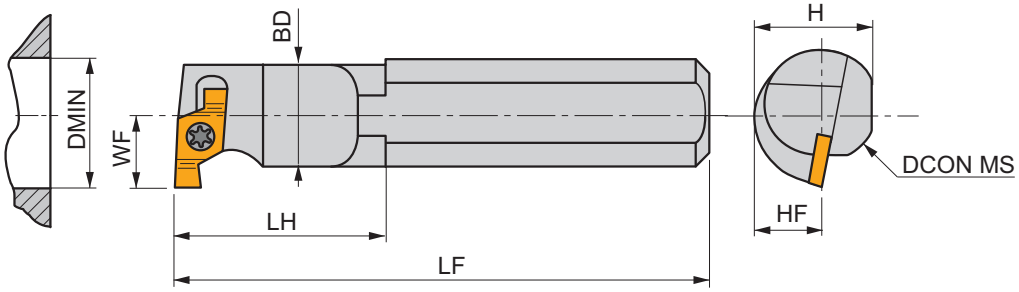
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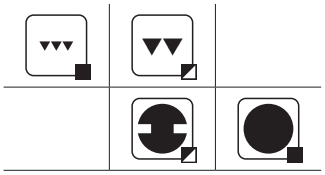


X61 Uç için Segman Delik Kateri

X61 çift taraflı kesici uçlarla kanal açmak için dahili Sağ/Sol kanal açma delik işleme barası. Segman veya O-halka kanallarının içten kesilmesi için uygundur.Gövde uzun takım ömrü için işlem görmüştür.









	Product	DCON MS (mm)	DMIN (mm)	BD (mm)	WF (mm)	H (mm)	LF (mm)	LH (mm)	KAPR (°)		kg		
R	P61.SGR-0012M-06	12	16	11.5	9	11	150	22.0	0	–	0.16	GI332_2	SV11
	P61.SGR-A-0016M-06	16	20	15	11	15	150	29.0	0	✓	0.23	GI332_2	SV11
	P61.SGR-A-0020P-06	20	25	19	13	18	170	29.0	0	✓	0.38	GI332_2	SV11
	P61.SGR-A-0025R-06	25	32	24	17	23	200	31.0	0	✓	0.70	GI332_2	SV11
	P61.SGR-A-0032T-06	32	40	31	22	30	300	49.0	0	✓	1.72	GI332_2	SV11
L	P61.SGL-0012M-06	12	16	11.5	9	11	150	22.0	0	–	0.16	GI332_1	SV11
	P61.SGL-A-0016M-06	16	20	15	11	15	150	29.0	0	✓	0.23	GI332_1	SV11
	P61.SGL-A-0020P-06	20	25	19	13	18	170	29.0	0	✓	0.39	GI332_1	SV11
	P61.SGL-A-0025R-06	25	32	24	17	23	200	31.0	0	✓	0.71	GI332_1	SV11
	P61.SGL-A-0032T-06	32	40	31	22	30	300	49.0	0	✓	1.72	GI332_1	SV11

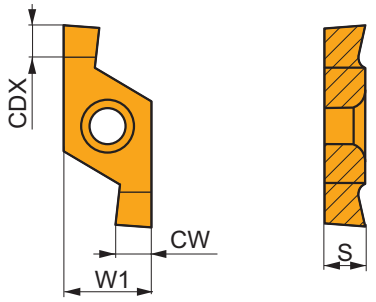
		Nm			
SV11	US 2003-T07P	0.8	M 2.5	6.5	FLAG T07P

Sağ delik kateri için sol uç.

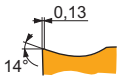
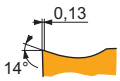
X 61

PRAMET

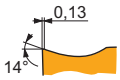
	W1	CWTOLL	CWTOLU	S
	(mm)	(mm)	(mm)	(mm)
0602	6.350	-0.03	0.03	2.33



Kesme hızı (vc), ilerleme (f) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P		M		K		N		S		H		CW	CDX
			vc	f	vc	f	vc	f	vc	f	vc	f	vc	f		
		(mm)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(mm)	(mm)
																
X61-R dış ve iç, sağ kesme yönlü, o-ring ve segman kanalı işlemek için, darbesiz kesim.																
X61 0602-080 R:6640	●	–	195	0.06	115	0.05	185	0.06	–	–	–	–	–	–	0.85	0.8
X61 0602-080 R:G8330	●	–	145	0.06	85	0.05	135	0.06	–	–	–	–	–	–	0.85	0.8
X61 0602-090 R:6640	●	–	195	0.06	115	0.05	185	0.06	–	–	–	–	–	–	0.95	0.8
X61 0602-090 R:G8330	●	–	145	0.06	85	0.05	135	0.06	–	–	–	–	–	–	0.95	0.8
X61 0602-100 R:6640	●	–	195	0.06	115	0.05	185	0.06	–	–	–	–	–	–	1.05	0.8
X61 0602-100 R:G8330	●	–	145	0.06	85	0.05	135	0.06	–	–	–	–	–	–	1.05	0.8
X61 0602-110 R:6640	●	–	185	0.06	110	0.05	175	0.06	–	–	–	–	–	–	1.15	1.2
X61 0602-110 R:G8330	●	–	140	0.06	80	0.05	130	0.06	–	–	–	–	–	–	1.15	1.2
X61 0602-130 R:6640	●	–	185	0.06	110	0.05	175	0.06	–	–	–	–	–	–	1.35	1.4
X61 0602-130 R:G8330	●	–	140	0.06	80	0.05	130	0.06	–	–	–	–	–	–	1.35	1.4
X61 0602-150 R:6640	●	–	180	0.06	105	0.05	170	0.06	–	–	–	–	–	–	1.55	1.6
X61 0602-150 R:G8330	●	–	135	0.06	80	0.05	125	0.06	–	–	–	–	–	–	1.55	1.6
X61 0602-160 R:6640	●	–	180	0.06	105	0.05	170	0.06	–	–	–	–	–	–	1.65	1.7
X61 0602-160 R:G8330	●	–	135	0.06	80	0.05	125	0.06	–	–	–	–	–	–	1.65	1.7
X61 0602-185 R:6640	●	–	150	0.09	90	0.08	140	0.09	–	–	–	–	–	–	1.90	2
X61 0602-185 R:G8330	●	–	120	0.09	70	0.08	110	0.09	–	–	–	–	–	–	1.90	2
X61 0602-200 R:G8330	●	–	115	0.09	65	0.08	105	0.09	–	–	–	–	–	–	2.05	2.2
X61 0602-215 R:6640	●	–	145	0.09	85	0.08	135	0.09	–	–	–	–	–	–	2.20	2.4
X61 0602-215 R:G8330	●	–	115	0.09	65	0.08	105	0.09	–	–	–	–	–	–	2.20	2.4
X61 0602-250 R:G8330	●	–	115	0.09	65	0.08	105	0.09	–	–	–	–	–	–	2.55	2.6
X61 0602-265 R:6640	●	–	125	0.12	75	0.11	115	0.12	–	–	–	–	–	–	2.70	2.7
X61 0602-265 R:G8330	●	–	105	0.12	60	0.11	95	0.12	–	–	–	–	–	–	2.70	2.7
X61 0602-300 R:6640	●	–	125	0.12	75	0.11	115	0.12	–	–	–	–	–	–	3.05	3
X61 0602-300 R:G8330	●	–	105	0.12	60	0.11	95	0.12	–	–	–	–	–	–	3.05	3
X61 0602-315 R:6640	●	–	125	0.12	75	0.11	115	0.12	–	–	–	–	–	–	3.20	3
X61 0602-315 R:G8330	●	–	105	0.12	60	0.11	95	0.12	–	–	–	–	–	–	3.20	3
																
X61-L dış ve iç, sol kesme yönlü, o-ring ve segman kanalı işlemek için, darbesiz kesim.																
X61 0602-080 L:6640	●	–	195	0.06	115	0.05	185	0.06	–	–	–	–	–	–	0.85	0.8
X61 0602-080 L:G8330	●	–	145	0.06	85	0.05	135	0.06	–	–	–	–	–	–	0.85	0.8
X61 0602-090 L:6640	●	–	195	0.06	115	0.05	185	0.06	–	–	–	–	–	–	0.95	0.8
X61 0602-090 L:G8330	●	–	145	0.06	85	0.05	135	0.06	–	–	–	–	–	–	0.95	0.8
X61 0602-100 L:6640	●	–	195	0.06	115	0.05	185	0.06	–	–	–	–	–	–	1.05	0.8
X61 0602-100 L:G8330	●	–	145	0.06	85	0.05	135	0.06	–	–	–	–	–	–	1.05	0.8
X61 0602-110 L:6640	●	–	185	0.06	110	0.05	175	0.06	–	–	–	–	–	–	1.15	1.2
X61 0602-110 L:G8330	●	–	140	0.06	80	0.05	130	0.06	–	–	–	–	–	–	1.15	1.2
X61 0602-130 L:6640	●	–	185	0.06	110	0.05	175	0.06	–	–	–	–	–	–	1.35	1.4
X61 0602-130 L:G8330	●	–	140	0.06	80	0.05	130	0.06	–	–	–	–	–	–	1.35	1.4

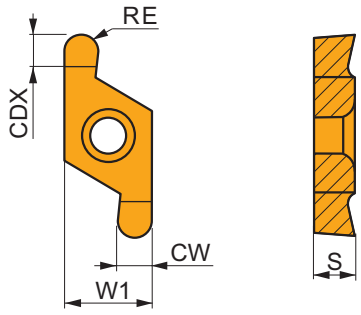
Kesme hızı (vc), ilerleme (f) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	M vc (m/min)	M f (mm/rev)	K vc (m/min)	K f (mm/rev)	N vc (m/min)	N f (mm/rev)	S vc (m/min)	S f (mm/rev)	H vc (m/min)	H f (mm/rev)	CW (mm)	CDX (mm)
 															
X61-L dış ve iç, sol kesme yönlü, o-ring ve segman kanalı işlemek için, darbesiz kesim.															
X61 0602-150 L:6640	–	180	0.06	105	0.05	170	0.06	–	–	–	–	–	–	1.55	1.6
X61 0602-150 L:G8330	–	135	0.06	80	0.05	125	0.06	–	–	–	–	–	–	1.55	1.6
X61 0602-160 L:6640	–	180	0.06	105	0.05	170	0.06	–	–	–	–	–	–	1.65	1.7
X61 0602-160 L:G8330	–	135	0.06	80	0.05	125	0.06	–	–	–	–	–	–	1.65	1.7
X61 0602-185 L:6640	–	150	0.09	90	0.08	140	0.09	–	–	–	–	–	–	1.90	2
X61 0602-185 L:G8330	–	120	0.09	70	0.08	110	0.09	–	–	–	–	–	–	1.90	2
X61 0602-200 L:G8330	–	115	0.09	65	0.08	105	0.09	–	–	–	–	–	–	2.05	2.2
X61 0602-215 L:6640	–	145	0.09	85	0.08	135	0.09	–	–	–	–	–	–	2.20	2.4
X61 0602-215 L:G8330	–	115	0.09	65	0.08	105	0.09	–	–	–	–	–	–	2.20	2.4
X61 0602-250 L:G8330	–	115	0.09	65	0.08	105	0.09	–	–	–	–	–	–	2.55	2.6
X61 0602-265 L:6640	–	125	0.12	75	0.11	115	0.12	–	–	–	–	–	–	2.70	2.7
X61 0602-265 L:G8330	–	105	0.12	60	0.11	95	0.12	–	–	–	–	–	–	2.70	2.7
X61 0602-300 L:6640	–	125	0.12	75	0.11	115	0.12	–	–	–	–	–	–	3.05	3
X61 0602-300 L:G8330	–	105	0.12	60	0.11	95	0.12	–	–	–	–	–	–	3.05	3
X61 0602-315 L:6640	–	125	0.12	75	0.11	115	0.12	–	–	–	–	–	–	3.20	3
X61 0602-315 L:G8330	–	105	0.12	60	0.11	95	0.12	–	–	–	–	–	–	3.20	3

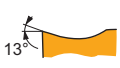
X 61 R

PRAMET

	W1 (mm)	CWTOLL (mm)	CWTOLU (mm)	S (mm)
0602	6.350	-0.03	0.03	2.33



Kesme hızı (vc), ilerleme (f) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	M vc (m/min)	M f (mm/rev)	K vc (m/min)	K f (mm/rev)	N vc (m/min)	N f (mm/rev)	S vc (m/min)	S f (mm/rev)	H vc (m/min)	H f (mm/rev)	CW (mm)	CDX (mm)
 															
X61R-R dış ve iç, sağ kesme yönlü, o-ring ve segman kanalı işlemek için, darbesiz kesim.															
X61 0602-R100 R:6640	1.0	170	0.06	100	0.05	160	0.06	–	–	–	–	–	–	2.09	3
X61 0602-R100 R:G8330	1.0	130	0.06	75	0.05	120	0.06	–	–	–	–	–	–	2.09	3
X61 0602-R150 R:6640	1.5	175	0.06	105	0.05	165	0.06	–	–	–	–	–	–	3.09	3
X61 0602-R150 R:G8330	1.5	135	0.06	80	0.05	125	0.06	–	–	–	–	–	–	3.09	3
 															
X61R-L dış ve iç, sol kesme yönlü, o-ring ve segman kanalı işlemek için, darbesiz kesim.															
X61 0602-R100 L:6640	1.0	170	0.06	100	0.05	160	0.06	–	–	–	–	–	–	2.09	3
X61 0602-R100 L:G8330	1.0	130	0.06	75	0.05	120	0.06	–	–	–	–	–	–	2.09	3
X61 0602-R150 L:6640	1.5	175	0.06	105	0.05	165	0.06	–	–	–	–	–	–	3.09	3
X61 0602-R150 L:G8330	1.5	135	0.06	80	0.05	125	0.06	–	–	–	–	–	–	3.09	3

P61S(RL)-1 INT

P M K N S

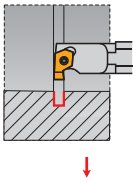
PRAMET

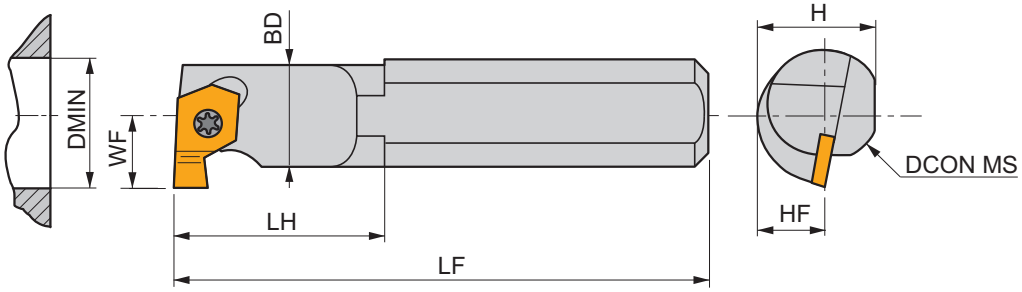
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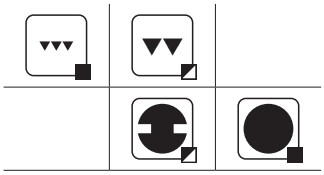


X61-1 Uç için Segman Delik Kateri

Tek taraflı X61-1 kesici uçlarla kanal açmak için dahili Sağ/Sol kanal açma delik işleme barası. Segman veya O-ring kanallarının iç çapa açılması için uygundur. Gövde uzun takım ömrü için işlem görmüştür.











	Product	DCON MS (mm)	DMIN (mm)	BD (mm)	WF (mm)	H (mm)	LF (mm)	LH (mm)	KAPR (°)	kg		
R	**P61.SGR-0010M-06/1**	10	12.5	10	7.5	9	150	19.0	0	0.12	GI333_2	SV11
	P61.SGR-0012M-06/1	12	12.5	10	7.5	11	150	19.0	0	0.16	GI333_2	SV11
L	**P61.SGL-0010M-06/1**	10	12.5	10	7.5	9	150	19.0	0	0.12	GI333_1	SV11
	P61.SGL-0012M-06/1	12	12.5	10	7.5	11	150	19.0	0	0.16	GI333_1	SV11

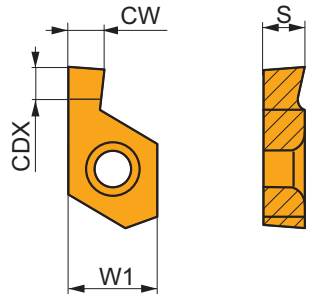
GI333_1	X61 0602..-1 R

		Nm			
SV11	US 2003-T07P	0.8	M 2.5	6.5	FLAG T07P

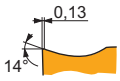
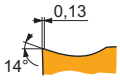
Sağ delik kateri için sol uç.

X 61-1

	W1	CWTOLL	CWTOLU	S
	(mm)	(mm)	(mm)	(mm)
0602	6.350	-0.03	0.03	2.33

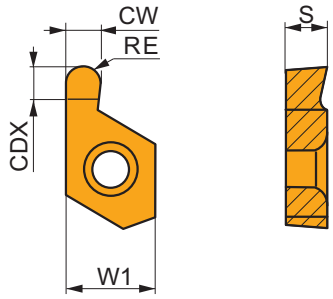


Kesme hızı (vc), ilerleme (f) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P		M		K		N		S		H		CW	CDX
			vc	f	vc	f	vc	f	vc	f	vc	f	vc	f		
		(mm)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(mm)	(mm)
																
X61-1-R iç, sağ kesme yönlü, tek ağızlı, o-ring ve segman kanalı işlemek için, darbesiz kesim.																
X61 0602-080 R1:6640	●	–	195	0.06	115	0.05	185	0.06	–	–	–	–	–	–	0.85	0.8
X61 0602-090 R1:6640	●	–	195	0.06	115	0.05	185	0.06	–	–	–	–	–	–	0.95	0.8
X61 0602-110 R1:6640	●	–	185	0.06	110	0.05	175	0.06	–	–	–	–	–	–	1.15	1.2
X61 0602-130 R1:6640	●	–	185	0.06	110	0.05	175	0.06	–	–	–	–	–	–	1.35	1.4
X61 0602-160 R1:6640	●	–	180	0.06	105	0.05	170	0.06	–	–	–	–	–	–	1.65	1.7
X61 0602-185 R1:6640	●	–	150	0.09	90	0.08	140	0.09	–	–	–	–	–	–	1.90	2
X61 0602-215 R1:6640	●	–	145	0.09	85	0.08	135	0.09	–	–	–	–	–	–	2.20	2.2
																
X61-1-L iç, sol kesme yönlü, tek ağızlı, o-ring ve segman kanalı işlemek için, darbesiz kesim.																
X61 0602-080 L1:6640	●	–	195	0.06	115	0.05	185	0.06	–	–	–	–	–	–	0.85	0.8
X61 0602-090 L1:6640	●	–	195	0.06	115	0.05	185	0.06	–	–	–	–	–	–	0.95	0.8
X61 0602-110 L1:6640	●	–	185	0.06	110	0.05	175	0.06	–	–	–	–	–	–	1.15	1.2
X61 0602-130 L1:6640	●	–	185	0.06	110	0.05	175	0.06	–	–	–	–	–	–	1.35	1.4
X61 0602-160 L1:6640	●	–	180	0.06	105	0.05	170	0.06	–	–	–	–	–	–	1.65	1.7
X61 0602-185 L1:6640	●	–	150	0.09	90	0.08	140	0.09	–	–	–	–	–	–	1.90	2
X61 0602-215 L1:6640	●	–	145	0.09	85	0.08	135	0.09	–	–	–	–	–	–	2.20	2.2

X 61 R-1

	W1	CWTOLL	CWTOLU	S
	(mm)	(mm)	(mm)	(mm)
0602	6.350	-0.03	0.03	2.33



Kesme hızı (vc), ilerleme (f) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P		M		K		N		S		H		CW	CDX
			vc	f	vc	f	vc	f	vc	f	vc	f	vc	f		
		(mm)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(mm)	(mm)
																
X61R-1-R iç, sağ kesme yönlü, tek ağızlı, o-ring ve segman kanalı işlemek için, darbesiz kesim.																
X61 0602-R050 R1:6640	●	0.5	145	0.06	85	0.05	135	0.06	–	–	–	–	–	–	1.09	1.3
X61 0602-R100 R1:6640	●	1.0	170	0.06	100	0.05	160	0.06	–	–	–	–	–	–	2.09	2.8
																
X61R-1-L iç, sol kesme yönlü, tek ağızlı, o-ring ve segman kanalı işlemek için, darbesiz kesim.																
X61 0602-R050 L1:6640	●	0.5	145	0.06	85	0.05	135	0.06	–	–	–	–	–	–	1.09	1.3
X61 0602-R100 L1:6640	●	1.0	170	0.06	100	0.05	160	0.06	–	–	–	–	–	–	2.09	2.8

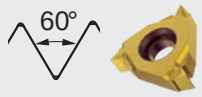


DİŞ TORNALAMA

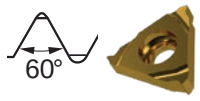
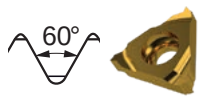
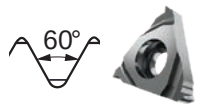
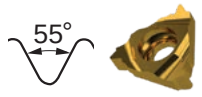
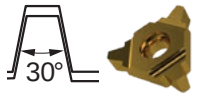
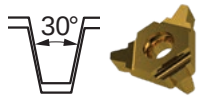
DİŞ AÇMA KESİCİ UÇLARI – REHBER

TAM PROFIL

EKONOMİK SERİ -P1 (doğrudan preslenmiş)

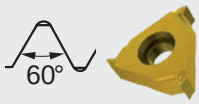
DIŞ		İÇ	
M		M	
UN		UN	
W		W	
NPT		NPT	

HASSAS SERİ (tamamen taşlanmış)

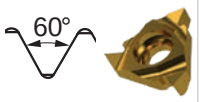
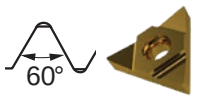
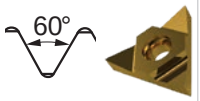
DIŞ		İÇ	
M		M	
M-AL		M-AL	
UN		UN	
W		W	
TR-S		TR-S	

KISMI PROFIL

EKONOMİK SERİ -P1 (doğrudan preslenmiş)

DIŞ		İÇ	
60°-PP		60°-PP	
55°-PP		55°-PP	

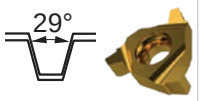
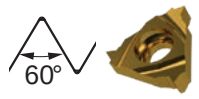
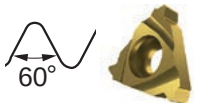
HASSAS SERİ (tamamen taşlanmış)

DIŞ		İÇ	
60°-PP		60°-PP	
55°-PP		55°-PP	
M-S PP		M-S PP	

TAM PROFIL

HASSAS SERİ (tamamen taşlanmış)

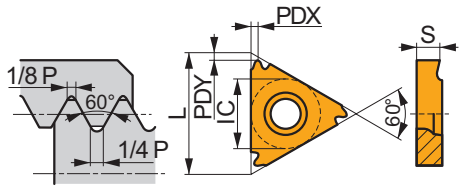
DIŞ		İÇ	
TR		TR	
BSPT		BSPT	
RD		RD	

DIŞ		İÇ	
ACME		ACME	
		STACME	
NPT		NPT	
API RD		API RD	

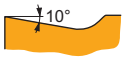
TN M EXT -P1

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47



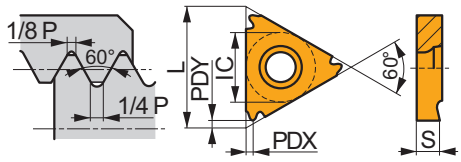
Kesme hızı (vc) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
			**TN** M-P1 ER preslenmiş dış, sağ kesme yönlü, ISO Metrik dişler için, darbesiz kesim.									
TN 16ER100M-P1:T8030	●	–	160	95	150	480	40	–	1.00	–	0.8	0.8
TN 16ER125M-P1:T8030	●	–	160	95	150	480	40	–	1.25	–	0.8	0.8
TN 16ER150M-P1:T8030	●	–	160	95	150	480	40	–	1.50	–	0.8	0.8
TN 16ER175M-P1:T8030	●	–	160	95	150	480	40	–	1.75	–	1.5	1.2
TN 16ER200M-P1:T8030	●	–	160	95	150	480	40	–	2.00	–	1.5	1.2
TN 16ER250M-P1:T8030	●	–	160	95	150	480	40	–	2.50	–	1.5	1.2
TN 16ER300M-P1:T8030	●	–	160	95	150	480	40	–	3.00	–	1.5	1.2

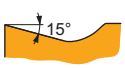
TN M INT -P1

PRAMET

	IC (mm)	L (mm)	S (mm)
11	6.350	11.00	3.00
16	9.525	16.50	3.47



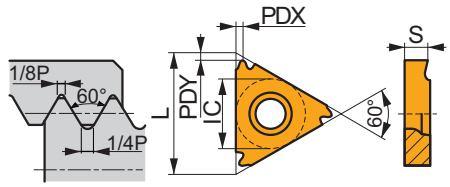
Kesme hızı (vc) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
			**TN** M-P1 NR preslenmiş iç, sağ kesme yönlü, ISO Metrik dişler için, darbesiz kesim.									
TN 11NR100M-P1:T8030	●	–	160	95	150	480	40	–	1.00	–	0.8	0.8
TN 11NR150M-P1:T8030	●	–	160	95	150	480	40	–	1.50	–	0.8	0.8
TN 11NR200M-P1:T8030	●	–	160	95	150	480	40	–	2.00	–	–	–
TN 16NR100M-P1:T8030	●	–	160	95	150	480	40	–	1.00	–	0.8	0.8
TN 16NR150M-P1:T8030	●	–	160	95	150	480	40	–	1.50	–	0.8	0.8
TN 16NR200M-P1:T8030	●	–	160	95	150	480	40	–	2.00	–	1.5	1.2
TN 16NR250M-P1:T8030	●	–	160	95	150	480	40	–	2.50	–	1.5	1.2
TN 16NR300M-P1:T8030	●	–	160	95	150	480	40	–	3.00	–	1.5	1.2

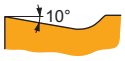
TN UN EXT -P1

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47



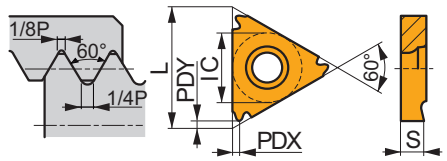
Kesme hızı (vc) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
												
TN UN-P1 ER preslenmiş dış, sağ kesme yönlü, Birleşik dişler için, darbesiz kesim.												
TN 16ER200UN-P1:T8030	●	–	160	95	150	480	40	–	–	20.0	0.8	0.8
TN 16ER180UN-P1:T8030	●	–	160	95	150	480	40	–	–	18.0	0.8	0.8
TN 16ER160UN-P1:T8030	●	–	160	95	150	480	40	–	–	16.0	0.8	0.8
TN 16ER140UN-P1:T8030	●	–	160	95	150	480	40	–	–	14.0	1.5	1.2
TN 16ER120UN-P1:T8030	●	–	160	95	150	480	40	–	–	12.0	1.5	1.2

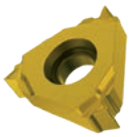
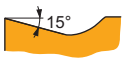
TN UN INT -P1

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47



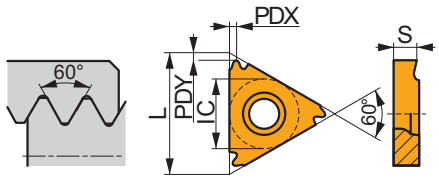
Kesme hızı (vc) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
												
TN UN-P1 NR preslenmiş iç, sağ kesme yönlü, Birleşik dişler için, darbesiz kesim.												
TN 16NR200UN-P1:T8030	●	–	160	95	150	480	40	–	–	20.0	0.8	0.8
TN 16NR180UN-P1:T8030	●	–	160	95	150	480	40	–	–	18.0	0.8	0.8
TN 16NR160UN-P1:T8030	●	–	160	95	150	480	40	–	–	16.0	0.8	0.8
TN 16NR140UN-P1:T8030	●	–	160	95	150	480	40	–	–	14.0	1.5	1.2
TN 16NR120UN-P1:T8030	●	–	160	95	150	480	40	–	–	12.0	1.5	1.2

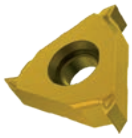
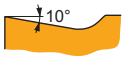
TN 60° PP EXT -P1

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47



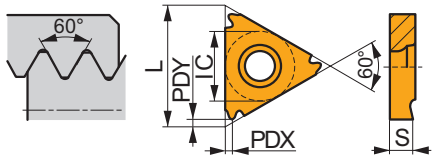
Kesme hızı (vc) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TPN (mm)	TPX (mm)	TPIN	TPIX	PDX (mm)	PDY (mm)
			**TN** M60-P1 PP ER preslenmiş dış, sağ kesme yönlü, Metrik ve Birleşik dişler için, darbesiz kesim.											
TN 16ERA60-P1:T8030	●	–	160	95	150	480	40	–	0.50	1.50	16	48	0.8	0.6
TN 16ERAG60-P1:T8030	●	–	160	95	150	480	40	–	0.50	3.00	8	48	1.5	1.1
TN 16ERG60-P1:T8030	●	–	160	95	150	480	40	–	1.75	3.00	8	14	1.5	1.2

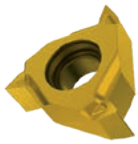
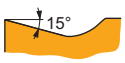
TN 60° PP INT -P1

PRAMET

	IC (mm)	L (mm)	S (mm)
11	6.350	11.00	3.00
16	9.525	16.50	3.47



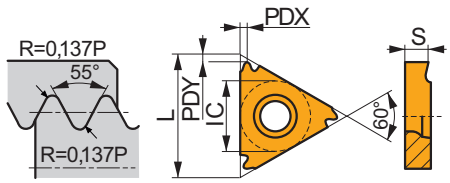
Kesme hızı (vc) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TPN (mm)	TPX (mm)	TPIN	TPIX	PDX (mm)	PDY (mm)
			**TN** M60-P1 PP NR preslenmiş iç, sağ kesme yönlü, Metrik ve Birleşik dişler için, darbesiz kesim.											
TN 11NRA60-P1:T8030	●	–	160	95	150	480	40	–	0.50	1.50	16	48	0.8	0.7
TN 16NRAG60-P1:T8030	●	–	160	95	150	480	40	–	0.50	3.00	8	48	1.5	1.1
TN 16NRG60-P1:T8030	●	–	160	95	150	480	40	–	1.75	3.00	8	14	1.5	1.2

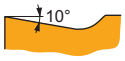
TN W EXT -P1

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47



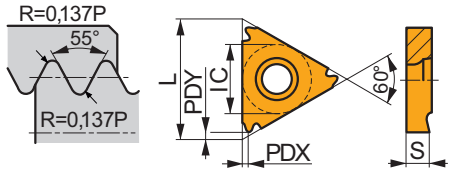
Kesme hızı (vc) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
  												
TN W-P1 ER preslenmiş dış, sağ kesme yönlü, Whitworth dişler için, darbesiz kesim.												
TN 16ER190W-P1:T8030	●	–	160	95	150	480	40	–	–	19.0	0.8	0.8
TN 16ER140W-P1:T8030	●	–	160	95	150	480	40	–	–	14.0	1.5	1.2
TN 16ER110W-P1:T8030	●	–	160	95	150	480	40	–	–	11.0	1.5	1.2

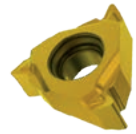
TN W INT -P1

PRAMET

	IC (mm)	L (mm)	S (mm)
11	6.350	11.00	3.00
16	9.525	16.50	3.47



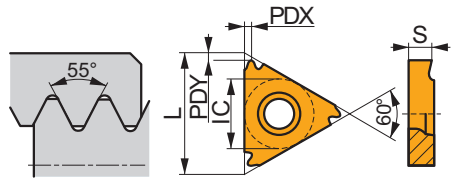
Kesme hızı (vc) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
  												
TN W-P1 NR preslenmiş iç, sol kesme yönlü, Whitworth dişler için, darbesiz kesim.												
TN 11NR190W-P1:T8030	●	–	160	95	150	480	40	–	–	19.0	0.8	0.8
TN 11NR140W-P1:T8030	●	–	160	95	150	480	40	–	–	14.0	0.9	0.7
TN 16NR140W-P1:T8030	●	–	160	95	150	480	40	–	–	14.0	1.5	1.2
TN 16NR110W-P1:T8030	●	–	160	95	150	480	40	–	–	11.0	1.5	1.2

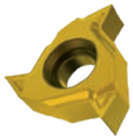
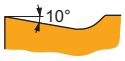
TN 55° PP EXT -P1

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47



Kesme hızı (vc) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

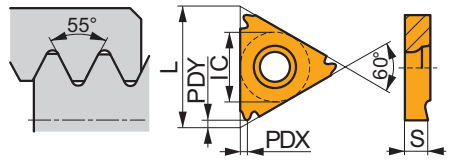
Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TPN (mm)	TPX (mm)	TPIN	TPIX	PDX (mm)	PDY (mm)
														
TN 16ERAG55-P1:T8030	●	–	160	95	150	480	40	–	0.50	3.00	8	48	–	–
TN 16ERG55-P1:T8030	●	–	160	95	150	480	40	–	1.75	3.00	8	14	–	–

TN W55-P1 PP ER preslenmiş dış, sağ kesme yönlü, Whitworth dişler için, darbesiz kesim.

