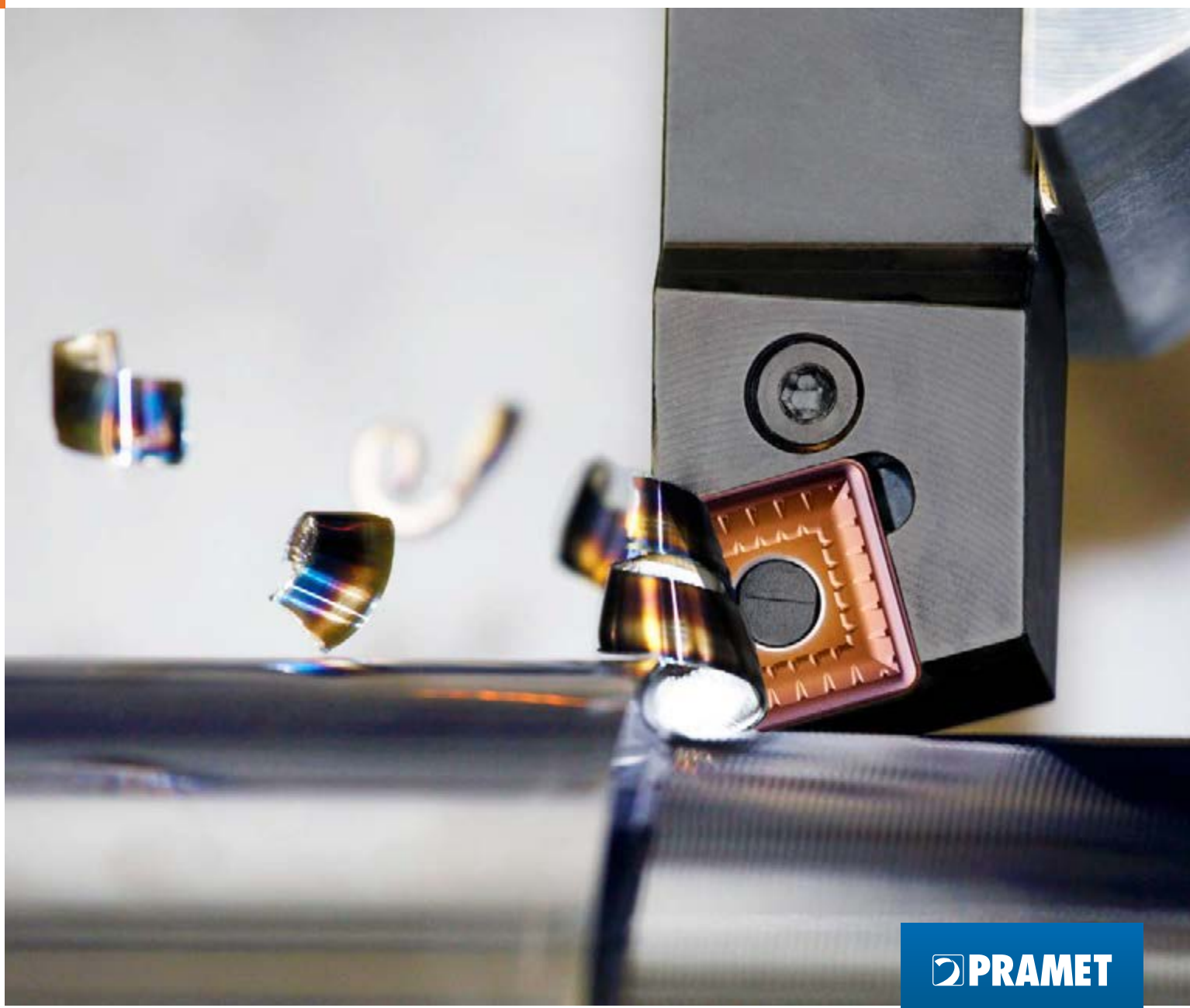
DORMER PRAMET

# DREJNING

2021 – 2022



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DORMER PRAMET

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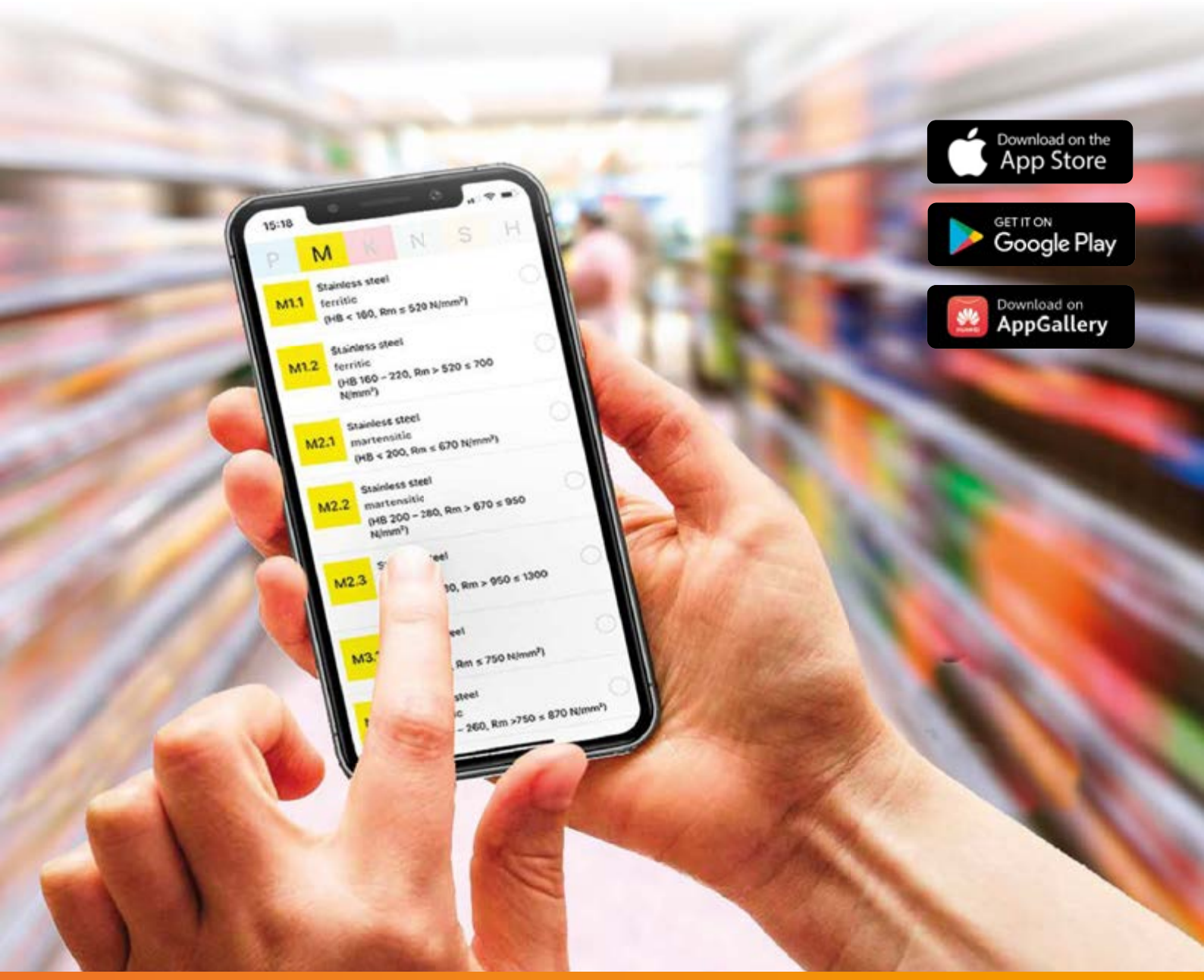

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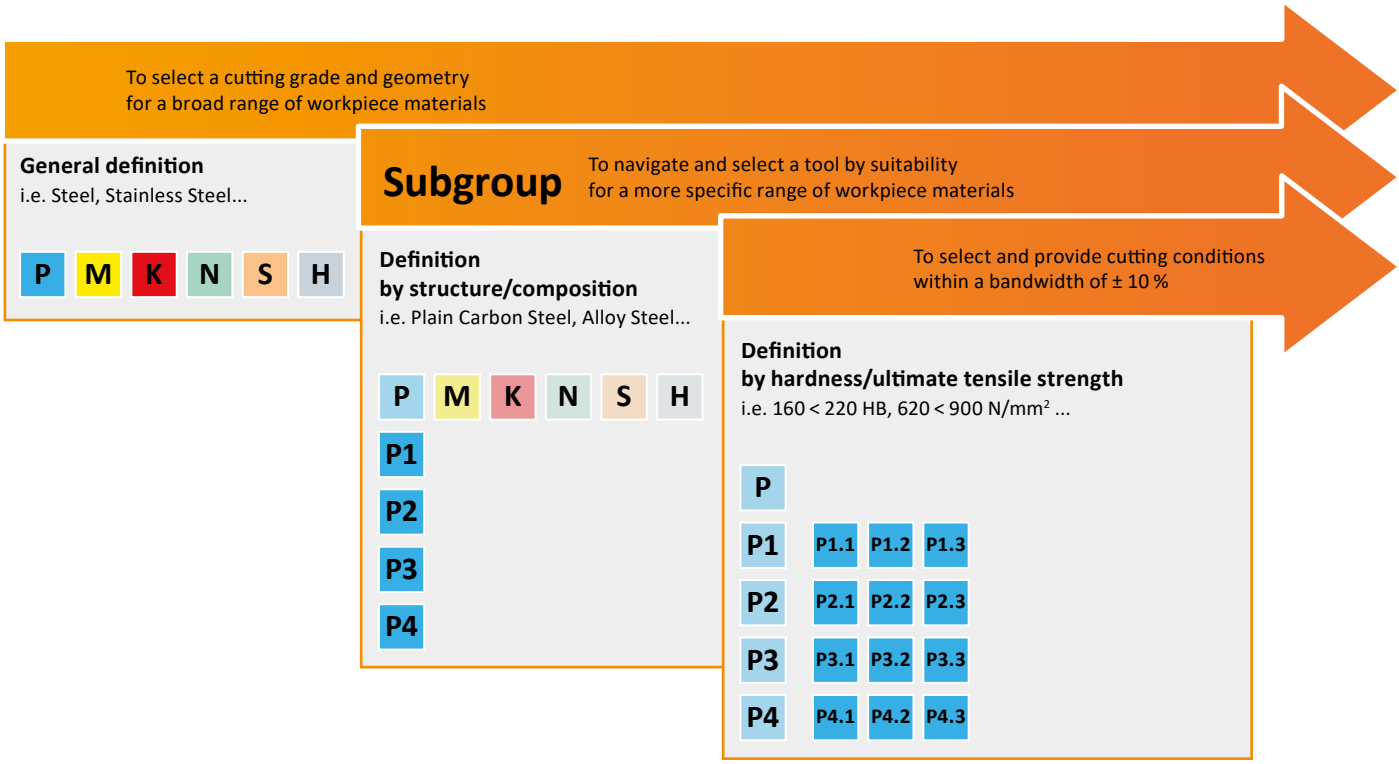
## WORKPIECE MATERIAL GROUPS (WMG)




## ABOUT DORMER PRAMET'S WORKPIECE MATERIAL CLASSIFICATION

**W**orkpiece **M**aterial **G**roups (**WMG**) are used to support easy and reliable selection of the right cutting tool and starting values for machining conditions in particular applications.

Dormer Pramet classifies workpiece materials into six different coloured groups;

- **Blue**: Steel and cast steel (P-group)
- **Yellow**: Stainless steel (M-group)
- **Red**: Cast iron (K-group)
- **Green**: Non-ferrous metals (N-group)
- **Brown**: High-temperature alloys (S-group)
- **Grey**: Hardened materials (H-group)

Each of these are divided into subgroups on the basis of their structure and/or composition. For example, P-group steel and cast steel is split into four subgroups, namely;

- **P1** – Free machining steel
- **P2** – Plain carbon steel
- **P3** – Alloy steel
- **P4** – Tool steel

A final division includes material properties, such as hardness and ultimate tensile strength. This is to provide our customers with a complete tool recommendation, including starting values for cutting speed and feed.

