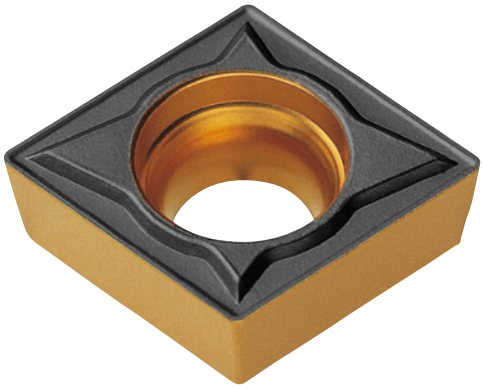
Wendeschneidplatte Hartmetall CCMT (mittlere Bearbeitung)

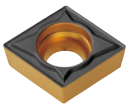
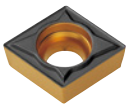
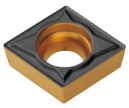
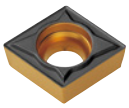
Ideal für mittlere Zustellungen und Vorschübe in Stahl (ISO P)

- Reduzierte Schnittlast dank weichschneidender Geometrie

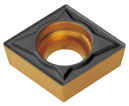
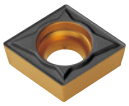
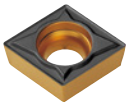
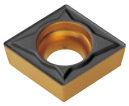


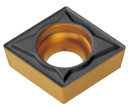
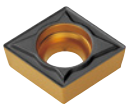
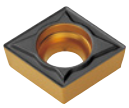
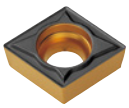
CNC|TEC

Zu bearbeitender Werkstoff	Stahl
Zustellungsart	Mittlere Bearbeitung
Werkstoff	Hartmetall
Spanbrecherbezeichnung	C25
Wendeschneidplattenform ISO	C
Freiwinkel Wendeschneid-platte ISO	C
Toleranzklasse Wende-schneidplatte ISO	M
Wendeschneidplattentyp ISO	T
Beschichtung	CVD
Hartmetallsortenbereich ISO	P
Werkstoffgruppe	P (Hauptanwendung)

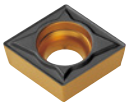
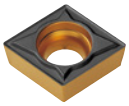
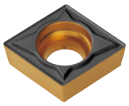
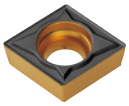
						
Art.-Nr.	**5445 321 304**	**5445 321 312**	**5445 321 320**	**5445 321 305**	**5445 321 313**	**5445 321 321**
VE	10	10	10	10	10	10
ISO-Code Drehen	CCMT 09T304	CCMT 09T304	CCMT 09T304	CCMT 09T308	CCMT 09T308	CCMT 09T308
Hartmetallsorte ISO	P15	P25	P30	P15	P25	P30
Hartmetallsorte	HC3215	HC3225	HC3030	HC3215	HC3225	HC3030
Bearbeitungsbe-dingung Wende-schneidplatte	Gut	Mittel	Ungünstig	Gut	Mittel	Ungünstig
Wendeschneid-plattengröße ISO	09	09	09	09	09	09
Wendeschneid-plattendicke ISO	T3	T3	T3	T3	T3	T3
Eckenradius Wendeschneid-platte ISO	04	04	04	08	08	08
ap min./max.	0,8-3 mm	0,8-3 mm	0,8-3 mm	1-3 mm	1-3 mm	1-3 mm
f min./max.	0,08-0,25 mm/U	0,08-0,25 mm/U	0,08-0,25 mm/U	0,1-0,3 mm/U	0,1-0,3 mm/U	0,1-0,3 mm/U
Vc in Stahl min./ max. (Vc in Stahl min./max. ●)	170-420 m/min	150-370 m/min	120-290 m/min	170-420 m/min	150-370 m/min	120-290 m/min