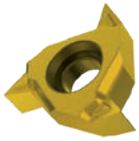
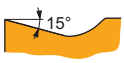
TN 55° PP INT -P1

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47



Kesme hızı (vc) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

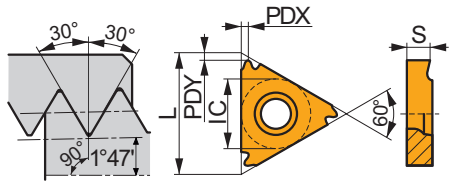
Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TPN (mm)	TPX (mm)	TPIN	TPIX	PDX (mm)	PDY (mm)
														
TN 16NRAG55-P1:T8030	●	–	160	95	150	480	40	–	0.50	1.50	16	48	–	–

TN W55-P1 PP NR preslenmiş iç, sol kesme yönlü, Whitworth dişler için, darbesiz kesim.

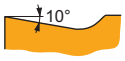
TN NPT EXT -P1

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47



Kesme hızı (vc) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

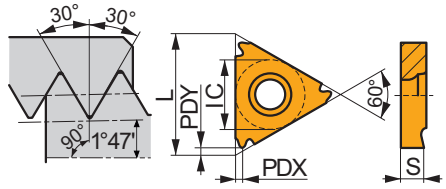
Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
												
TN 16ER115NPT-P1:T8030	●	–	160	95	150	480	40	–	–	11.5	–	–

TN NPT-P1 ER preslenmiş dış, sağ kesme yönlü, NPT dişler için, darbesiz kesim.

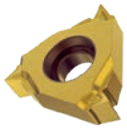
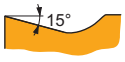
TN NPT INT -P1

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47



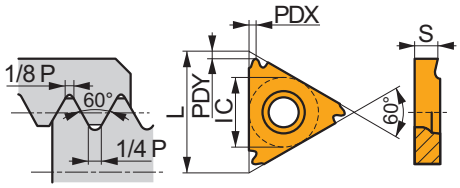
Kesme hızı (vc) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
												
TN 16NR115NPT-P1:T8030	●	–	160	95	150	480	40	–	–	11.5	–	–

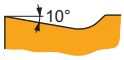
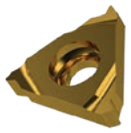
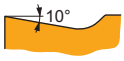
TN NPT-P1 NR preslenmiş iç, sağ kesme yönlü, NPT dişler için, darbesiz kesim.

TN M EXT

	IC	L	S
	(mm)	(mm)	(mm)
16	9.525	16.50	3.47
22	12.700	22.00	4.71



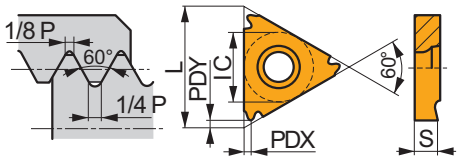
Kesme hızı (vc) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P	M	K	N	S	H	TP	TPI	PDX	PDY
			vc	vc	vc	vc	vc	vc				
		(mm)	(m/min)	(m/min)	(m/min)	(m/min)	(m/min)	(m/min)	(mm)		(mm)	(mm)
												
TN M ER dış, sağ kesme yönlü, ISO Metrik dişler için, darbesiz kesim.												
TN 16ER050M:T8010	●	–	175	105	165	–	40	–	0.50	–	0.8	0.8
TN 16ER050M:T8030	●	–	160	95	150	480	40	–	0.50	–	0.8	0.8
TN 16ER075M:T8010	●	–	175	105	165	–	40	–	0.75	–	0.8	0.8
TN 16ER075M:T8030	●	–	160	95	150	480	40	–	0.75	–	0.8	0.8
TN 16ER080M:T8030	●	–	160	95	150	480	40	–	0.80	–	0.6	0.8
TN 16ER100M:T8010	●	–	175	105	165	–	40	–	1.00	–	0.8	0.8
TN 16ER100M:T8030	●	–	160	95	150	480	40	–	1.00	–	0.8	0.8
TN 16ER125M:T8010	●	–	175	105	165	–	40	–	1.25	–	0.8	0.8
TN 16ER125M:T8030	●	–	160	95	150	480	40	–	1.25	–	0.8	0.8
TN 16ER150M:T8010	●	–	175	105	165	–	40	–	1.50	–	0.8	0.8
TN 16ER150M:T8030	●	–	160	95	150	480	40	–	1.50	–	0.8	0.8
TN 16ER175M:T8010	●	–	175	105	165	–	40	–	1.75	–	1.5	1.2
TN 16ER175M:T8030	●	–	160	95	150	480	40	–	1.75	–	1.5	1.2
TN 16ER200M:T8010	●	–	175	105	165	–	40	–	2.00	–	1.5	1.2
TN 16ER200M:T8030	●	–	160	95	150	480	40	–	2.00	–	1.5	1.2
TN 16ER250M:T8010	●	–	175	105	165	–	40	–	2.50	–	1.5	1.2
TN 16ER250M:T8030	●	–	160	95	150	480	40	–	2.50	–	1.5	1.2
TN 16ER300M:T8010	●	–	175	105	165	–	40	–	3.00	–	1.5	1.2
TN 16ER300M:T8030	●	–	160	95	150	480	40	–	3.00	–	1.5	1.2
TN 16ER350M:T8030[1)]	●	–	160	95	150	480	40	–	3.50	–	1.7	1.2
TN 22ER350M:T8030	●	–	160	95	150	480	40	–	3.50	–	2.5	1.8
TN 22ER400M:T8010	●	–	175	105	165	–	40	–	4.00	–	2.5	1.8
TN 22ER400M:T8030	●	–	160	95	150	480	40	–	4.00	–	2.5	1.8
TN 22ER450M:T8030	●	–	160	95	150	480	40	–	4.50	–	2.5	1.8
TN 22ER500M:T8030	●	–	160	95	150	480	40	–	5.00	–	2.5	1.8
												
TN M EL dış, sol kesme yönlü, ISO Metrik dişler için, darbesiz kesim.												
TN 16EL050M:T8030	●	–	160	95	150	480	40	–	0.50	–	0.8	0.8
TN 16EL075M:T8030	●	–	160	95	150	480	40	–	0.75	–	0.8	0.8
TN 16EL080M:T8030	●	–	160	95	150	480	40	–	0.80	–	0.6	0.8
TN 16EL100M:T8010	●	–	175	105	165	–	40	–	1.00	–	0.8	0.8
TN 16EL100M:T8030	●	–	160	95	150	480	40	–	1.00	–	0.8	0.8
TN 16EL125M:T8030	●	–	160	95	150	480	40	–	1.25	–	0.8	0.8
TN 16EL150M:T8010	●	–	175	105	165	–	40	–	1.50	–	0.8	0.8
TN 16EL150M:T8030	●	–	160	95	150	480	40	–	1.50	–	0.8	0.8
TN 16EL175M:T8030	●	–	160	95	150	480	40	–	1.75	–	1.5	1.2
TN 16EL200M:T8030	●	–	160	95	150	480	40	–	2.00	–	1.5	1.2
TN 16EL250M:T8030	●	–	160	95	150	480	40	–	2.50	–	1.5	1.2
TN 16EL300M:T8010	●	–	175	105	165	–	40	–	3.00	–	1.5	1.2
TN 16EL300M:T8030	●	–	160	95	150	480	40	–	3.00	–	1.5	1.2
TN 22EL350M:T8030	●	–	160	95	150	480	40	–	3.50	–	2.5	1.8
TN 22EL400M:T8030	●	–	160	95	150	480	40	–	4.00	–	2.5	1.8
TN 22EL450M:T8030	●	–	160	95	150	480	40	–	4.50	–	2.5	1.8

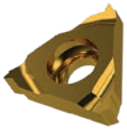
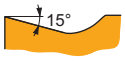
[1)] Toolholders have to be modified.

TN M INT

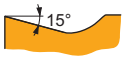
	IC (mm)	L (mm)	S (mm)
11	6.350	11.00	3.00
16	9.525	16.50	3.47
22	12.700	22.00	4.71



Kesme hızı (vc) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE (mm)	P vc (m/min)		M vc (m/min)		K vc (m/min)		N vc (m/min)		S vc (m/min)		H vc (m/min)		TP (mm)	TPI	PDX (mm)	PDY (mm)
																		
TN M NR iç, sağ kesme yönlü, ISO Metrik dişler için, darbesiz kesim.																		
TN 11NR050M:T8030	●	–	■	160	■	95	■	150	◩	480	◩	40		–	0.50	–	0.8	0.8
TN 11NR075M:T8010	●	–	■	175	◩	105	■	165		–	◩	40		–	0.75	–	0.8	0.8
TN 11NR075M:T8030	●	–	■	160	■	95	■	150	◩	480	◩	40		–	0.75	–	0.8	0.8
TN 11NR100M:T8030	●	–	■	160	■	95	■	150	◩	480	◩	40		–	1.00	–	0.8	0.8
TN 11NR125M:T8030	●	–	■	160	■	95	■	150	◩	480	◩	40		–	1.25	–	0.8	0.8
TN 11NR150M:T8010	●	–	■	175	◩	105	■	165		–	◩	40		–	1.50	–	0.8	0.8
TN 11NR150M:T8030	●	–	■	160	■	95	■	150	◩	480	◩	40		–	1.50	–	0.8	0.8
TN 11NR200M:T8010	●	–	■	175	◩	105	■	165		–	◩	40		–	2.00	–	0.9	0.8
TN 11NR200M:T8030	●	–	■	160	■	95	■	150	◩	480	◩	40		–	2.00	–	0.9	0.8
TN 16NR050M:T8030	●	–	■	160	■	95	■	150	◩	480	◩	40		–	0.50	–	0.8	0.8
TN 16NR075M:T8030	●	–	■	160	■	95	■	150	◩	480	◩	40		–	0.75	–	0.8	0.8
TN 16NR100M:T8010	●	–	■	175	◩	105	■	165		–	◩	40		–	1.00	–	0.8	0.8
TN 16NR100M:T8030	●	–	■	160	■	95	■	150	◩	480	◩	40		–	1.00	–	0.8	0.8
TN 16NR125M:T8030	●	–	■	160	■	95	■	150	◩	480	◩	40		–	1.25	–	0.8	0.8
TN 16NR150M:T8010	●	–	■	175	◩	105	■	165		–	◩	40		–	1.50	–	0.8	0.8
TN 16NR150M:T8030	●	–	■	160	■	95	■	150	◩	480	◩	40		–	1.50	–	0.8	0.8
TN 16NR175M:T8030	●	–	■	160	■	95	■	150	◩	480	◩	40		–	1.75	–	1.5	1.2
TN 16NR200M:T8010	●	–	■	175	◩	105	■	165		–	◩	40		–	2.00	–	1.5	1.2
TN 16NR200M:T8030	●	–	■	160	■	95	■	150	◩	480	◩	40		–	2.00	–	1.5	1.2
TN 16NR250M:T8010	●	–	■	175	◩	105	■	165		–	◩	40		–	2.50	–	1.5	1.2
TN 16NR250M:T8030	●	–	■	160	■	95	■	150	◩	480	◩	40		–	2.50	–	1.5	1.2
TN 16NR300M:T8010	●	–	■	175	◩	105	■	165		–	◩	40		–	3.00	–	1.5	1.2
TN 16NR300M:T8030	●	–	■	160	■	95	■	150	◩	480	◩	40		–	3.00	–	1.5	1.2
TN 16NR350M:T8030[1)]	●	–	■	160	■	95	■	150	◩	480	◩	40		–	3.50	–	1.6	1.2
TN 22NR350M:T8030	●	–	■	160	■	95	■	150	◩	480	◩	40		–	3.50	–	2.5	1.8
TN 22NR400M:T8010	●	–	■	175	◩	105	■	165		–	◩	40		–	4.00	–	2.5	1.8
TN 22NR400M:T8030	●	–	■	160	■	95	■	150	◩	480	◩	40		–	4.00	–	2.5	1.8
TN 22NR450M:T8010	●	–	■	175	◩	105	■	165		–	◩	40		–	4.50	–	2.5	1.8
TN 22NR450M:T8030	●	–	■	160	■	95	■	150	◩	480	◩	40		–	4.50	–	2.5	1.8
TN 22NR500M:T8010	●	–	■	175	◩	105	■	165		–	◩	40		–	5.00	–	2.5	1.8
TN 22NR500M:T8030	●	–	■	160	■	95	■	150	◩	480	◩	40		–	5.00	–	2.5	1.8

Kesme hızı (vc) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

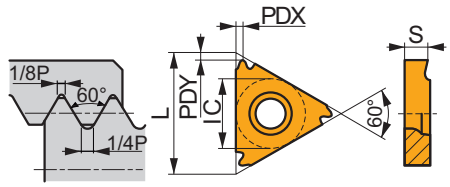
Product	RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
   **TN** M NL iç, sol kesme yönlü, ISO Metrik dişler için, darbesiz kesim.											
TN 11NL050M:T8030	–	160	95	150	480	40	–	0.50	–	0.8	0.8
TN 11NL100M:T8030	–	160	95	150	480	40	–	1.00	–	0.8	0.8
TN 11NL150M:T8030	–	160	95	150	480	40	–	1.50	–	0.8	0.8
TN 11NL200M:T8030	–	160	95	150	480	40	–	2.00	–	0.9	0.8
TN 16NL100M:T8030	–	160	95	150	480	40	–	1.00	–	0.8	0.8
TN 16NL125M:T8030	–	160	95	150	480	40	–	1.25	–	0.8	0.8
TN 16NL150M:T8010	–	175	105	165	–	40	–	1.50	–	0.8	0.8
TN 16NL150M:T8030	–	160	95	150	480	40	–	1.50	–	0.8	0.8
TN 16NL175M:T8030	–	160	95	150	480	40	–	1.75	–	1.5	1.2
TN 16NL200M:T8010	–	175	105	165	–	40	–	2.00	–	1.5	1.2
TN 16NL200M:T8030	–	160	95	150	480	40	–	2.00	–	1.5	1.2
TN 16NL250M:T8030	–	160	95	150	480	40	–	2.50	–	1.5	1.2
TN 16NL300M:T8010	–	175	105	165	–	40	–	3.00	–	1.5	1.2
TN 16NL300M:T8030	–	160	95	150	480	40	–	3.00	–	1.5	1.2
TN 22NL350M:T8030	–	160	95	150	480	40	–	3.50	–	2.5	1.8
TN 22NL400M:T8030	–	160	95	150	480	40	–	4.00	–	2.5	1.8

[1] Toolholders have to be modified.

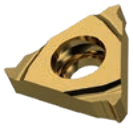
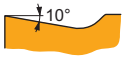
TN UN EXT

PRAMET

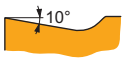
	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47
22	12.700	22.00	4.71



Kesme hızı (vc) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
   **TN** UN ER dış, sağ kesme yönlü, Birleşik dişler için, darbesiz kesim.											
TN 16ER320UN:T8030	–	160	95	150	480	40	–	–	32.0	0.8	0.8
TN 16ER280UN:T8030	–	160	95	150	480	40	–	–	28.0	0.8	0.8
TN 16ER240UN:T8030	–	160	95	150	480	40	–	–	24.0	0.8	0.8
TN 16ER200UN:T8010	–	175	105	165	–	40	–	–	20.0	0.8	0.8
TN 16ER200UN:T8030	–	160	95	150	480	40	–	–	20.0	0.8	0.8
TN 16ER180UN:T8030	–	160	95	150	480	40	–	–	18.0	0.8	0.8
TN 16ER160UN:T8030	–	160	95	150	480	40	–	–	16.0	0.8	0.8
TN 16ER140UN:T8030	–	160	95	150	480	40	–	–	14.0	1.5	1.2
TN 16ER130UN:T8030	–	160	95	150	480	40	–	–	13.0	1.5	1.2
TN 16ER120UN:T8030	–	160	95	150	480	40	–	–	12.0	1.5	1.2
TN 16ER110UN:T8030	–	160	95	150	480	40	–	–	11.0	1.5	1.2
TN 16ER100UN:T8030	–	160	95	150	480	40	–	–	10.0	1.5	1.2
TN 16ER090UN:T8030	–	160	95	150	480	40	–	–	9.0	1.5	1.2
TN 16ER080UN:T8030	–	160	95	150	480	40	–	–	8.0	1.5	1.2
TN 22ER070UN:T8030	–	160	95	150	480	40	–	–	7.0	2.5	1.8
TN 22ER060UN:T8030	–	160	95	150	480	40	–	–	6.0	2.5	1.8

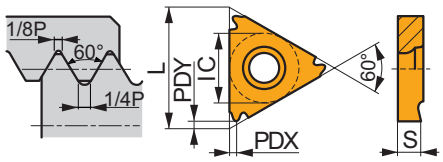
Kesme hızı (vc) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
   **TN** UN EL dış, sol kesme yönlü, Birleşik dişler için, darbesiz kesim.											
TN 16EL200UN:T8030	–	160	95	150	480	40	–	–	20.0	0.8	0.8
TN 16EL120UN:T8030	–	160	95	150	480	40	–	–	12.0	1.5	1.2
TN 16EL100UN:T8030	–	160	95	150	480	40	–	–	10.0	1.5	1.2

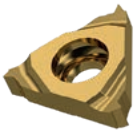
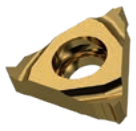
TN UN INT

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47
22	12.700	22.00	4.71

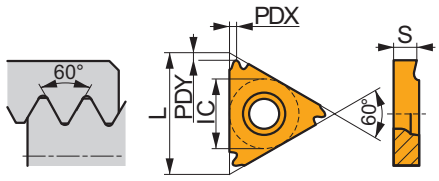


Kesme hızı (vc) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

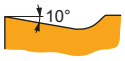
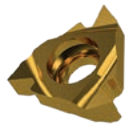
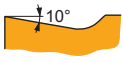
Product	RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
   **TN** UN NR iç, sağ kesme yönlü, Birleşik dişler için, darbesiz kesim.											
TN 16NR200UN:T8030	–	160	95	150	480	40	–	–	20.0	0.8	0.8
TN 16NR180UN:T8030	–	160	95	150	480	40	–	–	18.0	0.8	0.8
TN 16NR160UN:T8030	–	160	95	150	480	40	–	–	16.0	0.8	0.8
TN 16NR140UN:T8030	–	160	95	150	480	40	–	–	14.0	1.5	1.2
TN 16NR120UN:T8030	–	160	95	150	480	40	–	–	12.0	1.5	1.2
TN 16NR110UN:T8030	–	160	95	150	480	40	–	–	11.0	1.5	1.2
TN 16NR100UN:T8030	–	160	95	150	480	40	–	–	10.0	1.5	1.2
TN 16NR080UN:T8030	–	160	95	150	480	40	–	–	8.0	1.5	1.2
TN 22NR050UN:T8030	–	160	95	150	480	40	–	–	5.0	2.5	1.8
   **TN** UN NL iç, sol kesme yönlü, Birleşik dişler için, darbesiz kesim.											
TN 16NL120UN:T8030	–	160	95	150	480	40	–	–	12.0	1.5	1.2
TN 16NL080UN:T8030	–	160	95	150	480	40	–	–	8.0	1.5	1.2

TN 60° PP EXT

	IC	L	S
	(mm)	(mm)	(mm)
16	9.525	16.50	3.47
22	12.700	22.00	4.71

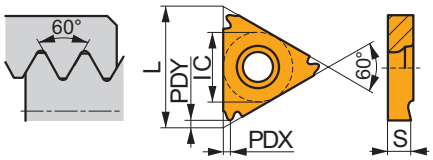


Kesme hızı (vc) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

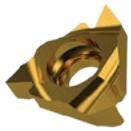
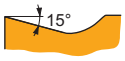
Product		RE	P	M	K	N	S	H	TPN	TPX	TPIN	TPIX	PDX	PDY
			vc	vc	vc	vc	vc	vc						
		(mm)	(m/min)	(m/min)	(m/min)	(m/min)	(m/min)	(m/min)	(mm)	(mm)			(mm)	(mm)
			**TN** M60 PP ER dış, sağ kesme yönlü, Metrik ve Birleşik dişler için, darbesiz kesim.											
TN 16ERA60:T8030	●	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	0.50	1.50	16	48	0.8	0.6
TN 16ERAG60:T8010	●	–	■ 175	◪ 105	■ 165	–	◪ 40	–	0.50	3.00	8	48	1.5	1.1
TN 16ERAG60:T8030	●	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	0.50	3.00	8	48	1.5	1.1
TN 16ERG60:T8010	●	–	■ 175	◪ 105	■ 165	–	◪ 40	–	1.75	3.00	8	14	1.5	1.1
TN 16ERG60:T8030	●	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	1.75	3.00	8	14	1.5	1.1
TN 22ERN60:T8010	●	–	■ 175	◪ 105	■ 165	–	◪ 40	–	3.50	5.00	5	7	2.5	1.8
TN 22ERN60:T8030	●	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	3.50	5.00	5	7	2.5	1.8
			**TN** M60 PP EL dış, sol kesme yönlü, Metrik ve Birleşik dişler için, darbesiz kesim.											
TN 16ELA60:T8030	●	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	0.50	1.50	16	48	0.8	0.6
TN 16ELAG60:T8010	●	–	■ 175	◪ 105	■ 165	–	◪ 40	–	0.50	3.00	8	48	1.5	1.1
TN 16ELAG60:T8030	●	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	0.50	3.00	8	48	1.5	1.1
TN 16ELG60:T8030	●	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	1.75	3.00	8	14	1.5	1.1
TN 22ELN60:T8030	●	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	3.50	5.00	5	7	2.5	1.8

TN 60° PP INT

	IC (mm)	L (mm)	S (mm)
11	6.350	11.00	3.00
16	9.525	16.50	3.47
22	12.700	22.00	4.71

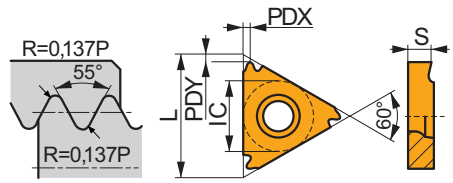


Kesme hızı (vc) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

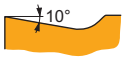
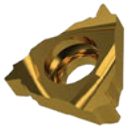
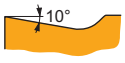
Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TPN (mm)	TPX (mm)	TPIN	TPIX	PDX (mm)	PDY (mm)
 														
TN M60 PP NR iç, sağ kesme yönlü, Metrik ve Birleşik dişler için, darbesiz kesim.														
TN 11NRA60:T8030	●	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	0.50	1.50	16	48	0.8	0.7
TN 16NRA60:T8030	●	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	0.50	1.50	16	48	0.8	0.7
TN 16NRAG60:T8010	●	–	■ 175	◪ 105	■ 165	–	◪ 40	–	0.50	3.00	8	48	1.5	1.1
TN 16NRAG60:T8030	●	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	0.50	3.00	8	48	1.5	1.1
TN 16NRG60:T8030	●	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	1.75	3.00	8	14	1.5	1.1
TN 22NRN60:T8010	●	–	■ 175	◪ 105	■ 165	–	◪ 40	–	3.50	5.00	5	7	2.5	1.8
TN 22NRN60:T8030	●	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	3.50	5.00	5	7	2.5	1.8
 														
TN M60 PP NL iç, sol kesme yönlü, Metrik ve Birleşik dişler için, darbesiz kesim.														
TN 11NLA60:T8030	●	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	0.50	1.50	16	48	0.8	0.7
TN 16NLAG60:T8030	●	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	0.50	3.00	8	48	1.5	1.1
TN 22NLN60:T8030	●	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	3.50	5.00	5	7	2.5	1.8

TN W EXT

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47
22	12.700	22.00	4.71

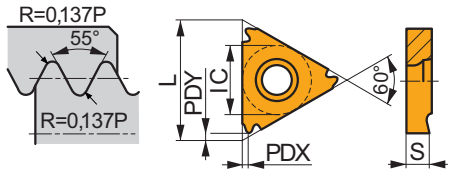


Kesme hızı (vc) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

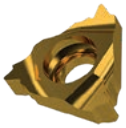
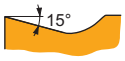
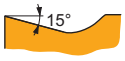
Product	RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
   **TN** W ER dış, sağ kesme yönlü, Whitworth dişler için, darbesiz kesim.											
TN 16ER280W:T8030	–	160	95	150	480	40	–	–	28.0	0.8	0.8
TN 16ER240W:T8030	–	160	95	150	480	40	–	–	24.0	0.8	0.8
TN 16ER200W:T8030	–	160	95	150	480	40	–	–	20.0	0.8	0.8
TN 16ER190W:T8010	–	175	105	165	–	40	–	–	19.0	0.8	0.8
TN 16ER190W:T8030	–	160	95	150	480	40	–	–	19.0	0.8	0.8
TN 16ER180W:T8030	–	160	95	150	480	40	–	–	18.0	0.8	0.8
TN 16ER160W:T8030	–	160	95	150	480	40	–	–	16.0	0.8	0.8
TN 16ER140W:T8030	–	160	95	150	480	40	–	–	14.0	1.5	1.2
TN 16ER120W:T8030	–	160	95	150	480	40	–	–	12.0	1.5	1.2
TN 16ER110W:T8010	–	175	105	165	–	40	–	–	11.0	1.5	1.2
TN 16ER110W:T8030	–	160	95	150	480	40	–	–	11.0	1.5	1.2
TN 16ER100W:T8030	–	160	95	150	480	40	–	–	10.0	1.5	1.2
TN 16ER080W:T8030	–	160	95	150	480	40	–	–	8.0	1.5	1.2
TN 22ER070W:T8030	–	160	95	150	480	40	–	–	7.0	2.5	1.8
TN 22ER060W:T8030	–	160	95	150	480	40	–	–	6.0	2.5	1.8
TN 22ER050W:T8030	–	160	95	150	480	40	–	–	5.0	2.5	1.7
   **TN** W EL dış, sol kesme yönlü, Whitworth dişler için, darbesiz kesim.											
TN 16EL190W:T8030	–	160	95	150	480	40	–	–	19.0	0.8	0.8
TN 16EL140W:T8030	–	160	95	150	480	40	–	–	14.0	1.5	1.2
TN 16EL120W:T8030	–	160	95	150	480	40	–	–	12.0	1.5	1.2
TN 16EL110W:T8030	–	160	95	150	480	40	–	–	11.0	1.5	1.2
TN 16EL100W:T8030	–	160	95	150	480	40	–	–	10.0	1.5	1.2
TN 16EL080W:T8030	–	160	95	150	480	40	–	–	8.0	1.5	1.2

TN W INT

	IC (mm)	L (mm)	S (mm)
11	6.350	11.00	3.00
16	9.525	16.50	3.47
22	12.700	22.00	4.71



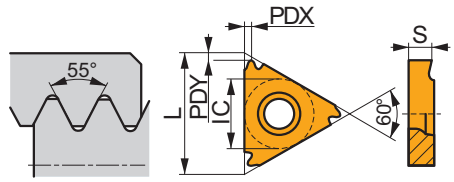
Kesme hızı (vc) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
   **TN** W NR iç, sağ kesme yönlü, Whitworth dişler için, darbesiz kesim.											
TN 11NR190W:T8030	–	160	95	150	480	40	–	–	19.0	0.8	0.8
TN 11NR140W:T8010	–	175	105	165	–	40	–	–	14.0	0.9	0.7
TN 11NR140W:T8030	–	160	95	150	480	40	–	–	14.0	0.9	0.7
TN 16NR280W:T8030	–	160	95	150	480	40	–	–	28.0	0.8	0.8
TN 16NR190W:T8010	–	175	105	165	–	40	–	–	19.0	0.8	0.8
TN 16NR190W:T8030	–	160	95	150	480	40	–	–	19.0	0.8	0.8
TN 16NR160W:T8030	–	160	95	150	480	40	–	–	16.0	0.8	0.8
TN 16NR140W:T8010	–	175	105	165	–	40	–	–	14.0	1.5	1.2
TN 16NR140W:T8030	–	160	95	150	480	40	–	–	14.0	1.5	1.2
TN 16NR120W:T8030	–	160	95	150	480	40	–	–	12.0	1.5	1.2
TN 16NR110W:T8010	–	175	105	165	–	40	–	–	11.0	1.5	1.2
TN 16NR110W:T8030	–	160	95	150	480	40	–	–	11.0	1.5	1.2
TN 16NR100W:T8030	–	160	95	150	480	40	–	–	10.0	1.5	1.2
TN 16NR090W:T8030	–	160	95	150	480	40	–	–	9.0	1.5	1.2
TN 16NR080W:T8030	–	160	95	150	480	40	–	–	8.0	1.5	1.2
TN 22NR060W:T8030	–	160	95	150	480	40	–	–	6.0	2.5	1.8
TN 22NR050W:T8030	–	160	95	150	480	40	–	–	5.0	2.5	1.7
   **TN** W NL iç, sol kesme yönlü, Whitworth dişler için, darbesiz kesim.											
TN 16NL140W:T8030	–	160	95	150	480	40	–	–	14.0	1.5	1.2
TN 16NL120W:T8030	–	160	95	150	480	40	–	–	12.0	1.5	1.2
TN 16NL110W:T8030	–	160	95	150	480	40	–	–	11.0	1.5	1.2
TN 16NL100W:T8030	–	160	95	150	480	40	–	–	10.0	1.5	1.2
TN 16NL080W:T8030	–	160	95	150	480	40	–	–	8.0	1.5	1.2

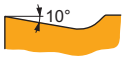
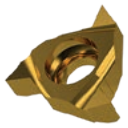
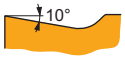
TN 55° PP EXT

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47
22	12.700	22.00	4.71



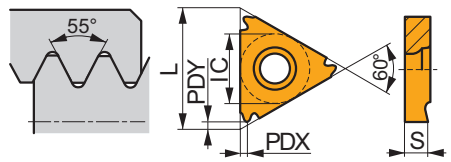
Kesme hızı (vc) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TPN (mm)	TPX (mm)	TPIN	TPIX	PDX (mm)	PDY (mm)
 		**TN** W ER dış, sağ kesme yönlü, Whitworth dişler için, darbesiz kesim.											
TN 16ERA55:T8030	–	160	95	150	480	40	–	0.50	1.50	16	48	0.8	0.6
TN 16ERAG55:T8010	–	175	105	165	–	40	–	0.50	3.00	8	48	1.5	1.1
TN 16ERAG55:T8030	–	160	95	150	480	40	–	0.50	3.00	8	48	1.5	1.1
TN 16ERG55:T8030	–	160	95	150	480	40	–	1.75	3.00	8	14	1.5	1.1
TN 22ERN55:T8010	–	175	105	165	–	40	–	3.50	5.00	5	7	2.5	1.8
TN 22ERN55:T8030	–	160	95	150	480	40	–	3.50	5.00	5	7	2.5	1.8
 		**TN** W55 PP EL dış, sol kesme yönlü, Whitworth dişler için, darbesiz kesim.											
TN 16ELAG55:T8030	–	160	95	150	480	40	–	0.50	3.00	8	48	1.5	1.1
TN 16ELG55:T8030	–	160	95	150	480	40	–	1.75	3.00	8	14	1.5	1.1
TN 22ELN55:T8030	–	160	95	150	480	40	–	3.50	5.00	5	7	2.5	1.8

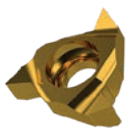
TN 55° PP INT

PRAMET

	IC (mm)	L (mm)	S (mm)
11	6.350	11.00	3.00
16	9.525	16.50	3.47
22	12.700	22.00	4.71



Kesme hızı (vc) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TPN (mm)	TPX (mm)	TPIN	TPIX	PDX (mm)	PDY (mm)
 		**TN** W NR iç, sol kesme yönlü, Whitworth dişler için, darbesiz kesim.											
TN 11NRA55:T8030	–	160	95	150	480	40	–	0.50	1.50	16	48	0.8	0.6
TN 16NRA55:T8030	–	160	95	150	480	40	–	0.50	1.50	16	48	0.8	0.6
TN 16NRAG55:T8010	–	175	105	165	–	40	–	0.50	3.00	8	48	1.5	1.1
TN 16NRAG55:T8030	–	160	95	150	480	40	–	0.50	3.00	8	48	1.5	1.1
TN 16NRG55:T8030	–	160	95	150	480	40	–	1.75	3.00	8	14	1.5	1.1
TN 22NRN55:T8030	–	160	95	150	480	40	–	3.50	5.00	5	7	2.5	1.8

Kesme hızı (vc) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P	M	K	N	S	H	TPN	TPX	TPIN	TPIX	PDX	PDY
			vc	vc	vc	vc	vc	vc						
		(mm)	(m/min)	(m/min)	(m/min)	(m/min)	(m/min)	(m/min)	(mm)	(mm)			(mm)	(mm)







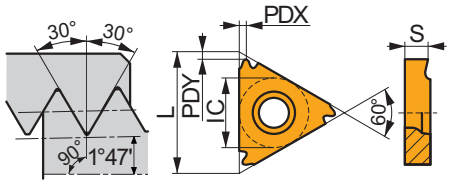
TN W NL iç, sol kesme yönlü, Whitworth dişler için, darbesiz kesim.

TN 11NLA55:T8030	●	–	■	160	■	95	■	150	◪	480	◪	40	–	0.50	1.50	16	48	0.8	0.6
TN 16NLA55:T8030	●	–	■	160	■	95	■	150	◪	480	◪	40	–	0.50	1.50	16	48	0.8	0.6
TN 16NLAG55:T8030	●	–	■	160	■	95	■	150	◪	480	◪	40	–	0.50	3.00	8	48	1.5	1.1
TN 16NLG55:T8030	●	–	■	160	■	95	■	150	◪	480	◪	40	–	1.75	3.00	8	14	1.5	1.1

TN NPT EXT

PRAMET

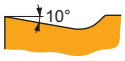
	IC	L	S
	(mm)	(mm)	(mm)
16	9.525	16.50	3.47



Kesme hızı (vc) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P	M	K	N	S	H	TP	TPI	PDX	PDY
			vc	vc	vc	vc	vc	vc				
		(mm)	(m/min)	(m/min)	(m/min)	(m/min)	(m/min)	(m/min)	(mm)		(mm)	(mm)





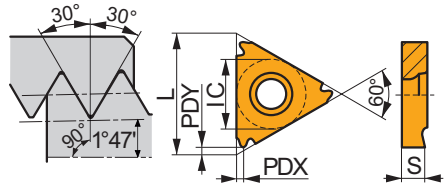


TN NPT ER dış, sağ kesme yönlü, NPT dişler için, darbesiz kesim.