The table on the next page includes a description of each workpiece material group, as well as examples of commonly used designations.

| ISO group | | WMG (Work Material Group) | | | Hardness (HB or HRC) | Ultimate Tensile Strength (MPa) | Examples |
|---|---|---|---|---|---|---|---|
| P | P1 | P1.1 | Free machining steel (carbon steels with increased machinability) | Sulfurized | < 240 HB | ≤ 830 | |
| | | P1.2 | | Sulfurized and phosphorized | < 180 HB | ≤ 620 | |
| | | P1.3 | | Sulfurized/phosphorized and leaded | < 180 HB | ≤ 620 | |
| | P2 | P2.1 | Plain carbon steel (steels comprised of mainly iron and carbon) | Containing <0.25 % C | < 180 HB | ≤ 620 | |
| | | P2.2 | | Containing <0.55 % C | < 240 HB | ≤ 830 | |
| | | P2.3 | | Containing >0.55 % C | < 300 HB | ≤ 1030 | |
| | P3 | P3.1 | Alloy steel (carbon steels with an alloying content ≤ 10%) | Annealed | < 180 HB | ≤ 620 | |
| | | P3.2 | | Hardened and tempered | 180 – 260 HB | > 620 ≤ 900 | |
| | | P3.3 | | | 260 – 360 HB | > 900 ≤ 1240 | |
| | P4 | P4.1 | Tool steel (special alloy steel for tools, dies and molds) | Annealed | < 26 HRC | ≤ 900 | |
| | | P4.2 | | Hardened and tempered | 26 – 39 HRC | > 900 ≤ 1240 | |
| | | P4.3 | | | 39 – 45 HRC | > 1240 ≤ 1450 | |
| M | M1 | M1.1 | Ferritic stainless steel (straight chromium non-hardenable alloys) | | < 160 HB | ≤ 520 | |
| | | M1.2 | | | 160 – 220 HB | > 520 ≤ 700 | |
| | M2 | M2.1 | Martensitic stainless steel (straight chromium hardenable alloys) | Annealed | < 200 HB | ≤ 670 | |
| | | M2.2 | | Quenched and tempered | 200 – 280 HB | > 670 ≤ 950 | |
| | | M2.3 | | Precipitation-hardened | 280 – 380 HB | > 950 ≤ 1300 | |
| | M3 | M3.1 | Austenitic stainless steel (chromium-nickel and chromium-nickel-manganese alloys) | | < 200 HB | ≤ 750 | |
| | | M3.2 | | | 200 – 260 HB | > 750 ≤ 870 | |
| | | M3.3 | | | 260 – 300 HB | > 870 ≤ 1040 | |
| | M4 | M4.1 | Austenitic-ferritic (DUPLEX) or super-austenitic stainless steel | | < 300 HB | ≤ 990 | |
| | | M4.2 | Precipitation hardening austenitic stainless steel | | 300 – 380 HB | ≤ 1320 | |
| K | K1 | K1.1 | Gray iron or Automotive Gray iron (GG) (iron-carbon castings with a lamellar graphite microstructure) | Ferritic or ferritic-pearlitic | < 180 HB | ≤ 190 | |
| | | K1.2 | | Ferritic-pearlictic or pearlitic | 180 – 240 HB | > 190 ≤ 310 | |
| | | K1.3 | | Pearlitic | 240 – 280 HB | > 310 ≤ 390 | |
| | K2 | K2.1 | Malleable iron (GTS/GTW) (iron-carbon castings with a graphite-free microstructure) | Ferritic | < 160 HB | ≤ 400 | |
| | | K2.2 | | Ferritic or pearlitic | 160 – 200 HB | > 400 ≤ 550 | |
| | | K2.3 | | Pearlitic | 200 – 240 HB | > 550 ≤ 660 | |
| | K3 | K3.1 | Ductile iron (GGG) (iron-carbon castings with a nodular graphite microstructure) | Ferritic | < 180 HB | ≤ 560 | |
| | | K3.2 | | Ferritic or pearlitic | 180 – 220 HB | > 560 ≤ 680 | |
| | | K3.3 | | Pearlitic | 220 – 260 HB | > 680 ≤ 800 | |
| | K4 | K4.1 | Austenitic gray iron (ASTM A436) (iron-carbon alloy castings with an austenitic lamellar graphite microstructure) | | < 180 HB | ≤ 190 | |
| | | K4.2 | Austenitic ductile iron (ASTM A439 or ASTM A571) (iron-carbon alloy castings with an austenitic nodular graphite microstructure) | | < 240 HB | ≤ 740 | |
| | | K4.3 | Austempered ductile iron (ASTM A897) (iron-carbon alloy castings with an ausferrite microstructure) | | < 280 HB | > 840 ≤ 980 | |
| | | K4.4 | | | 280 – 320 HB | > 980 ≤ 1130 | |
| | | K4.5 | | | 320 – 360 HB | > 1130 ≤ 1280 | |
| | K5 | K5.1 | Compacted graphite iron CGI (ASTM A842) (iron-carbon castings with a vermicular graphite structure) | Ferritic | < 180 HB | ≤ 400 | |
| | | K5.2 | | Ferritic-pearlitic | 180 – 220 HB | > 400 ≤ 450 | |
| | | K5.3 | | Pearlitic | 220 – 260 HB | > 450 ≤ 500 | |
| N | N1 | N1.1 | Commercially pure wrought aluminium | | < 60 HB | ≤ 240 | |
| | | N1.2 | Wrought aluminium alloys | Half hard tempered | 60 – 100 HB | > 240 ≤ 400 | |
| | | N1.3 | | Full hard tempered | 100 – 150 HB | > 400 ≤ 590 | |
| | N2 | N2.1 | Cast aluminium alloys | | < 75 HB | ≤ 240 | |
| | | N2.2 | | | 75 – 90 HB | > 240 ≤ 270 | |
| | | N2.3 | | | 90 – 140 HB | > 270 ≤ 440 | |
| | N3 | N3.1 | Free-cutting copper-alloys materials with excellent machining properties | | – | – | |
| | | N3.2 | Short-chip copper-alloys with good to moderate machining properties | | – | – | |
| | | N3.3 | Electrolytic copper and long-chip copper-alloys with moderate to poor machining properties | | – | – | |
| | N4 | N4.1 | Thermoplastic polymers | | – | – | |
| | | N4.2 | Thermosetting polymers | | – | – | |
| | | N4.3 | Reinforced polymers or composites | | – | – | |
| | N5 | N5.1 | Graphite | | – | – | |
| S | S1 | S1.1 | Titanium or titanium alloys | | < 200 HB | ≤ 660 | |
| | | S1.2 | | | 200 – 280 HB | > 660 ≤ 950 | |
| | | S1.3 | | | 280 – 360 HB | > 950 ≤ 1200 | |
| | S2 | S2.1 | Fe-based high-temperature alloys | | < 200 HB | ≤ 690 | |
| | | S2.2 | | | 200 – 280 HB | > 690 ≤ 970 | |
| | S3 | S3.1 | Ni-based high-temperature alloys | | < 280 HB | ≤ 940 | |
| | | S3.2 | | | 280 – 360 HB | > 940 ≤ 1200 | |
| | S4 | S4.1 | Co-based high-temperature alloys | | < 240 HB | ≤ 800 | |
| | | S4.2 | | | 240 – 320 HB | > 800 ≤ 1070 | |
| H | H1 | H1.1 | Chilled cast iron | | < 440 HB | – | |
| | H2 | H2.1 | Hardened cast iron | | < 55 HRC | – | |
| | | H2.2 | | | > 55 HRC | – | |
| | H3 | H3.1 | Hardened steel <55 HRC | | < 51 HRC | – | |
| | | H3.2 | | | 51 – 55 HRC | – | |
| | H4 | H4.1 | Hardened steel >55 HRC | | 55 – 59 HRC | – | |
| | | H4.2 | | | > 59 HRC | – | |

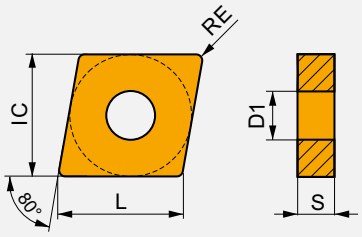
Examples of machining materials – see chapter **INDEXABLE MILLS – TECHNICAL INFORMATION** (page 539).

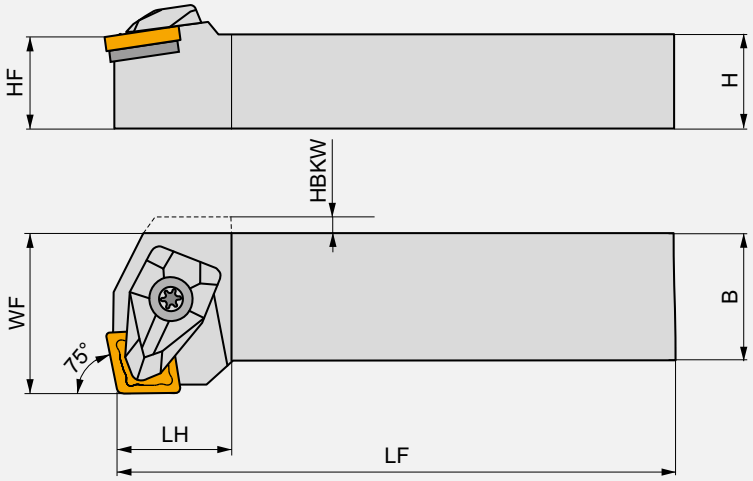
# CUTTING TOOL PARAMETERS ACCORDING TO ISO 13399

**All cutting tools are defined by a number of parameters according to the standard ISO 13399. This list contains all the parameters used in this catalogue and their definitions.**

ISO 13399 is an international cutting tool information standard. It provides dimensions and parameters in a neutral format that is independent of any particular system or company nomenclature. When cutting tools are clearly defined according to a global standard, all types of software can process the electronic data more quickly, improving the quality of communication and helping to make the exchange of information run smoothly. Supporting a common language in our cutting tool descriptions this will assist system to system communication. It will save you a significant amount of time, providing an easier gathering of high-quality data across our 40,000 solid and indexable tools. By using an ISO 13399 compliant system, there will be no need to manually interpret data and key-enter it into your system.

**EXAMPLES ONLY!**



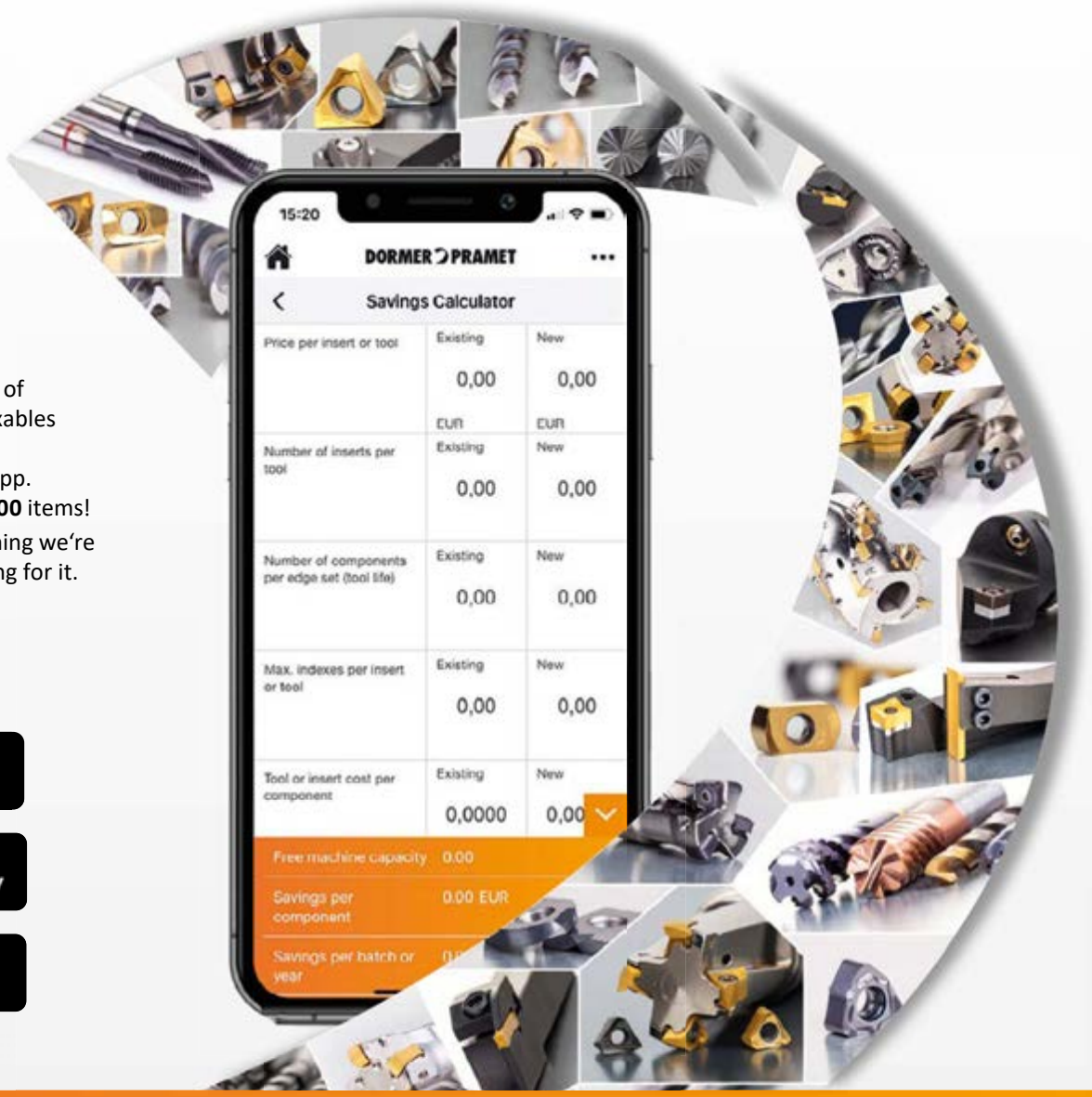




| ISO 13399 | Description |
|---|---|
| **APMX** | Depth of cut maximum |
| **B** | Shank width |
| **BD** | Body diameter |
| **BLRAD** | Blade reinforcement radius |
| **BW** | Insert body width |
| **CDX** | Cutting depth maximum |
| **CND** | Coolant entry diameter |
| **CUTDIA** | Work piece parting diameter maximum |
| **CW** | Cutting width |
| **CWTOLL** | Cutting width lower tolerance |
| **CWTOLU** | Cutting width upper tolerance |
| **D1** | Fixing hole diameter |
| **DAXIN** | Minimum axial groove inside diameter |
| **DAXN** | Minimum axial groove outside diameter |
| **DAXX** | Maximum axial groove outside diameter |
| **DCON MS** | Connection diameter |
| **DMIN** | Minimum bore diameter |
| **DMINP** | Minimum bore diameter perpendicular |
| **GAMO** | Ortogonal rake angle |
| **GAMP** | Axial rake angle |
| **H** | Shank height |
| **HBH** | Head bottom offset height |
| **HBKW** | Head bottom offset width |
| **HF** | Functional height |
| **IC** | Inscribed circle diameter |
| **INSD** | Insert diameter |
| **INSL** | Insert length |

| ISO 13399 | Description |
|---|---|
| **KAPR** | Tool cutting edge angle |
| **L** | Cutting edge length |
| **LAMS** | Inclination angle |
| **LB** | Body length |
| **LF** | Functional length |
| **LFA** | A dimension on LF |
| **LFS** | Functional length secondary |
| **LH** | Head length |
| **LU** | Usable length |
| **M** | M-dimension |
| **OAL** | Overall length |
| **PDX** | Profile distance X |
| **PDY** | Profile distance Y |
| **PSIRL** | Tool lead angle left |
| **PSIRR** | Tool lead angle right |
| **RE** | Corner radius |
| **S** | Insert thickness |
| **S1** | Insert thickness total |
| **TP** | Thread pitch |
| **TPI** | Threads per inch |
| **TPIN** | Threads per inch |
| **TPIX** | Threads per inch |
| **TPN** | Thread pitch minimum |
| **TPX** | Thread pitch maximum |
| **W1** | Insert width |
| **WF** | Functional width |
| **WFS** | Functional width secondary |

DORMER PRAMET

# ALL TOOLS TOGETHER




Our entire assortment of rounds tools and indexables is included within the machining calculator app. That's more than **40,000** items!