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Art.-Nr.	**5445 321 301**	**5445 321 309**	**5445 321 317**	**5445 321 302**	**5445 321 310**	**5445 321 318**
VE	10	10	10	10	10	10
ISO-Code Drehen	CCMT 060202	CCMT 060202	CCMT 060202	CCMT 060204	CCMT 060204	CCMT 060204
Hartmetallsorte ISO	P15	P25	P30	P15	P25	P30
Hartmetallsorte	HC3215	HC3225	HC3030	HC3215	HC3225	HC3030
Bearbeitungsbedingung Wendeschneidplatte	Gut	Mittel	Ungünstig	Gut	Mittel	Ungünstig
Wendeschneidplattengröße ISO	06	06	06	06	06	06
Wendeschneidplattendicke ISO	02	02	02	02	02	02
Eckenradius Wendeschneidplatte ISO	02	02	02	04	04	04
ap min./max.	0,4-2 mm	0,4-2 mm	0,4-2 mm	0,6-2,3 mm	0,6-2,3 mm	0,6-2,3 mm
f min./max.	0,03-0,12 mm/U	0,03-0,12 mm/U	0,03-0,12 mm/U	0,05-0,15 mm/U	0,05-0,15 mm/U	0,05-0,15 mm/U
Vc in Stahl min./max. (Vc in Stahl min./max. ●)	170-420 m/min	150-370 m/min	120-290 m/min	170-420 m/min	150-370 m/min	120-290 m/min

						
Art.-Nr.	**5445 321 303**	**5445 321 311**	**5445 321 319**	**5445 321 306**	**5445 321 314**	**5445 321 322**
VE	10	10	10	10	10	10
ISO-Code Drehen	CCMT 060208	CCMT 060208	CCMT 060208	CCMT 120404	CCMT 120404	CCMT 120404
Hartmetallsorte ISO	P15	P25	P30	P15	P25	P30
Hartmetallsorte	HC3215	HC3225	HC3030	HC3215	HC3225	HC3030
Bearbeitungsbedingung Wendeschneidplatte	Gut	Mittel	Ungünstig	Gut	Mittel	Ungünstig
Wendeschneidplattengröße ISO	06	06	06	12	12	12
Wendeschneidplattendicke ISO	02	02	02	04	04	04
Eckenradius Wendeschneidplatte ISO	08	08	08	04	04	04
ap min./max.	0,8-2,3 mm	0,8-2,3 mm	0,8-2,3 mm	0,8-3 mm	0,8-3 mm	0,8-3 mm
f min./max.	0,08-0,25 mm/U	0,08-0,25 mm/U	0,08-0,25 mm/U	0,1-0,32 mm/U	0,1-0,32 mm/U	0,1-0,32 mm/U
Vc in Stahl min./max. (Vc in Stahl min./max. ●)	170-420 m/min	150-370 m/min	120-290 m/min	170-420 m/min	150-370 m/min	120-290 m/min

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Art.-Nr.	**5445 321 307**	**5445 321 315**	**5445 321 323**	**5445 321 308**	**5445 321 316**
VE	10	10	10	10	10
ISO-Code Drehen	CCMT 120408	CCMT 120408	CCMT 120408	CCMT 120412	CCMT 120412
Hartmetallsorte ISO	P15	P25	P30	P15	P25
Hartmetallsorte	HC3215	HC3225	HC3030	HC3215	HC3225
Bearbeitungsbedingung Wendeschneidplatte	Gut	Mittel	Ungünstig	Gut	Mittel
Wendeschneidplattengröße ISO	12	12	12	12	12
Wendeschneidplattendicke ISO	04	04	04	04	04
Eckenradius Wendeschneidplatte ISO	08	08	08	12	12
ap min./max.	1,2-3,5 mm	1,2-3,5 mm	1,2-3,5 mm	1,4-3,5 mm	1,4-3,5 mm
f min./max.	0,12-0,36 mm/U	0,12-0,36 mm/U	0,12-0,36 mm/U	0,12-0,36 mm/U	0,12-0,36 mm/U
Vc in Stahl min./max. (Vc in Stahl min./max. ●)	170-420 m/min	150-370 m/min	120-290 m/min	170-420 m/min	150-370 m/min

Details/Anwendung

Längs- und Plandrehen bei moderaten Zustellungen