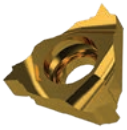
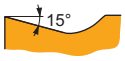
TN 16ER270NPT:T8030	●	–	■	160	■	95	■	150	◪	480	◪	40	–	–	27.0	0.8	0.7
TN 16ER180NPT:T8030	●	–	■	160	■	95	■	150	◪	480	◪	40	–	–	18.0	0.8	0.7
TN 16ER140NPT:T8030	●	–	■	160	■	95	■	150	◪	480	◪	40	–	–	14.0	1.5	1.1
TN 16ER115NPT:T8030	●	–	■	160	■	95	■	150	◪	480	◪	40	–	–	11.5	1.5	1.1
TN 16ER080NPT:T8030	●	–	■	160	■	95	■	150	◪	480	◪	40	–	–	8.0	1.6	1.1

TN NPT INT

	IC (mm)	L (mm)	S (mm)
11	6.350	11.00	3.00
16	9.525	16.50	3.47

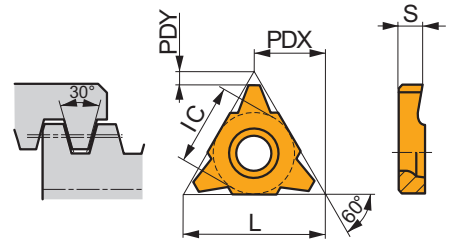


Kesme hızı (vc) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

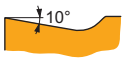
Product	RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
   **TN** NPT NR iç, sağ kesme yönlü, NPT dişler için, darbesiz kesim.											
TN 11NR180NPT:T8030	–	160	95	150	480	40	–	–	18.0	0.8	0.7
TN 11NR140NPT:T8030	–	160	95	150	480	40	–	–	14.0	1.0	0.7
TN 16NR140NPT:T8010	–	175	105	165	–	40	–	–	14.0	1.5	1.1
TN 16NR140NPT:T8030	–	160	95	150	480	40	–	–	14.0	1.5	1.1
TN 16NR115NPT:T8010	–	175	105	165	–	40	–	–	11.5	1.5	1.1
TN 16NR115NPT:T8030	–	160	95	150	480	40	–	–	11.5	1.5	1.1
TN 16NR080NPT:T8030	–	160	95	150	480	40	–	–	8.0	1.6	1.1

TN TR-S EXT

	IC (mm)	L (mm)	S (mm)
22	12.700	22.00	4.60

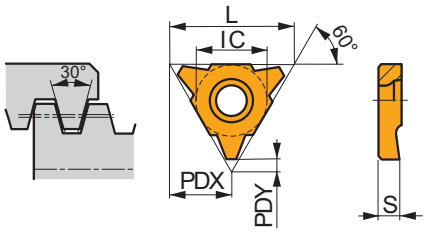


Kesme hızı (vc) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

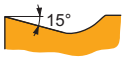
Product	RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
   **TN** TR-S PP iç, sol ve sağ kesme yönlü, Trapez dişler için, darbesiz kesim.											
TN 22EN600TR:T8030	–	160	95	150	480	40	–	6.00	–	11.0	1.9
TN 22EN700TR:T8030	–	160	95	150	480	40	–	7.00	–	11.0	2.3

TN TR-S INT

	IC (mm)	L (mm)	S (mm)
22	12.700	22.00	4.60



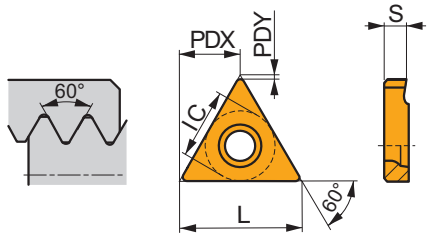
Kesme hızı (vc) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
												
TN 22NN600TR:T8030	●	–	160	95	150	480	40	–	6.00	–	11.0	1.9
TN 22NN700TR:T8030	●	–	160	95	150	480	40	–	7.00	–	11.0	1.9

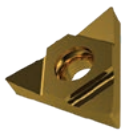
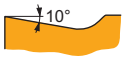
TN M60-S PP NN iç, sağ ve sol kesme yönlü, Metrik ve Birleşik dişler için, darbesiz kesim.

TN 60°-S PP EXT

	IC (mm)	L (mm)	S (mm)
22	12.700	22.00	4.60



Kesme hızı (vc) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

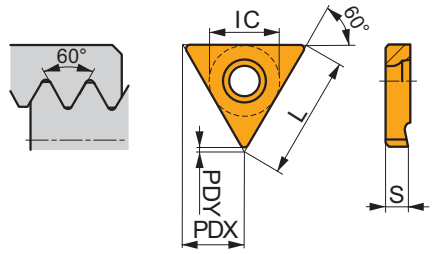
Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TPN (mm)	TPX (mm)	TPIN	TPIX	PDX (mm)	PDY (mm)
														
TN 22EN350-500M:T8030	●	–	160	95	150	480	40	–	3.50	5.00	5	7	11.0	0.5
TN 22EN550-800M:T8030	●	–	160	95	150	480	40	–	5.50	8.00	3	4.5	11.0	0.8

TN M60-S PP EN iç, sağ ve sol kesme yönlü, Metrik ve Birleşik dişler için, darbesiz kesim.

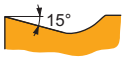
TN 60°-S PP INT

PRAMET

	IC (mm)	L (mm)	S (mm)
22	12.700	22.00	4.60



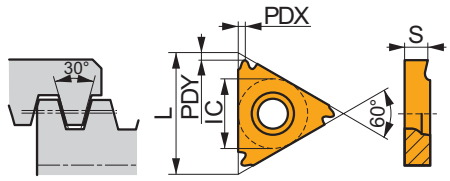
Kesme hızı (vc) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TPN (mm)	TPX (mm)	TPIN	TPIX	PDX (mm)	PDY (mm)
   **TN** M60-S PP NN iç, sağ ve sol kesme yönlü, Metrik ve Birleşik dişler için, darbesiz kesim.													
TN 22NN350-500M:T8030	–	160	95	150	480	40	–	3.50	5.00	5	7	11.0	0.2
TN 22NN550-800M:T8030	–	160	95	150	480	40	–	5.50	8.00	3	4.5	11.0	0.5

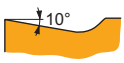
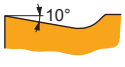
TN TR EXT

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47
22	12.700	22.00	4.71



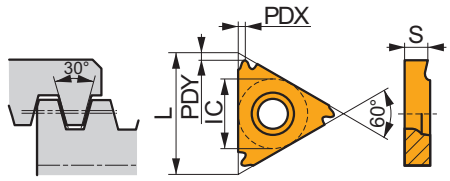
Kesme hızı (vc) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
   **TN** TR ER dış, sağ kesme yönlü, Trapez dişler için, darbesiz kesim.											
TN 16ER150TR:T8030	–	160	95	150	480	40	–	1.50	–	0.8	0.9
TN 16ER200TR:T8030	–	160	95	150	480	40	–	2.00	–	1.5	1.3
TN 16ER300TR:T8030	–	160	95	150	480	40	–	3.00	–	1.6	1.3
TN 22ER400TR:T8030	–	160	95	150	480	40	–	4.00	–	2.2	1.8
TN 22ER500TR:T8030	–	160	95	150	480	40	–	5.00	–	2.2	1.8
   **TN** TR EL dış, sol kesme yönlü, Trapez dişler için, darbesiz kesim.											
TN 16EL300TR:T8030	–	160	95	150	480	40	–	3.00	–	1.6	1.3
TN 22EL400TR:T8030	–	160	95	150	480	40	–	4.00	–	2.2	1.8
TN 22EL500TR:T8030	–	160	95	150	480	40	–	5.00	–	2.2	1.8

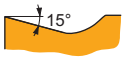
TN TR INT

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47
22	12.700	22.00	4.71



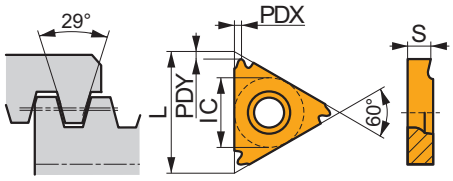
Kesme hızı (vc) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
			**TN** TR NR iç, sağ kesme yönlü, Trapez dişler için, darbesiz kesim.									
TN 16NR150TR:T8030	●	–	160	95	150	480	40	–	1.50	–	0.8	0.9
TN 16NR200TR:T8030	●	–	160	95	150	480	40	–	2.00	–	1.5	1.3
TN 16NR300TR:T8030	●	–	160	95	150	480	40	–	3.00	–	1.6	1.3
TN 22NR400TR:T8030	●	–	160	95	150	480	40	–	4.00	–	2.2	1.8
TN 22NR500TR:T8030	●	–	160	95	150	480	40	–	5.00	–	2.2	1.8
			**TN** TR NL iç, sol kesme yönlü, Trapez dişler için, darbesiz kesim.									
TN 16NL300TR:T8030	●	–	160	95	150	480	40	–	3.00	–	1.6	1.3

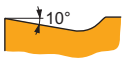
TN ACME EXT

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47
22	12.700	22.00	4.71

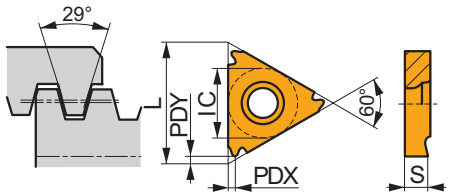


Kesme hızı (vc) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

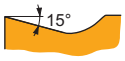
Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
			**TN** ACME ER dış, sağ kesme yönlü, ACME dişler için, darbesiz kesim.									
TN 16ER080ACME:T8030	●	–	160	95	150	480	40	–	–	8.0	1.5	1.3
TN 22ER060ACME:T8030	●	–	160	95	150	480	40	–	–	6.0	2.5	2.0
TN 22ER050ACME:T8030	●	–	160	95	150	480	40	–	–	5.0	2.3	2.0

TN ACME INT

	IC	L	S
	(mm)	(mm)	(mm)
22	12.700	22.00	4.71



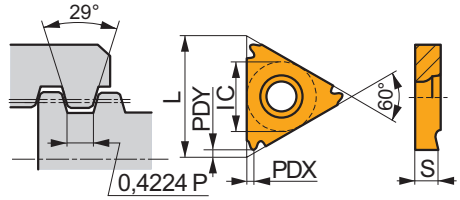
Kesme hızı (vc) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P	M	K	N	S	H	TP	TPI	PDX	PDY
			vc	vc	vc	vc	vc	vc				
		(mm)	(m/min)	(m/min)	(m/min)	(m/min)	(m/min)	(m/min)	(mm)		(mm)	(mm)
												
TN 22NR060ACME:T8030	●	–	160	95	150	480	40	–	–	6.0	2.5	2.0

TN ACME NR iç, sağ kesme yönlü, ACME dişler için, darbesiz kesim.

TN STACME INT

	IC	L	S
	(mm)	(mm)	(mm)
16	9.525	16.50	3.47



Kesme hızı (vc) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P	M	K	N	S	H	TP	TPI	PDX	PDY
			vc	vc	vc	vc	vc	vc				
		(mm)	(m/min)	(m/min)	(m/min)	(m/min)	(m/min)	(m/min)	(mm)		(mm)	(mm)
												
TN 16NR060STACME:T8030[1)]	●	–	160	95	150	480	40	–	–	6.0	1.3	1.3

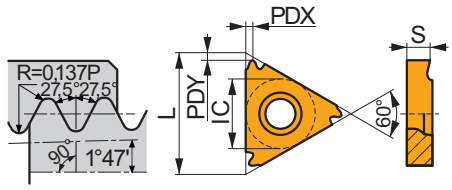
TN STACME NR iç, ağ kesme yönlü, STACME dişler için, darbesiz kesim.

[1)] Toolholders have to be modified.

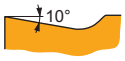
TN BSPT EXT

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47



Kesme hızı (vc) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

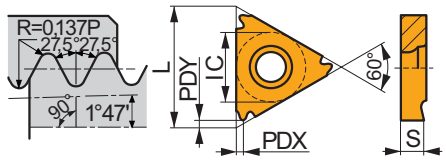
Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
												
TN 16ER190BSPT:T8030	●	–	160	95	150	480	40	–	–	19.0	1.5	1.2
TN 16ER140BSPT:T8030	●	–	160	95	150	480	40	–	–	14.0	1.5	1.2
TN 16ER110BSPT:T8030	●	–	160	95	150	480	40	–	–	11.0	1.5	1.2

TN BSPT ER dış, sağ kesme yönlü, BSPT dişler için, darbesiz kesim.

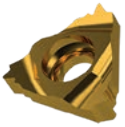
TN BSPT INT

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47



Kesme hızı (vc) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

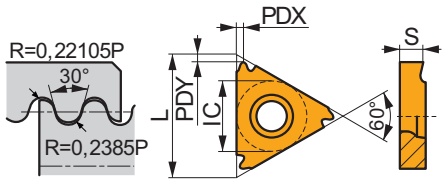
Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
												
TN 16NR140BSPT:T8030	●	–	160	95	150	480	40	–	–	14.0	1.5	1.2
TN 16NR110BSPT:T8030	●	–	160	95	150	480	40	–	–	11.0	1.5	1.2

TN BSPT NR iç, sağ kesme yönlü, BSPT dişler için, darbesiz kesim.

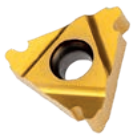
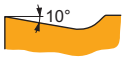
TN RD EXT

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47
22	12.700	22.00	4.71



Kesme hızı (vc) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
												
TN 16ER080RD:T8030	●	–	160	95	150	480	40	–	–	8.0	1.5	1.2
TN 16ER060RD:T8030[1)]	●	–	160	95	150	480	40	–	–	6.0	1.5	1.2
TN 22ER060RD:T8030	●	–	160	95	150	480	40	–	–	6.0	2.5	1.8

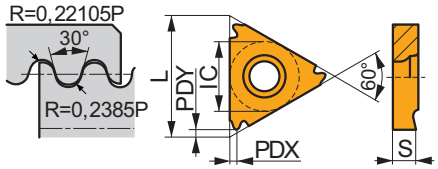
TN RD ER dış, sağ kesme yönlü, Metrik Dairesel dişler için, darbesiz kesim.

[1)] Toolholders have to be modified.

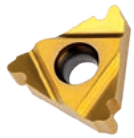
TN RD INT

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47
22	12.700	22.00	4.71



Kesme hızı (vc) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
												
TN 16NR080RD:T8030	●	–	160	95	150	480	40	–	–	8.0	1.5	1.2
TN 16NR060RD:T8030[1)]	●	–	160	95	150	480	40	–	–	6.0	1.5	1.2
TN 22NR060RD:T8030	●	–	160	95	150	480	40	–	–	6.0	2.5	1.8

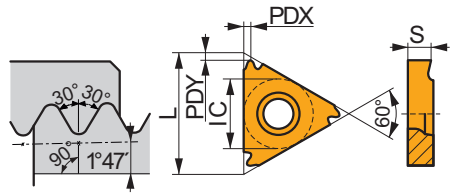
TN RD NR iç, sol kesme yönlü, Metrik Dairesel dişler için, darbesiz kesim.

[1)] Toolholders have to be modified.

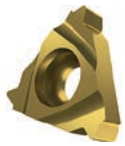
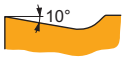
TN API RD EXT

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47



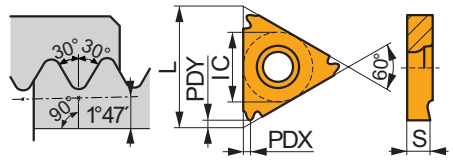
Kesme hızı (vc) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
												
TN API ER dış, sağ kesme yönlü, API dişler için, darbesiz kesim.												
TN 16ER100API-RD01:T8030	●	–	160	95	150	480	40	–	–	10.0	1.5	1.2
TN 16ER080API-RD01:T8030	●	–	160	95	150	480	40	–	–	8.0	1.5	1.2

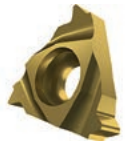
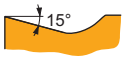
TN API RD INT

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47

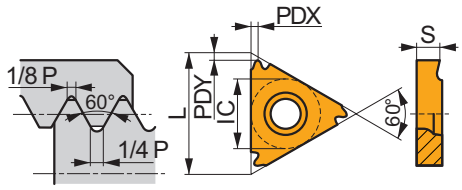


Kesme hızı (vc) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

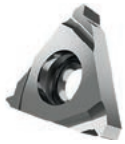
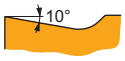
Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
												
TN API NR iç, sağ kesme yönlü, API dişler için, darbesiz kesim.												
TN 16NR100API-RD01:T8030	●	–	160	95	150	480	40	–	–	10.0	1.5	1.2
TN 16NR080API-RD01:T8030	●	–	160	95	150	480	40	–	–	8.0	1.5	1.2

TN M EXT

	IC	L	S
	(mm)	(mm)	(mm)
16	9.525	16.50	3.47



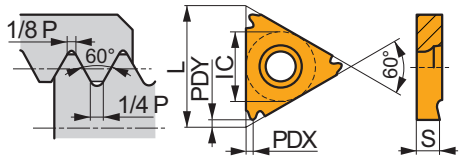
Kesme hızı (vc) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P	M	K	N	S	H	TP	TPI	PDX	PDY
			vc	vc	vc	vc	vc	vc				
		(mm)	(m/min)	(m/min)	(m/min)	(m/min)	(m/min)	(m/min)	(mm)		(mm)	(mm)
												
TN 16ER100M-AL:HF7	●	–	–	◪ 95	–	■ 480	–	–	1.00	–	0.8	0.8
TN 16ER125M-AL:HF7	●	–	–	◪ 95	–	■ 480	–	–	1.25	–	0.8	0.8
TN 16ER150M-AL:HF7	●	–	–	◪ 95	–	■ 480	–	–	1.50	–	0.8	0.8
TN 16ER200M-AL:HF7	●	–	–	◪ 95	–	■ 480	–	–	2.00	–	1.5	1.2

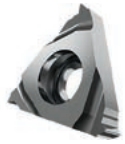
TN M-AL ER dış, sağ kesme yönlü, ISO Metrik dişler için, darbesiz kesim.

TN M INT

	IC	L	S
	(mm)	(mm)	(mm)
16	9.525	16.50	3.47



Kesme hızı (vc) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product		RE	P	M	K	N	S	H	TP	TPI	PDX	PDY
			vc	vc	vc	vc	vc	vc				
		(mm)	(m/min)	(m/min)	(m/min)	(m/min)	(m/min)	(m/min)	(mm)		(mm)	(mm)
												
TN 16NR150M-AL:HF7	●	–	–	◪ 95	–	■ 480	–	–	1.50	–	0.8	0.8
TN 16NR200M-AL:HF7	●	–	–	◪ 95	–	■ 480	–	–	2.00	–	1.5	1.2

TN M-AL NR iç, sağ kesme yönlü, ISO Metrik dişler için, darbesiz kesim.

SE(RL)

P M K N S H

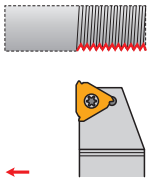
PRAMET

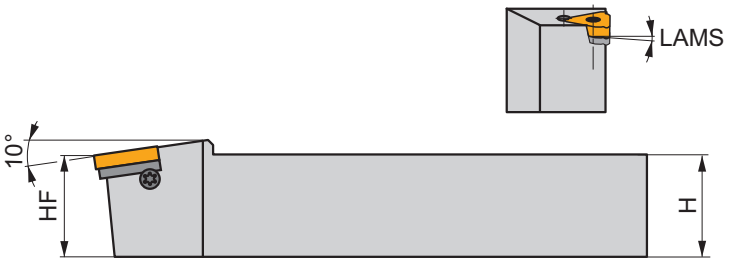
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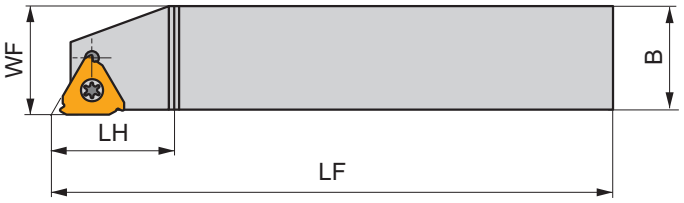


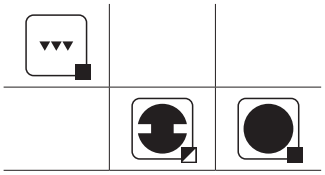
TN 16, 22 veya 27 Kesici Uç için Vida Sıkmalı Diş Açma Kateri

TN 16, 22 veya 27 ER/EL uçlar için Sağ/Sol yönlü vida sıkmalı dış çap diş açma kateri. Metrik veya inç profilde diş açma için uygundur. TN 16 ve 22, sığ kanal açma için de uygundur. Gövde uzun takım ömrü için işlem görmüştür.











	Product	H (mm)	HF (mm)	B (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)		
R	**SER 2020 K 16**	20	20	20	20	125	22.5	–	GI068	Z12
	SER 2525 M 16	25	25	25	25	150	24.0	–	GI068	Z12
	SER 3225 P 16	32	32	25	25	170	24.5	–	GI068	Z12
	SER 2525 M 22-A	25	25	25	25	150	25.5	–	GI071	Z13
	SER 3225 P 22-A	32	32	25	25	170	25.5	–	GI071	Z13
L	**SEL 2020 K 16**	20	20	20	20	125	22.5	–	GI068	Z12
	SEL 2525 M 16	25	25	25	25	150	24.0	–	GI068	Z12
	SEL 2525 M 22-A	25	25	25	25	150	25.5	–	GI071	Z13

GI068	TN 16ER..	TN 16EL..
GI071	TN 22ER..	TN 22EL..

		Nm							
Z12	US 3512A-T15P	3.0	M 3.5	12.7	–	HS 0304	FLAG T15P	HXK 2.5	Page xx
Z13	US 4514A-T20	5.0	M 4.5	14	SP 0405	–	FLAG T20	–	Page xx

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P M K N S H

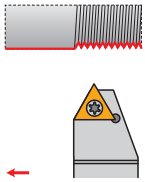
PRAMET

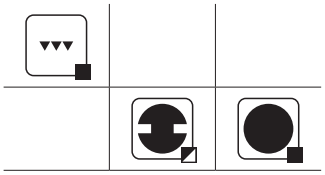
S

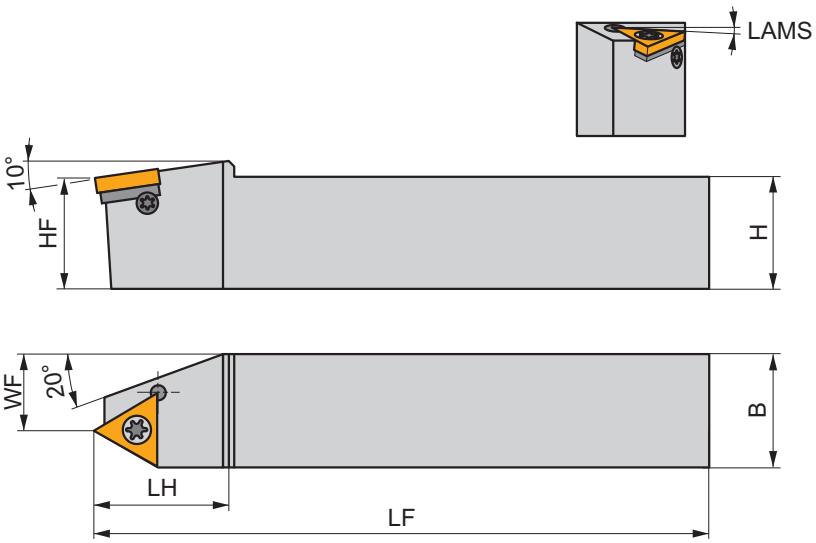


TN 22 veya 27 Kesici Uç için Vida Sıkmalı Diş Açma Kateri

TN 22 veya 27 EN uçlar için Sağ/Sol yönlü vida sıkmalı dış çap diş açma kateri. Metrik veya inç profilde diş açma için uygundur. Gövde uzun takım ömrü için işlem görmüştür.







	Product	H	HF	B	WF	LF	LH	LAMS		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)		
R	SER-S 2525 M 22-A	25	25	25	14	150	30.0	–	GI086	Z15
	SER-S 3225 P 22-A	32	32	25	14	170	30.0	–	GI086	Z15
L	SEL-S 2525 M 22-A	25	25	25	14	150	30.0	–	GI086	Z15

GI086	TN 22EN..

Z15	US 4514A-T20	5.0 Nm	M 4.5	14	SP 0405	FLAG T20	Page xx

SI(RL)

P M K N S H

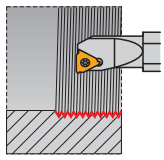
PRAMET

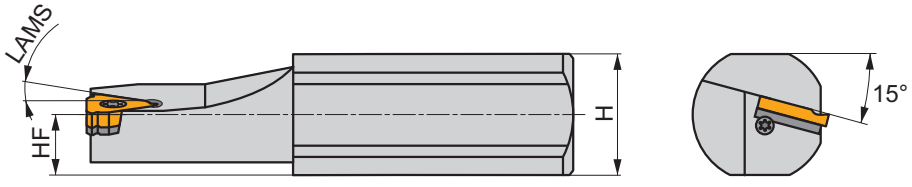
S

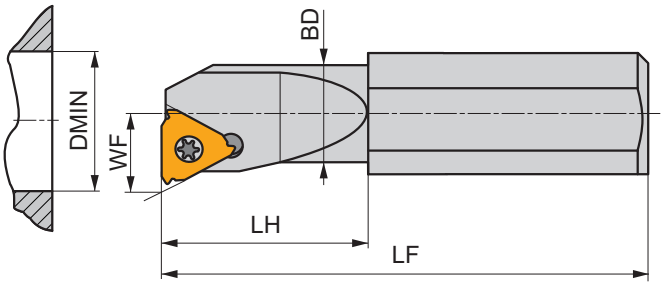


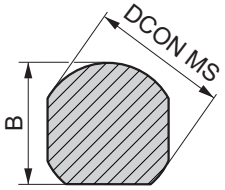
TN 11, 16, 22 veya 27 Kesici Uç için Vida Sıkmalı Diş Açma Delik Kateri

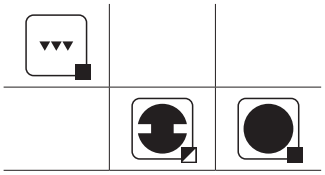
TN NR/NL uçlar için Sağ/Sol yönlü vida sıkmalı diş açma delik kateri. Metrik veya inç profilde diş açma için uygundur. . Gövde uzun takım ömrü için işlem görmüştür.













	Product	B	DCON MS	DMIN	BD	WF	H	HF	LF	LH	LAMS			
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)			
R	SIR 0010 K 11-0	14.5	16	13	10	7.45	14	7	125	25.0	0	–	GI085	Z11
	SIR 0010 K 11-1	14.5	16	13	10	7.45	14	7	125	25.0	1	–	GI085	Z11
	SIR 0013 M 11-0	14.5	16	16	13	9	14	7	150	32.0	0	–	GI085	Z11
	SIR 0013 M 11-1	14.5	16	16	13	9	14	7	150	32.0	1	–	GI085	Z11
	SIR 1416 N 16-0	14	16	22	17	11.4	14.5	7.25	160	–	0	–	GI022	Z9
	SIR 1416 N 16-1	14	16	22	17	11.4	14.5	7.25	160	–	1	–	GI022	Z9
	SIR 1416 N 16-2	14	16	16.5	15.5	10.6	14.5	7.25	160	40.0	2	✓	GI022	Z10
	SIR 1820 P 16	18.5	20	27	21	13.85	18	9	170	–	–	–	GI022	Z12
	SIR 2325 Q 16	23.5	25	29	26	16.55	23	11.5	180	–	–	–	GI022	Z12
	SIR 2532 S 16	30	32	36	32	19.75	25	12.5	250	–	–	–	GI022	Z12
	SIR 2532 S 22-2	30	32	25	25	16.65	25	12.5	250	80.0	2	✓	GI076	Z14
	SIR 2532 S 22-A	30	32	36	32	21.65	25	12.5	250	–	–	–	GI076	Z13
	SIR 3240 T 22-A	38	40	48	40	25.85	32	16	300	–	–	–	GI076	Z13
L	SIL 0010 K 11-0	14.5	16	13	10	7.45	14	7	125	25.0	0	–	GI085	Z11
	SIL 0010 K 11-1	14.5	16	13	10	7.45	14	7	125	25.0	1	–	GI085	Z11
	SIL 0013 M 11-1	14.5	16	16	13	9	14	7	150	32.0	1	–	GI085	Z11
	SIL 1416 N 16-0	14	16	22	17	11.4	14.5	7.25	160	–	0	–	GI022	Z9
	SIL 1416 N 16-1	14	16	22	17	11.4	14.5	7.25	160	–	1	–	GI022	Z9
	SIL 1416 N 16-2	14	16	16.5	15.5	10.6	14.5	7.25	160	40.0	2	✓	GI022	Z10
	SIL 1820 P 16	18.5	20	24	21	13.85	18	9	170	–	–	–	GI022	Z12
	SIL 2325 Q 16	23.5	25	29	26	16.55	23	11.5	180	–	–	–	GI022	Z12
	SIL 2532 S 16	30	32	36	32	19.75	25	12.5	250	–	–	–	GI022	Z12
	SIL 2532 S 22-2	30	32	25	25	16.65	25	12.5	250	80.0	2	✓	GI076	Z14

GI022	TN 16NR..	TN 16NL..

GI076	TN 22NR..	TN 22NL..
GI085	TN 11NR..	TN 11NL..

		Nm							
Z10	US 3510A-T15P	3.0	M 3.5	10.6	–	–	FLAG T15P	–	–
Z11	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–	–
Z12	US 3512A-T15P	3.0	M 3.5	12.7	–	HS 0304	FLAG T15P	HXK 2.5	Page xx
Z13	US 4514A-T20	5.0	M 4.5	14	SP 0405	–	FLAG T20	–	Page xx
Z14	US 4514A-T20	5.0	M 4.5	14	–	–	FLAG T20	–	–
Z9	US 3510A-T15P	3.0	M 3.5	10.6	–	–	FLAG T15P	–	P-16

SI(RL)-S

P M K N S H

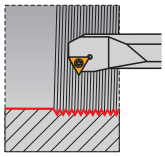
PRAMET

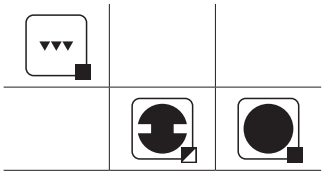
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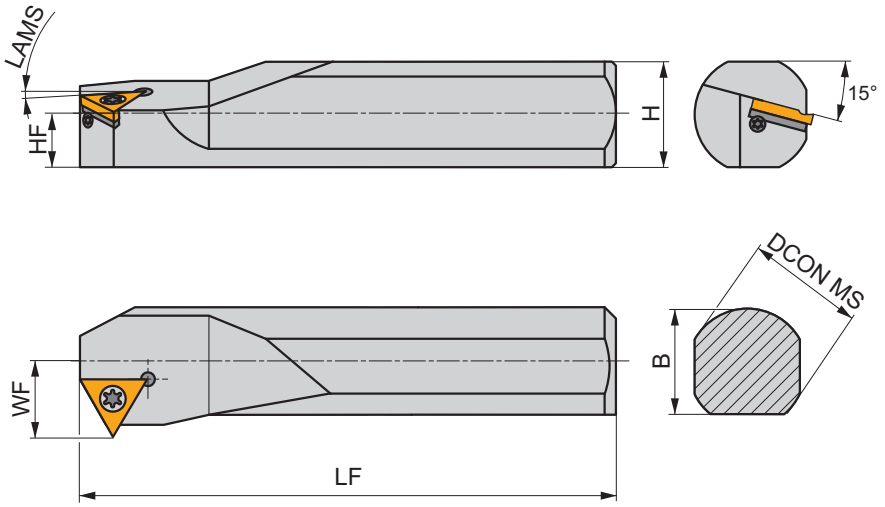


TN 22 veya 27 Kesici Uç için Vida Sıkmalı Diş Açma Delik Kateri

TN NN uçlar için Sağ/Sol yönlü vida sıkmalı diş açma delik kateri. Metrik veya inç profilde diş açma için uygundur. Gövde uzun takım ömrü için işlem görmüştür.









	Product	B	DCON MS	DMIN	WF	H	HF	LF	LAMS		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)		
R	SIR-S 2532 S 22-A	30	32	39	22.3	25	12.5	250	–	GI107	Z15
	SIR-S 3240 T 22-A	38	40	48	27	32	16	300	–	GI107	Z15

GI107	TN 22NN..

Nm							
Z15	US 4514A-T20	5.0	M 4.5	14	SP 0405	FLAG T20	Page xx



BROŞLAMA & TORNA KALEMLERİ

PHZ

P M K N S H

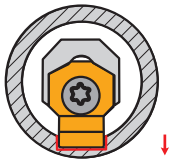
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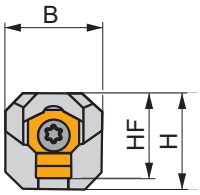
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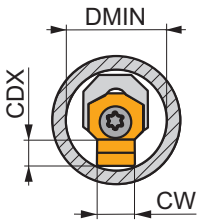


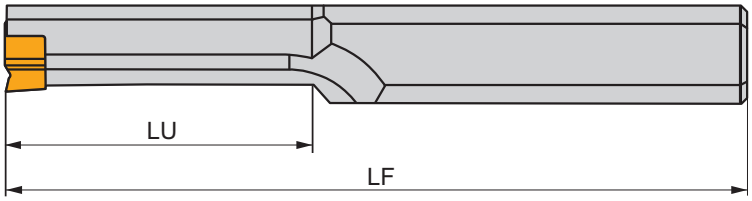
Tek Taraflı HZ Uçlar için Küçük Çap Delik Broş Kateri

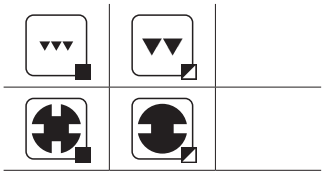
12mm genişliğe kadar broşlama için delik kateri. Gövde uzun takım ömrü için işlem görmüştür.