Whatever your machining we're likely to have something for it.

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# ISO TURNING

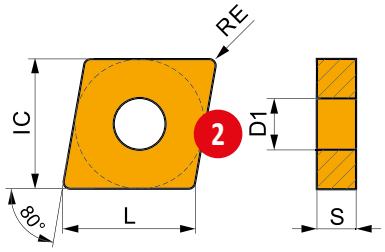


| | | |
|---|---|---|
| 📖 6 | | WMG & ISO 13399 |
| 📖 10 | ISO TURNING | INSTRUCTIONS |
| 📖 18 | | NAVIGATORS |
| 📖 57 | | POSITIVE INSERTS |
| 📖 219 | | NEGATIVE INSERTS |
| 📖 386 | | PARTING-OFF & GROOVING |
| 📖 482 | | THREAD TURNING |
| 📖 526 | | BROACHING |
| 📖 533 | | TECHNICAL INFORMATION |

## 1 CNMM

PRAMET

| | 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 |




Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

| 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] |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 4 | 0,35 / 23° (5) | | 6 S | | | | | | | | | | | | | | | | | |
| 10 DR geometry for semi-rough to rough machining, and continuous to interrupted cuts. | | | | | | | | | | | | | | | | | | | | |
| CNMM 160612E-DR (7) | T9315 | 1.2 | 225 | 0.45 | 6.0 | – | – | – | 210 | 0.45 | 6.0 | – | – | – | – | – | – | – | – | – |
| (8) | T9315 | (9) | 200 | 0.45 | 6.0 | 120 | 0.41 | 6.0 | 190 | 11 | 6.0 | – | – | – | – | – | – | – | – | – |
| | T9[illegible] | | 170 | 0.45 | 6.0 | 100 | 0.41 | 6.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| CNMM 190608E-DR | T9315 | 0.8 | 215 | 0.40 | 8.0 | – | – | – | 200 | 0.40 | 8.0 | – | – | – | – | – | – | – | – | – |
| | T9325 | 0.8 | 190 | 0.40 | 8.0 | 110 | 0.36 | 8.0 | 180 | 0.40 | 8.0 | – | – | – | – | – | – | – | – | – |
| CNMM 190612E-DR | T9315 | 1.2 | 220 | 0.45 | 8.0 | – | – | – | 205 | 0.45 | 8.0 | – | – | – | – | – | – | – | – | – |
| | T9325 | 1.2 | 195 | 0.45 | 8.0 | 115 | 0.41 | 8.0 | 185 | 0.45 | 8.0 | – | – | – | – | – | – | – | – | – |
| | T9335 | 1.2 | 170 | 0.45 | 8.0 | 100 | 0.41 | 8.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| CNMM 190616E-DR | T9325 | 1.6 | 195 | 0.50 | 9.0 | 115 | 0.45 | 9.0 | 185 | 0.50 | 9.0 | – | – | – | – | – | – | – | – | – |
| | T9335 | 1.6 | 170 | 0.50 | 9.0 | 100 | 0.45 | 9.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | 0,4 / 0,07 / 12° / 14° / 34° | | P | | | | | | | | | | | | | | | | | |
| HR geometry for rough to heavy-rough machining, and continuous to interrupted cuts. | | | | | | | | | | | | | | | | | | | | |
| CNMM 190616E-HR | 6640 | 1.6 | 75 | 0.60 | 10.0 | 45 | 0.54 | 10.0 | 70 | 0.60 | 10.0 | – | – | – | – | – | – | – | – | – |
| | T8345 | 1.6 | 55 | 0.60 | 10.0 | 30 | 0.54 | 10.0 | 50 | 0.60 | 10.0 | – | – | – | – | – | – | – | – | – |
| | T9325 | 1.6 | 105 | 0.60 | 10.0 | 60 | 0.54 | 10.0 | 95 | 0.60 | 10.0 | – | – | – | – | – | – | – | – | – |
| | T9335 | 1.6 | 80 | 0.60 | 10.0 | 45 | 0.54 | 10.0 | – | – | – | – | – | – | – | – | – | – | – | – |

**CNMM190616E-HR:T8345** Use full insert specification code when ordering!

- Grade
- Include colon
- ISO insert code

Typical page with inserts displayed – specific page details will differ.

## INSERTS – PAGE OVERVIEW

| Pos. | Description |
|---|---|
| 1 | Designation of insert |
| 2 | Schematic drawing of insert |
| 3 | Table with insert sizes (mm) |
| 4 | Picture of representative insert |
| 5 | Profile of main cutting edge |
| 6 | Icons – specific features and cutting edge type |

| Pos. | Description |
|---|---|
| 7 | ISO insert code |
| 8 | Grade |
| 9 | Insert radii (mm) |
| 10 | Geometry description |
| 11 | Application area of insert |

1 **DDUN(RL) INT** P M K N S I 2

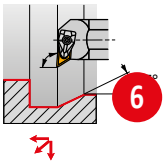
PRAMET 3 D

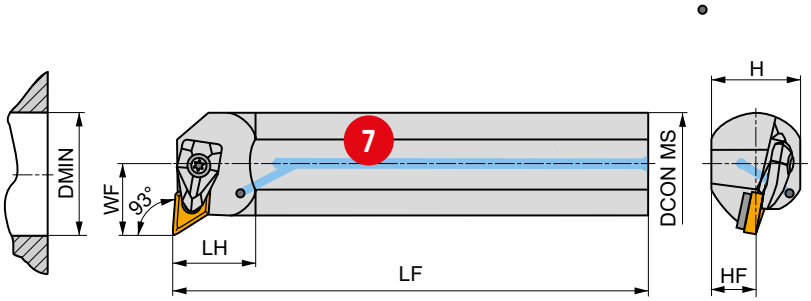

4

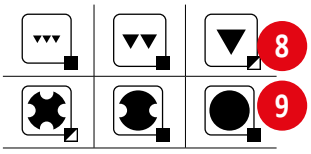
**Internal Double Clamp Boring Bar with 93° Cutting Angle for DN.. Insert**

Internal Right/Left hand double clamp boring bar, through coolant, 93° cutting angle for DN.. 11 and 15 inserts. Minimum internal turning diameter Ø32 mm. Suited for wide range of internal turning applications, copy turning up to 27°. Available with shank size Ø25 up to Ø50 mm. Body treated for longer tool life.

5


6





8 9


10

| | 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 | -12 | -6 | ✓ | 0.96 | GI046 | DD11 | – |
| | **A32T-DDUNR 11** | 32 | 40 | 22 | 30 | 15 | 300 | 30 | -10 | -6 | ✓ | 1.68 | GI046 | DD11 | – |
| | **A40T-DDUNR 15** | 40 | 50 | 27 | 37 | 18.5 | 300 | 36 | -11 | -6 | | | | | |
| | **A50U-DDUNR 15** | 50 | 63 | 35 | 47 | 23.5 | 350 | 39 | -8 | -6 | | | | | |
| L | **A25T-DDUNL 11** | 25 | 32 | 17 | 23 | 11.5 | 300 | 28 | -12 | -6 | ✓ | 0.96 | GI046 | DD11 | – |
| | **A32T-DDUNL 11** | 32 | 40 | 22 | 30 | 15 | 300 | 30 | -10 | -6 | ✓ | 1.69 | GI046 | DD11 | – |
| | **A40T-DDUNL 15** | 40 | 50 | 27 | 37 | 18.5 | 300 | 36 | -11 | -6 | ✓ | 2.59 | GI044 | DD154 | AT002 |
| | **A50U-DDUNL 15** | 50 | 63 | 35 | 47 | 23.5 | 350 | 39 | -8 | -6 | ✓ | 5.25 | GI044 | DD154 | AT002 |

11 12 13 14 15 16 17 18

19

| | |
|---|---|
| GI044 | DN.. 1506.. |
| GI046 | DN.. 1104.. |

20

| | | 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 |

21

| | | | |
|---|---|---|---|
| AT002a | DN.. 1504.. | – | DDS 266-01 |
| AT002b | CER DN.N 1506.. | DCS 12C4 | – |
| AT002c | CER DN.A 1506.. | DCS 12C2 | – |

Typical page with turning holder displayed – specific page details will differ.

## TURNING HOLDERS – PAGE OVERVIEW

| Pos. | Description |
|---|---|
| 1 | Designation of turning holder |
| 2 | Material group recommendations |
| 3 | Clamping system of insert |
| 4 | Illustrative picture [1] |
| 5 | Tool description |
| 6 | Workpiece profile |
| 7 | Schematic drawing of tool |
| 8 | Achievable quality of surface |
| 9 | Character of cut/working conditions |
| 10 | Product applications |
| 11 | Tool design |

| Pos. | Description |
|---|---|
| 12 | ISO code of holder |
| 13 | Dimensions (mm) and angles [2] (°) of holder |
| 14 | Internal coolant supply |
| 15 | Weight (kg) |
| 16 | Group of compatible inserts [3] |
| 17 | Group of spare parts [3], [4] |
| 18 | Group of accessories [3], [4] |
| 19 | Compatible inserts |
| 20 | Spare parts |
| 21 | Special accessories |

[1] Drejeholderen vises primært med højreopsætning (R)

[2] GAMO = retvinklet hældningsvinkel (se den tekniske del)
LAMS = stigningsvinkel for hovedskær (se den tekniske del)

[3] Gruppekoden for kompatible vendeskær, reservedele og specialtilbehør bruges kun til dette katalog. Den kan ikke bruges til ordrer.

[4] Reservedels- og specialtilbehørsikoner er designet skematisk, så de er nemme at forstå. De er ikke inkluderet på listen over ikoner. Skruer er i visse tilfælde forsynet med oplysninger om tilspændingsmoment i Nm, skruelængde og gevindstørrelse.

# TURNING HOLDERS – ICONS OVERVIEW

## GENERAL ICONS

| | |
|---|---|
| ■ | Primary use |
| ◪ | Possible use |

| | |
|---|---|
| ▼▼▼ | Finishing – very good surface quality |
| ▼▼ | Medium machining – good surface quality |
| ▼ | Roughing – unlimited surface roughness |

| | |
|---|---|
| ● | Suitable for stable working conditions |
| ● | Suitable for unstable working conditions |
| ● | Suitable for very unstable working conditions |

## FEATURES

| | |
|---|---|
| 1 | First choice |
| | For short chipping materials |
| | For tough materials (long chipping) |
| | Heavy working conditions |
| HFC | High Feed Cutting |
| HSC | High Speed Cutting |

| | |
|---|---|
| W | Insert with Wiper geometry |
| | Large overhang |
| | Railway wheel machining |
| | Thin-walled and slim workpieces |
| U | Universal wide range option |

| | |
|---|---|
| F | Sharp edge |
| E | Rounded edge |
| T | Edge with facet |
| S | Rounded edge with facet |
| K | Edge with double facet |
| P | Rounded edge with double facet |

## TURNING OPERATIONS

| | |
|---|---|
| | Cone turning – external |
| | Cone turning – internal |
| | Copy turning (multi directional machining) |
| | Face copy turning |
| | Face copy turning in hole |
| | Face turning with shoulder |
| | Face turning without shoulder |

| | |
|---|---|
| | Chamfering (bevelling) |
| | Chamfering (bevelling) from the back |
| | Chamfering (bevelling) in hole |
| | Longitudinal turning with shoulder – external |
| | Longitudinal turning with shoulder – internal |
| | Longitudinal turning without shoulder – external |
| | Longitudinal turning without shoulder – internal |

| | |
|---|---|
| | Machining the rear face (shoulder) from the back |
| | Multi directional copy turning – external |
| | Multi directional copy turning – internal |
| | One directional copy turning – external |
| | One directional copy turning – internal |
| | Shallow radial groove |

# TURNING HOLDERS – ICONS OVERVIEW

## EKNISK DEL

| | |
|---|---|
| FF | Ekstra finsletning |
| F | Finbearbejdning |
| M | Mellem maskinbearbejdning |
| R | Grovbearbejdning |
| HR | Grovbearbejdning |
| X.V | Multiplication factor for cutting speed |
| $a_p$ | Skæredybde [mm] |

| | |
|---|---|
| f | Tilspænding [mm/omdr.] |
| | Holdbarhed [min] |
| | Kvalitet |
| (MT)CVD / PVD | Belægning |
| V | Skærehastighed |
| | Skærprofil |
| | Køling |

| | |
|---|---|
| | Meget høj skærehastighed, fremragende systemstivhed (stabile arbejdsforhold) |
| | Høj skærehastighed, høj systemstivhed (stabile arbejdsforhold) |
| | Høj skærehastighed, systemstivhed let begrænset (skæredybde skiftende) |
| | Mellem skærehastighed, systemstivhed begrænset (let afbrudt skæring) |
| | Lav skærehastighed, lav systemstivhed (afbrudt skæring) |
| | Meget lav skærehastighed, meget lav system-stivhed (meget ustabile arbejdsforhold) |