	Product	H (mm)	HF (mm)	B (mm)	OAL (mm)	LU (mm)	CW (mm)	DMIN (mm)	CDX (mm)	kg		
N	**PHZ 90 1104-06**	11.3	9	8.5	160	35	3.00	9.5	1.6	0.14	GI239	SH21
	PHZ 90 1107-06	11.3	10	7	200	60	–	–	–	0.19	GI240	SH21
	PHZ 90 1111-06	11.3	12	–	200	60	–	–	–	0.21	GI240	SH21
	PHZ 1512-10	15.5	16.2	–	220	–	–	–	–	0.33	GI224	SH22
	PHZ 2014-13	20.6	21.5	–	250	–	–	–	–	0.58	GI225	SH23

GI224	HZ 1006-60	HZ 1006-80
GI225	HZ 1309-100	HZ 1309-120
GI239	HZ90 0604-30	–
GI240	HZ90 0604-40	HZ90 0604-50

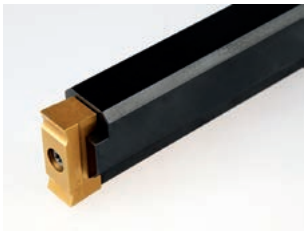
SH21	DVF 3593	0.8	M 2.5	10	TX207PLUS
SH22	DVF 2260	3.6	M 4	15	TX215PLUS
SH23	5513 020-14	8.5	M 6	18	TX225PLUS

PHZ-2

P M K N S H

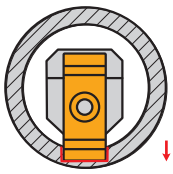
PRAMET

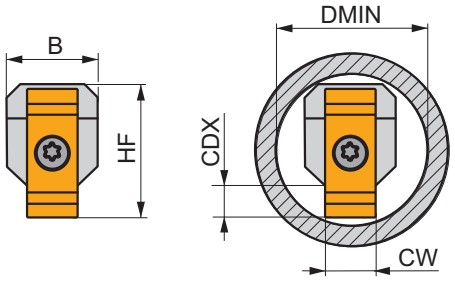
S

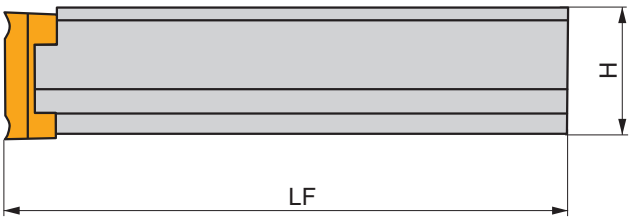


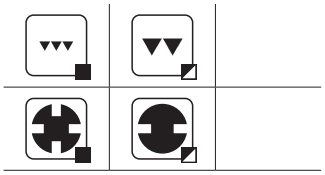
Çift Taraflı HZ Uçlar için Büyük Çap Delik Broş Kateri

20mm genişliğe kadar broşlama için delik kateri. Gövde uzun takım ömrü için işlem görmüştür.











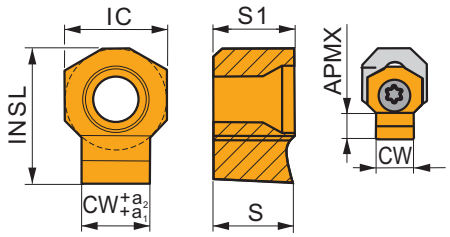
	Product	H (mm)	HF (mm)	B (mm)	OAL (mm)	CW (mm)	DMIN (mm)	CDX (mm)	kg		
N	**PHZ/2 3625-14**	36	37.5	25	300	–	44	–	1.84	GI235	SH23
	PHZ/2 4832-18	48	50	32	400	–	58	–	2.00	GI241	SH24

GI235	HZ/2 14-14	HZ/2 16-16
GI241	HZ/2 18-18	HZ/2 20-20

		Nm			
SH23	5513 020-14	8.5	M 6	18	TX225PLUS
SH24	5513 021-03	13.0	M 8	22	DMN 3124

HZ

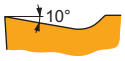
	CW	INSL	APMX	S	S1
	(mm)	(mm)	(mm)	(mm)	(mm)
0604-30	3.00	7.5	1.60	4.66	4.76
0604-40	4.00	8.0	2.50	4.66	4.76
0604-50	5.00	8.0	3.00	4.66	4.76
1006-60	6.00	13.5	4.20	6.25	6.35
1006-80	8.00	13.5	5.20	6.25	6.35
1309-100	10.00	18.5	6.20	9.40	9.53
1309-120	12.00	18.5	7.20	9.40	9.53



Kesme hızı (vc), ilerleme (fz) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	Interrupted/ Continuous cut	RE	P		M		K		N		S		H		CW	CWTOLL	CWTOLU
			vc	f	vc	f	vc	f	vc	f	vc	f	vc	f			
		(mm)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(mm)	(mm)	(mm)



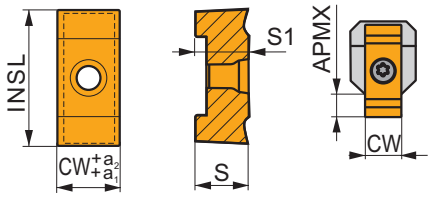


HZ broşlama için uygun pozitif geometri (tek kesme ağızı).

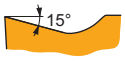
HZ 1006-60 C11:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10	–	–	–	–	–	–	6.00	0.07	0.14
HZ 1006-60 D10:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10	–	–	–	–	–	–	6.00	0.03	0.08
HZ 1006-60 H7:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10	–	–	–	–	–	–	6.00	0.00	0.01
HZ 1006-60 P9:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10	–	–	–	–	–	–	6.00	-0.04	-0.01
HZ 1006-80 C11:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10	–	–	–	–	–	–	8.00	0.08	0.17
HZ 1006-80 D10:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10	–	–	–	–	–	–	8.00	0.04	0.10
HZ 1006-80 H7:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10	–	–	–	–	–	–	8.00	0.00	0.01
HZ 1006-80 P9:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10	–	–	–	–	–	–	8.00	-0.05	-0.01
HZ 1309-100 C11:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10	–	–	–	–	–	–	10.00	0.08	0.17
HZ 1309-100 D10:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10	–	–	–	–	–	–	10.00	0.04	0.10
HZ 1309-100 H7:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10	–	–	–	–	–	–	10.00	0.00	0.01
HZ 1309-100 P9:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10	–	–	–	–	–	–	10.00	-0.05	-0.01
HZ 1309-120 C11:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10	–	–	–	–	–	–	12.00	0.10	0.20
HZ 1309-120 D10:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10	–	–	–	–	–	–	12.00	0.05	0.12
HZ 1309-120 H7:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10	–	–	–	–	–	–	12.00	0.00	0.02
HZ 1309-120 P9:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10	–	–	–	–	–	–	12.00	-0.06	-0.02
HZ90 0604-30 C11:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10	–	–	–	–	–	–	3.00	0.06	0.12
HZ90 0604-30 D10:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10	–	–	–	–	–	–	3.00	0.02	0.06
HZ90 0604-30 H7:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10	–	–	–	–	–	–	3.00	0.00	0.01
HZ90 0604-30 P9:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10	–	–	–	–	–	–	3.00	-0.03	-0.01
HZ90 0604-40 C11:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10	–	–	–	–	–	–	4.00	0.07	0.14
HZ90 0604-40 D10:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10	–	–	–	–	–	–	4.00	0.03	0.08
HZ90 0604-40 H7:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10	–	–	–	–	–	–	4.00	0.00	0.01
HZ90 0604-40 P9:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10	–	–	–	–	–	–	4.00	-0.04	-0.01
HZ90 0604-50 C11:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10	–	–	–	–	–	–	5.00	0.07	0.14
HZ90 0604-50 D10:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10	–	–	–	–	–	–	5.00	0.03	0.08
HZ90 0604-50 H7:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10	–	–	–	–	–	–	5.00	0.00	0.01
HZ90 0604-50 P9:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10	–	–	–	–	–	–	5.00	-0.04	-0.01

HZ-2

	INSL	APMX	S	S1	CW
	(mm)	(mm)	(mm)	(mm)	(mm)
14-14	36.0	8.00	13.90	14.00	14.00
16-16	36.0	9.00	13.90	14.00	16.00
18-18	45.0	12.00	15.90	16.00	18.00
20-20	45.0	13.00	15.90	16.00	20.00



Kesme hızı (vc), ilerleme (fz) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

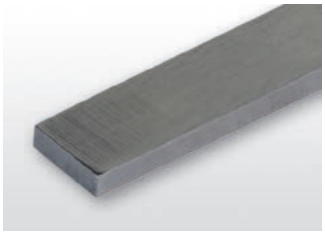
Product	Interrupted/ Continuous cut	RE	P		M		K		N		S		H		CW	CWTOLL	CWTOLU
			vc	f	vc	f	vc	f	vc	f	vc	f	vc	f			
		(mm)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(mm)	(mm)	(mm)
																	

HZ-2 broşlama için uygun pozitif geometri (çift kesme ağızı).

HZ/2 14-14 C11:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10	–	–	–	–	–	–	14.00	0.10	0.20
HZ/2 14-14 H7:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10	–	–	–	–	–	–	14.00	0.00	0.02
HZ/2 14-14 P9:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10	–	–	–	–	–	–	14.00	-0.06	-0.02
HZ/2 16-16 C11:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10	–	–	–	–	–	–	16.00	0.10	0.20
HZ/2 16-16 H7:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10	–	–	–	–	–	–	16.00	0.00	0.02
HZ/2 16-16 P9:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10	–	–	–	–	–	–	16.00	-0.06	-0.02
HZ/2 18-18 C11:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10	–	–	–	–	–	–	18.00	0.10	0.20
HZ/2 18-18 H7:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10	–	–	–	–	–	–	18.00	0.00	0.02
HZ/2 18-18 P9:333TN	✱	–	■	50	0.10	◪	30	0.10	◪	45	0.10	–	–	–	–	–	–	18.00	-0.06	-0.02
HZ/2 20-20 C11:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10	–	–	–	–	–	–	20.00	0.11	0.24
HZ/2 20-20 H7:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10	–	–	–	–	–	–	20.00	0.00	0.02
HZ/2 20-20 P9:333TN	✱	–	■	50	0.10	◪	30	0.10	◪	45	0.10	–	–	–	–	–	–	20.00	-0.07	-0.02

TOOL BITS F

DORMER



HSS-E Dikdörtgen Takım ucu

DIN 4964 D standardına göre taşlanmış dikdörtgen takım ucu. 65-67 HRC sertliğinde %10 Kobalt içerikli T2000S HSS-E parlak çelik.



HSS-E	DIN 4964D	Bright
h13		

Product	H (mm)	B (mm)	OAL (mm)
8X6X200:T2000S	8	6	200.0
10X2X200:T2000S	10	2	200.0
10X3X200:T2000S	10	3	200.0
10X4X200:T2000S	10	4	200.0
10X5X200:T2000S	10	5	200.0
10X6X200:T2000S	10	6	200.0
10X8X200:T2000S	10	8	200.0
12X3X200:T2000S	12	3	200.0
12X4X200:T2000S	12	4	200.0
12X6X200:T2000S	12	6	200.0
12X8X200:T2000S	12	8	200.0
15X3X200:T2000S	15	3	200.0
15X4X200:T2000S	15	4	200.0
15X5X200:T2000S	15	5	200.0
15X6X200:T2000S	15	6	200.0
15X8X200:T2000S	15	8	200.0
15X10X200:T2000S	15	10	200.0
16X8X200:T2000S	16	8	200.0
16X10X200:T2000S	16	10	200.0

Product	H (mm)	B (mm)	OAL (mm)
16X12X200:T2000S	16	12	200.0
20X3X200:T2000S	20	3	200.0
20X4X200:T2000S	20	4	200.0
20X5X200:T2000S	20	5	200.0
20X6X200:T2000S	20	6	200.0
20X8X200:T2000S	20	8	200.0
20X10X200:T2000S	20	10	200.0
20X12X200:T2000S	20	12	200.0
20X15X200:T2000S	20	15	200.0
25X5X200:T2000S	25	5	200.0
25X6X200:T2000S	25	6	200.0
25X10X200:T2000S	25	10	200.0
25X12X200:T2000S	25	12	200.0
30X4X200:T2000S	30	4	200.0
30X5X200:T2000S	30	5	200.0
30X10X200:T2000S	30	10	200.0
30X15X200:T2000S	30	15	200.0
30X20X200:T2000S	30	20	200.0

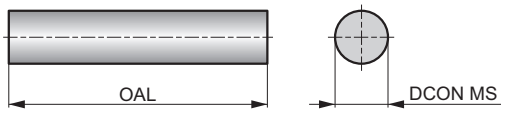
TOOL BITS R

DORMER



HSS-E Yuvarlak Takım ucu

DIN 4964 A standardına göre taşlanmış yuvarlak takım ucu. 65-67 HRC sertliğinde %10 Kobalt içerikli T2000S HSS-E parlak çelik.



HSS-E	DIN 4964A	Bright
h9		

Product	DCON MS (mm)	OAL (mm)
3X200 T:T2000S	3.00	200.0
4X200 T:T2000S	4.00	200.0
5X200 T:T2000S	5.00	200.0
6X200 T:T2000S	6.00	200.0
7X200 T:T2000S	7.00	200.0
8X200 T:T2000S	8.00	200.0
10X200 T:T2000S	10.00	200.0
12X200 T:T2000S	12.00	200.0
14X200 T:T2000S	14.00	200.0
16X200 T:T2000S	16.00	200.0
20X200 T:T2000S	20.00	200.0

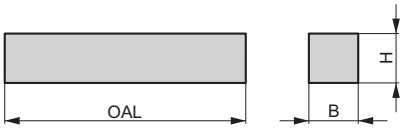
TOOL BITS S

DORMER



HSS-E Kare Takım ucu

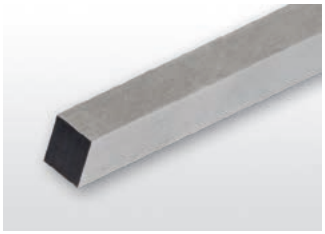
DIN 4964 B standardına göre taşlanmış kare takım ucu. 65-67 HRC sertliğinde %10 Kobalt içerikli T2000S HSS-E parlak çelik.



HSS-E	DIN 4964B	Bright
+0 -0.1		

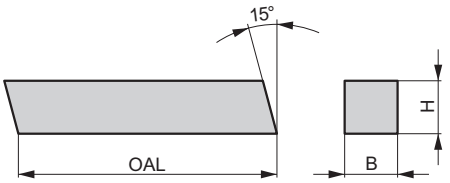
Product	H (mm)	B (mm)	OAL (mm)
4X4X200:T2000S	4	4	200.0
6X6X200:T2000S	6	6	200.0
8X8X200:T2000S	8	8	200.0
10X10X200:T2000S	10	10	200.0
12X12X200:T2000S	12	12	200.0
14X14X200:T2000S	14	14	200.0
15X15X200:T2000S	15	15	200.0
16X16X200:T2000S	16	16	200.0
20X20X200:T2000S	20	20	200.0
25X25X200:T2000S	25	25	200.0

DORMER



HSS-E Eğimli Kare Takım ucu

DIN 4964 B standardına göre eğimli uçlara sahip taşlanmış kare takım ucu. 65-67 HRC sertliğinde %10 Kobalt içerikli T2000S HSS-E parlak çelik.



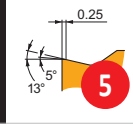
HSS-E	DIN 4964B	Bright
h13		

Product	H (mm)	B (mm)	OAL (mm)	H (inch)	B (inch)	OAL (inch)
4X4X200A:T2000S	4	4	200.0	–	–	–
6X6X100A:T2000S	6	6	100.0	–	–	–
6X6X200A:T2000S	6	6	200.0	–	–	–
8X8X100A:T2000S	8	8	100.0	–	–	–
8X8X160A:T2000S	8	8	160.0	–	–	–
8X8X200A:T2000S	8	8	200.0	–	–	–
10X10X100A:T2000S	10	10	100.0	–	–	–
10X10X160A:T2000S	10	10	160.0	–	–	–
10X10X200A:T2000S	10	10	200.0	–	–	–
12X12X100A:T2000S	12	12	100.0	–	–	–
12X12X200A:T2000S	12	12	200.0	–	–	–
14X14X200A:T2000S	14	14	200.0	–	–	–
15X15X200A:T2000S	15	15	200.0	–	–	–
16X16X200A:T2000S	16	16	200.0	–	–	–
20X20X200A:T2000S	20	20	200.0	–	–	–
25X25X200A:T2000S	25	25	200.0	–	–	–
3/16X3/16X2.1/2A:T2000S	–	–	–	3/16	3/16	2.500
1/4X1/4X2.1/2A:T2000S	–	–	–	1/4	1/4	2.500
1/4X1/4X4A:T2000S	–	–	–	1/4	1/4	4.000
5/16X5/16X2.1/2A:T2000S	–	–	–	5/16	5/16	2.500
5/16X5/16X4A:T2000S	–	–	–	5/16	5/16	4.000
3/8X3/8X3A:T2000S	–	–	–	3/8	3/8	3.000
3/8X3/8X4A:T2000S	–	–	–	3/8	3/8	4.000
3/8X3/8X6A:T2000S	–	–	–	3/8	3/8	6.000
1/2X1/2X4A:T2000S	–	–	–	1/2	1/2	4.000
1/2X1/2X6A:T2000S	–	–	–	1/2	1/2	6.000
5/8X5/8X6A:T2000S	–	–	–	5/8	5/8	6.000



AÇIKLAMALAR

SM





SM talaş kırıcı çok yönlüdür ve Çeliklerin ve Süper alaşımların orta düzeyde işlenmesi için ilk tercihtir. Hafif pozitif eğim açısı ve dengeli, ılımlı T-land özelliğine sahiptir. Ayrıca Paslanmaz çelikler, Dökme demirler ve şartlara bağlı olarak Demir dışı alaşımlar ve Sert malzemeler için de uygundur.

10

PRAMET

1

CNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.1	12.90	4.76
1606	15.875	6.35	16.10	6.35
1906	19.050	7.94	19.30	6.35

3

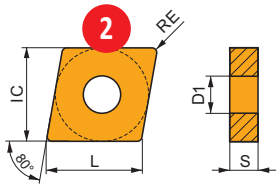
DNMG

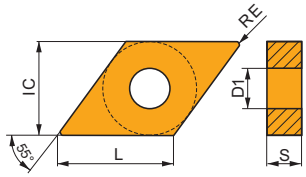
	IC (mm)	D1 (mm)	L (mm)	S (mm)
1104	9.525	3.81	11.60	4.76
1504	12.700	5.16	15.50	4.76
1506	12.700	5.16	15.50	6.35

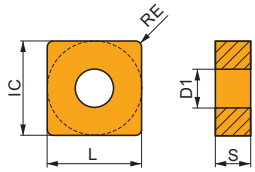
SNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76
1906	19.050	7.94	19.05	6.35

2







TNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76

VNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.60	4.76

WNMG

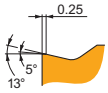
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0604	9.525	3.81	6.50	4.76

Kesme hızı (vc), ilerleme (f) ve kesme derinliği (ap) için uygunluk ve başlangıç değerleri. Daha ileri hesaplamalar için İşleme Hesaplayıcısı uygulamasına başvurun.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
CNMG 120404E-SM:T6310	0.4	155	0.20	2.0	110	0.18	2.0	125	0.20	2.0	465	0.24	2.0	45	0.18	1.6	30	0.13	0.3
CNMG 120404E-SM:T7325		180	0.20	2.0	140	0.18	2.0	–	–	–	–	–	–	55	0.18	1.6	–	–	–
CNMG 120404E-SM:T7335		175	0.20	2.0	135	0.18	2.0	–	–	–	–	–	–	55	0.18	1.6	–	–	–
CNMG 120404E-SM:T8415	0.4	200	0.20	2.0	105	0.18	2.0	185	0.20	2.0	510	0.24	2.0	45	0.18	1.6	35	0.13	0.3
CNMG 120404E-SM:T8430	0.4	180	0.20	2.0	95	0.18	2.0	145	0.20	2.0	495	0.24	2.0	35	0.18	1.6	30	0.13	0.3

4







SM talaş kırıcı çok yönlüdür ve Çeliklerin ve Süper alaşımların orta düzeyde işlenmesi için ilk tercihtir. Hafif pozitif eğim açısı ve dengeli, ılımlı T-land özelliğine sahiptir. Ayrıca Paslanmaz çelikler, Dökme demirler ve şartlara bağlı olarak Demir dışı alaşımlar ve Sert malzemeler için de uygundur.

7 8 9 11

Poz.	Açıklama
1	Kesici ucun işareti
2	Kesici ucun şematik çizimi
3	Kesici uç boyutları tablosu (mm)
4	Temsili kesici ucun resmi
5	Ana Kesme kenarının profili
6	Simgeler - spesifik özellikler ve kesme kenarı tipi

Poz.	Açıklama
7	ISO kesici uç kodu: Kalite
8	Çalışma koşulları
9	Kesici uç yarıçapları (mm)
10	Geometri açıklaması
11	Kesici ucun uygulama alanı

Typical page with inserts displayed – specific page details will differ.

1 DDUN(RL) INT

P M K N S H 2

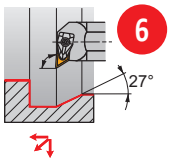
PRAMET

D 3

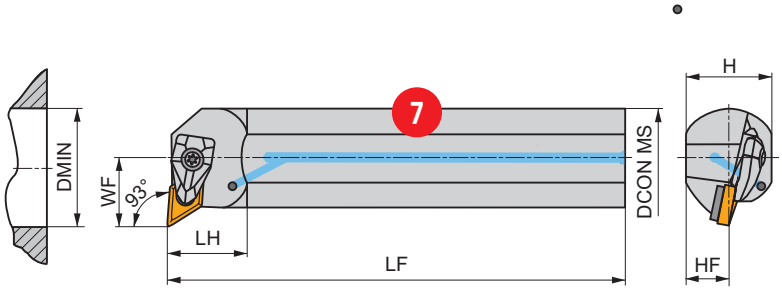

4

DN.. Uç için Çift Sıkmalı 93° Açılı Delik Kateri

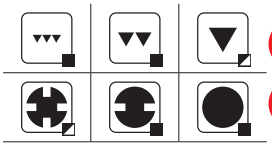
Çift sıkmalı 93° Sağ/Sol içten su vermeli delik kateri. Negatif DN.. uçlarla , birçok uygulama ve 27°'ye kadar kopya tornalama için uygundur. Gövde uzun takım ömrü için işlem görmüştür. 5



6



7


8 9


10

	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	HF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)		kg			
	A25T-DDUNR 11	25	32	17	23	11.5	300	28.0	-12	-6	✓	0.96	GI046	DD11	–
R	A32T-DDUNR 11	32	40	22	30	15	300	30.0	-10	-6	✓	1.68	GI046	DD11	–
	A40T-DDUNR 15	40	50	27	37	18.5	300	36.0	-11	-6	✓	2.58	GI044	DD154	AT002
	A50U-DDUNR 15	50	63	35	47	23.5	350	39.0	-8	-6	✓	5.25	GI044	DD154	AT002
	A25T-DDUNL 11	25	32	17	23	11.5	300	28.0	-12	-6	✓	0.96	GI046	DD11	–
L	A32T-DDUNL 11	32	40	22	30	15	300	30.0	-10	-6	✓	1.69	GI046	DD11	–
	A40T-DDUNL 15	40	50	27	37	18.5	300	36.0	-11	-6	✓	2.59	GI044	DD154	AT002
	A50U-DDUNL 15	50	63	35	47	23.5	350	39.0	-8	-6	✓	5.25	GI044	DD154	AT002

11 12 13 14 15 16 17 18

	19
GI044	DN.. 1506..
GI046	DN.. 1104..

		Nm	20		
DD11	DCS 09	1.7	67-01	US 2004-T09P	FLAG T09P
DD154	DCS 12	3.9	DDS 266-02	US 2002-T15P	FLAG T15P/3,5

		21	
AT002a	DN.. 1504..	–	DDS 266-01
AT002b	CER DN.N 1506..	DCS 12C4	–
AT002c	CER DN.A 1506..	DCS 12C2	–

Standart tornalama tutucusu görüntüleme sayfası - sayfada yer alan belirli detaylar farklılık gösterebilir.

TORNALAMA TAKILARI – GENEL BAKIŞ SAYFASI

Poz.	Açıklama
1	Tornalama tutucusunun işareti
2	Malzeme grubu önerileri
3	Kesici ucun bağlama sistemi
4	Açıklayıcı resim [1]
5	Takım açıklaması
6	İş parçası profili
7	Takımın şematik çizimi
8	Ulaşılabilir yüzey kalitesi
9	Kesim karakteri/çalışma koşulları
10	Ürün uygulamaları
11	Takım tasarımı

Poz.	Açıklama
12	ISO tutucu kodu
13	Tutucunun ölçüleri [mm] ve açıları [2] [°]
14	İçten kesme sıvısı beslemesi
15	Ağırlık [kg]
16	Uyumlu kesici uç grubu [3]
17	Yedek parça grubu [3], [4]
18	Aksesuarlar grubu [3], [4]
19	Uyumlu kesici uçlar
20	Yedek parçalar
21	Özel aksesuarlar

[1] Resimlerde birincil olarak sağ kesme yönlü (R) takım gösterilmiştir.

[2] GAMO = ortogonal açı (bkz. teknik bölüm)

LAMS = Ana kesici kenar eğim açısı (bkz. teknik bölüm)

[3] Uyumlu kesici uçlar, yedek parçalar ve özel aksesuarlar kodlama grubu sadece katalog amaçlıdır ve siparişler için kullanılamaz.

[4] Yedek parçaların ve özel aksesuarların simgeleri kolay anlaşılabilmesi için şematik olarak tasarlanmıştır. Bazı durumlarda vidalar Nm tork moment, vida boyu ve diş ölçüsü bilgileri ile tamamlanmıştır.

SİMGELERE GENEL BAKIŞ

Genel Simgeler

■	Birincil kullanim
◪	Olasi kullanim

▼▼▼	Finiş işleme – çok iyi yüzey kalitesi
▼▼	Orta talaş işleme – iyi yüzey kalitesi
▼	Kaba talaş işleme – sinirlanmamiş yüzey pürüzlülügü

●	Stabil çalişma koşullarina uygun
◓	Stabil olmayan çalişma koşullarina uygun
✚	Çok dengesiz çalişma koşullarina uygun

Tornalama Işlemleri

	Omuz olmadan boyuna tornalama
	Omuz ile boyuna tornalama
	Koni tornalama – diştan
	Pah verme (kenar kirma)
	Omuzsuz alin tornalama
	Omuzlu alin tornalama
	Tek yönlü kopya tornalama – diştan
	Çok yönlü kopya tornalama – diştan
	Alin kopya tornalama
	Sig radyal oluk
	O-ring için sig oluk
	Geniş radyal oluk (takip eden genişlemeyle)

	Omuz olmadan boyuna tornalama
	Omuz ile boyuna tornalama
	Koni tornalama – içten
	Delik içinde pah verme (kenar kirma)
	Arkadan pah verme (kenar kirma)
	Arka yüzü (omuz) arkadan işleme
	Tek yönlü kopya tornalama – içten
	Çok yönlü kopya tornalama – içten
	Delik içinde alin kopya tornalama
	Iç kanal açma
	O-ring için iç oluk
	Iç kanal açma (takip eden genişlemeyle)

	Derin radyal oluk
	Dilimleme
	Boru dilimleme
	Sig eksenel oluk
	Sig ve geniş eksenel oluk (takip eden genişlemeyle)
	Derin eksenel oluk
	Derin ve geniş eksenel oluk (takip eden genişlemeyle)
	Kopya tornalama (çok yönlü işleme)
	Alin kopya tornalama
	Diş Tornalama – diş çap
	Diş Tornalama – iç çap
	Broşlama

SİMGELERE GENEL BAKIŞ

Genel Simgeler

■	Birincil kullanim
◪	Olasi kullanim

▼▼▼	Finiş işleme – çok iyi yüzey kalitesi
▼▼	Orta talaş işleme – iyi yüzey kalitesi
▼	Kaba talaş işleme – sinirlanmamiş yüzey pürüzlülügü

●	Stabil çalişma koşullarina uygun
◓	Stabil olmayan çalişma koşullarina uygun
✚	Çok dengesiz çalişma koşullarina uygun

Özellikler

1	Ilk tercih
U	Üniversal geniş aralik seçenegi
	Kisa talaş oluşturan malzemeler için
	Sert malzemeler için (uzun talaş oluşturan)
	Ince duvarli ve ince iş parçalari

	Büyük kullanma mesafesi
	Agir çalişma koşullari
W	Silici geometrisine sahip kesici uç
HSC	Yüksek hizli kesim
HFC	Yüksek Ilerlemeli Kesim

Kesme kenari durum kodu (CECC)

F	Keskin kenar
E	Yuvarlatilmiş kenar
T	Fazli kenar
S	Fazli yuvarlatilmiş kenar
K	Çift fazli kenar
P	Çift fazli yuvarlatilmiş kenar

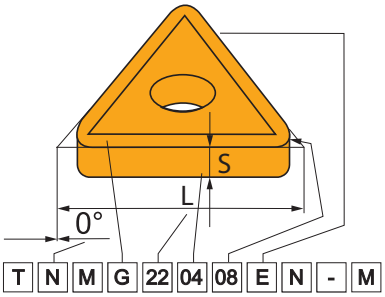
Teknik Parçalar

FF	Hassas finiş
F	Finiş
M	Orta
R	Kaba
HR	Agir kaba

V	Kesme hizi
f	Ilerleme [mm/dev]
a_p	Kesme derinligi [mm]
X.V	Multiplication factor for cutting speed
	Dayaniklilik [dk]

Nm	Vidanin baglama torku [Nm]
	Kaba işleme için kafa grubu
	Içten kesme sivisi beslemesi

UÇLAR – ISO KODLAMA SİSTEMİ



	1	2	3	4
ISO	T	N	U	N
	T	N	M	G
ANSI	1	2	3	4
	T	N	U	
	T	N	M	G

1 Uç şekli

H	O	P	R
S	T	C (80°)	D (55°)
E (75°)	M (86°)	V (35°)	W (80°)
L	A (85°)	B (82°)	K (55°)

2 Serbest açı

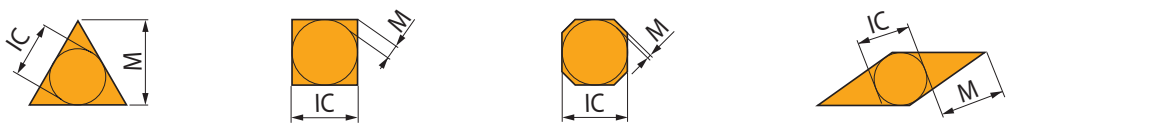
A (3°)		B (5°)	
C (7°)		D (15°)	
E (20°)		F (25°)	
G (30°)		N (0°)	
P (11°)		O	Özel

4 Talaş kırıcı ve sıkma tipi

N	
R	
F	
A	
M	
G	
W	40° – 60°
T	
Q	
U	
B	70° – 90°
H	
C	
J	
X	Özel

3 Toleranslar

	(mm)			(″)		
	M (±)	S (±)	IC (±)	M (±)	S (±)	IC (±)
A	0.005	0.025	0.025	.0002″	.001″	.0010″
F	0.005	0.025	0.013	.0002″	.001″	.0005″
C	0.013	0.025	0.025	.0005″	.001″	.0010″
H	0.013	0.025	0.013	.0005″	.001″	.0005″
E	0.025	0.025	0.025	.0010″	.001″	.0010″
G	0.025	0.130	0.025	.0010″	.005″	.0010″
J	0.005	0.025	0.05 – 0.13	.0002″	.001″	.002 – 0.005″
K	0.013	0.025	0.05 – 0.13	.0005″	.001″	.002 – 0.005″
L	0.025	0.025	0.05 – 0.13	.0010″	.001″	.002 – 0.005″
M	0.08 – 0.18	0.130	0.05 – 0.13	.003 – 0.007″	.005″	.002 – 0.005″
N	0.08 – 0.18	0.025	0.05 – 0.13	.003 – 0.007″	.001″	.002 – 0.005″
U	0.05 – 0.38	0.130	0.05 – 0.13	.005 – 0.015″	.005″	.003 – 0.010″



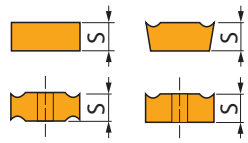
UÇLAR – ISO KODLAMA SİSTEMİ

5	6	7	8	9		10
22	04	08			-	
22	04	08	E	N		M
5	6	7	8	9		10
4	3	2			-	
4	3	2	E	N		M

5 Kesici kenar uzunluğu

d = IC (mm)	d = IC (in)	H	O	P	S	T	C	D	E	M	V	W	R	K
3.97					03	06		04			06	02		
	5/32"	1.2												
4.76					04	08	04	05	04	04	08	L3		
	3/16"	1.5												
5.56					05	09	05	06	05	05	09	03		
	7/32"	1.8												
6.35		03	02	04	08	11	06	07	08	08	11	04	06	
	1/4"	2												
7.94		04	03	05	07	13	08	09	06	07	13	05	07	
	5/16"	2.5												
9.525		05	04	07	09	16	09	11	09	09	16	06	09	16
	3/8"	3												
12.7		07	05	09	12	22	12	15	13	12	22	08	12	
	1/2"	4												
15.875		09	06	11	15	27	16	19	16	15	27	10	15	
	5/8"	5												
19.05		11	07	13	19	33	19	23	19	19	33	13	19	
	3/4"	6												
25.40		14	10	18	25	44	25	31	26	25	44	17	25	
	1"	8												
31.75		18	13	23	31	54	32	38	32	31	54	21	31	
	1 1/4"	10												

6 Uç kalınlığı



	S (mm)	S (")
01	1.59	1/16"
T1	1.98	5/64"
02	2.38	3/32"
03	3.18	1/8"
T3	3.97	5.32"
04	4.76	3/16"
05	5.56	7/32"
06	6.35	1/4"
07	7.94	5/16"
09	9.52	3/8"

7 Kesici kenar köşesi

	RE (mm)	RE (")
00	0	0"
02	0.2	1/128"
04	0.4	1/64"
08	0.8	1/32"
12	1.2	3/64"
16	1.6	1/16"
24	2.4	3/32"
32	3.2	1/8"



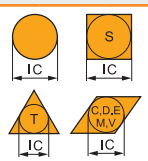
Yuvarlak uçlar

d = I.C.	
(")	00
(mm)	M0



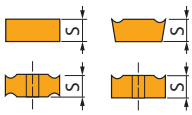
ANSI

5 İç teğet çapı



Symbol	d = I.C. (mm)	d = I.C. (")
1	3.175	1/8"
1.2	3.969	5/32"
1.5	4.763	3/16"
1.8	5.556	7/32"
2	6.350	1/4"
2.5	7.938	5/16"
3	9.525	3/8"
4	12.700	1/2"
5	15.875	5/8"
6	19.050	3/4"
7	22.225	7/8"
8	25.400	1"
10	31.750	5/4"
12	38.100	6/4"

6 Uç kalınlığı



Symbol	S (mm)	S (")
1	1.588	1/16"
1.2	1.984	5/64"
1.5	2.381	3/32"
2	3.175	1/8"
2.5	3.969	5/32"
3	4.763	3/16"
3.5	5.556	7/32"
4	6.350	1/4"
5	7.938	5/16"
6	9.525	3/8"
7	11.113	7/16"
8	12.700	1/2"
9	14.288	9/16"
10	15.875	5/8"

7 Kesici kenar köşesi



Symbol	RE (mm)	RE (")
0	0	0"
0.2	0.099	1/256"
0.5	0.198	1/128"
1	0.397	1/64"
2	0.794	1/32"
3	1.191	3/64"
4	1.588	1/16"
5	1.984	5/64"
6	2.381	3/32"
7	2.778	7/64"
8	3.175	1/8"
10	3.969	5/32"
12	4.763	3/16"
14	5.556	7/32"
16	6.350	1/4"

8 Kesme kenar tasarımı

F Keskin kesme kenarlı	E Yuvarlatılmış kesme kenarlı
T ahlı kesme kenarlı	S Pahlı ve yuvarlatılmış kesme kenarlı
K Çift pahlı kesme kenarlı	P Çift pahlı ve yuvarlatılmış kesme kenarlı

9 Kesme yönü

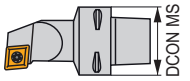
R	Sağ kesme yönlü	N	Sağ kesme yönlü — Sağ kesme yönlü
L	Sağ kesme yönlü		

10 Talaş kırıcı tipi

DIŞ ÇAP TORNALAMA TAKIMLARI – ISO KODU İŞARETİ

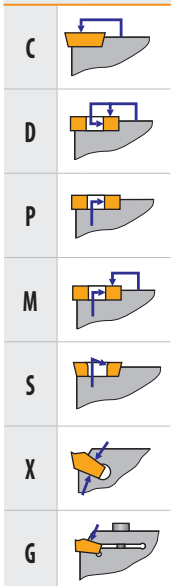
Şaft takım	ISO	2	3	4	5	6		7	8	11	12		13	
		P	C	L	N	R	–	32	25	L	12	–	M	
PSC	ISO	1	2	3	4	5	6		9	10		12		
		C4	– D	C	L	N	R	–	27	050	–	12		
Şaft takım	ANSI	2	3	4	5	6			7 & 8	12		11		
		D	C	L	N	R	–		16	4		D		

1 Bağlantı boyutu

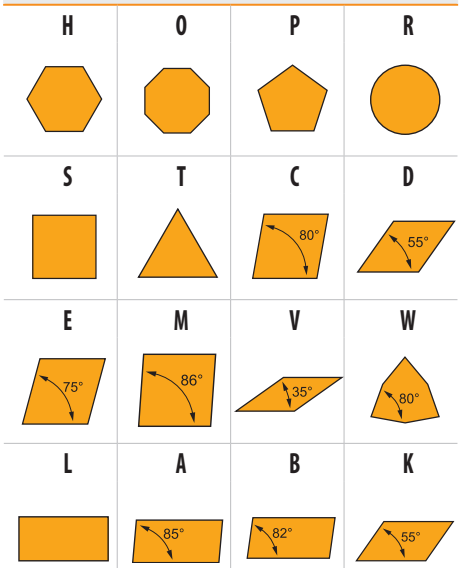


C	DCON MS
C3	32
C4	40
C5	50
C6	63
C8	80

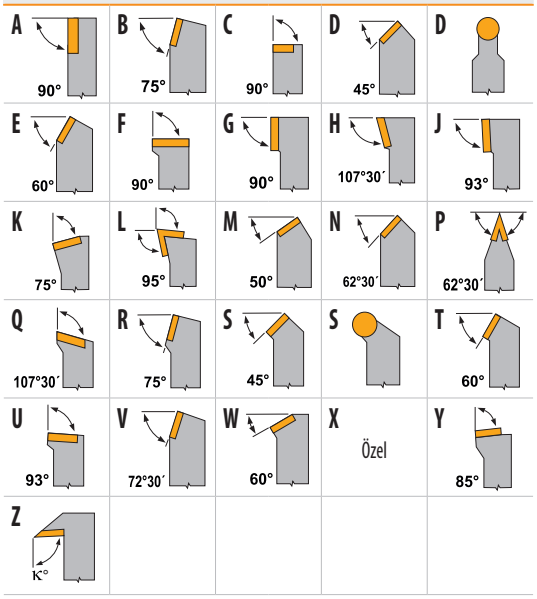
2 Sıkma tipi



3 Uç şekli



4 Yanaşma açısı

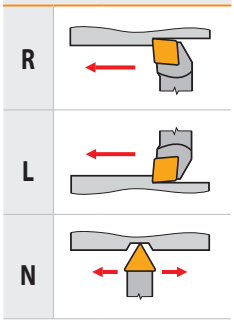


5 Serbest açı



N	B	C	P
0°	5°	7°	11°

6 Kesme yönü



7 & 8 Kesme kenar yüksekliği (")

Symbol	B (")	H (")
05	5/16"	5/16"
06	3/8"	3/8"
08	1/2"	1/2"
10	5/8"	5/8"
12	3/4"	3/4"
16	1"	1"
85	1"	1 1/4"
86	1"	1 1/2"
20	1 1/4"	1 1/4"
24	1 1/2"	1 1/2"
32	2"	2"

Kare şaftlar için, genişlik ve yükseklik inç olarak 16'lık sayılardır. Dikdörtgen şaftlar için ilk basamak genişlik inç olarak 8'lik sayılardır ve ikinci basamak yükseklik inç olarak 4'lük sayılardır.

7 Kesme kenar yüksekliği (mm)



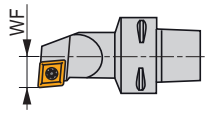
08	10	12	16	20	25
32	38	40	45	50	60

8 Şaft genişliği (mm)

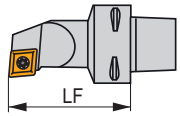


08	10	12	16	20	25
32	38	40	45	50	60

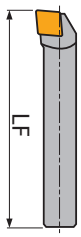
9 Fonksiyonel genişlik [mm]



10 Fonksiyonel uzunluk [mm]



11 Şaft boyu



	LF (")
A	4.000"
B	4.500"
C	5.000"
D	6.000"
E	7.000"
F	8.000"
M	4.000"
N	4.500"
R	6.000"
S	7.000"
T	8.000"

LF [mm]	
D	60
E	70
F	80
H	100
J	110
K	125
L	140
M	150
N	160
P	170
Q	180
R	200
S	250
T	300
U	350
V	400
W	450
X	Özel
Y	500

İÇ ÇAP TORNALAMA TAKIMLARI – ISO KODU İŞARETİ

	15	16	17		2	3	4	5	6	12		14
ISO	A	25	T	–	P	C	L	N	L	12	–	X
ANSI	A	16	T	–	D	C	L	N	L	4		

12 / 12 – Kesici kenar uzunluğu

d = I.C. (mm)	(″)	H	O	P	S	T	C	D	E	M	V	W	R	K
3.97					03	06		04			06	02		
	5/32″	1.2												
4.76					04	08	04	05	04	04	08	L3		
	3/16″	1.5												
5.56					05	09	05	06	05	05	09	03		
	7/32″	1.8												
6.35		03	02	04	08	11	06	07	08	08	11	04	06	
	1/4″	2												
7.94		04	03	05	07	13	08	09	06	07	13	05	07	
	5/16″	2.5												
9.525		05	04	07	09	16	09	11	09	09	16	06	09	16
	3/8″	3												
12.7		07	05	09	12	22	12	15	13	12	22	08	12	
	1/2″	4												
15.875		09	06	11	15	27	16	19	16	15	27	10	15	
	5/8″	5												
19.05		11	07	13	19	33	19	23	19	19	33	13	19	
	3/4″	6												
25.40		14	10	18	25	44	25	31	26	25	44	17	25	
	1″	8												
31.75		18	13	23	31	54	32	38	32	31	54	21	31	
	1 1/4″	10												

13 – Üretici kodlaması

M	Şimli S tipi sıkma sistemi

14 – Üretici kodlaması

X	Özel şaft tipi
. .	
93	Z= Özel yanaşma açılı
. .	

15 / 15 – Takım malzemesi

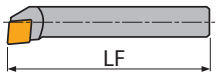
S	Çelik şaft
A	Soğutma suyu kanallı çelik şaft
E	Soğutma suyu kanallı çelik başlıklı ve sert metal gövde

16 / 16 – Şaft Ø [mm]



DCON MS [mm]		DCON MS (″)	
08	8	03	.1875″
10	10	04	.250″
12	12	05	.3125″
16	16	06	.375″
20	20	08	.500″
25	25	10	.625″
32	32	12	.750″
40	40	16	1.000″
50	50	20	1.250″
60	60	24	1.500″
		32	2.000″

17 / 17 – Şaft boyu



	LF (″)
F	3.250″
H	4.000″
K	5.000″
M	6.000″
P	6.250″
Q	7.250″
R	8.000″
S	10.000″
T	12.000″
U	14.000″
V	15.750″
W	17.750″
Y	20.000″
X	Özel

	LF [mm]
D	60
E	70
F	80
H	100
J	110
K	125
L	140
M	150
N	160
P	170
Q	180
R	200
S	250
T	300
U	350
V	400
W	450
X	Özel
Y	500

KAFALAR – ISO KODU İŞARETİ

KARTUŞ

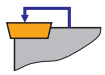
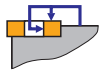
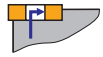
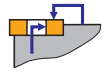
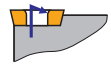
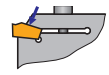
1	2		3	4	5	6	7
KH	P	–	C	L	N	R	25

TUTUCU

8	6	9	10	11
DKH	R	50	60	W

1 Kartuş

2 Sıkma tipi

C	
D	
P	
M	
S	
X	
G	

3 Uç şekli

S		C	
T		D	
R		K	
W		V	
L		X	Special

4 Yanaşma açısı

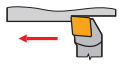
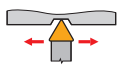
A 90°	B 75°	C 90°	D 45°	D
E 60°	F 90°	G 90°	H 107°30′	J 93°
K 75°	L 95°	M 50°	N 62°30′	P 62°30′
Q 107°30′	R 75°	S 45°	S	T 60°
U 93°	V 72°30′	W 60°	X Special	Y 85°
Z K°				

5 Serbest açı



N	C	P
0°	7°	11°

6 Kesme yönü

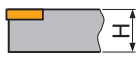
R	
L	
N	

7 Kesici kenar uzunluğu

d = I.C. (mm)	(″)	H	O	P	S	T	C	D	E	M	V	W	R	K
3.97					03	06		04			06	02		
	5/32″	1.2												
4.76					04	08	04	05	04	04	08	L3		
	3/16″	1.5												
5.56					05	09	05	06	05	05	09	03		
	7/32″	1.8												
6.35		03	02	04	08	11	06	07	08	08	11	04	06	
	1/4″	2												
7.94		04	03	05	07	13	08	09	06	07	13	05	07	
	5/16″	2.5												
9.525		05	04	07	09	16	09	11	09	09	16	06	09	16
	3/8″	3												
12.7		07	05	09	12	22	12	15	13	12	22	08	12	
	1/2″	4												
15.875		09	06	11	15	27	16	19	16	15	27	10	15	
	5/8″	5												
19.05		11	07	13	19	33	19	23	19	19	33	13	19	
	3/4″	6												
25.40		14	10	18	25	44	25	31	26	25	44	17	25	
	1″	8												
31.75		18	13	23	31	54	32	38	32	31	54	21	31	
	1 1/4″	10												

8 Kartuş kateri

9 Kesme kenar yüksekliği (mm)



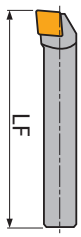
08	10	12	16	20	25
32	40	50	60	70	80

10 Şaft genişliği (mm)



08	10	12	16	20	25
32	40	50	60	70	80

11 Şaft boyu



	LF (mm)
H	100
J	110
K	125
L	140
M	150
N	160
P	170
Q	180
R	200
S	250
T	300
U	350
V	400
W	450
X	Special.
Y	500

KOD İŞARETLERİ – KESME VE KANAL AÇMA KESİCİ UÇLARI

1	2		3	4	5	6	7		8
GL	3	–	D	300	G	02	L06	–	PM

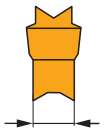


1 Takım grubu

GL

2 Yuva boyutu

1, 2, 3, 4, 5, 6



3 Kenar sayısı

S	Tek kenarlı
D	İki kenarlı

4 Kesme genişliği - CW

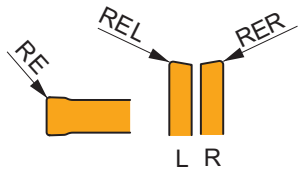


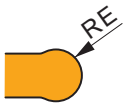
	CW
150	1.50
200	2.00
250	2.50
300	3.00
400	4.00
500	5.00
600	6.00
800	8.00

5 Kenar tasarımı

G	Taşlanmış
M	Direkt preslenmiş

6 Köşe radyusu



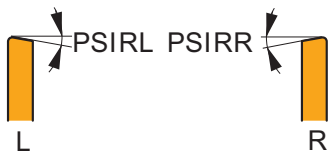


	RE, RER, REL (mm)
015	0.15
02	0.2
03	0.3
04	0.4
08	0.8

ROUND GEOMETRY

	RE (mm)
M0	RE = CW/2

7 Kesme kenarı açısı



	(°)
06	6
12	12

8 Talaş kırıcı

PM
PR
GM
MM

KESME VE KANAL AÇMA TUTUCULARI (DIŞ ÇAP TORNALAMA) – GL KODU İŞARETİ

1	2		3	4	5	6	7		8		9	10	11
GL	3	–	S	2525	M	F	R	–	20	–	R	120	090

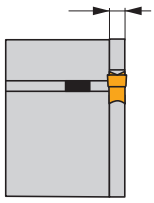


1 Takım grubu

GL

2 Yuva boyutu

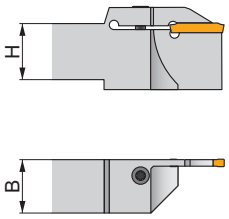
1, 2, 3, 4, 5, 6



3 Şaft tipi

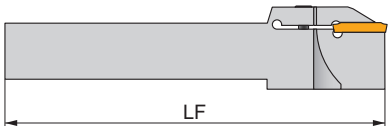
A	İçten soğutmalı çelik şaft
S	İçten soğutmasız çelik şaft

4 Şaft ölçüleri



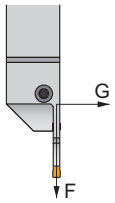
	H × B (mm)
1212 –	12 × 12
1616 –	16 × 16
2020 –	20 × 20
2525 –	25 × 25
3232 –	32 × 32

5 Şaft boyu - LF

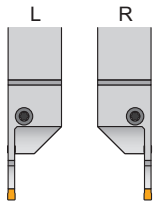


	LF (mm)
H	100
K	125
M	150
P	170

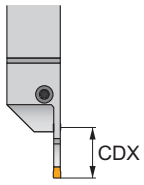
6 Yanaşma açısı



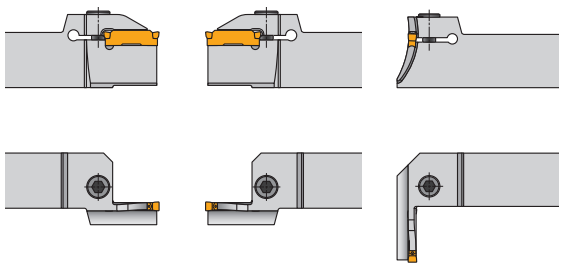
7 Model (sağ/sol)



8 Maksimum kesme derinliği - CDX

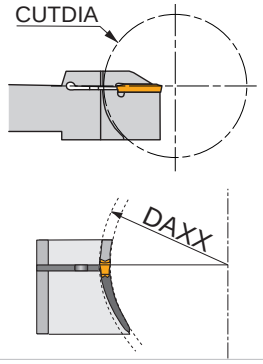


9 Takım kavis yönü

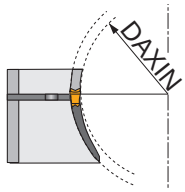


Eksenel tornalama için ek bilgi.

10 Maksimum çap



11 Minimum çap



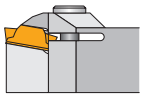
KESME VE KANAL AÇMA TAKIMLARI (DIŞ ÇAP TORNALAMA) – ISO KODU İŞARETİ

	1	2	3	4	5	6	7	8	9	10	11
ISO	G	F	I	L	25	25	M	0316	R	030	017
	1	2	3	4	5 & 6		7	8	9	10	11
ANSI	G	F	I	L	16		D	0316	R	1.18	.670

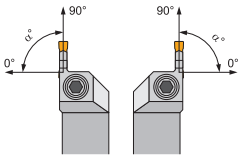


1 Sıkma tipi

G



2 Yanaşma açısı



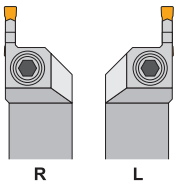
α°	
G = 0°	K = 75°
R = 15°	F = 90°
T = 30°	B = 105°
S = 45°	E = 120°
W = 60°	D = 135°

3 Maksimum kesme derinliği – CDX

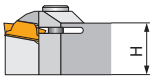


G = 2.0 × CW	N = 5.5 × CW
H = 2.5 × CW	O = 6.0 × CW
I = 3.0 × CW	P = 6.5 × CW
J = 3.5 × CW	Q = 7.0 × CW
K = 4.0 × CW	R = 7.5 × CW
L = 4.5 × CW	S = 8.0 × CW
M = 5.0 × CW	T = 8.5 × CW

4 Model (sağ/sol) R/L

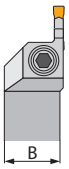


5 Kesme kenar yüksekliği (mm)



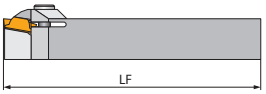
12 = 12 mm
16 = 16 mm
20 = 20 mm
etc.

6 Şaft genişliği (mm)



12 = 12 mm
16 = 16 mm
20 = 20 mm
etc.

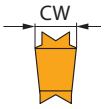
7 Şaft boyu



	LF (mm)
H	100
J	110
K	125
L	140
M	150
N	160
P	170
Q	180
R	200

	LF (")
A	4.000"
B	4.500"
C	5.000"
D	6.000"
E	7.000"
F	8.000"

8 Uç genişliği



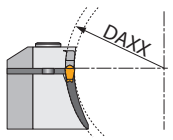
	CW (mm)	CW (")
02	2.0	.079"
03, 0313, 0316	3.0	.118"
04, 0413, 0416	4.0	.157"
05, 0516	5.0	.197"
06, 0616	6.0	.236"
08, 0830	8.0	.315"

5 & 6

	B (")	H (")
05	5/16"	5/16"
06	3/8"	3/8"
08	1/2"	1/2"
10	5/8"	5/8"
12	3/4"	3/4"
16	1"	1"
85	1"	1 1/4"
86	1"	1 1/2"
20	1 1/4"	1 1/4"
24	1 1/2"	1 1/2"
32	2"	2"

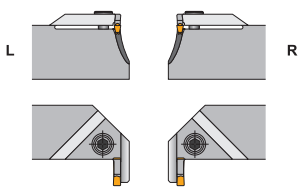
Kare şaftlar için, genişlik ve yükseklik inç olarak 16'lık sayılardır. Dikdörtgen şaftlar için ilk basamak genişlik inç olarak 8'lik sayılardır ve ikinci basamak yükseklik inç olarak 4'lük sayılardır.

10 Maksimum çap- alın kanal açma



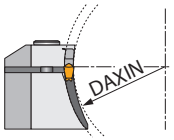
Eksenel tornalama için ek bilgi.

9 Takım kavis yönü



Eksenel tornalama için ek bilgi.

11 Minimum çap - alın kanal açma

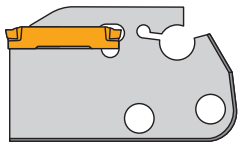


Eksenel tornalama için ek bilgi.

KESME VE KANAL AÇMA LAMALARI (DIŞ ÇAP TORNALAMA) – GL KODU İŞARETİ

1	2		3	4	5	6	7		8
GL	1	–	S	26	K	B	R	–	16



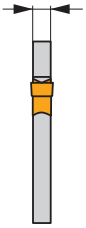


1 – Takım grubu

GL

2 – Yuva boyutu

1, 2, 3, 4, 5, 6



3 – Şaft tipi

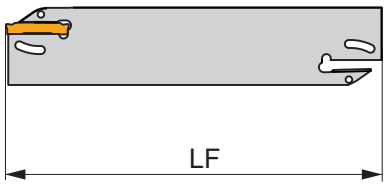
A	İçten soğutmalı çelik şaft
S	İçten soğutmasız çelik şaft

4 – Şaft ölçüleri



	H (mm)
26	26
29	29
32	32

5 – Toplam lama uzunluğu - LF

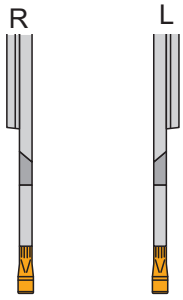


	LF (mm)
C	50
K	125
M	150

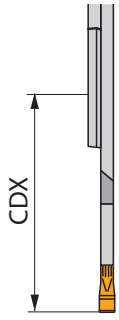
6 – Yanaşma açısı

B – lama
BS – modüler lama

7 – Model (sağ/sol)

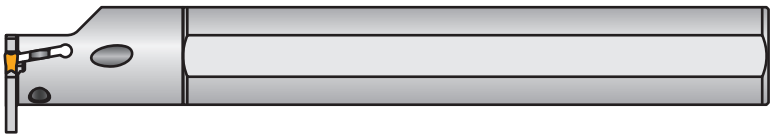


8 – Maksimum kesme derinliği - CDX



KESME VE KANAL AÇMA TUTUCULARI (DIŞ ÇAP TORNALAMA) – GL KODU İŞARETİ

1	2		3	4	5	6	7		8		9
GL	3	–	A	32	S	G	R	–	12	–	45

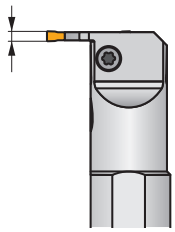


1 Takım grubu

GL

2 Yuva boyutu

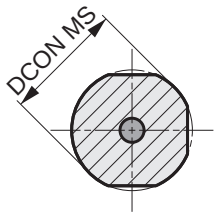
2, 3, 4



3 Şaft tipi

A	İçten soğutmalı çelik şaft
S	İçten soğutmasız çelik şaft

4 Şaft ölçüleri



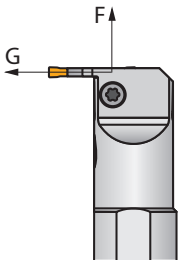
	DCON MS (mm)
25	25
32	32
40	40

5 Şaft boyu - LF

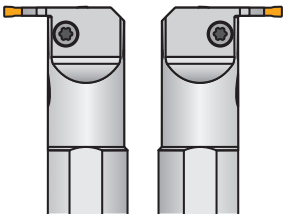


	LF (mm)
Q	180
S	250
T	300

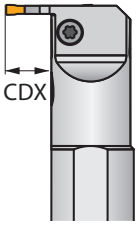
6 Yanaşma açısı



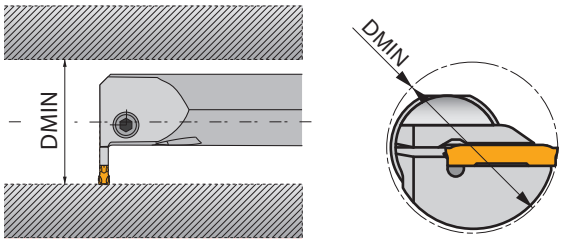
7 Model (sağ/sol)



8 Maksimum kesme derinliği - CDX



9 Minimum çap



KESME VE KANAL AÇMA TAKIMLARI (İÇ ÇAP TORNALAMA) – ISO KODU İŞARETİ

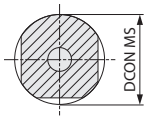
	1	2	3		4	5	6	7	8
ISO	A	25	S	–	G	G	H	L	0313
ANSI	1	2	3		4	5	6	7	8
	A	16	S	–	G	G	H	L	0313



1 Takım malzemesi

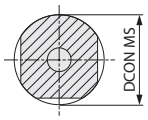
S	Çelik şaft
A	Soğutma suyu kanallı çelik şaft

2 Şaft çapı



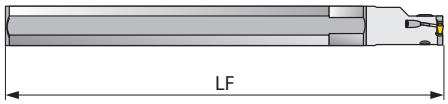
	DCON MS [mm]
12	12
16	16
20	20
25	25
32	32
40	40

2 Şaft çapı



	DCON MS (")
08	.500"
10	.625"
12	.750"
16	1.000"
20	1.250"
24	1.500"

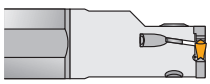
3 Şaft boyu



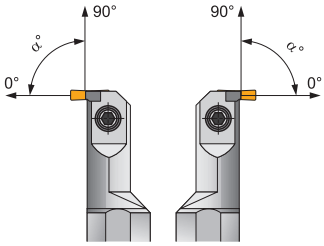
	LF [mm]	LF (")		LF [mm]	LF (")
M	150	6.000"	S	250	10.000"
P	170	6.250"	T	300	12.000"
Q	180	7.250"	U	350	14.000"
R	200	8.000"	V	400	15.750"

4 Sıkma tipi

G



5 Yanaşma açısı



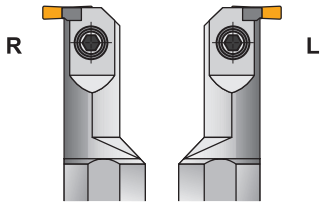
α°	
G = 0°	K = 75°
R = 15°	F = 90°
T = 30°	B = 105°
S = 45°	E = 120°
W = 60°	D = 135°

6 Maksimum kesme derinliği – CDX

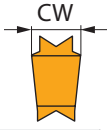


E = 1.0 × CW	J = 3.5 × CW
F = 1.5 × CW	K = 4.0 × CW
G = 2.0 × CW	L = 4.5 × CW
H = 2.5 × CW	M = 5.0 × CW
I = 3.0 × CW	N = 5.5 × CW
X = Özel	

7 Model (sağ/sol) R/L



8 Uç genişliği

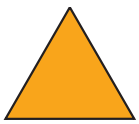


	CW [mm]
0313	3.0
0413	4.0

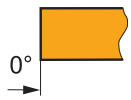
ISO DİŞ AÇMA İÇİN DEĞİŞTİRİLEBİLİR KESİCİ UÇLAR - KOD İŞARETİ

	1	2	3	4	5	6	7		8
ISO	T	N	16	E	R	175	M	–	P1
ANSI	T	N	16	E	R	120	W	–	P1

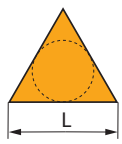
1 Uç şekli

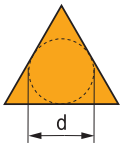
T	

2 Serbest açı

N	

3 Kesici kenar uzunluğu





L		d = IC	
(mm)	(")	(mm)	(")
11	.433"	**6,350**	1/4"
16	.650"	**9,525**	3/8"
22	.866"	**12,7**	1/2"

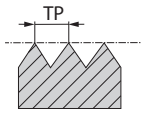
4 Dış - İç

E	Dış
N	İç

5 Kesme yönü

R	Sağ
L	Sol
N	Nötr

6 Adım



s × 100

Adım mm × 100

6 No. of threads

Parmaktaki diş sayısı × 10

7 Diş profili

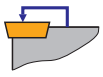
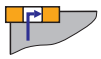
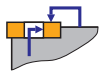
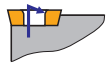
M	Metrik 60°	**TR**	TR 30° ISO 2901/3–1977
MJ	SEA MA1370	**UN**	Amerikan UN 60° ISO 5864–1978
W	Whitworth 55° ISO 228–1982	**UNJ**	SEA AS8879
RD	Yuvarlak 30°	**ACME**	ACME 29° ANSI B1.5–1988
BSPT	ISO 228/1 35 21 1959 ISO 7/1	**STACME**	ASME/ANSI B1.8-1988
NPT	ANSI B1.1–1983	**API RD**	API

8 Talaş kırıcısı işareti

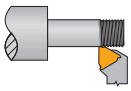
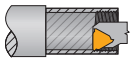
P1	Preslenmiş
AL	Demir içermeyenler için

	1	2	3		4	5	6	7		8
ISO	S	E	R	–	S	2525	M	16	–	
ANSI	S	E	R	–	S	16	D	16	–	

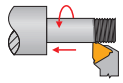
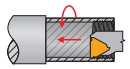
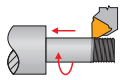
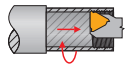
1 Sıkma tipi

C	
P	
M	
S	

2 Dış Çap/ Delik İç

E	Dış çap	
I	Delik içi	

3 Direction of cut

R	Sağ	Dış çap	
		Delik içi	
L	Sol	Dış çap	
		Delik içi	

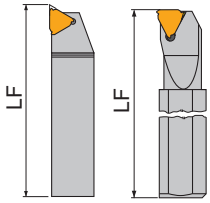
4 Type of construction

–	Normal
S	Özel

5 Boyutlar (mm)

Dış çap tornalama	2525	25 × 25 mm
İç çap tornalama	1416	Takım malzemesi – 14 mm Kesme kenar yüksekliği Ø – 16 mm

6 Şaft boyu (mm)

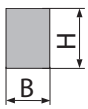


	LF (mm)
K	125
L	140
M	150
N	160
P	170
Q	180
R	200
S	250
T	300

7 Kesici kenar uzunluğu

d = IC		T
(mm)	(")	
6.350	1/4"	11
9.525	3/8"	16
12.700	1/2"	22

5 Tool dimensions (")



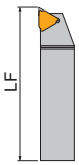
	B (")	H (")
10	5/8"	5/8"
12	3/4"	3/4"
16	1"	1"
85	1"	1 1/4"
86	1"	1 1/2"
20	1 1/4"	1 1/4"

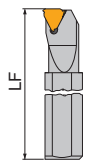


	DCON (")
08	.500"
10	.625"
12	.750"
16	1.000"
20	1.250"
24	1.500"

Kare şaftlar için, genişlik ve yükseklik inç olarak 16'lık sayılardır. Dikdörtgen şaftlar için ilk basamak genişlik inç olarak 8'lik sayılardır ve ikinci basamak yükseklik inç olarak 4'lük sayılardır.

6 Şaft boyu (")





	LF (")
C	5.000"
D	6.000"
E	7.000"
F	8.000"
K	5.000"
M	6.000"
P	6.250"
Q	7.250"
R	8.000"
S	10.000"
T	12.000"
U	14.000"

8 Helis açısı λ

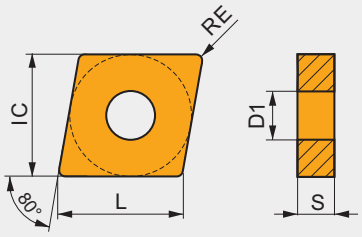
0	Helis açısı λ = 0°
1	Helis açısı λ = 1°
2	Helis açısı λ = 2°

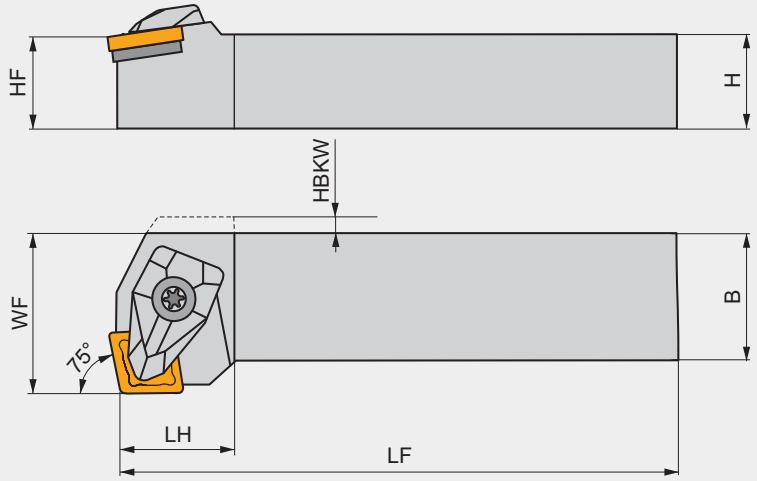
ISO 13399'A GÖRE KESİCİ TAKIM PARAMETRELERİ

Tüm kesici takımlar ISO 13399 standardına göre çeşitli parametreler ile tanımlanır. Bu listede, bu katalogda kullanılan tüm parametreler ve bunların tanımları yer alır.