## OTHERS

| | |
|---|---|
| Nm | Clamping torque of screw (Nm) |
| | Group of heads for roughing |
| | Internal supply of coolant |

**CCGT**



60

**CCMT**



62

**CCMW**



68

**CCGW CBN**



69

**DCGT**



86

**DCMT**



87

**DCMW**



92

**DCGW CBN**



92

**DCMW PCD**



93

**ECGT**



104

**ECMT**



105

**ECMW**



106

**EPGX**



110

**EPMT**



110

**RCGT**



118

**RCMT**



118

**RCMW**



120

**RCMX**



121

**RCGX CER**



123

**SCGT**



134

**SCMT**



135

**SCMW**



138

**SPMR**



146

**SPUN**



146

**SPGN CER**



147

**TCGT**



149

**TCMT**



150

**TCMW**



154

**TCGW CBN**



154

**TPGX**



162

**TPMR**



163

**TPUN**



164

**TPGN CER**



164

**VBMT**



168

**VBGW CBN**



171

**VCGT**



186

**VCGW**



189

**VCGX**



189

**VCMT**



190

**VCMW**



191

**VCMW PCD**



192

**WCGT**



212

**WCGX**



213

**WCMT**



213

**CNGG**



222

**CNMA**



222

**CNMG**



223

**CNMM**



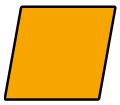
234

**CNGA CER**



238

**CNGN CER**



238

**CNGA CBN**



239

**DNMA**



260

**DNMG**



260

**DNMM**



270

**DNGA CER**



271

**DNGN CER**



271

**DNGA CBN**



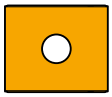
272

**KNUX**



284

**LNUX 40, LN.X 50**



289

**RNMG**



294

**RNGN CER**



294

**SNMA**



300

**SNMG**



301

**SNMM**



307

**SNMX**



311

**SNGA CER**



311

**SNGN CER**



312

**TNMA**



334

**TNMG**



335

**TNMM**



342

**TNGA CER**



343

**TNGN CER**



344

**TNGA CBN**



344

**VNMG**



356

**VNGA CER**



359

**VNGA CBN**



359

**WNMA**



366

**WNMG**



366

**WNMM**



375

**WNGA CBN**



376

# P

Meget ustabile arbejdsforhold

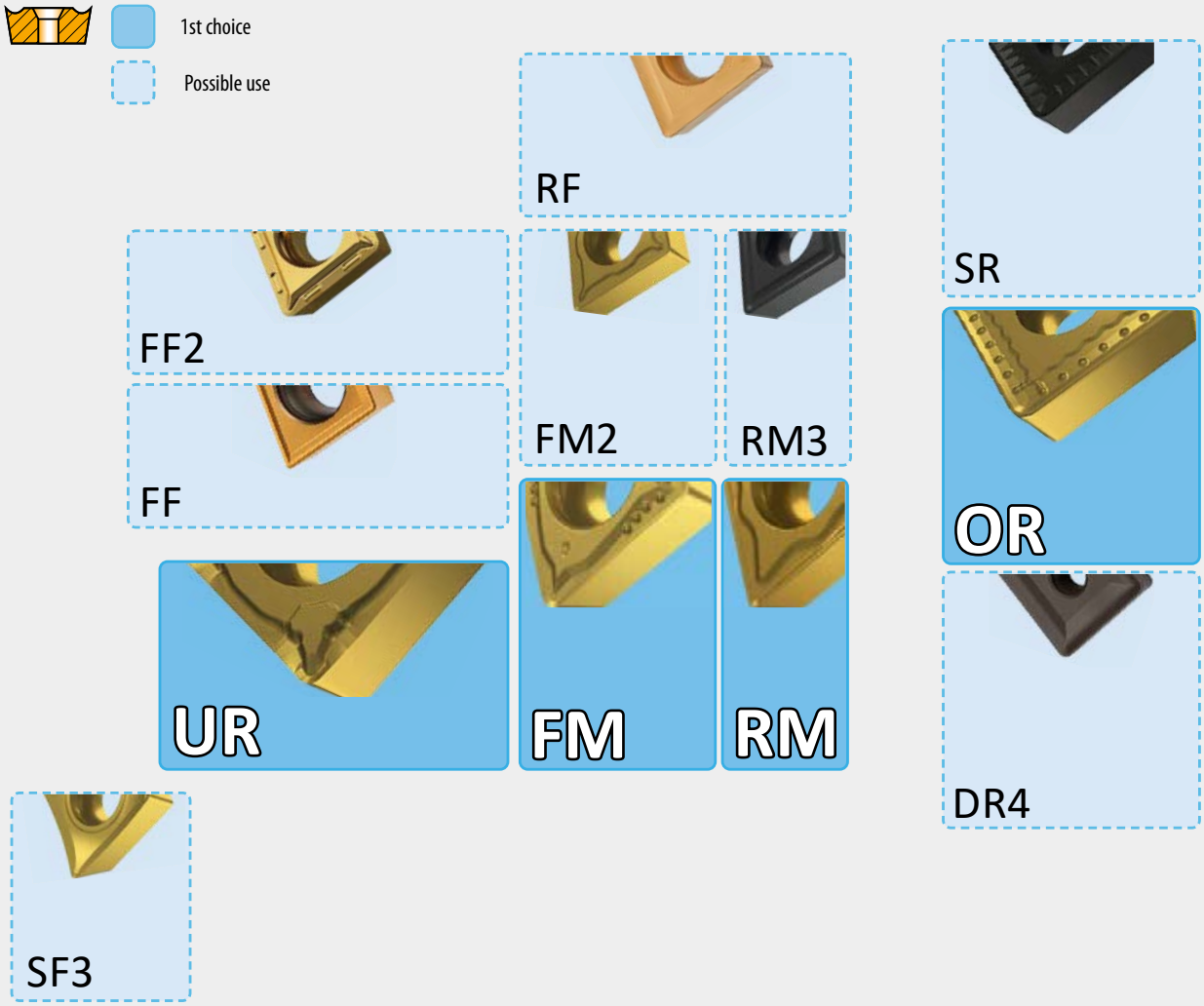
Ustabile arbejdsforhold

Stabile arbejdsforhold

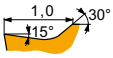
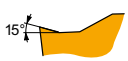
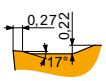
Tyndvæggede og slanke arbejdsemner

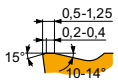
1st choice

Possible use




| | FF | F | M | R | HR |
|---|---|---|---|---|---|
| f | 0.05 – 0.2 mm/omdr. | 0.05 – 0.2 mm/omdr. | 0.2 – 0.4 mm/omdr. | 0.4 – 1.0 mm/omdr. | > 1.0 mm/omdr. |
| $a_p$ | 0.05 – 2 mm | 0.05 – 2 mm | 2 – 4 mm | 4 – 10 mm | > 10 mm |

| | | |
|---|---|---|
| **UR** |   | Designed for fine to finish machining, steels and cast irons and potentially stainless steel, continuous and interrupted cuts |
| **FM** |   | Designed for finish to semi-rough machining, steels and stainless steels, potentially cast irons and non ferrous materials, continuous and moderately interrupted cuts |
| **RM** |   | Designed for semi-rough machining, steels, stainless steels and cast irons, potentially super alloys and hard-ened materials, continuous and interrupted cuts |

| | | |
|---|---|---|
| **OR** |   | Designed for rough and heavy rough machining, steels, stainless steels and cast irons, potentially super alloys. continuous and interrupted cuts |
| | | |
| | | |

# M

Meget ustabile arbejdsforhold

Ustabile arbejdsforhold

Stabile arbejdsforhold

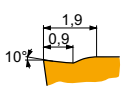
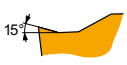
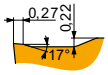
Tyndvæggede og slanke arbejdsemner

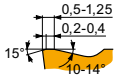
1st choice

Possible use




| | FF | F | M | R | HR |
|---|---|---|---|---|---|
| f | 0.05 – 0.2 mm/omdr. | 0.05 – 0.2 mm/omdr. | 0.2 – 0.4 mm/omdr. | 0.4 – 1.0 mm/omdr. | > 1.0 mm/omdr. |
| $a_p$ | 0.05 – 2 mm | 0.05 – 2 mm | 2 – 4 mm | 4 – 10 mm | > 10 mm |

| | | |
|---|---|---|
| **NF1** |  | Positive design for fine-finish to medium machining, stainless steels and super alloys, potentially steels, non ferrous and hard materials, continuous cuts |
| **FM** |  | Designed for finish to semi-rough machining, steels and stainless steels, potentially cast irons and non ferrous materials, continuous and moderately interrupted cuts |
| **RM** |  | Designed for semi-rough machining, steels, stainless steels and cast irons, potentially super alloys and hard-ened materials, continuous and interrupted cuts |

| | | |
|---|---|---|
| **OR** |  | Designed for rough and heavy rough machining, steels, stainless steels and cast irons, potentially super alloys. continuous and interrupted cuts |

# K

Meget ustabile arbejdsforhold

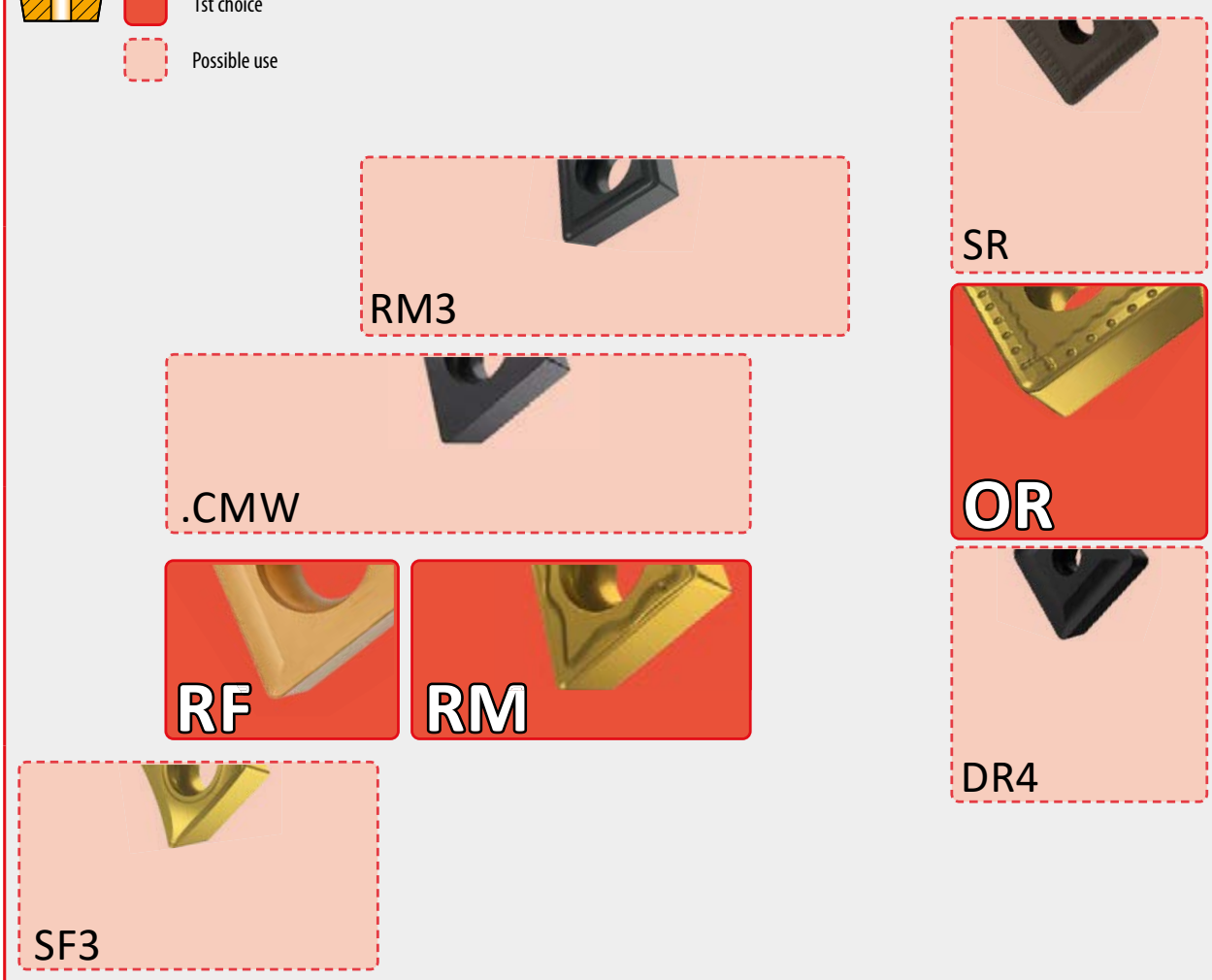
Ustabile arbejdsforhold

Stabile arbejdsforhold

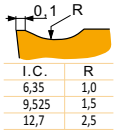
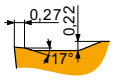
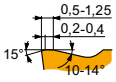
Tyndvæggede og slanke arbejdsemner

1st choice

Possible use




| | FF | F | M | R | HR |
|---|---|---|---|---|---|
| f | 0.05 – 0.2 mm/omdr. | 0.05 – 0.2 mm/omdr. | 0.2 – 0.4 mm/omdr. | 0.4 – 1.0 mm/omdr. | > 1.0 mm/omdr. |
| $a_p$ | 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 | Designed for rough machining, cast irons, potentially steels, stainless steels and hard materials, continuous and interrupted cuts |
| **RM** |  | Designed for semi-rough machining, steels, stainless steels and cast irons, potentially super alloys and hardened materials, continuous and interrupted cuts |
| **OR** |  | Designed for rough and heavy rough machining, steels, stainless steels and cast irons, potentially super alloys. continuous and interrupted cuts |