ISO 13399, uluslararası kesici takım bilgisi standardıdır. Belirli bir sistem veya şirket terminolojisinden bağımsız, nötr formatta boyutlar ve parametreler sağlar. Kesici takımlar global bir standarda göre net bir biçimde tanımlandığında, tüm yazılım türleri elektronik verileri daha hızlı bir şekilde işleyebilir, böylece iletişimin kalitesi artar ve bilgi alışverişinin sorunsuz çalışması sağlanır. Kesici takım açıklamalarımızda ortak bir dili destekleyerek sistem iletişiminde bu sisteme yardımcı olur. 40.000 farklı yekpare ve değiştirilebilir takımımız ile yüksek kalitede verilerin daha kolay toplanmasını sağlayarak size önemli miktarda zaman tasarrufu sağlar. ISO 13399 uyumlu bir sistem kullandığınızda verileri manuel olarak yorumlamanız ve sisteminize girmeniz gerekmez.

SADECE NUMUNELER!





ISO 13399	Açıklama
APMX	Maksimum kesme derinliği
B	Şaft genişliği
BD	Gövde çapı
BLRAD	Kesici destekleme yarıçapı
BW	Kesici uç gövde genişliği
CDX	Maksimum kesme derinliği
CND	Kesme sıvısı giriş çapı
CUTDIA	İş parçası maksimum dilimleme yarıçapı
CW	Kesme genişliği
CWTOLL	Kesme genişliği alt toleransı
CWTOLU	Kesme genişliği üst toleransı
D1	Sabitleme deliği çapı
DAXIN	Minimum eksenel kanal iç çapı
DAXN	Minimum eksenel kanal dış çapı
DAXX	Maksimum eksenel kanal dış çapı
DCON MS	Bağlantı çapı
DMIN	Minimum delik yarıçapı
DMINP	Minimum dikey delik yarıçapı
GAMO	Dikey kesme Açısı
GAMP	Eksenel kesme açısı
H	Şaft yüksekliği
HBH	Baştan aşağı ofset yüksekliği
HBKW	Baştan aşağı ofset genişliği
HF	Fonksiyonel yükseklik
IC	İç teğet daire çapı
INSD	Kesici uç çapı
INSL	Kesici uç uzunluğu

ISO 13399	Açıklama
KAPR	Takım kesme kenarı açısı
L	Kesme kenarı uzunluğu
LAMS	Eğim açısı
LB	Gövde uzunluğu
LF	Fonksiyonel uzunluk
LFA	LF'deki A boyutu
LFS	İkincil fonksiyonel uzunluk
LH	Kafa uzunluğu
LU	Kullanılabilir uzunluk
M	M-ölçüsü
OAL	Toplam uzunluk
PDX	Profil mesafesi X
PDY	Profil mesafesi Y
PSIRL	Takım giriş açısı sol
PSIRR	Takım giriş açısı sağ
RE	Köşe yarıçapı
S	Kesici uç kalınlığı
S1	Toplam kesici uç kalınlığı
TP	Diş hatvesi
TPI	İnç başına dişler
TPIN	İnç başına dişler
TPIX	İnç başına dişler
TPN	Minimum diş hatvesi
TPX	Maksimum diş hatvesi
W1	Kesici uç genişliği
WF	Fonksiyonel genişlik
WFS	İkincil fonksiyonel genişlik

T	9	4	1	5
İşlem	Kaplama / Alt yapı	Nesil	ISO aralığı	

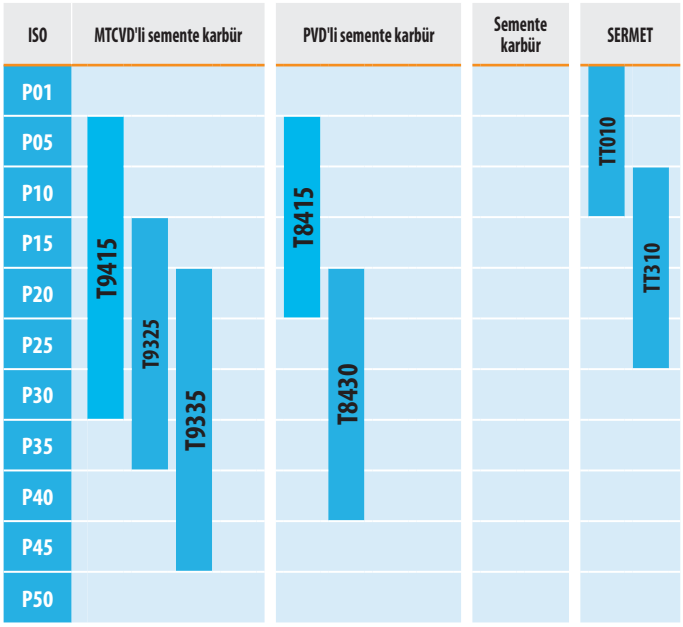
D	Delik delme
M	Frezeleme
T	Tornalama
G	Kanal açma ve Dilimleme

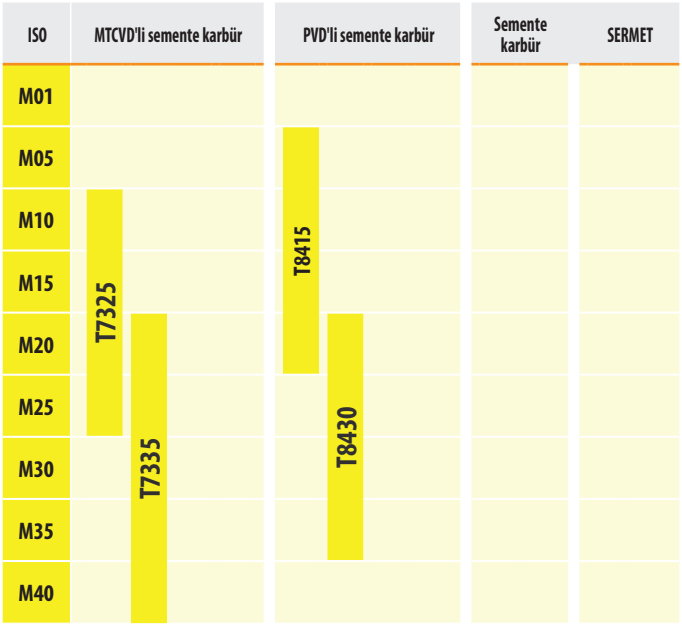
0 PVD 1 CVD	Özel uygulama
2 PVD 3 CVD	Boş
4 PVD 5 CVD	K, H grubu
6 PVD 7 CVD	M,S grubu
8 PVD 9 CVD	Üniversal
B	CBN
C	Seramik
D	PCD
T	Sermet

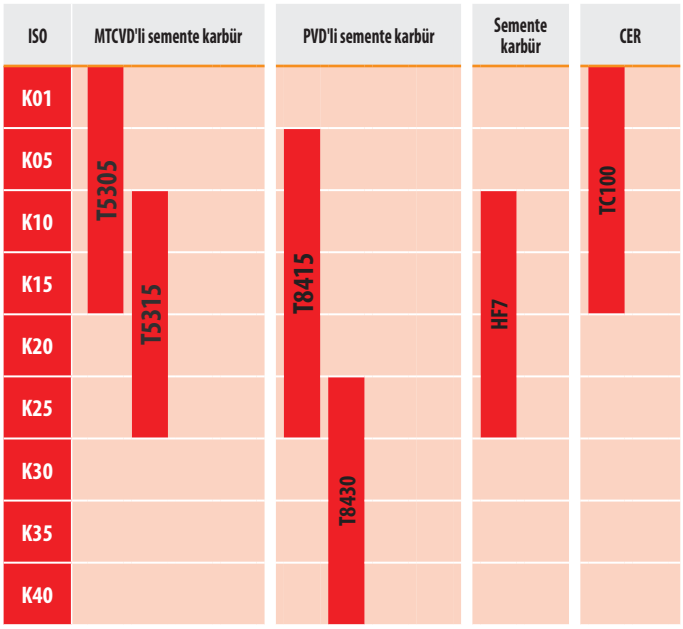
1 – 9

01 – 50	
	**01 – 05**
	**05 – 10**
	**10 – 20**
	**20 – 30**
	**30 – 40**
	**40 – 50**

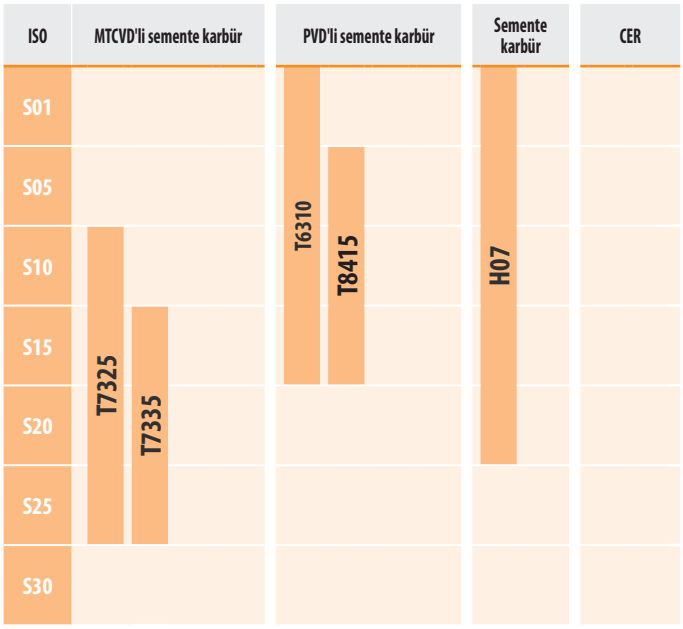
TORNALAMA KALİTELERİ – REHBER

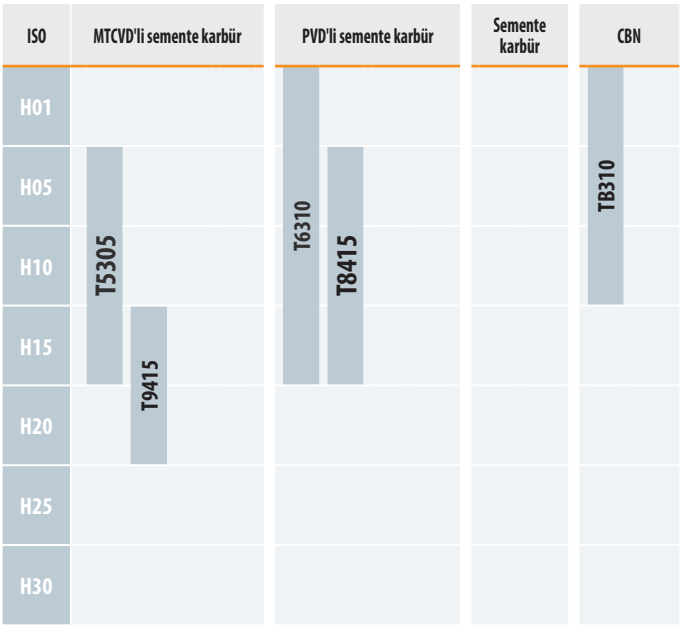












CVD TORNALAMA KALİTELERİ

Kalite Tanımlama	Uygulama Alanı	Uygulama	İlerleme	Kesme hızı	Olumsuz Çalışma Koşullarına Direnç	Kaplama	Renk	Altyapı	Kesme sıvısı avantajı	Kalite açıklaması
T9415 NEW	P05 - P30 K05 - K25 H10 - H20	■ ◪ ◪				MT-CVD		FGM	+ +	Öncelikle yaygın karbon ve alaşımlı çeliklerin ince talaş işlemesi için tasarlanmış aşınmaya karşı yüksek dirençli malzeme. Yüksek aşınma direncine rağmen darbeli kesim işlemleri için de uygundur. Bu malzemeyi, özellikle yüksek üretim uygulamalarında çoğu tornalama işlemi için ilk tercih olarak tavsiye ederiz.
T9310	P01 - P15 K05 - K20 H10 - H20	■ ◪ ◪				MT-CVD		FGM	+ +	Hafif darbeli kesimler için kullanılabilen yüksek aşınma direncine sahip kalite. Bu kalite finiş işleme veya yarı kaba işleme operasyonları için kullanılır. Bu malzeme, takım tezgahı-iş parçası konfigürasyonunun yeterince rijit olması koşuluyla kaba işleme operasyonları için de kullanılabilir.
T9315	P05 - P25 K05 - K25 H10 - H20	■ ◪ ◪				MT-CVD		FGM	+ +	Şiddetli kesme koşulları altında bile mükemmel aşınma direnci özelliklerine sahip çok yönlü bir kalite. Darbeli kesimlerin olduğu operasyonlar için de kullanılabilir.
T9325	P15 - P35 M10 - M30 K15 - K35 S10 - S20	■ ■ ◪ ◪				MT-CVD		FGM	+ +	Teknolojik açıdan bakıldığında bu, olumsuz kesme koşullarında mekanik hasara karşı yüksek dirence sahip son derece çok yönlü bir kalitedir ve mükemmel aşınma direncini korur. Bu malzemenin doğru uygulanması için yüksek kesme hızları gerekir.
T9335	P20 - P45 M15 - M40 S15 - S25	■ ■ ◪				MT-CVD		FGM	+ + +	Orta ila yüksek ilerleme hızlarında ve orta kesme hızlarında özellikle olumsuz kesme koşulları için uygun olan en tok kalitelerden biridir. Önceki modellere kıyasla M15 - M40 sadece daha tok değil, aynı zamanda aşınmaya karşı daha dayanıklıdır ve bu özellik yoğun kesme koşullarında avantaj sağlar.
T9226	P15 - P35 M10 - M30 K15 - K35 S15 - S25	■ ■ ◪ □				MT-CVD		FGM	+ + +	Ağır kaba işleme uygulamaları için tasarlanmış kalitedir. Mekanik hasara karşı yüksek dirençli ve çok iyi aşınma direncini koruyan çok yönlü bir kalitedir. Düşük kesme hızlarında kullanılabilir.
T7325	P15 - P35 M10 - M25 S10 - S25	◪ ■ ■				MT-CVD		FGM	+ + +	En üniversal tornalama kalitelerinden biridir. Paslanmaz çelik işleme için özel olarak tasarlanmıştır. Aşınma direnci ve performans güvenilirliği arasında optimum denge sunar. Tornalama işlemlerinde çok çeşitli uygulamalar için uygundur.
T7335	P20 - P40 M20 - M40 S15 - S25	◪ ■ ■				MT-CVD		FGM	+ + +	Çok yüksek operasyonel güvenilirliğe ve çok iyi aşınma direncine sahip, fonksiyonel bir şekilde derecelendirilmiş altyapısı bulunan kalitedir. En uygun kullanım alanı yüksek tokluğa sahip M20 - M40 malzemelerin işlenmesidir.
T5305	P05 - P15 K01 - K15 H05 - H15	◪ ■ ◪				MT-CVD		H	+	Kimyasal aşınmaya karşı çok yüksek dirençli kalitedir; yüksek kesme hızları kullanan finiş işleme operasyonları için uygundur. Ayrıca, yüksek aşınma direnci sayesinde sertleştirilmiş ve işlenmiş K01 - K15 malzemelerin verimli bir şekilde işlenmesi için de uygundur..
T5315	P10 - P25 K10 - K25 H15 - H25	◪ ■ ◪				MT-CVD		H	+	Öncelikle verimli işlemeye yönelik, yüksek aşınma direncine ve iyi operasyonel güvenilirliğe sahip kalite. Özellikleri sayesinde bu malzeme iyi veya hafif olumsuz kesme koşullarında kaba ve finiş işleme operasyonları için uygundur.
6640	P20 - P40 M20 - M35 K25 - K40	■ ■ ■				MT-CVD		H	+ + +	Özellikle kaba işleme operasyonlarında veya olumsuz kesme koşulları altında operasyonel güvenilirliğin öncelikli olduğu durumlarda kullanılabilen en tok tornalama malzemelerinden biridir. Düşük ila orta kesme hızlarında ve orta ila yüksek ilerleme hızlarında çalışan makineler için diğer bir ideal seçimdir.

PVD TORNALAMA KALİTELERİ

Kalite Tanımlama	Uygulama Alanı	Uygulama	İlerleme	Kesme hızı	Olumsuz Çalışma Koşullarına Direnç	Kaplama	Renk	Altyapı	Kesme sıvısı avantajı	Kalite açıklaması
T8415 NEW	P05 - P20 M05 - M20 K05 - K25 N05 - N25 S05 - S15 H05 - H15	■ ■ ■ ◪ ■ ■				PVD		submicron H	+ +	Öncelikle çelik işleme için tasarlanmış, ancak paslanmaz çelikler ve ısıya dayanıklı süper alaşımlar (HRSA) için de uygun olan, sertleştirilmiş çelikler için de uygulanabilen çok yönlü, yüksek performanslı bir tornalama kalitesi. Çok çeşitli kesme hızlarında, hafif ila orta ilerlemelerde ve iyi kesme koşulları altında, tercihen soğutma sıvısı ile işlemeye uygundur.
T8315	P05 - P20 M05 - M20 K05 - K25 N05 - N25 S05 - S15 H05 - H15	◪ ■ ■ ■ ◪ ■				PVD		submicron H	+ +	Ortalamanın üzerinde operasyonel güvenilirliği korurken mükemmel aşınma direncine sahip kalitedir ve kısa talaşlı sert malzemelerde orta ila yüksek kesme hızlarında işleme için uygundur.
T8430	P20 - P40 M20 - M35 K25 - K40 N15 - N30 S15 - S25 H15 - H25	■ ■ ◪ ◪ ◪ ◪				PVD		submicron H	+ + +	Çok yönlülük açısından kuşkusuz en güçlü kesme malzemesi olan bu kalite tüm işlenmiş malzemelerin işlenmesinde kullanılır ve hemen her tür tornalama işleminde pratik olarak uygulanabilir. Başlıca avantajları yüksek operasyonel güvenilirlik ve çok iyi sürtünme özellikleridir; bu nedenle orta ve düşük kesme hızlarındaki uygulamalar için uygundur.
T8345	P30 - P50 M20 - M40 K30 - K40 S20 - S30	■ ◪ ◪ ◪				PVD		submicron H	+ + +	Bu kalite, en tok tornalama kalitesidir ve esas olarak en kötü kesme koşullarında ve en yüksek çalışma güvenilirliği gereksinimleri olan uygulamalarda işleme için tasarlanmıştır. Bu özelliklerinden dolayı bu malzeme daha düşük kesme hızları için tavsiye edilir.
T6310	P01 - P15 M01 - M15 K05 - K20 N05 - N20 S01 - S15 H01 - H15	■ ■ ■ ■ ■ ■				PVD		ultra submicron H	+ + +	Üstü PVD kaplamalı, yüksek aşınmaya dayanıklı tornalama kalitesidir. Keskin kesme kenarı ve yüksek yanak aşınma direncinin çok önemli olduğu finiş işleme operasyonları ve uygulamaları için uygundur
T0315	N05 - N20	■				PVD		submicron H	+ +	Demir dışı metalleri ve alaşımlarını dengeli bir aşınma direnci ve tokluk oranıyla tornalamak için mikron altı kalitedir. Mükemmel sürtünme özelliklerine sahip benzersiz bir kaplama ile sunulur.
G8330 	P25 - P40 M20 - M35 K20 - K40 N15 - N30 S15 - S25	■ ■ ■ ◪ ◪				PVD		submicron H	+ + +	Kanal açma ve dilimleme uygulamaları için üniversal kesme kalitesi. Bu kalitenin karakteristik özellikleri olağanüstü güvenilirlik ve çok yönlülüktür. Çoğu iş parçası malzemesine ait işleme koşullarına uyacak şekilde geliştirilmiştir.
T8330 	P25 - P40 M20 - M35 K20 - K40 N15 - N30 S15 - S25 H15 - H25	■ ■ ■ ◪ ◪ ◪				PVD		submicron H	+ + +	Çok yönlülük açısından kuşkusuz en güçlü kesme malzemesi olan bu kalite tüm işlenmiş malzemelerin işlenmesinde kullanılır ve hemen her tür tornalama işleminde pratik olarak uygulanabilir. Başlıca avantajları yüksek operasyonel güvenilirlik ve çok iyi sürtünme özellikleridir; bu nedenle orta ve düşük kesme hızlarındaki uygulamalar için uygundur.
T8010 	P05 - P15 M05 - M15 K10 - K20 S10 - S15	■ ■ ■ ◪				PVD		submicron H	+ + +	Bu kalite çelik, paslanmaz çelik, dökme demir ve süper alaşımlarda sürekli yüksek hassasiyetli diş tornalama işlemleri için uygundur. Operasyonel güvenilirlik ve mükemmel aşınma direnci sunar
T8030 	P25 - P40 M20 - M35 K20 - K40 N15 - N30 S15 - S25	■ ■ ■ ◪ ◪				PVD		submicron H	+ + +	Kesinlikle en iyi çok yönlü kalitedir, her tür malzemeyi işlemek için uygundur ve hemen tüm tornalama işlemlerinde uygulanabilir. Başlıca avantajları yüksek operasyonel güvenilirlik ve mükemmel sürtünme özellikleridir; bu nedenle orta ila düşük kesme hızlarındaki uygulamalar için uygundur.

DİĞER TORNALAMA KALİTELERİ

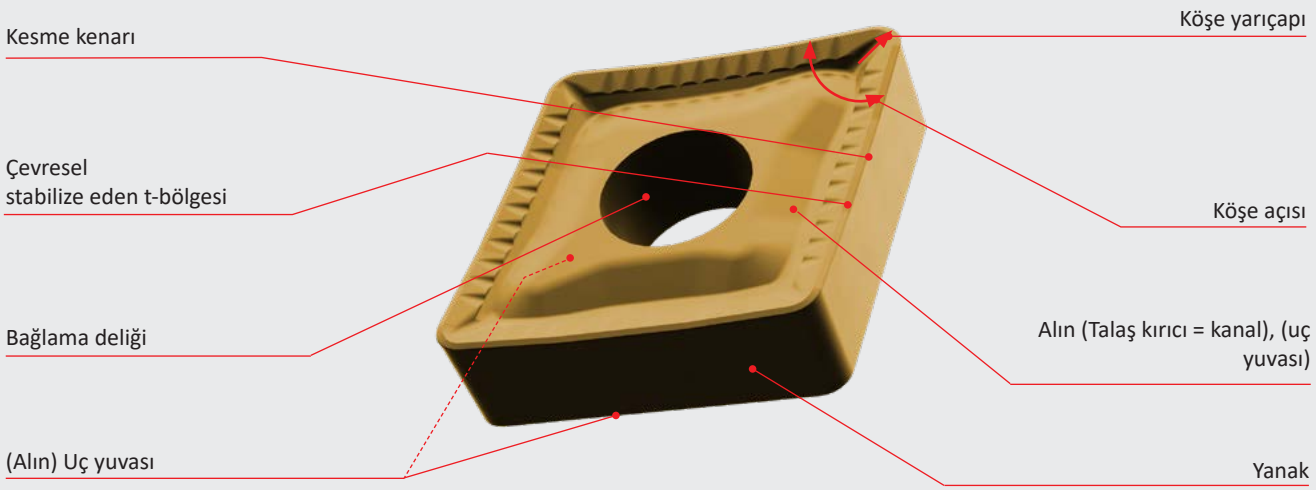
Kalite Tanımlama	Uygulama Alanı	Uygulama	İlerleme	Kesme hızı	Olumsuz Çalışma Koşullarına Direnç	Kaplama	Renk	Altyapı	Kesme sıvısı avantajı	Kalite açıklaması
HF7	M10 - M20 K10 - K25 N10 - N25	◪ ■ ■	▰▰▰▰	▰▰▱▱	▰▰▰▰	×		submicron H	+ +	Esas olarak demir dışı metallerin işlenmesi için tasarlanmış kaplamasız kalitedir; ancak diğer işlenmiş malzemeler için de kullanılabilir (çelik hariç). Bu malzeme tornalama, frezeleme ve hatta delik işlemede kullanılabilir.
H07	M05 - M15 K10 - K25 N10 - N30 S01 - S20	◪ ■ ■ ■	▰▰▰▰	▰▰▰▱	▰▰▰▱	×		submicron H	+ +	Oksidasyon direncinin takım ömrü açısından baskın kriter olmadığı işleme uygulamalarında kullanılan kaplamasız tornalama kalitesidir. Ti bazlı alaşımların işlenmesi için tasarlanmıştır. Kalite, iyi aşınma direnci ile birlikte yüksek kesme kenarı mukavemeti sergiler.
TT310	P10 - P25 M15 - M25	■ ◪	▰▰▱▱	▰▰▰▱	▰▰▱▱	PVD		cermet	+ / -	Karbon ve alaşımlı çeliklerin (paslanmaz dahil) ince ve yüzey tornalanmasında kullanılan kaplamalı sermet. PVD tekniğiyle uygulanan kaplama sayesinde mükemmel sürtünme özellikleri daha da iyileştirilmiştir.
TT010	P01 - P10 M01 - M10	■ ◪	▰▰▱▱	▰▰▰▱	▰▰▱▱	×		cermet	+ / -	Her tür çeliğin (paslanmaz dahil) çok düşük ilerleme hızlarında ince işlenmesi için uygun kaplamasız sermet. Başlıca avantajı, kesme kenarının minimum yarıçapı ve fiziksel ve kimyasal aşınma mekanizmalarına karşı yüksek direncidir.
TC100	K01 - K15	■	▰▰▱▱	▰▰▰▱	▰▰▱▱	×		ceramics	- -	Dökme demir işleme için seramik kalitesi. Stabil koşullarda yüksek kesme hızıyla işlemeye uygundur.
TB310	K01 - K10 S05 - S10 H01 - H10	■ ◪ ◪	▰▰▱▱	▰▰▰▱	▰▰▱▱	×		CBN	- -	Sertleştirilmiş malzemelerin işlenmesi için CBN kalitesi. Stabil koşullarda yüksek kesme hızı ve küçük ilerlemelerle işlemeye uygundur.
PD1	N05 - N25	■	▰▰▱▱	▰▰▰▱	▰▰▱▱	×		PCD	-	Demir içermeyen malzemeleri tornalamak için PKD kalitesi. Stabil koşullarda yüksek kesme hızı ve küçük ilerlemelerle işleme için ideal tercihtir.
333TN	P45 - P50 M35 - M40 K35 - K40	■ ◪ ◪	▰▰▰▰	▰▰▱▱	▰▰▰▰	PVD		HSS	+ + +	HSS altyapı ve ince sert PVD kaplamadan oluşan özel kalitedir. Portföydeki en tok kesme kalitesidir. Bu kaliteye sahip kesici uçlar sadece kama oluğu açmak için kullanılır.

Alt yapı	
H	WC-Co bazlı alt yapı
submicron H	İnce tanecikli (< 1 µm) WC-Co bazlı alt yapı
ultra submicron H	Çok ince tanecikli (< 0,5 µm) WC-Co bazlı alt yapı
FGM	İşlevsel kaliteli alt yapı
Cermet	WC'süz semente karbür
ceramics	Seramik
PCD	Polikristal Elmas
CBN	Kübik Boron Nitrür
HSS	Yüksek hız çeliği

Kaplama	
MT-CVD	Orta sıcaklıkta kimyasal kaplama
PVD	Düşük sıcaklıkta fiziksel kaplama
×	Kaplamasız kalite

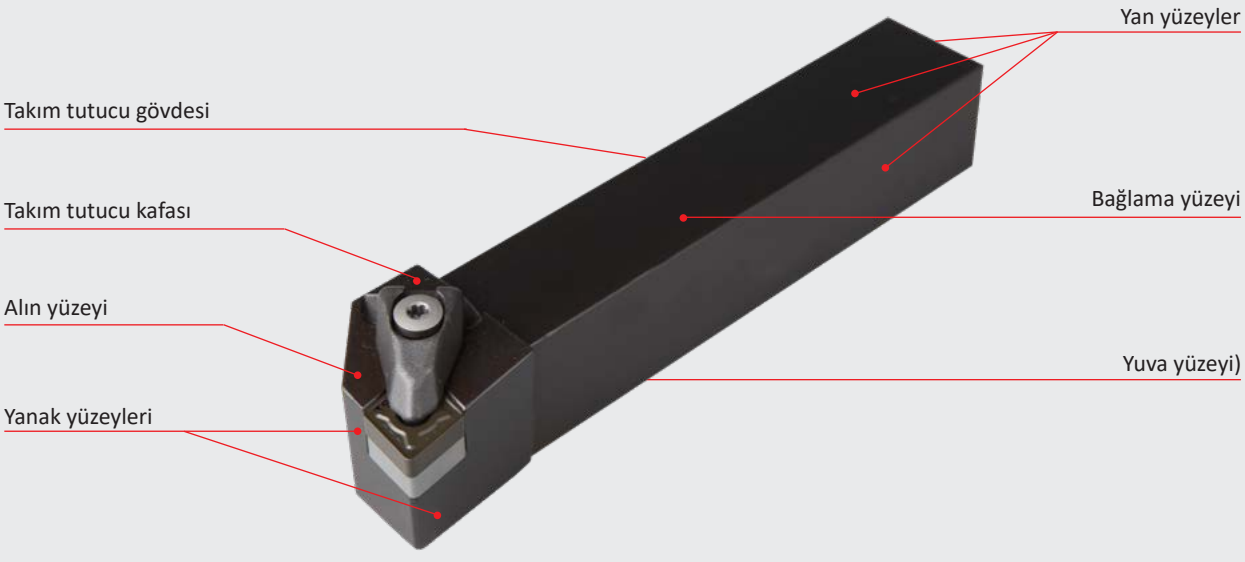
Kesme sıvısının avantajları	
+ + +	Kesme sıvısı kullanımı esastır
+ +	Önemle tavsiye edilir
+	Tavsiye edilir
+ / –	İsteğe bağlı
– -	Kesme sıvısı kullanmayın
–	Kesme sıvısı tavsiye edilmez

Kesici uç parçaları



Köşe yarıçapı – çoğu durumda önerilen minimum kesme derinliğini ve ayrıca ilerlemeyle birlikte elde edilen pürüzlülüğü de belirler.
Kesici kenar alın ve yanak yüzeylerinin kesişimidir. Kenarın boyuna pürüzlülüğü, bir kesici uç değerlendirilirken ilk değerlendirme kriterlerinden biridir.
Kesici uç köşe açısı kullanılabilir kesme kenarı uzunluğu, darbeli kesimlere karşı direnç, kesme noktasından ısı dağılımı, vb. açılarından çok önemlidir.
Dikey stabilize eden t-bölgesi kesme kenarından sonra bulunan bir alandır. Genişliği çok değişkendir ve açısı da düzenli olarak değişir. Çoğu durumda, t-alanının genişliği, kesici ucun çalıştığı ayarlama açısı ile birlikte, minimum ilerlemeyi belirlemek için sınırlayıcı bir faktördür.
Talaş kırıcısı – t-bölgesiyle birlikte uygulama alanını belirler (dar kanallar - finiş işleme ve malzemeler, geniş kanallar - çoğunlukla kaba işleme işlemleri ve sert malzemeler).
Sıkma deliği – delik yoksa, kesici uç kesinlikle ISO C bağlama sistemi içindir. Delik silindir şeklindeyse kesici uç ISO P, M, D + bağlama sistemleri için tasarlanmıştır (hemen tüm durumlarda yanak açısı 0°'dir. Delik trompet şeklindeyse ve yanak açısı pozitifse, kesici uç tek taraflıdır ve ISO S bağlama sistemi için tasarlanmıştır. Delik konikse ve kesici ucun her iki tarafında aynıysa, büyük olasılıkla teğetsel bir kesici uçtur (çift taraflı).
Uç yuvası – alın yüzeyi ile aynı boşaltma ile oluşturulmuşsa, ek parça çift taraflıdır, farklıysa ek tek taraflıdır. Değerlendirme, planlanan yüke veya kesim türüne göre yapılmalıdır. (yarıçapın ve kesme kenarlarının boyutu ve mesafesi).