# N

Meget ustabile arbejdsforhold

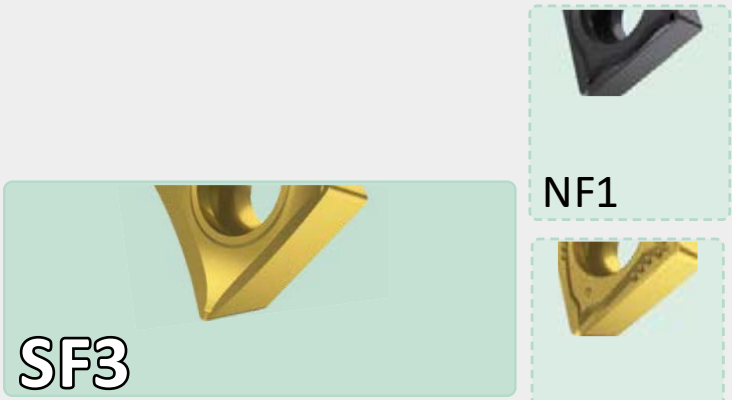
Ustabile arbejdsforhold

Stabile arbejdsforhold

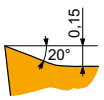
Tyndvæggede og slanke arbejdsemner

1st choice

Possible use




| | FF | F | M | R | HR |
|---|---|---|---|---|---|
| f | 0.05 – 0.2 mm/omdr. | 0.05 – 0.2 mm/omdr. | 0.2 – 0.4 mm/omdr. | 0.4 – 1.0 mm/omdr. | > 1.0 mm/omdr. |
| $a_p$ | 0.05 – 2 mm | 0.05 – 2 mm | 2 – 4 mm | 4 – 10 mm | > 10 mm |

| | | |
|---|---|---|
| **SF3** |   | Very positive design for fine and finish machining, super alloys, stainless steels and non ferrous materials, potentially steel, cast irons and hard materials, continuous cuts |
| **AL** |   | Highly positive design for fine finish to rough machining, aluminium, aluminium alloys and other non ferrous materials, potentially super alloys, continuous cuts |

# S

Meget ustabile arbejdsforhold

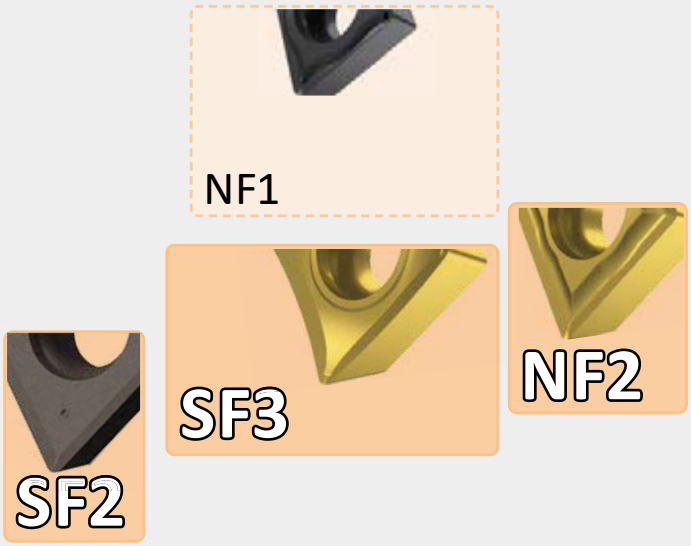
Ustabile arbejdsforhold

Stabile arbejdsforhold

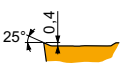
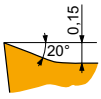
Tyndvæggede og slanke arbejdsemner

1st choice

Possible use




| | FF | F | M | R | HR |
|---|---|---|---|---|---|
| f ⇨ | 0.05 – 0.2 mm/omdr. | 0.05 – 0.2 mm/omdr. | 0.2 – 0.4 mm/omdr. | 0.4 – 1.0 mm/omdr. | > 1.0 mm/omdr. |
| $a_p$ | 0.05 – 2 mm | 0.05 – 2 mm | 2 – 4 mm | 4 – 10 mm | > 10 mm |

| | | |
|---|---|---|
| **SF2** |   | Very positive design for fine and finish machining, super alloys, potentially stainless steels, steels and non ferrous materials, continuous cuts |
| **SF3** |   | Very positive design for fine and finish machining, super alloys, stainless steels and non ferrous materials, potentially steel, cast irons and hard materials, continuous cuts |
| **NF2** |   | Positive design for fine-finish to semi rough machining, stainless steels and super alloys, continuous cuts |

# H

1st choice

Possible use

Meget ustabile arbejdsforhold

Ustabile arbejdsforhold

Stabile arbejdsforhold

Tyndvæggede og slanke arbejdsemner

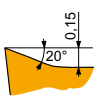
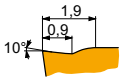

RM3

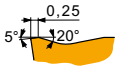

NF1


.CMW

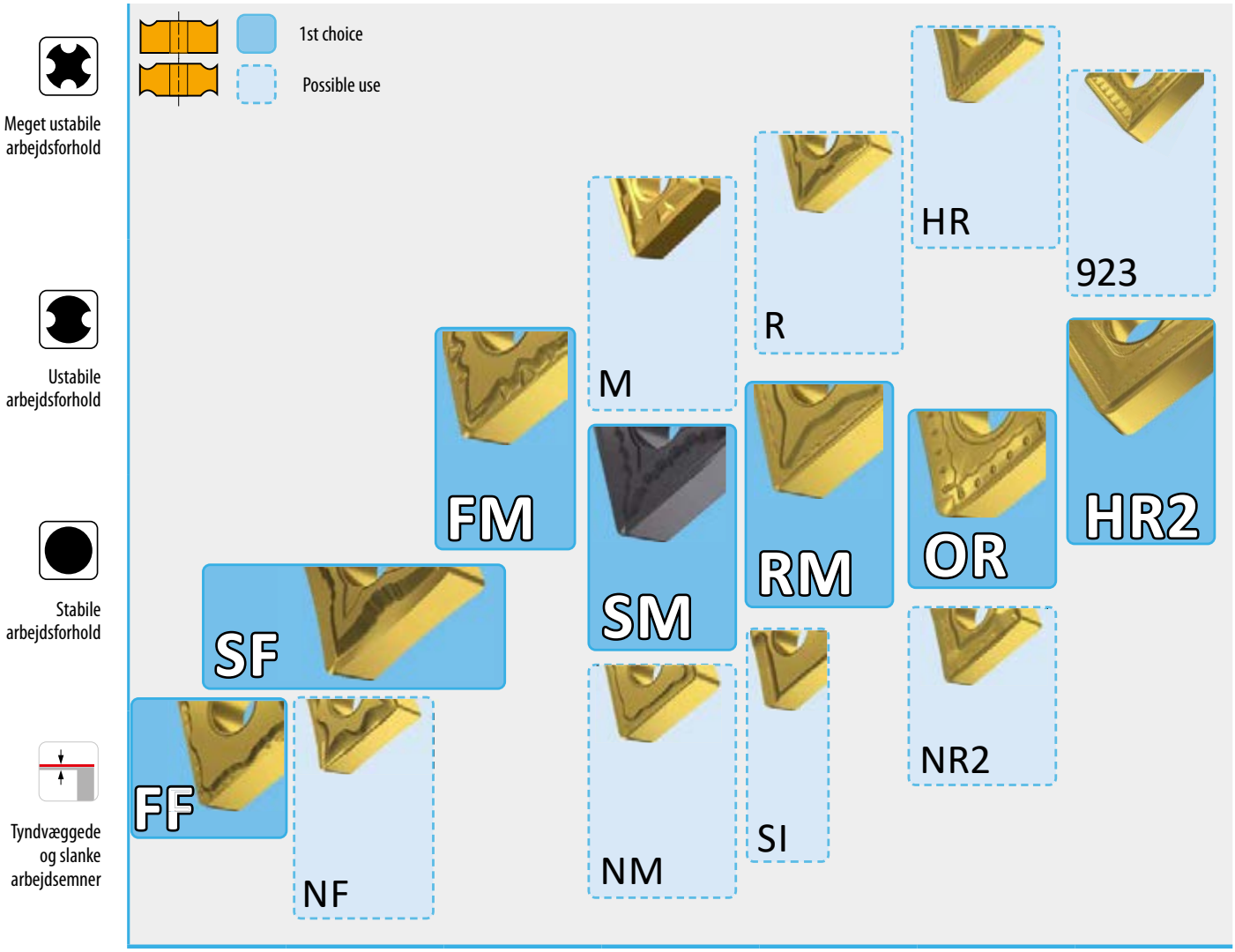

SF3

| | FF | F | M | R | HR |
|---|---|---|---|---|---|
| f | 0.05 – 0.2 mm/omdr. | 0.05 – 0.2 mm/omdr. | 0.2 – 0.4 mm/omdr. | 0.4 – 1.0 mm/omdr. | > 1.0 mm/omdr. |
| $a_p$ | 0.05 – 2 mm | 0.05 – 2 mm | 2 – 4 mm | 4 – 10 mm | > 10 mm |

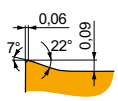
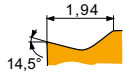
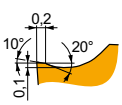
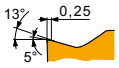
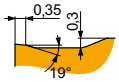
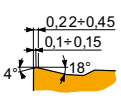
| | | |
|---|---|---|
| **SF3** |  | Very positive design for fine and finish machining, super alloys,stainless steels and non ferrous materials, potentially steel, cast irons and hard materials, continuous cuts |
| **NF1** |  | Positive design for fine-finish to medium machining, stainless steels and super alloys, potentially steels, non ferrous and hard materials, continuous cuts |
| **.CMW** |  | Designed for fine finish to semi rough machining, cast irons, potentially hard materials, continuous and slightly interrupted cuts |

| | | |
|---|---|---|
| **RM3** |  | Designed for rough machining, cast irons, potentially steels, stainless steels and hard materials, continuous and interrupted cuts |
| | | |
| | | |

# P




| | FF | F | M | R | HR |
|---|---|---|---|---|---|
| f | 0.05 – 0.2 mm/omdr. | 0.05 – 0.2 mm/omdr. | 0.2 – 0.4 mm/omdr. | 0.4 – 1.0 mm/omdr. | > 1.0 mm/omdr. |
| $a_p$ | 0.05 – 2 mm | 0.05 – 2 mm | 2 – 4 mm | 4 – 10 mm | > 10 mm |

| | | |
|---|---|---|
| **FF** |   | Highly positive geometry designed for fine finish machining, stainless steel and steel, potentially cast irons, continuous cuts |
| **SF** |   | Versatile positive geometry designed for fine finish machining, steels, stainless steels, cast irons and super alloys and hard materials, potentially non ferous materials and for machining thin walls, with continuous cuts |
| **FM** |   | Positive geometry designed for finish to semi-rough machining, steel and cast irons, potentially and super alloys, continuous and moderately interrupted cuts |
| **SM** |   | Positive geometry designed for medium machining, stainless steels, super alloys, steels and cast irons, potentially non ferrous and hard materials and for machining thin walls, continuous and interrupted cuts |
| **RM** |   | Designed for semi-rough and rough machining, steels, stainless steels and cast irons, potentailly super alloys, continuous and interrupted cuts |
| **OR** |   | Designed for finish to heavy rough machining, steels and cast irons, potentially stainless steel and super alloys, continuous and interrupted cuts |

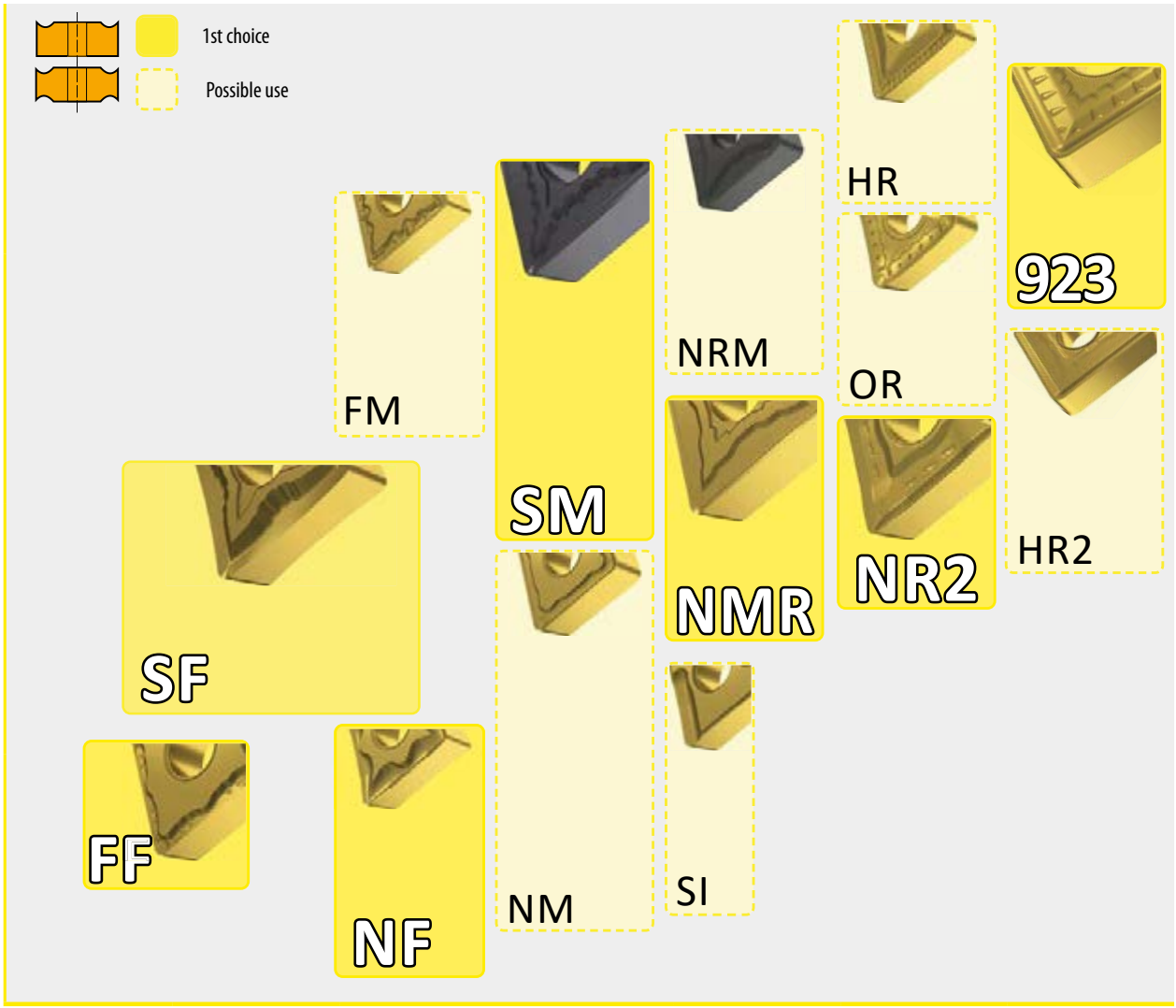
# M

Meget ustabile arbejdsforhold

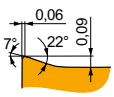
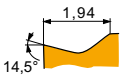
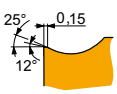
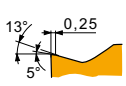
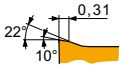
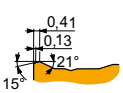
Ustabile arbejdsforhold