Takım tutucu parçaları



TEMEL TERİMLERİN TANIMI

Torna takımı iki temel parçadan oluşur:

1) gövde bölümünde bulunanlar:
- yuva yüzeyi
- bağlama yüzeyi
- yan yüzeyler (ayrıca ayar vidalarıyla da sağlanabilir)

Not: Dış çap tornalama için, takım tutucu gövdesi genellikle kare bir kesittir (kare veya dikdörtgen). İç tornalama için tutucu gövdesinin kesiti daireseldir ve daha büyük kesitler için ayar yüzeyleri ile donatılmıştır. Ancak tutucu gövdesi, CAPTO (PSC) veya HSK gibi özel tipte bir şaftla da oluşturulabilir

2) kafa bölümünde bulunanlar:
- yüzey
- yanak yüzeyleri

Takım tutucu kafa ayrıca içine uçların yerleştirildiği bir bağlama sistemi içerir
Alından kenara (radyal uçlar için) veya yanak yüzeyinden itibaren (teğetsel uçlar için)

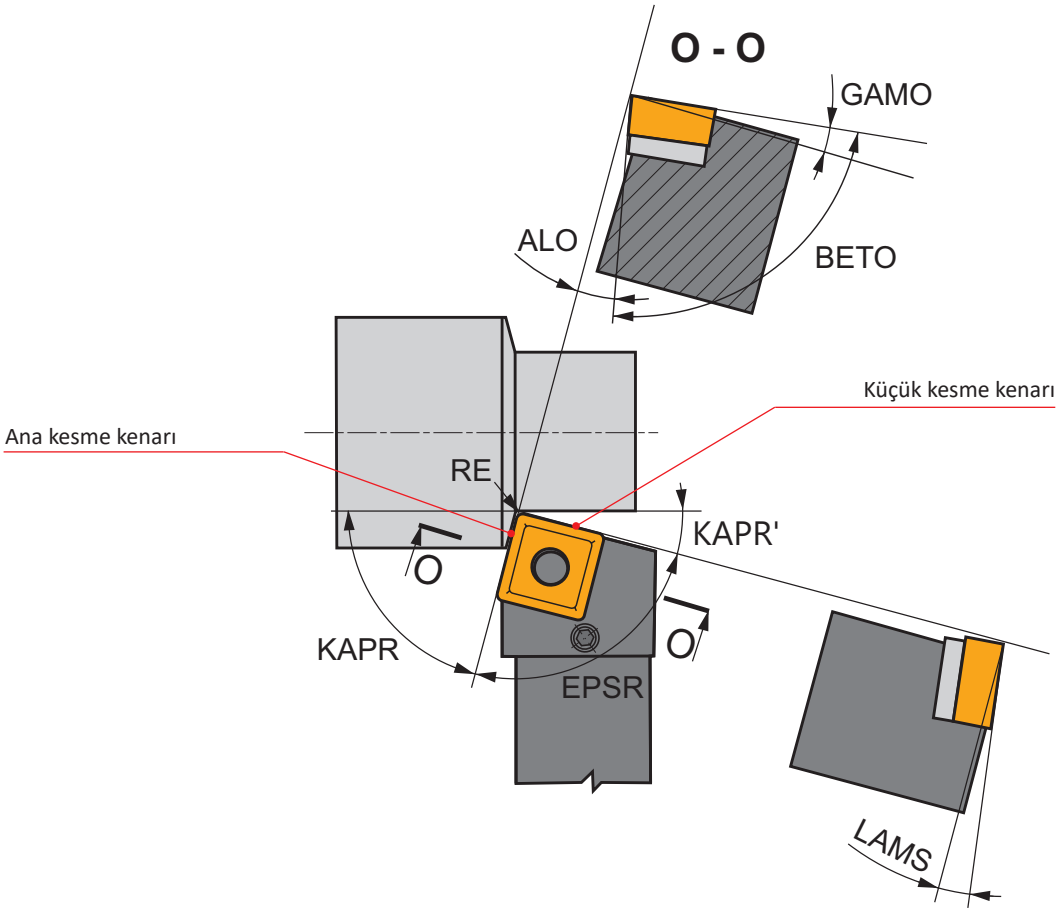
Not: kafa tipleri:
- düz – her iki yönde tornalama olanağı sunar
- kenar – sol ve sağ tasarım olarak ayrılır
- bükülmüş – sol ve sağ tasarım olarak ayrılır (karmaşık yüzeyleri tornalarken daha iyi erişim sağlar)

Torna takımlarının çalışma ve yapım açıları

Kesme kenarının iş parçasına ve onun geometrik şekline göre konumu ve yönü, kesme açısı özelliklerini belirler.
Kesme kenarındaki açılar iki koordinatlı bir sistemle belirlenir:

a) tasarım
b) çalışma

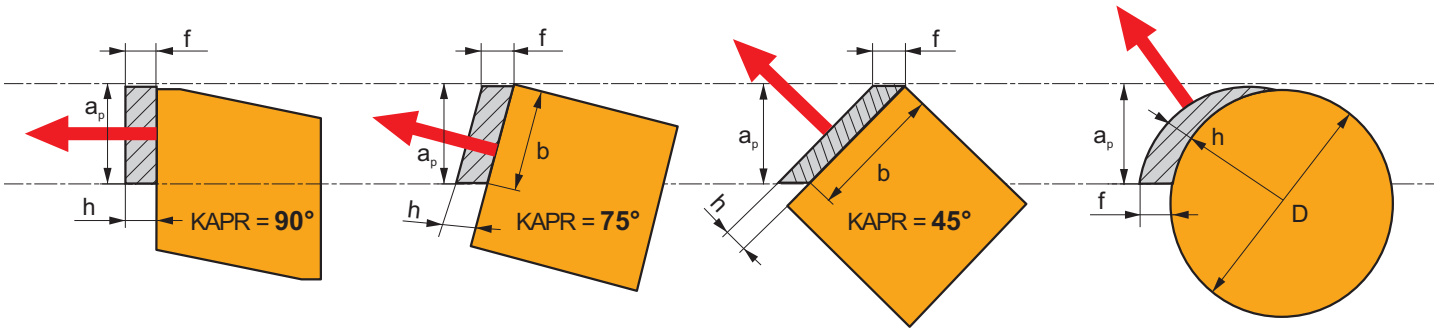
a) takım koordinat sistemi (sabit), tasarım, üretim ve kontrol sırasında kesici kenar geometrisini belirlemek için kullanılır. Bu sistemde tanımlanan tüm açılara takım kesme açıları denir. Uç şekline göre ISO standartları tarafından tanımlanan tüm açılar bu gruba aittir.



b) çalışma koordinat sistemi, işleme sırasında kesme kenarı geometrisini belirlemek için kullanılır. Bu açılara çalışma açıları denir ve bunlar, takım tutucuya kelepçelenen ucun konumuna bağlıdır. Örneğin kesici uç SNUN ..... ile ilgili takım boşluk açısı ***AN*** = 0° ve eğim açısı ***GAMP*** = 0° şeklindedir, bununla birlikte kesici ucun takım tutucuya bağlantısında çalışma boşluğu açısı ***ALO*** = 6° ve çalışma eğim açısı ***GAMO*** = -6° değerindedir. Çalışma açıları, önceden şekillendirilmiş talaş kırıcıları olan takım açılarını etkiler. Ancak en önemlisi kesme işlemine ait çalışma açılarıdır.

Temel takım açıları, resimde temel takım düzleminde (takım tutucunun yatak yüzeyi ile birlikte) ve normal takım düzleminde (kesme kenarına çaprazlama - O-O kesimi) gösterilir.
Bizi ilgilendiren açılar şunlardır:
Eğim açısı ***GAMO*** – kesme işlemini önemli ölçüde etkiler. Boyutu, talaş oluşturma sırasındaki plastik deformasyonun ilerlemesini ve yoğunluğunu belirler; aynı zamanda kesme kuvvetlerinin değerini ve kesme kenarındaki termal gerilimi belirler. Eğim açıları geniş bir aralıktadır, frezeleme ve tornalama için değiştirilebilir kesici uçlara sahip kesici takımlarda ***GAMO*** = +25° ile -15° arasındadır. Pozitif bir eğim açısı, talaş oluşturma koşullarını iyileştirir, kesme kuvvetlerini azaltır ve kesme sıcaklığı seviyesini düşürür. Negatif bir kesim açısı kesme kenarının mukavemetini iyileştirir, ancak talaş oluşumu sırasında plastik deformasyonu ve dolayısıyla kesme kuvvetlerini ve sıcaklıkları da artırır.

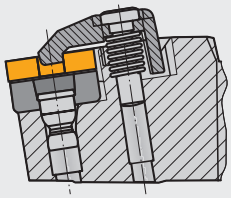
Boşluk açısı ***ALO*** yanak ve işlenmiş yüzey arasındaki sürtünmenin değerini etkiler. ***ALO*** boşluk açısının artırılması bu sürtünmeyi ve dolayısıyla yanak aşınmasını azaltır.
Kama açısı ***BETO*** kesici ucun kamasının açısıdır. ***BETO*** açısının artırılması kesme kenarının gücünü artırır (şoka karşı direnç), ancak aynı zamanda kesme direncini de artırır.
Ana kesme kenarının eğim açısı ***LAMS*** – kesici kenar ile iş parçası arasındaki ilk temas noktasını belirler; bu nokta darbeli kesimler için önem taşır. ***LAMS*** is pozitif olursa temas noktası kesici ucun burnuna yakındır. ***LAMS*** açısının negatif olması ilk temas noktasını burundan uzaklaştırır ve kesme kenarının mekanik gerilime karşı direncini etkiler. Dahası, ***LAMS*** talaş tahliyesinin yönünü etkiler. ***LAMS*** negatif olursa, talaş boşaltma yönü işlenmiş yüzeye doğrudur. Ancak ***LAMS*** pozitif olursa, talaş boşaltma yönü işlenmiş yüzeyden uzağa doğru olur.
Ana kesme kenarının ***KAPR*** açısının ayarlanması esas olarak kesme kuvvetlerinin değerlerini ve talaşın kesit şeklini etkiler. ***KAPR*** açısı düşürüldüğünde belirli bir f ilerlemesi ve a_p kesme derinliğinde talaş kalınlığı düşer. Eğer ***KAPR*** = 90° olursa talaş kalınlığı $h = f$ ve talaş genişliği $b = a_p$ daha geniş olur. Azalan ayar açısıyla ilgili olarak, T-bölgesinin fonksiyon genişliği artar ve kesici ucun eğim açısı azalır.
Küçük kesme kenarının ***KAPR´*** ayar açısı ve ***RE*** köşe yarıçapı sonuçtaki yüzey kalitesini tanımlar.



$h = f$ | $h = 0{,}96\,f$ | $h = 0{,}71\,f$ | $h = 0 \div f$

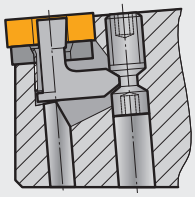
Bağlama tekniğine göre takım tutucu seçimi

PRAMET TOOLS teklifi, takım tutucular, ayarlanabilir tutucular, taret kafaları ve boyuna dış çap, alın, kopya tornalama ve elbette içten tornalama için ayarlanabilen tutucular içerir. Takım tutucular, kesici uç bağlama sistemine göre aşağıdaki bölümde şematik olarak gösterilen altı gruba ayrılır.



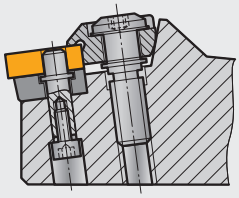
ISO D

Bu, silindirik bir deliğe sahip negatif kesici uçların sıkıştırılması için en sağlam sistemdir. Kesici uç cebe sadece kesici ucun deliğine oturan ve kesici ucu aşağı doğru ve aynı zamanda cebin arka yüzlerine doğru iten özel bir sıktırma ile sabitlenir. Bu sistemin dezavantajı, talaş tahliyesinde sorunlara neden olabilen yine sıktırmadır. Bu nedenle, bu sisteme sahip tutucular özellikle takım üzerinde yüksek dinamik gerilimlerle karakterize edilen dış çap işleme operasyonları için uygundur.



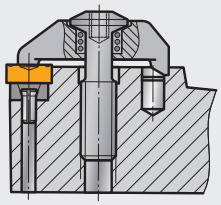
ISO P

Bu sistem, silindirik delikli negatif uçların hem talaş oluşturucularla hem de bunlar olmadan bağlanmasını sağlar. Uç sıkıştırması, vidanın sıkılmasıyla ucu tutucu yatağa doğru bastıran bir açılı kol tarafından sağlanır. Bu bağlama sistemine sahip takım tutucular, kesici ucun güvenilir ve tam olarak sıkıştırılmasını sağlar. Dış tornalama işlemlerinde, yani hem finiş işleme hem de kaba talaş işlemede en iyi ve aynı zamanda en yaygın kullanımı sunar. Alternatif olarak bu tip bir bağlama, daha büyük çaplı deliklerin içten tornalanması için tasarlanan tutucularda da kullanılabilir.



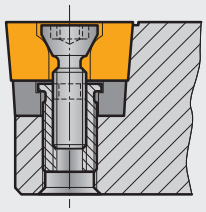
ISO M

Bu sistem, ISO P sistemiyle aynı tipteki kesici uçların bağlanması için kullanılır. Bu durumda uç, bir kelepçe ile bastırılarak güçlü bir pime yerleştirilir ve bu pim aynı zamanda ucun üst kısmını da sabitler. Bu bağlama sistemi genelde daha çok dinamik yük taşıdığı düşünülen tutucular için uygundur. Bu tutucular neredeyse sadece dış tornalama için kullanılır.



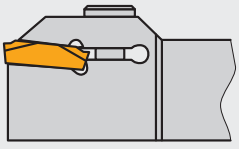
ISO C

Bu sistem hem negatif hem de pozitif, yani talaş oluşturucuları olan (önceden preslenmiş, taşlanmış ve yandan preslenmiş) ve olmayan deliksiz uçların bağlanmasında kullanılır. Uç, takım tutucu yatağına vidalı bir kelepçe ile sabitlenir ve altında hala bazı uç tiplerinde yandan preslenmiş bir talaş oluşturucu bulunur. Bu bağlama sistemine sahip tutucular hem dış hem de iç yüzey işleme için kullanılır. Günümüzde C tipi bağlama sistemi önemini yitirmiş durumdadır. Özellikle iç tornalama takımlarında daha avantajlı olan S sistemi ile değiştirilir.



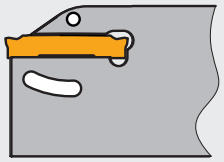
ISO S

Bu bağlama sistemi esas olarak hem dış hem de iç tornalama (delme) için tasarlanmış küçük kesitli takımlarda kullanılır. Bu durumda uç koni deliğinden geçen özel bir vida bağlamayı sağlar. Uç, bu vidanın sıkılmasıyla takım yatağına sabitlenir. Talaş akışının önünde herhangi bir engel olmadığı için bu çözüm özellikle kullanışlıdır.



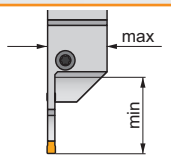
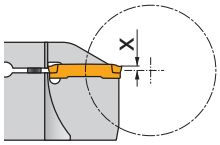
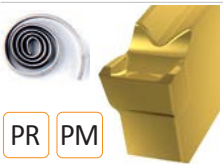
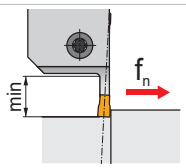
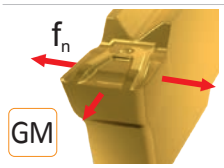
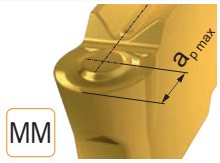
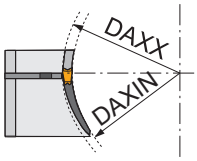
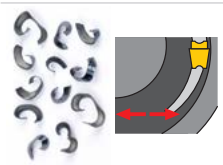
ISO G

Bu bağlama sistemi, yuva tornalama ve kopya tornalama takımlarında (CTP sistemi) kullanılır. Uç, üstten bir bağlama ile tutucu yatağa itilir. Tutucuda, bağlamada ve ayrıca ucun içinde bulunan temas yüzeyi, ucun yerinin kesme hızı ilerleme bileşeni tarafından değiştirilmesini önlemek üzere şekillendirilmiştir.



ISO X

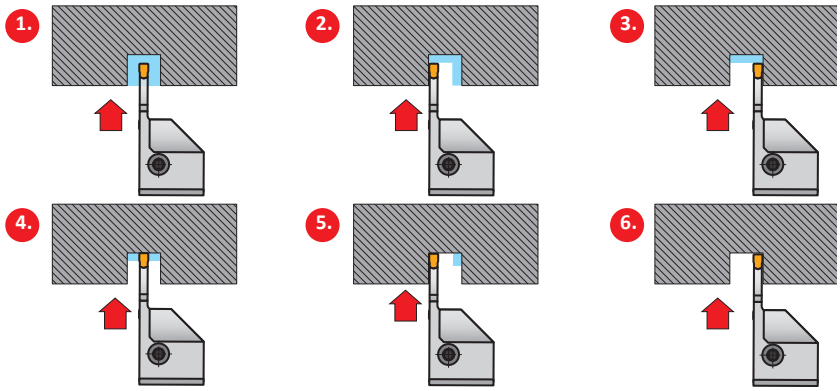
Bu işaret, özel bağlama sistemine sahip olarak adlandırılan (yani, takım üreticilerine ve tedarikçilerine göre farklılıklar gösteren) takımları tanımlar. Bizim durumumuzda bu işaret altında, kendiliğinden kilitlenen yatağa kesici uç sıkıştırmak için kesme direncini kullanan takım tutucularını belirtiyoruz. Bu kenetleme sistemi, ayırma ve yuva oluşturma için tasarlanmış takımlarda kullanılır.

Örnek	Öneriler
	Titreşimleri azaltmak için mümkün olduğunca maksimum enine kesite, minimum takım kullanma mesafesine ve CDX'e (maksimum kesme derinliği) sahip bir takım tutucu seçin.
	Yeterli miktarda kesme sıvısının doğrudan kesme kenarına uygulanması, kesme kenarının ve yuvanın sıcaklığını düşürerek daha uzun takım ömrü sağlar.
	Dilimleme veya derin kanal açma sırasında, titreşimleri azaltmak için kesme kenarının iş parçası eksenine göre biraz daha yüksekte ayarlanması tavsiye edilir.
	Kesme veya derin kanal açma işlemlerinde, spiral biçimli talaşlar oluşturan PM veya PR talaş kırıcıları kullanın.
	Boyuna tornalama sırasında, titreşimleri ve takım sapmasını azaltmak için mümkün olduğunca minimum CDX'e (maksimum kesme derinliği) sahip takımların kullanılması tavsiye edilir.
	Boyuna tornalama uygulamalarında, kesme kenarının ön tarafında ve her iki yanında uygun geometriye sahip GM talaş kırıcı kullanın.
	MM talaş kırıcı ile kopya tornalama yaparken, maksimum kesme derinliği geometri çapının %50'sidir.
	Delik içi kanal açma işlemlerinde, sadece kısa talaşlar oluşturan GM ve MM talaş kırıcıları kullanın.
	Alına kanal açma sırasında, işlenecek ilk kanal için doğru çap aralığına sahip bir takım tutucu seçilmesi gerekir.
	Derin alına kanal açma uygulamalarında, sadece alın kanalında sıkışıp kalmayan uzun helisel talaşlar oluşturan GM talaş kırıcı kullanın.
	Alın tornalama ve profil işleme uygulamalarında, sadece kısa talaşlar oluşturan GM ve MM talaş kırıcıları kullanın.

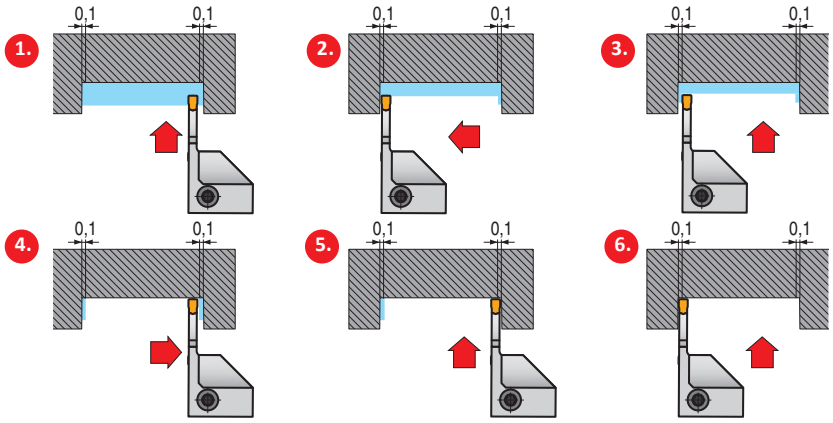
Pratik kullanım için öneri:

Bir oyuğu tornalama (derinleştirme ve genişletme) prosedürü aşağıdaki şekilde gösterilmiştir.

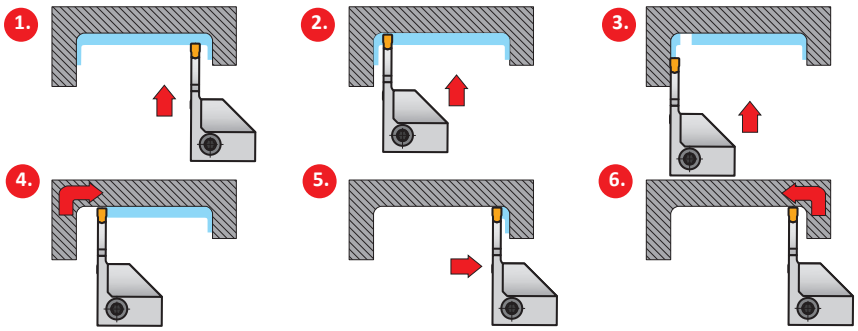
Not: Düz bir yuva yüzeyi oluşturmak için, **GL** tipi ucu **GM** talaş kırıcısıyla veya **LCMF** ucu **F** talaş kırıcısıyla birlikte kullanın. Dışa doğru radyal kanal açma geçişleri, uç köşe yarıçapının iki katı kadar olarak merkezi geçişle örtüşmelidir.



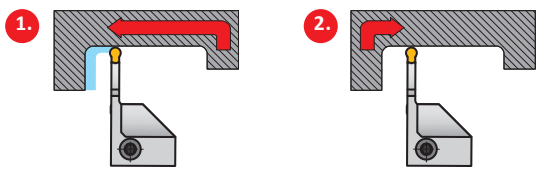
Geniş bir oyuğu işlerken, aşağıdaki şekilde gösterilen prosedürü izleyin.



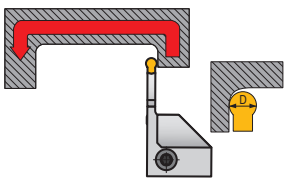
Yan tornalama kullanarak bir konturu açarken veya derinleştirirken, aşağıdaki resimde gösterilen prosedürü kullanın.



Konturun kaba işlenmesi (yuvarlak kesme kenarlı kesici uç)

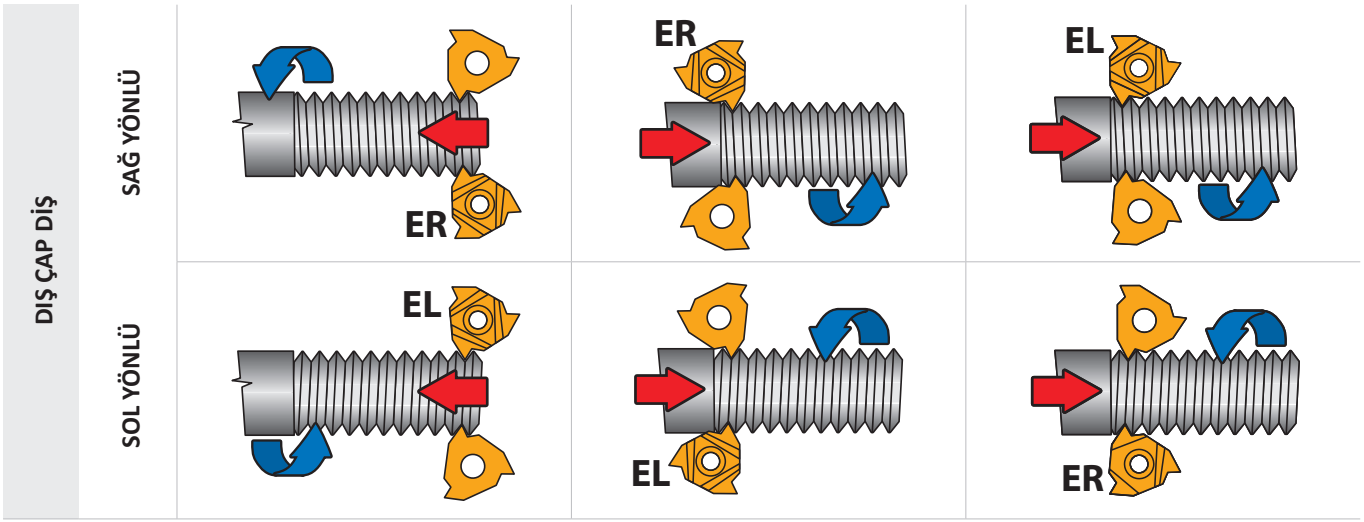


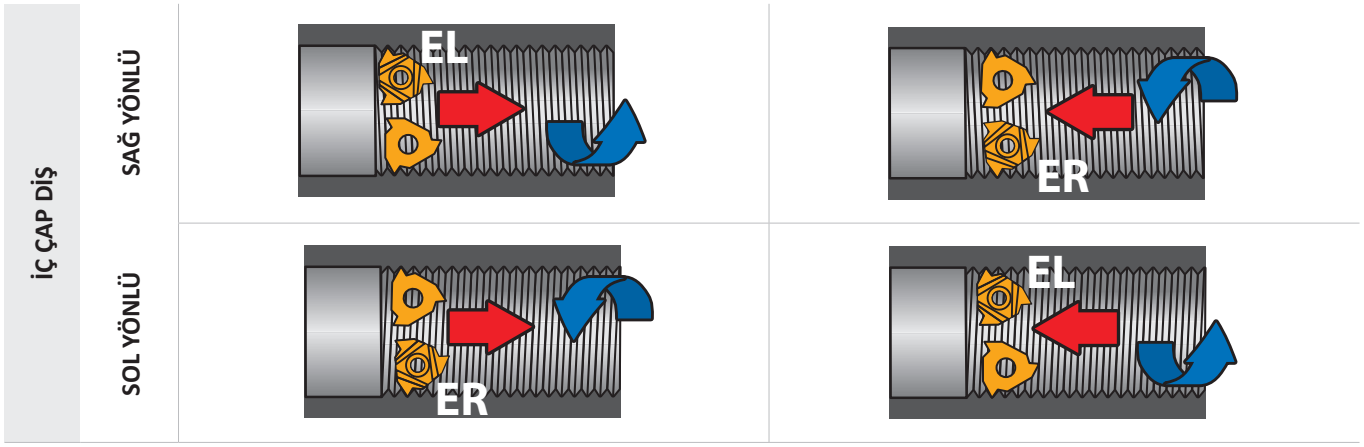
Konturun finiş işlemesi (yuvarlak kesme kenarlı kesici uç)



DİŞ AÇMA

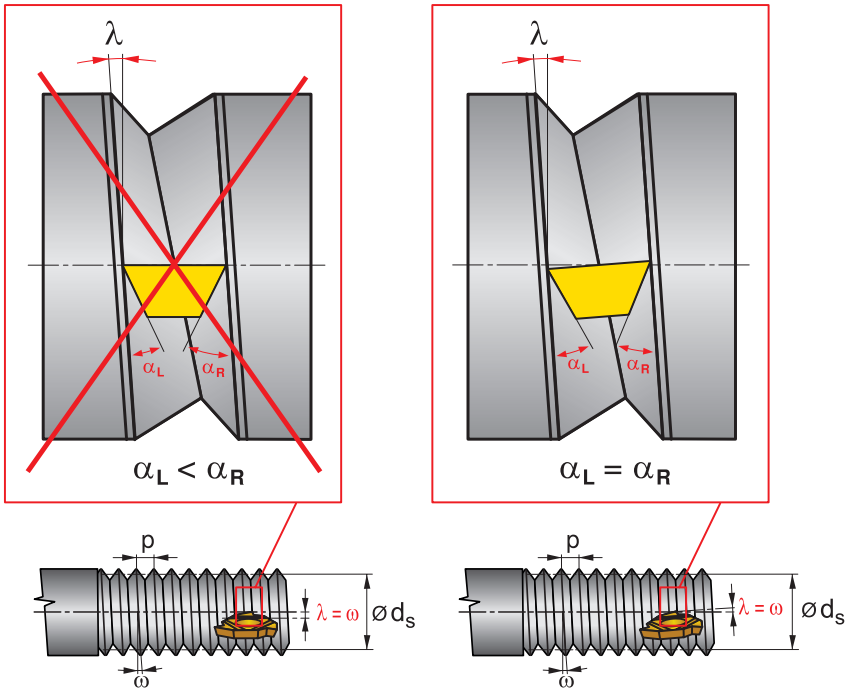
Üretim yöntemi seçimi iş parçasından ve makineden etkilenir. İş parçası dış veya iç diş, sağ veya sol diş. Makine sağ veya sol yönlü takım. Aşağıdaki Tablo i kullanabilirsiniz.





İş parçası hareketi Takım hareketi **L / R** Uç tasarımı

Helis açısının hesaplanması için aşağıdaki formül kullanılabilir:



$$tg\ \omega = \frac{p}{d_s \cdot \pi}$$

ω Helis açısı [°]

p Hatve [mm]

d_s Hatve çapı [mm]

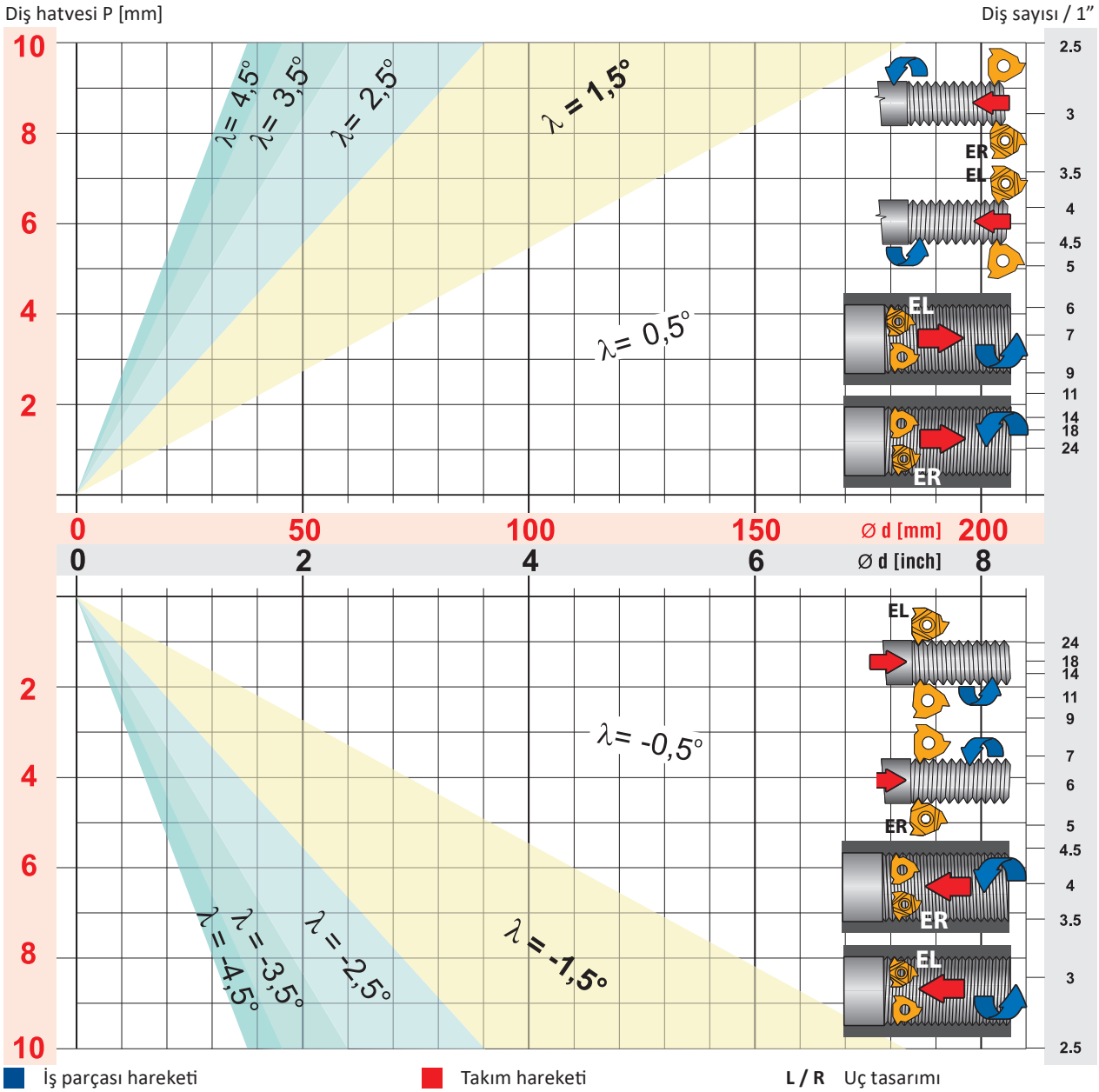
Doğru diş formunu ve uç üzerinde aynı aşınmayı oluşturmak için kesme kenarı helis açısı diş kılavuz açısına eşit olmalıdır.
Takım tutucular genellikle helis açısı λ = 1.5° olarak temin edilir. Altlık değiştirilerek farklı helis açısı seçilebilir.
Doğru altlık seçimi için aşağıdaki Tablo ve ya Şekil Grafik 'i kullanabilirsiniz.