Stabile arbejdsforhold

Tyndvæggede og slanke arbejdsemner




| | FF | F | M | R | HR |
|---|---|---|---|---|---|
| f | 0.05 – 0.2 mm/omdr. | 0.05 – 0.2 mm/omdr. | 0.2 – 0.4 mm/omdr. | 0.4 – 1.0 mm/omdr. | > 1.0 mm/omdr. |
| $a_p$ | 0.05 – 2 mm | 0.05 – 2 mm | 2 – 4 mm | 4 – 10 mm | > 10 mm |

| | | |
|---|---|---|
| **FF** |  | Highly positive geometry designed for fine finish machining, stainless steel and steel, potentially cast irons, continuous cuts |
| **SF** |  | Versatile positive geometry designed for fine finish machining, steels, stainless steels, cast irons and super alloys and hard materials, potentially non ferous materials and for machining thin walls, with continuous cuts |
| **NF** |  | Highly positive design for fine finish and medium machining, stainless steels. steel, potentially cast irons, non ferrous materials and super alloys, continuous cuts |
| **SM** |  | Positive geometry designed for medium machining, stainless steels, super alloys, steels and cast irons, potentially non ferrous and hard materials and for machining thin walls, continuous and interrupted cuts |
| **NMR** |  | Positive design for medium to rough machining, stainless steels as well as soft steels and super alloys, continuous cuts |
| **NR2** |  | Designed for finish to rough machining, stainless steels and steels, potentially cast irons and super alloys, continuous and interrupted cuts |

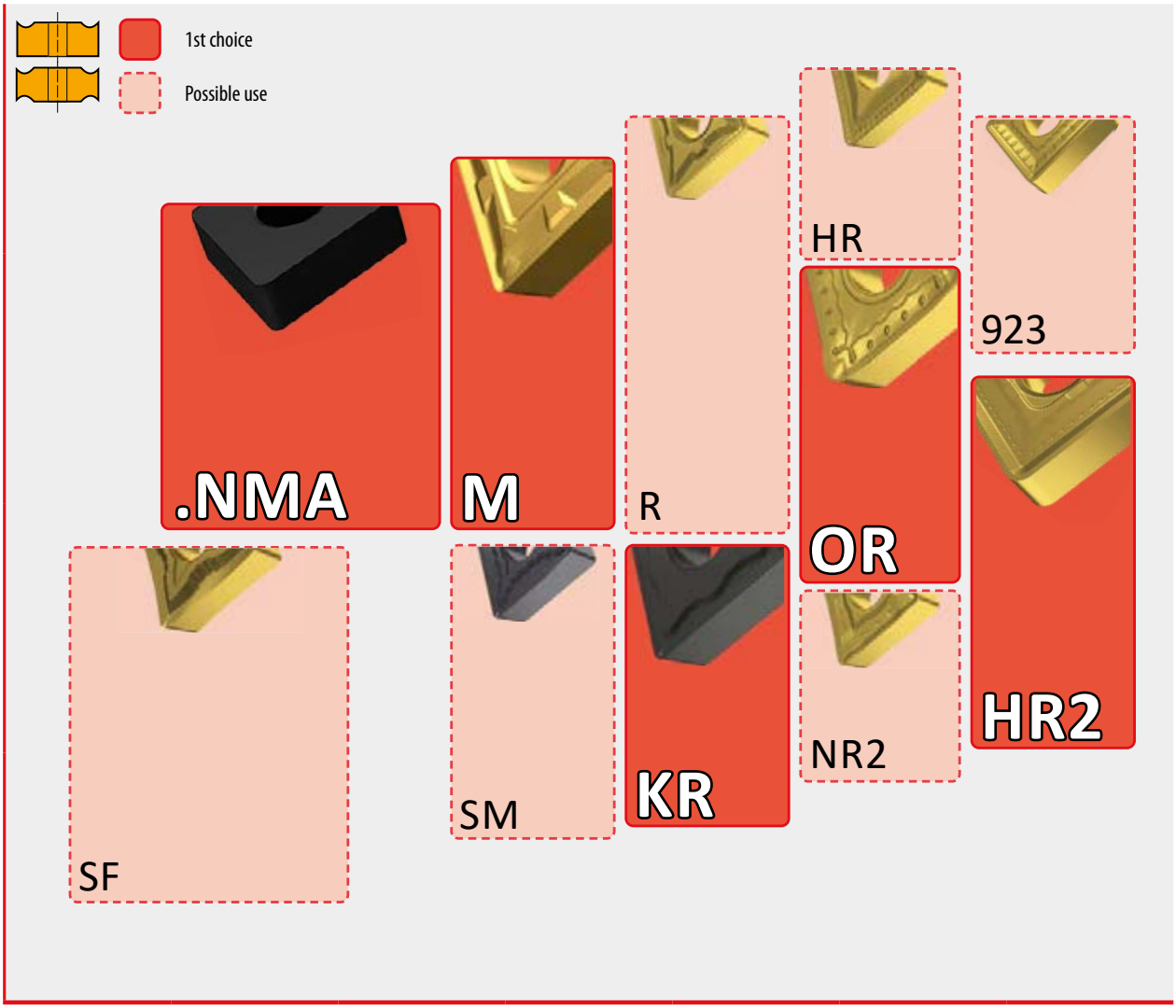
# K

Meget ustabile arbejdsforhold

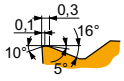
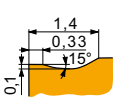
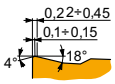
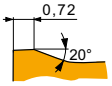
Ustabile arbejdsforhold

Stabile arbejdsforhold

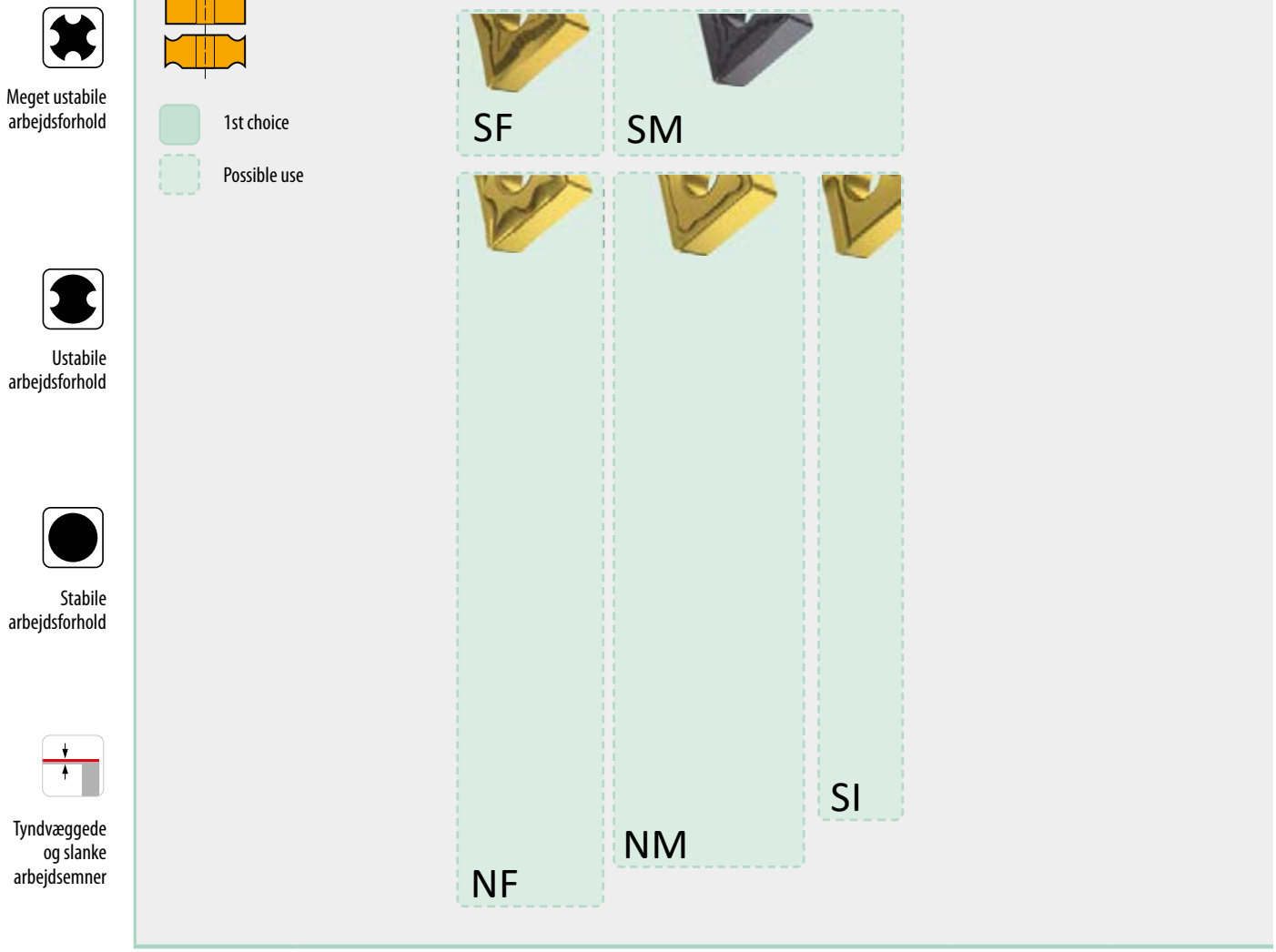
Tyndvæggede og slanke arbejdsemner



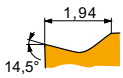
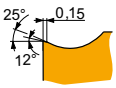
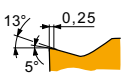
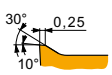
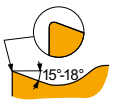

| | FF | F | M | R | HR |
|---|---|---|---|---|---|
| f | 0.05 – 0.2 mm/omdr. | 0.05 – 0.2 mm/omdr. | 0.2 – 0.4 mm/omdr. | 0.4 – 1.0 mm/omdr. | > 1.0 mm/omdr. |
| $a_p$ | 0.05 – 2 mm | 0.05 – 2 mm | 2 – 4 mm | 4 – 10 mm | > 10 mm |

| | | |
|---|---|---|
| **.NMA** |  | Designed for fine finish to semi rough machining, cast irons, potentially hard materials, continuous and slightly interrupted cuts |
| **M** |   | Designed for finish and semi-rough machining, cast irons, potentially steels and hard materials, continuous and interrupted cuts |
| **KR** |   | Designed for semi-rough and rough machining, cast irons, potentially steel and hard materials, continuous and interrupted cuts |
| **OR** |   | Designed for finish to heavy rough machining, steels and cast irons, potentially stainless steel and super alloys, continuous and interrupted cuts |
| **HR2** |   | Designed for rough to heavy rough machining with high feeds, steels and cast irons, potentially stainless steels, continuous and interrupted cuts |

# N




| | FF | F | M | R | HR |
|---|---|---|---|---|---|
| f | 0.05 – 0.2 mm/omdr. | 0.05 – 0.2 mm/omdr. | 0.2 – 0.4 mm/omdr. | 0.4 – 1.0 mm/omdr. | > 1.0 mm/omdr. |
| $a_p$ | 0.05 – 2 mm | 0.05 – 2 mm | 2 – 4 mm | 4 – 10 mm | > 10 mm |

| | | |
|---|---|---|
| **SF** |   | Versatile positive geometry designed for fine finish machining, steels, stainless steels, cast irons and super alloys and hard materials, potentially non ferous materials and for machining thin walls, with continuous cuts |
| **NF** |   | Highly positive design for fine finish and medium machining, stainless steels. steel, potentially cast irons, non ferrous materials and super alloys, continuous cuts |
| **SM** |   | Positive geometry designed for medium machining, stainless steels, super alloys, steels and cast irons, potentially non ferrous and hard materials and for machining thin walls, continuous and interrupted cuts |
| **NM** |   | Highly positive design for fine finish, medium and rough machining, stainless steels, steels, potentially non ferrrous materials and super alloys, continuous cuts |
| **SI** |   | Positive geometry for fine finish to semi-rough machining, steels, stainless steels and cast irons and potentially non ferrous materials, continuous cuts |