Ayar sacı seçimi

Helis açısı λ	Pozitif					Negatif	
	4.5°	3.5°	2.5°	1.5°	0.5°	-0.5°	-1.5°
Tutucu	**Altlık tanımı**						
SER .... .16; SIL .... .16	PE16+4.5	PE16+3.5	PE16+2.5	**PE16+1.5**	PE16+0.5	PE16-0.5	PE16-1.5
SEL .... .16; SIR .... .16	PI16+4.5	PI16+3.5	PI16+2.5	**PI16+1.5**	PI16+0.5	PI16-0.5	PI16-1.5
SER .... .22; SIL .... .22	PE22+4.5	PE22+3.5	PE22+2.5	**PE22+1.5**	PE22+0.5	PE22-0.5	PE22-1.5
SEL .... .22; SIR .... .22	PI22+4.5	PI22+3.5	PI22+2.5	**PI22+1.5**	PI22+0.5	PI22-0.5	PI22-1.5
SER-S .... .22; SIL-S .... .22	PE22S+4.5	PE22S+3.5	PE22S+2.5	**PE22S+1.5**	PE22S+0.5	PE22S-0.5	PE22S-1.5
SEL-S .... .22; SIR-S .... .22	PI22S+4.5	PI22S+3.5	PI22S+2.5	**PI22S+1.5**	PI22S+0.5	PI22S-0.5	PI22S-1.5

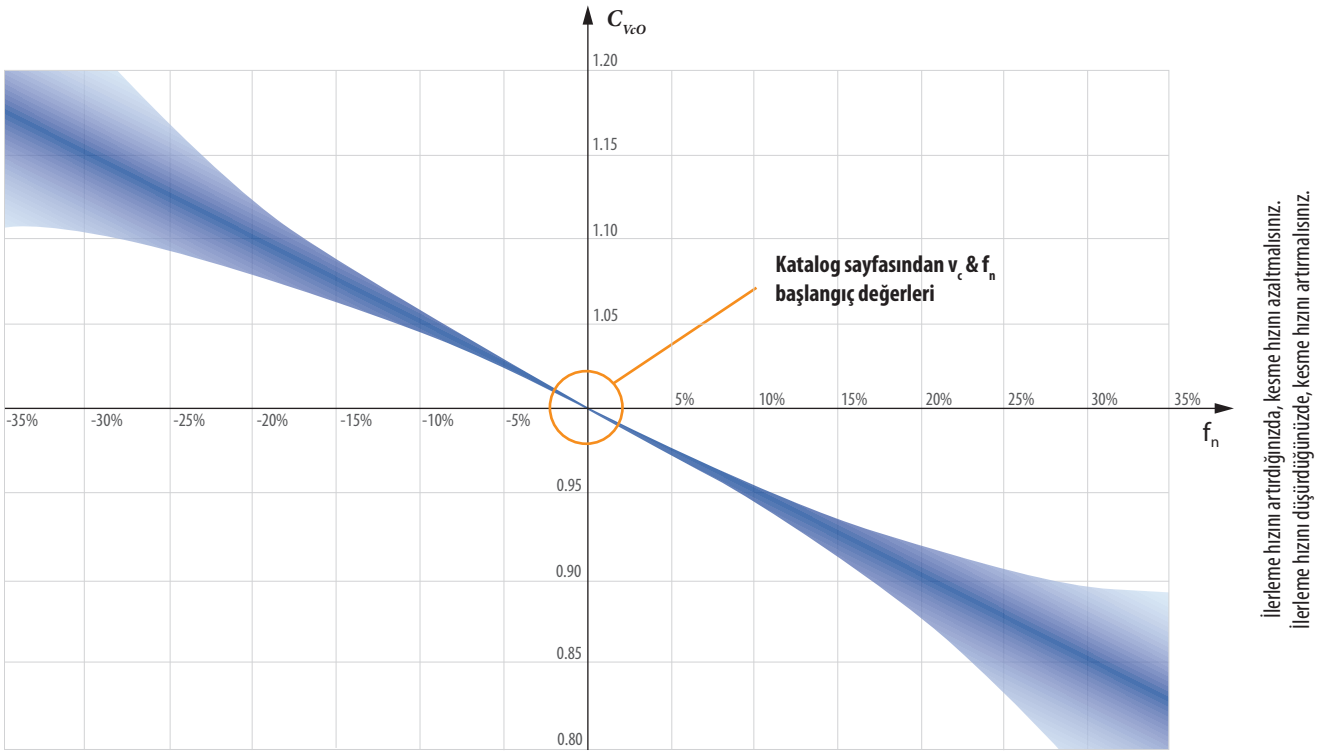
Takım tutucular genellikle helis açısı λ = 1.5° olarak temin edilir. Altlık değiştirilerek farklı helis açısı seçilebilir.
Doğru altlık seçimi için aşağıdaki Tablo 16 ve ya Şekil Grafik 21'i kullanabilirsiniz. SER-S ...., SIR-S .... tutucuları için ayar sacları „***S***" ile işaretlenmiştir.

Ayar sacı seçimi için grafik



DÜZELTME FAKTÖRLERİ

İlerleme hızı değişiminin bir fonksiyonu olarak kesme hızı düzeltme faktörü C_{VcO}:



Gerekli dayanıklılık için düzeltme faktörleri C_{VcT}

dakika	10	15	20	30	45	60
Genel işleme (finiş işlemeden kaba talaş işlemeye)	1.13	1.00	0.93	0.84	0.76	0.71
Ağır işleme (ağır kaba işleme)	–	–	–	1.10	1.00	0.93

Ek düzeltme faktörleri C_{VcA}

İşleme ortamı	C_{VcA}	C_{VcB}
İş malzemesinin durumu (dövme veya döküm nedeniyle bozuk yüzey)	0.70	
İç çap tornalama	0.75	
Dilimleme ve kanal açma (radyal)	0.88	
Alına Kanal Açma	0.80	
Darbeli Kesim		0.80
Stabil olmayan işleme şartları		0.85
Yaygın işleme şartları		1.00
Stabil işleme şartları		1.20

Ortaya çıkan düzeltilmiş kesme hızı v_{cC}

$$v_{cC} = v_c \cdot k_{vG} \cdot C_{VcO} \cdot C_{VcT} \cdot C_{VcA} \cdot C_{VcB}$$

k_{vG} – kullanılan malzemenin katsayısı
v_c – katalog sayfasından başlangıç hızı

KESME HIZI FORMÜLLERİ

Değer	Formül	Birim	Not
Fener mili hızı	$n = \frac{v_c \cdot 1000}{D \cdot \pi}$	[1/dk]	n Fener mili hızı [1/dk] D Çap (takım veya işparçası) [mm] v_c Kesme hızı [m/dk] f_{rev} Devir başına ilerleme [mm/dev] f_{min} Dakika başına ilerleme [mm/dk]
Kesme hızı	$v_c = \frac{\pi \cdot D \cdot n}{1000}$	[m/dk]	
Devir başına ilerleme	$f_{rev} = \frac{f_{min}}{n}$	[mm/dev]	
Dakika başına ilerleme	$f_{min} = v_f = f_{rev} \cdot n$	[mm/dk]	
Maks.Yüzey yüksekliği R_{max}	$R_{max} = \frac{125 \cdot f_{rev}^{\ 2}}{RE}$	[mm]	R_{max} Maks.Yüzey yüksekliği [mm] R_a Yüzey kalitesi [mm] f_{rev} Devir başına ilerleme [mm/dev] RE Uç radyusu [mm]
Yüzey kalitesi R_a	$R_a = \frac{43{,}9 \cdot f_{rev}^{\ 1{,}88}}{RE^{\ 0{,}97}}$	[mm]	
Talaş kesiti	$A = f_{rev} \cdot a_p$	(mm^2)	A Talaş kesiti [mm^2] f_{rev} Devir başına ilerleme [mm/dev] a_p Eksenel paso [mm] κ_r Birinci köşe yanaşma açısı [°] h Talaş kalınlığı [mm] v_c Kesme hızı [m/dk] f_{min} Dakika başına ilerleme [mm/dk] Q Dakikada talaş kaldırma hacmi [cm^3/dk] $INSD$ Kesici uç çapı (mm)
Talaş kalınlığı (düz kenarlı uçlar için)	$h = f_{rev} \cdot \sin \kappa_r$	(mm)	
Talaş kalınlığı (yuvarlak kesici uçlar için)	$h = f_{rev} \cdot \sqrt{\frac{a_p}{INSD}}$	(mm)	
Talaş kaldırma hacmi	$Q = a_p \cdot f_{rev} \cdot v_c$	(cm^3/dk)	
Güç gereksinimi	$P_c = \frac{a_p \cdot f_{rev}^{\ 1-c} \cdot k_{c1} \cdot v_c \cdot k\kappa_r}{6 \cdot 10^4 \cdot \eta}$	(kW)	P_c Güç gereksinimi [kW] a_p Paso [mm] f_{rev} rev İlerlem (mm/dev) [mm/dev] c Sabit KTV [1] k_c Özgül kesme kuvveti [MPa] k_{κ_r} kr sabit açı [1] η Verimlilik (genellikle n= 0,75) [1] x Malzeme sabiti [1]
Ortalama güç gereksinimi	$P_c = \frac{a_p \cdot f_{rev} \cdot v_c}{x}$	(kW)	

Malzeme	Çelik	Dökme Demir	Al
Katsayısı x	20	25	100

TAVSİYE EDİLEN TORK ANAHTARLARI

VİDA SIKMA

Vida tipi	Vida	Tork (Nm)*
28588	MA2-8304	0.8
28992	MA2-8304	0.8
416.1-832	PT-8002	3.6
5513 020-01	PT-8004	3.6
5513 020-03	PT-8001	0.8
5513 020-04	PT-8003	1.5
5513 020-05	PT-8001	0.8
5513 020-14	TX 225PLUS	8.5
5513 020-24	PT-8002	1.5
5513 020-27	PT-8000	0.6
5513 020-28	PT-8000	0.6
5513 021-03	DMN 3124	13
CS 8601-T09P	SDR T09P	1.7
CS 8601-T15P	SDR T15P	3.9
CS 8601-T20P	SDR T20P	6.4
CS 8601-T25P	SDR T25P	9.5
DVF 0573	PT-8002	1.5
DVF 2260	TX 215PLUS	3.6
DVF 3584	DMD 1650	0.6
DVF 3593	TX 207PLUS	0.8
HS 0408	HXK 3	5
HS 0412	HXK 3	5
HS 0516	HXK 4	5
HS 0520C	HXK 4	5
HS 0616C	HXK 5	8
HS 0620	HXK 5	6
HS 0620C	HXK 5	6
HS 0625	HXK 5	6
HS 0625C	HXK 5	6
HS 0630	HXK 5	6
HS 0825	HXK 6	10
HS 0830	HXK 6	10
HS 0835	HXK 6	10
HS 0840	HXK 8	11
HS 1030	HXK 8	8
HS 1060	HXK 6	10
HS 93	HXK 5	8
HS 94	HXK 5	8
HSI 1020	HXK 6	8
PS 0512	HXK 2	2
PS 0512-A	HXK 2	2
PS 0616	HXK 2,5	4
PS 12040	HXK 5	8

VİDA SIKMA

Vida tipi	Vida	Tork (Nm)*
PS 6026-709P	SRD T09P	2
PS 8290	HXK 2	2
SR 14	HXK 10	10
SR 85011-T15P	SDR T15P	5
SR 85017-T09P	SDR T09P	2
SR 85020-T15P	SDR T15P	3
SR 86025-T20P	SRD T20P	5
SR 88026-T30P	LKT30P	5
T20.037	DMD 1650	0.6
UP 0909-T09P	SRD T09P	2
UP 1515-T15P	SDR T15P	8
US 2505-T07P	SDR T07P	0.9
US 2506-T07P	SDR T07P	0.9
US 3007-T09P	SDR T09P	2
US 34	HXK 3	5
US 35	HXK 4	6
US 3508-T15P	SDR T15P	3
US 3510A-T15P	SDR T15P	3
US 3510-T15P	SDR T15P	3
US 3512A-T15P	SDR T15P	3
US 3512-T15P	SDR T15P	3
US 36	HXK 4	6
US 38	HXK 5	8
US 39	HXK 5	8
US 40	HXK 4	6
US 4008-T15P	SDR T15P	3.5
US 4011-T15P	SDR T15P	3.5
US 41	HXK 4	6
US 42	HXK 4	6
US 45013-T20P	SDR T20P	5
US 4512-T15P	SDR T15P	5
US 4514A-T20	SDR T20	5
US 46	HXK 3	5
US 46017-T20P	SDR T20P	5
US 47	HXK 5	8
US 5012-T15P	SDR T15P	5
US 5015-T20P	SDR T20P	5
US 5018-T20P	SDR T20P	5
US 6020-T25P	SDR T25P	6
US 64518-T15P	SDR T15P	5
US 8025-T30P	SDR T20P	13
US 83	HXK 4	6
US 95	HXK 4	10

TORK ANAHTARLARI

Tork kolu	Tork (Nm)	Vida dişi sıkma
MR-0.8-2.0 vario	0.5 – 2.0	M 2 – M 3
MR-1.0-5.0 vario	0.8 – 5.0	M 2.5 – M 5
MR-0.9 fix	0.9	M 2
MR-2.0 fix	2.0	M 3
MR-3.0 fix	3.0	M 3.5
MR-3.5 fix	3.5	M 4
MR-5.0 fix	5.0	M 5

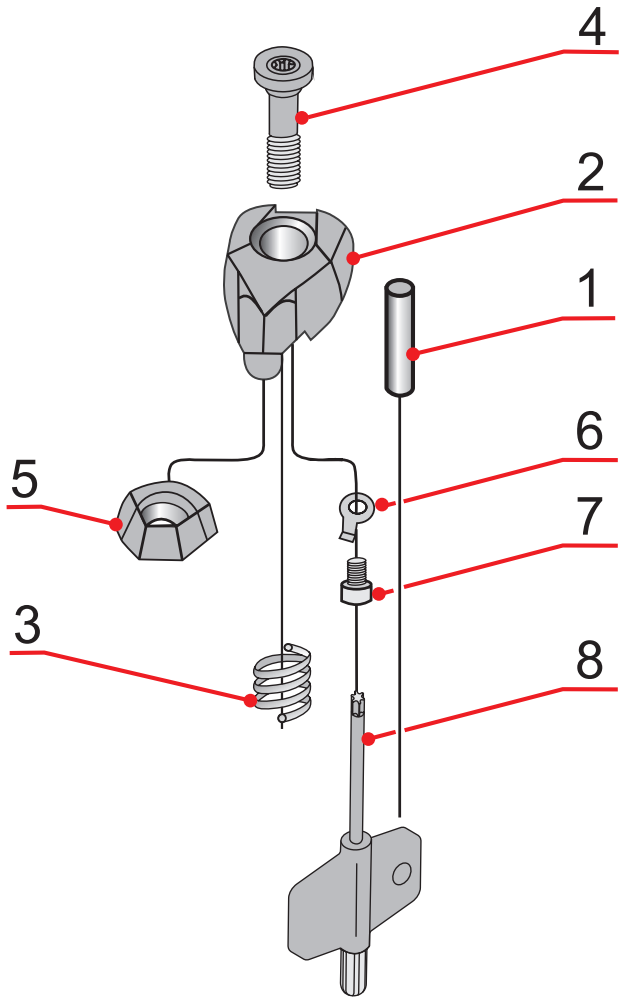
DEĞİŞTİRİLEBİLİR GÖVDELER

Değiştirilebilir gövdeler		
D-T6	**D-T8**	**D-T15**
D-T6P	**D-T8P**	**D-T15P**
D-T7	**D-T9**	**D-T20**
D-T7P	**D-T9P**	**D-T20P**

VİDA YAĞLAMA

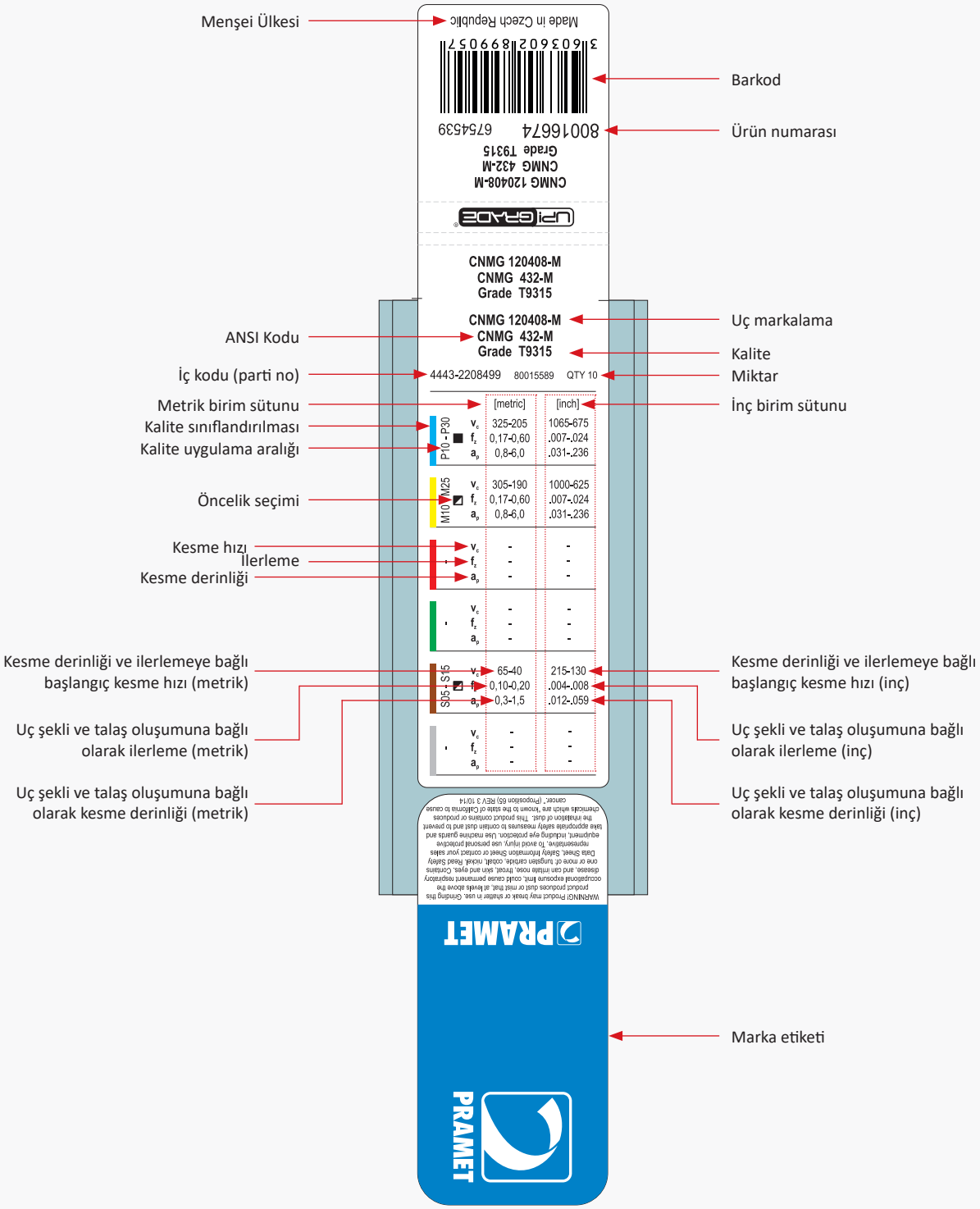
Uç sıkma vidaları yüksek ısıl gerilime maruz kalır. Tüm vidaların MOLYCOTE 1000 gibi yüksek kaliteli macun ile yağlanması tavsiye edilir.

KOMPLE SIKMA SETİ



	1	2	3	4		5	6	7	8
					Nm				
DCS 09	CP 2655	CD 09	PR 0157	CS 8601-T09P	1.7	–	–	–	–
DCS 12	CP 2607	CD 12	PR 0158	CS 8602-T15P	3.9	–	–	–	–
DCS 16	CP 2607	CD 16	PR 0159	CS 8603-T20P	6.4	–	–	–	–
DCS 19	CP 2607	CD 19	PR 0159	CS 8603-T20P	6.4	–	–	–	–
DCS 25	CP 2607	CD 25	PR 0101	CS 8604-T25P	9.5	–	–	–	–
DCS 16V	CP 2607	CD 16V	PR 0158	CS 8602-T15P	3.9	–	–	–	–
DCS 12C2	CP 2607	CD 12C2	PR 0158	CS 8602-T15P	3.9	PP 3002	H 1201	CS 9701-T07P	FLAG T07P
DCS 16C2	CP 2607	CD 16C2	PR 0159	CS 8603-T20P	6.4	PP 3003	H 1201	CS 9701-T07P	FLAG T07P
DCS 12C4	CP 2607	CD 12C4	PR 0158	CS 8602-T15P	3.9	PP 3002	H 1201	CS 9701-T07P	FLAG T07P
DCS 16C4	CP 2607	CD 16C4	PR 0159	CS 8603-T20P	6.4	PP 3003	H 1201	CS 9701-T07P	FLAG T07P

UÇ KUTUSU ÜZERİNDEKİ TEKNİK BİLGİLER



WMG (İŞ PARÇASI MALZEME GRUPLARI)

ISO grup		WMG (İş Parçası Malzeme Grupları)			Sertlik (HB veya HRC)	Toplam Gerilme Dayanımı (MPa)	Düzeltme fakt. *kvG*
P	P1	P1.1	Kolay işlenebilir çelik (İşlenebilirliği artırılmış karbon çeliği)	Sülfürlü	< 240 HB	≤ 830	1.33
		P1.2		Sülfürlü ve fosforlu	< 180 HB	≤ 620	1.49
		P1.3		Sülfürlü/fosforlu ve kurşunlu	< 180 HB	≤ 620	1.53
	P2	P2.1	Yalın karbon çeliği (demir ve karbon ağırlıklı çelik)	İçerik < 0.25 % C	< 180 HB	≤ 620	1.14
		P2.2		İçerik < 0.55 % C	< 240 HB	≤ 830	1.00
		P2.3		İçerik > 0.55 % C	< 300 HB	≤ 1030	0.89
	P3	P3.1	Alaşımlı çelik (karbonlu çelik, alaşım ≤ %10)	Tavlanmış	< 180 HB	≤ 620	0.92
		P3.2		Sertleştirilmiş ve tavlanmış	180 – 260 HB	> 620 ≤ 900	0.74
		P3.3			260 – 360 HB	> 900 ≤ 1240	0.63
	P4	P4.1	Takım çeliği (kalıp için özel alaşımlı çelikler)	Tavlanmış	< 26 HRC	≤ 900	0.55
		P4.2		Sertleştirilmiş ve tavlanmış	26 – 39 HRC	> 900 ≤ 1240	0.47
		P4.3			39 – 45 HRC	> 1240 ≤ 1450	0.38
M	M1	M1.1	Ferritik paslanmaz çelik (sertleştirilemiyen düz krom alaşımı)		< 160 HB	≤ 520	1.22
		M1.2			160 – 220 HB	> 520 ≤ 700	1.03
	M2	M2.1	Martensitik paslanmaz çelik (sertleştirilebilir düz krom alaşımı)	Tavlanmış	< 200 HB	≤ 670	1.08
		M2.2		Sertleştirilmiş ve tavlanmış	200 – 280 HB	> 670 ≤ 950	0.89
		M2.3		Yaş sertleştirme	280 – 380 HB	> 950 ≤ 1300	0.75
	M3	M3.1	Östenitik paslanmaz çelik (krom nikel ve krom nikel manganlı alaşımlar)		< 200 HB	≤ 750	1.00
		M3.2			200 – 260 HB	> 750 ≤ 870	0.86
		M3.3			260 – 300 HB	> 870 ≤ 1040	0.77
	M4	M4.1	Östenitik ferritik (DUPLEX) veya süper östenitik paslanmaz çelik		< 300 HB	≤ 990	0.75
		M4.2	Yaş sertleştirilmiş östenitik paslanmaz çelik		300 – 380 HB	≤ 1320	0.64
K	K1	K1.1	Pik döküm (ASTM A48) veya Otomotiv Pik döküm (ASTM A159) (lamelli grafit mikroyapıya sahip demir karbon döküm)	Ferritik veya ferritik perlitik	< 180 HB	≤ 190	1.35
		K1.2		Ferritik perlitik veya perlitik	180 – 240 HB	> 190 ≤ 310	1.00
		K1.3		Perlitik	240 – 280 HB	> 310 ≤ 390	0.75
	K2	K2.1	Dövülebilir demir (ASTM A602) (grafitsiz mikroyapılı demir karbon dökümü)	Ferritic	< 160 HB	≤ 400	1.39
		K2.2		Ferritik veya perlitik	160 – 200 HB	> 400 ≤ 550	1.13
		K2.3		Perlitik	200 – 240 HB	> 550 ≤ 660	0.90
	K3	K3.1	Sfero döküm (ASTM A536) (sfero grafit mikroyapılı demir karbon dökümü)	Ferritik	< 180 HB	≤ 560	1.23
		K3.2		Ferritik veya perlitik	180 – 220 HB	> 560 ≤ 680	0.94
		K3.3		Perlitik	220 – 260 HB	> 680 ≤ 800	0.76
	K4	K4.1	Östenitik pik döküm (ASTM A436) (östenitik lamelli grafit mikroyapılı demir-karbon alaşımlı döküm)		< 180 HB	≤ 190	1.14
		K4.2	Östenitik sfero döküm (ASTM A439 veya ASTM A571) (östenitik sfero grafit mikroyapılı demir karbon alaşımlı döküm)		< 240 HB	≤ 740	0.86
		K4.3	Östemperlenmiş pik döküm (ASTM A897) (österrit mikroyapılı demir karbon alaşımlı döküm)		< 280 HB	> 840 ≤ 980	0.63
		K4.4			280 – 320 HB	> 980 ≤ 1130	0.54
		K4.5			320 – 360 HB	> 1130 ≤ 1280	0.45
	K5	K5.1	Sıkıştırılmış grafit demir CGI (ASTM A842) (kıvrımlı grafit yapılı demir karbon döküm)	Ferritik	< 180 HB	≤ 400	1.29
		K5.2		Ferritik-perlitik	180 – 220 HB	> 400 ≤ 450	0.97
		K5.3		Perlitik	220 – 260 HB	> 450 ≤ 500	0.75
N	N1	N1.1	Saf dövme alüminyum		< 60 HB	≤ 240	1.33
		N1.2	Dövme alüminyum alaşımları	Yarı sert tavlanmış	60 – 100 HB	> 240 ≤ 400	1.00
		N1.3		Tam sert tavlanmış	100 – 150 HB	> 400 ≤ 590	0.67
	N2	N2.1	Döküm alüminyum alaşımları		< 75 HB	≤ 240	0.67
		N2.2			75 – 90 HB	> 240 ≤ 270	0.60
		N2.3			90 – 140 HB	> 270 ≤ 440	0.43
	N3	N3.1	Kolay işlenebilir bakır alaşımları		–	–	0.70
		N3.2	Orta zorlukta işlenebilir, kısa talaş veren bakır alaşımları		–	–	0.41
		N3.3	Zor işlenebilir, uzun talaş veren bakır alaşımları		–	–	0.21
	N4	N4.1	Termoplastik polimerler		–	–	0.70
		N4.2	Termoset polimerler		–	–	0.27
		N4.3	Camelyaf polimer veya kompozitler		–	–	0.29
	N5	N5.1	Grafit		–	–	1.00
S	S1	S1.1	Titanyum ya da titanyum alaşımları		< 200 HB	≤ 660	1.94
		S1.2			200 – 280 HB	> 660 ≤ 950	1.72
		S1.3			280 – 360 HB	> 950 ≤ 1200	1.44
	S2	S2.1	Fe-bazlı sıcak iş alaşımları		< 200 HB	≤ 690	1.33
		S2.2			200 – 280 HB	> 690 ≤ 970	1.17
	S3	S3.1	Ni-bazlı sıcak iş alaşımları		< 280 HB	≤ 940	1.00
		S3.2			280 – 360 HB	> 940 ≤ 1200	0.83
	S4	S4.1	Co-bazlı sıcak iş alaşımları		< 240 HB	≤ 800	0.78
		S4.2			240 – 320 HB	> 800 ≤ 1070	0.67
H	H1	H1.1	Soğutulmuş dökme demir		< 440 HB	–	1.52
	H2	H2.1	Sertleştirilmiş dökme demir		< 55 HRC	–	0.90
		H2.2			> 55 HRC	–	0.77
	H3	H3.1	Sertleştirilmiş çelik < 55 HRC		< 51 HRC	–	1.00
		H3.2			51 – 55 HRC	–	0.82
	H4	H4.1	Sertleştirilmiş çelik > 55 HRC		55 – 59 HRC	–	0.64
		H4.2			> 59 HRC	–	0.54

SERTLİK ÇEVRİM TABLOSU

Dayanım (MPa)	Sertlik			
	BRINELL	VICKERS	ROCKWELL	ROCKWELL
R_m	HB	HV	HRB	HRC
285	86	**90**	1190	–
320	95	**100**	56.2	–
350	105	**110**	62.3	–
385	114	**120**	66.7	–
415	124	**130**	71.2	–
450	133	**140**	75.0	–
480	143	**150**	78.7	–
510	152	**160**	81.7	–
545	162	**170**	85.8	–
575	171	**180**	87.1	–
610	181	**190**	89.5	–
640	190	**200**	91.5	–
675	199	**210**	93.5	–
705	209	**220**	95	–
740	219	**230**	96.7	–
770	228	**240**	98.1	–
800	238	**250**	99.5	–
820	242	**255**	–	23.1
850	252	**265**	–	24.8
880	261	**275**	–	26.4
900	266	**280**	–	27.1
930	276	**290**	–	28.5
950	280	**295**	–	29.2
995	295	**310**	–	31.0
1030	304	**320**	–	32.2
1060	314	**330**	–	33.3
1095	323	**340**	–	34.4
1125	333	**350**	–	35.5
1155	342	**360**	–	36.6

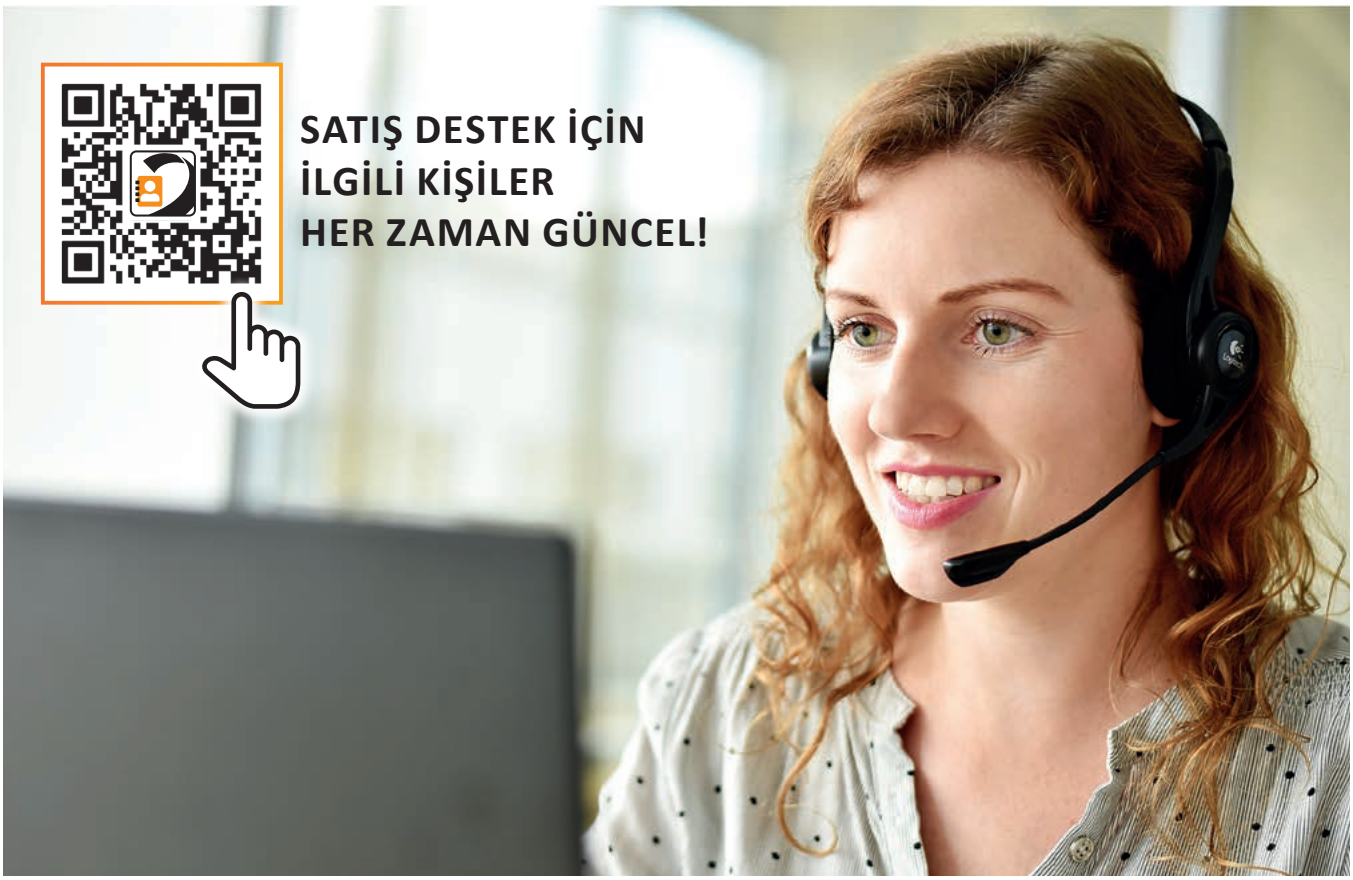
Dayanım (MPa)	Sertlik			
	BRINELL	VICKERS	ROCKWELL	ROCKWELL
R_m	HB	HV	HRB	HRC
1190	352	**370**	–	37.7
1220	361	**380**	–	38.8
1255	371	**390**	–	39.8
1290	380	**400**	–	40.8
1320	390	**410**	–	41.8
1350	399	**420**	–	42.7
1385	409	**430**	–	43.6
1420	418	**440**	–	44.5
1455	428	**450**	–	45.3
1485	437	**460**	–	46.1
1520	447	**470**	–	46.9
1555	456	**480**	–	47.7
1595	466	**490**	–	48.4
1630	475	**500**	–	49.1
1665	485	**510**	–	49.8
1700	494	**520**	–	50.5
1740	504	**530**	–	51.1
1775	513	**540**	–	51.7
1810	523	**550**	–	52.3
1845	532	**560**	–	53.0
1880	542	**570**	–	53.6
1920	551	**580**	–	54.1
1955	561	**590**	–	54.7
1995	570	**600**	–	55.2
2030	580	**610**	–	55.7
2070	589	**620**	–	56.3
2105	599	**630**	–	56.8
2145	608	**640**	–	57.3
2180	618	**650**	–	57.8

SIMPLY RELIABLE

Profesyoneller sadece talaşa bakarak işin kalitesini eğerlendirebilir. Bizim talaşımız kendi öyküsünü anlatan pürüzsüz ve basit şekillidir. Açık ve istikrarlı işaretinden dolayı basitçe güvenilir olmak için sembolümüz olarak talaş **şeklini kullanıyoruz**.

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