# S

Meget ustabile arbejdsforhold

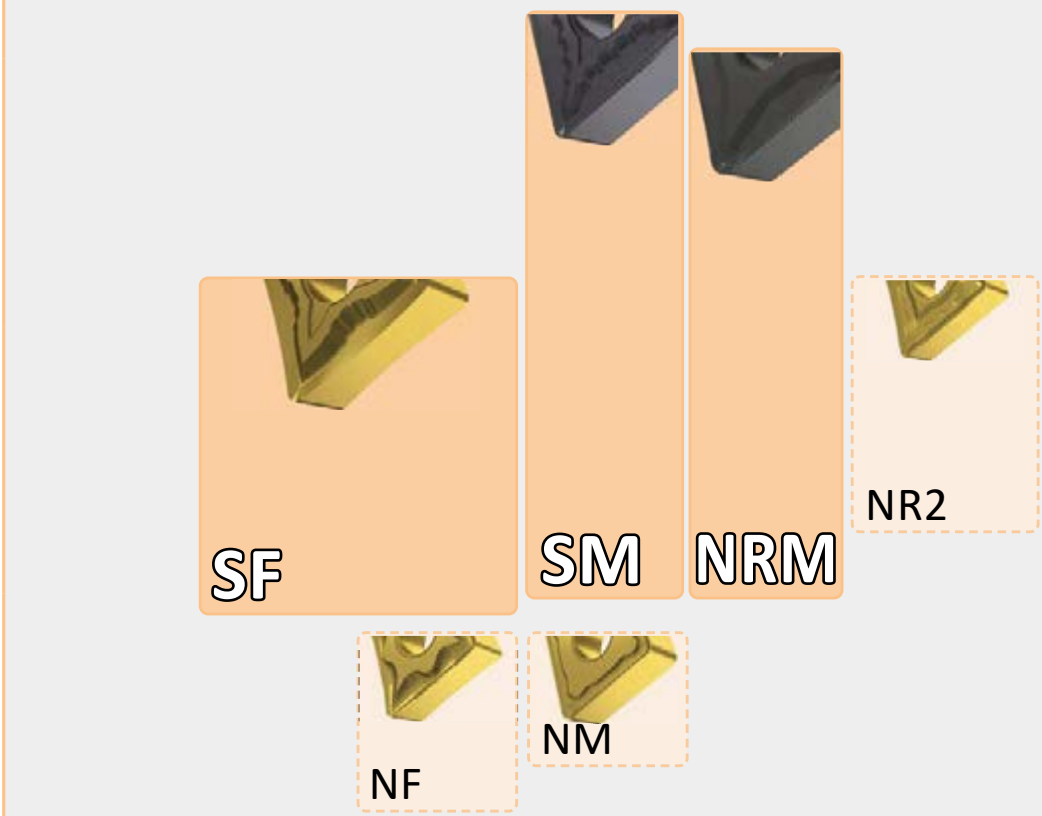
Ustabile arbejdsforhold

Stabile arbejdsforhold

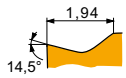
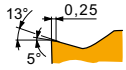
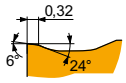
Tyndvæggede og slanke arbejdsemner

1st choice

Possible use




| | FF | F | M | R | HR |
|---|---|---|---|---|---|
| f ⇨ | 0.05 – 0.2 mm/omdr. | 0.05 – 0.2 mm/omdr. | 0.2 – 0.4 mm/omdr. | 0.4 – 1.0 mm/omdr. | > 1.0 mm/omdr. |
| $a_p$ | 0.05 – 2 mm | 0.05 – 2 mm | 2 – 4 mm | 4 – 10 mm | > 10 mm |

| | | |
|---|---|---|
| **SF** |   | Versatile positive geometry designed for fine finish machining, steels, stainless steels, cast irons and super alloys and hard materials, potentially non ferous materials and for machining thin walls, with continuous cuts |
| **SM** |   | Positive geometry designed for medium machining, stainless steels, super alloys, steels and cast irons, potentially non ferrous and hard materials and for machining thin walls, continuous and interrupted cuts |
| **NRM** |   | Positive design for semi-rough and rough machining, stainless steel, soft steels and super alloys, continuous cuts |

# H

Meget ustabile arbejdsforhold

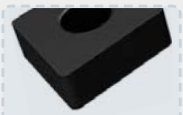
Ustabile arbejdsforhold

Stabile arbejdsforhold

Tyndvæggede og slanke arbejdsemner

1st choice

Possible use



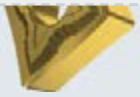
.NMA



R

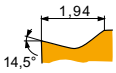
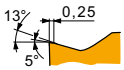


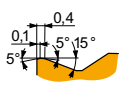
SM

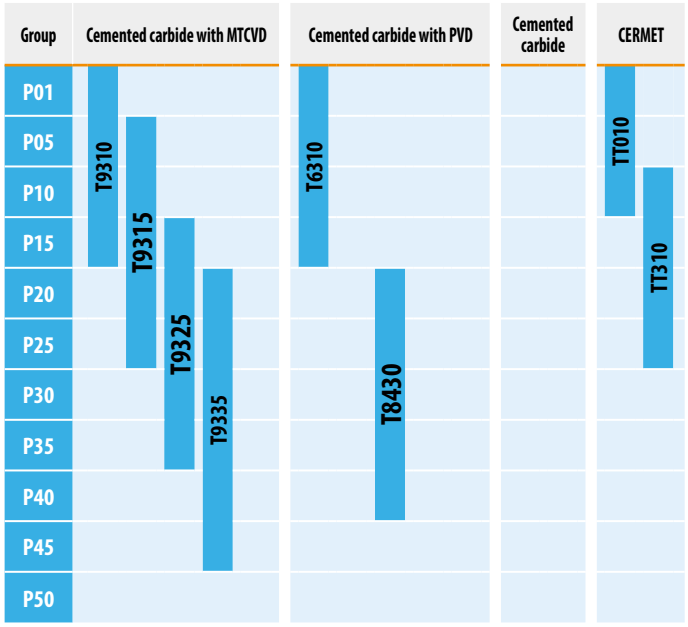


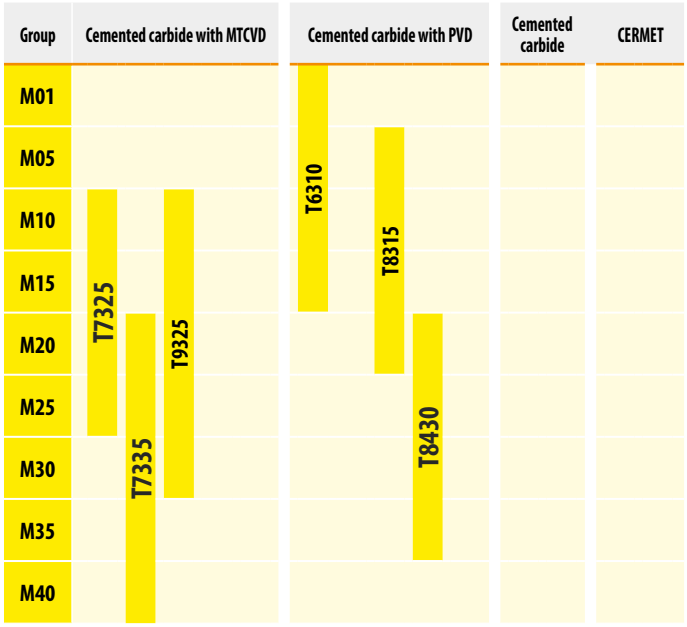
SF

| | FF | F | M | R | HR |
|---|---|---|---|---|---|
| f | 0.05 – 0.2 mm/omdr. | 0.05 – 0.2 mm/omdr. | 0.2 – 0.4 mm/omdr. | 0.4 – 1.0 mm/omdr. | > 1.0 mm/omdr. |
| $a_p$ | 0.05 – 2 mm | 0.05 – 2 mm | 2 – 4 mm | 4 – 10 mm | > 10 mm |

| | | |
|---|---|---|
| **SF** |   | Versatile positive geometry designed for fine finish machining, steels, stainless steels, cast irons and super alloys and hard materials, potentially non ferous materials and for machining thin walls, with continuous cuts |
| **SM** |   | Positive geometry designed for medium machining, stainless steels, super alloys, steels and cast irons, potentially non ferrous and hard materials and for machining thin walls, continuous and interrupted cuts |
| **.NMA** |  | Designed for fine finish to semi rough machining, cast irons, potentially hard materials, continuous and slightly interrupted cuts |

| | | |
|---|---|---|
| **R** |   | Designed for semi-rough and rough machining, cast irons, potentially steel and hard materials, continuous and interrupted cuts |
| | | |
| | | |


Group
Cemented carbide with MTCVD
Cemented carbide with PVD
Cemented carbide
CERMET
P01
P05
P10
P15
P20
P25
P30
P35
P40
P45
P50
T9310
T9315
T9325
T9335
T6310
T8430
TT010
TT310


Group
Cemented carbide with MTCVD
Cemented carbide with PVD
Cemented carbide
CERMET
M01
M05
M10
M15
M20
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M30
M35
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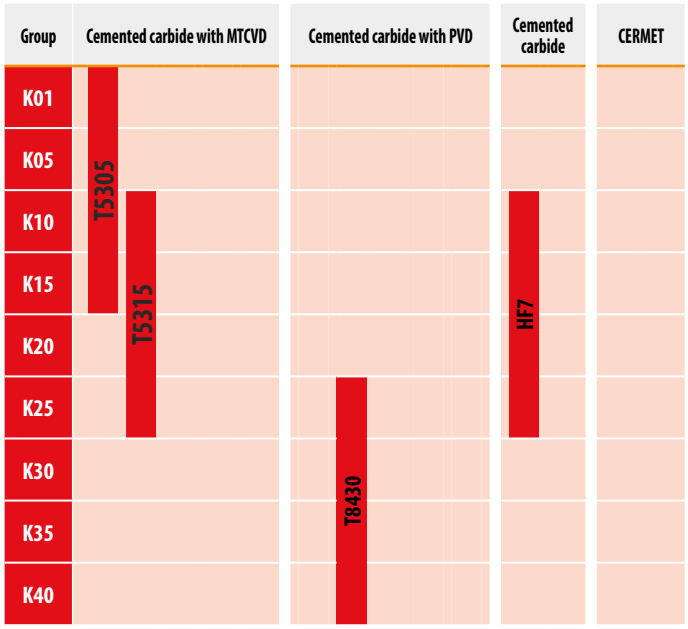
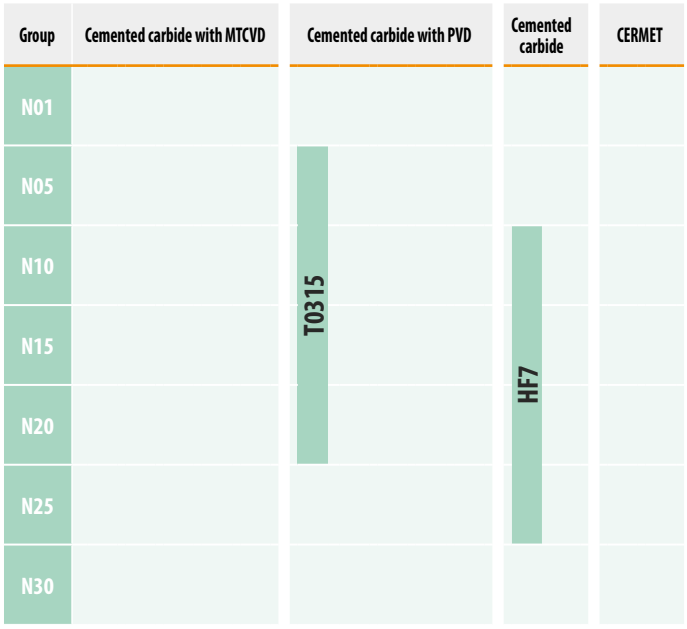
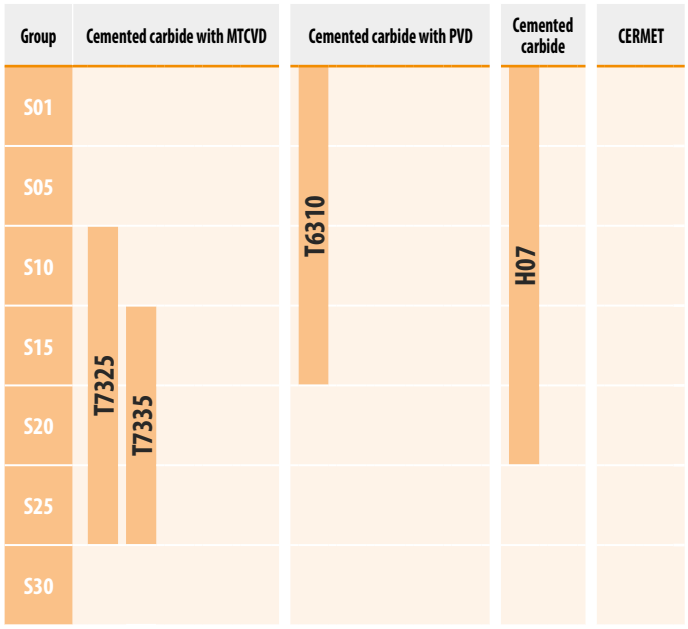
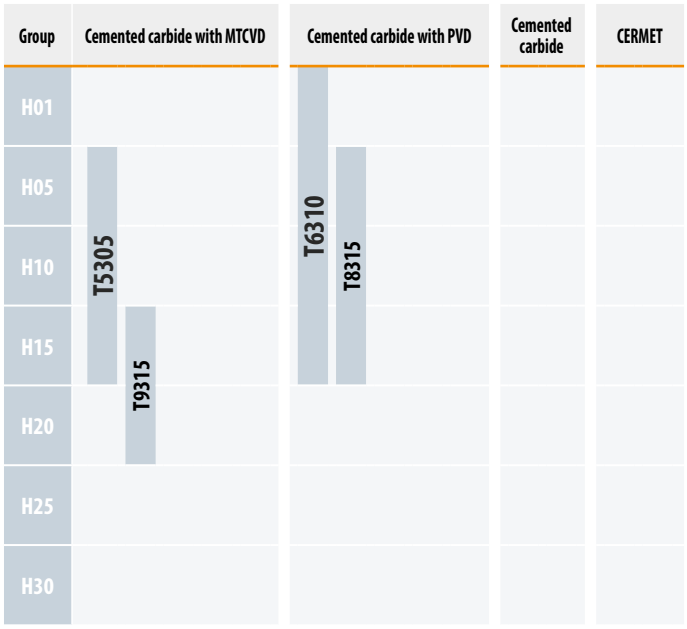
T7325
T7335
T9325
T6310
T8315
T8430


Group
Cemented carbide with MTCVD
Cemented carbide with PVD
Cemented carbide
CERMET
K01
K05
K10
K15
K20
K25
K30
K35
K40
T5305
T5315
T8430
HF7


Group
Cemented carbide with MTCVD
Cemented carbide with PVD
Cemented carbide
CERMET
N01
N05
N10
N15
N20
N25
N30
T0315
HF7


Group
Cemented carbide with MTCVD
Cemented carbide with PVD
Cemented carbide
CERMET
S01
S05
S10
S15
S20
S25
S30
T7325
T7335
T6310
H07


Group
Cemented carbide with MTCVD
Cemented carbide with PVD
Cemented carbide
CERMET
H01
H05
H10
H15
H20
H25
H30
T5305
T9315
T6310
T8315

| Grade Identification | Area of Application | Application | Feed | Cutting speed | Resistance to adverse Working Conditions | Coating | Colour | Substrate | Coolant benefit | Grade description |
|---|---|---|---|---|---|---|---|---|---|---|
| **T9310** | P01 - P15<br>K05 - K20<br>H10 - H20 | ■<br>◪<br>◪ |  |  |  | MT-CVD | | FGM | + + | Grade with high abrasion resistance which can be used for slightly interrupted cutting. It will be used for finishing or semi-roughing operations. This material can also be used for roughing operations provided the machine-tool-workpiece configuration is sufficiently rigid. |
| **T9315** | P05 - P25<br>K05 - K25<br>H10 - H20 | ■<br>◪<br>◪ |  |  |  | MT-CVD | | FGM | + + | A versatile grade with excellent wear resistance properties even under intense cutting conditions. It can also be used for operations with interrupted cuts. With it's well balanced properties this grade can be first choice for a wide range of turning operations. Not suited to low cutting speeds. |
| **T9325** | P15 - P35<br>M10 - M30<br>K15 - K35<br>S10 - S20 | ■<br>■<br>◪<br>◪ |  |  |  | MT-CVD | | FGM | + + | From a technological perspective this is an extremely versatile grade with high resistance to mechanical damage in adverse cutting conditions and retains excellent wear resistance. The correct application of this material requires high cutting speeds. |
| **T9335** | P20 - P45<br>M15 - M40<br>S15 - S25 | ■<br>■<br>◪ |  |  |  | MT-CVD | | FGM | + + + | One of the toughest grades which is especially suitable for adverse cutting conditions at medium to high feed rates and medium cutting speeds. Compared to its predecessors, M15 – M40 it is not only tougher, but also more abrasion resistant which will be useful when using intensive cutting conditions. |
| **T7325** | P15 - P35<br>M10 - M25<br>S10 - S25 | ◪<br>■<br>■ |  |  |  | MT-CVD | | FGM | + + + | One of the most universal turning grades. Especially designed for stainless steel machining. Optimal balance between wear resistance and performance reliability. Suitable for broad variety of application in turning operations. |
| **T7335** | P20 - P40<br>M20 - M40<br>S15 - S25 | ◪<br>■<br>■ |  |  |  | MT-CVD | | FGM | + + + | Grade with functionally graded substrate, featuring very high operational reliability and very good wear-resistance. It is best suited to use in the machining of very tough M20 – M40 materials. |
| **T5305** | P05 - P15<br>K01 - K15<br>H05 - H15 | ◪<br>■<br>◪ |  |  |  | MT-CVD | | H | + | Grade with very high resistance to chemical wear; suitable for finishing operations using high cutting speeds. With its high abrasion resistance, it is also suitable for productive K01 – K15, machining of hardened and treated materials. |
| **T5315** | P10 - P25<br>K10 - K25<br>H15 - H25 | ◪<br>■<br>◪ |  |  |  | MT-CVD | | H | + | Grade intended primarily for productive machining which has high abrasion resistance and good operational reliability. Due to its properties, this material is particularly suitable for roughing and finishing operations for good or slightly adverse cutting conditions. |
| **6640** | P20 - P40<br>M20 - M35<br>K25 - K40 | ■<br>■<br>■ |  |  |  | MT-CVD | | H | + + + | One of the toughest turning materials which can be used especially in roughing operations, or where operational reliability under adverse cutting conditions is a priority. Another ideal choice for machines working with low to medium cutting speeds and medium to high feed rates. |

| Grade Identification | Area of Application | Application | Feed | Cutting speed | Resistance to adverse Working Conditions | Coating | Colour | Substrate | Coolant benefit | Grade description |
|---|---|---|---|---|---|---|---|---|---|---|
| **T8315** | P05 - P20<br>M05 - M20<br>K05 - K25<br>N05 - N25<br>S05 - S15<br>H05 - H15 | ◪<br>■<br>■<br>■<br>◪<br>■ |  |  |  | PVD | | submicron H | + + | Grade featuring excellent abrasion resistance while maintaining above average operational reliability, it is suitable for machining at medium to high cutting speeds in short chipping harder materials. |
| **T8430**<br>NEW | P20 - P40<br>M20 - M35<br>K25 - K40<br>N15 - N30<br>S15 - S25<br>H15 - H25 | ■<br>■<br>◪<br>◪<br>◪<br>◪ |  |  |  | PVD | | submicron H | + + + | Undoubtedly the most versatile cutting material, this is useful for machining of all types of machined materials and is practically applicable in almost all types of turning operations. Its main benefits are its high operational reliability and very good frictional properties; it is therefore suitable for applications at medium and lower cutting speeds. |
| **T8330** | P25 - P40<br>M20 - M35<br>K20 - K40<br>N15 - N30<br>S15 - S25<br>H15 - H25 | ■<br>■<br>■<br>◪<br>◪<br>◪ |  |  |  | PVD | | submicron H | + + + | Versatile cutting material, this is useful for machining of all types of machined materials and is practically applicable in almost all types of turning operations. Its main benefits are its high operational reliability and very good frictional properties; it is therefore suitable for applications at medium and lower cutting speeds. |
| **T8345** | P30 - P50<br>M20 - M40<br>K30 - K40<br>S20 - S30 | ■<br>◪<br>◪<br>◪ |  |  |  | PVD | | submicron H | + + + | This is the toughest turning grade, which is intended mainly for machining under the worst cutting conditions and in applications with the highest requirements for operating reliability. Because of these properties, this material is recommended for lower cutting speeds. |
| **T6310** | P01 - P15<br>M01 - M15<br>K05 - K20<br>N05 - N20<br>S01 - S15<br>H01 - H15 | ■<br>■<br>■<br>■<br>■<br>■ |  |  |  | PVD | | ultra submicron H | + + + | High wear resistant turning grade with top PVD coating. Suitable for finishing operation and applications, where sharp cutting edge together with high flank wear resistance is of high importance |
| **T0315** | N05 - N20 | ■ |  |  |  | PVD | | submicron H | + + | Submicron grade for turning non-ferrous metals and their alloys with a balance of wear resistance and toughness. It is provided with a unique coating with excellent friction properties. |
| **HF7** | M10 - M20<br>K10 - K25<br>N10 - N25 | ◪<br>■<br>■ |  |  |  | × | | submicron H | + + | Uncoated grade which is primarily designed for machining non-ferrous metals; but can also be used for other machined materials (except steel). This material can be used in turning, milling, and even boring. |
| **H07** | M05 - M15<br>K10 - K25<br>N10 - N30<br>S01 - S20 | ◪<br>■<br>■<br>■ |  |  |  | × | | submicron H | + + | Uncoated turning grade suitable for machining applications where oxidation resistance is not dominating criterion of tool life. Designed for machining of Ti-based alloys. Grade exhibits high strength of cutting edge together with good wear resistance. |
| **TT310** | P10 - P25<br>M15 - M25 | ■<br>◪ |  |  |  | PVD | | cermet | + / – | Coated cermet used for fine and finish turning of carbon and alloy steels (including stainless). Its excellent friction properties are further improved by the coating applied using the PVD technique. |

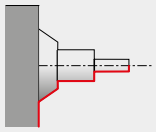
| Grade Identification | Area of Application | Application | Feed | Cutting speed | Resistance to adverse Working Conditions | Coating | Colour | Substrate | Coolant benefit | Grade description |
|---|---|---|---|---|---|---|---|---|---|---|
| **TT010** | P01 - P10<br>M01 - M10 | ■<br>◪ | | | | × | | cermet | + / – | Uncoated cermet, which is suitable for fine machining of all types of steel (including stainless) at very low feed rates. Its main advantage is the minimal radius of the cutting edge and its high resistance to physical and chemical wear mechanisms. |
| **TC100** | K01 - K15 | ■ | | | | × | | ceramics | – - | Ceramic grade for cast iron machining. Suitable for machining with high cutting speed at stable conditions. |
| **TB310** | K01 - K10<br>S05 - S10<br>H01 - H10 | ■<br>◪<br>◪ | | | | × | | CBN | – - | CBN grade for machining of hardened materials. Suitable for machining with high cutting speed and small feeds at stable conditions. |
| **PD1** | N05 - N25 | ■ | | | | × | | PCD | - | PKD grade for turning non-ferrous materials. Ideal choice for working with high cutting speed and small feeds at stable conditions. |
| **333TN** | P45 - P50<br>M35 - M40<br>K35 - K40 | ■<br>◪<br>◪ | | | | PVD | | HSS | + + + | Special grade composed of HSS substrate and thin hard PVD coating. The most tough cutting grade in the portfolio. Inserts with this grade are one and only used for slotting of key groove. |

| Substrat | |
|---|---|
| **H** | WC-Co-baseret substrat |
| **submicron H** | WC-Co-baseret substrat fintkornet (< 1 µm) |
| **ultra submicron H** | WC-Co-baseret substrat meget fintkornet (< 0,5 µm) |
| **FGM** | Substrat med funktionel klassificering |
| **Cermet** | Hårdmetal uden WC |
| **ceramics** | Keramisk skær |
| **PCD** | Polykrystallinsk diamant |
| **CBN** | Kubik bornitrid |
| **HSS** | SS |

| Coating | |
|---|---|
| **MT-CVD** | Kemikaliemetode til belægning ved mellemhøj temperatur |
| **PVD** | Fysisk metode til coating ved lav temperatur |
| × | Ubelagt kvalitet |

| Benefits of cutting fluid | |
|---|---|
| + + + | Use of coolant is essential |
| + + | Highly recommended |
| + | Recommended |
| + / – | Optional |
| – - | Do not use coolant |
| – | Coolant not recommended |

## ISO-DREJNING – UDVENDIGT
LANGE OG USTABILE KOMPONENTER (Positive skær)



### SCAC(RL) EXT
90° | CC..
06
09
08×08
16×16
70 | 60 – 69

### SCBC(RL) EXT
75° | CC..
09
12
12×12
25×25
71 | 60 – 69

### SCDCR EXT
45° | CC..
06
50°
10×10
72 | 60 – 69

### SCFC(RL) EXT
90° | CC..
06
09
08×08
16×16
73 | 60 – 69

### SCLC(RL) EXT
95° | CC..
06
08
09
12
08×08
25×25
74 | 60 – 69

### SDJC(RL) EXT
93° | DC..
07
11
15
30°
08×08
25×25
94 | 86 – 93

### SDNCN EXT
62°30´ | DC..
7
11
62,5°
08×08
25×25
95 | 86 – 93

### SEGC(RL) EXT
90° | EC..
08
15°
12×12
16×16
107 | 104 – 106

### SRDC(RL) EXT
RC..
08
20×20
32×25
126 | 118 – 123

### SRDCN EXT
RC..
06
08
10
12
16
90°
12×12
32×25
127 | 118 – 123

### SRSC(RL) EXT
RC..
06
08
10
12
16
27°
12×12
32×25
128 | 118 – 123

### SSBC(RL) EXT
75° | SC..
09
12
25
38
12×12
60×60
139 | 134 – 138

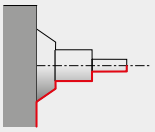
### SSDCN EXT
45° | SC..
09
12
45°
45°
12×12
25×25
140 | 134 – 138

### SSKC(RL) EXT
75° | SC..
09
12
12×12
25×25
141 | 134 – 138

### STFC(RL) EXT
90° | TC..
11
16
16×16
25×25
155 | 149 – 154

### STFC(RL)-A EXT
90° | TC..
11
20×20
156 | 149 – 154

## ISO-DREJNING – UDVENDIGT
LANGE OG USTABILE KOMPONENTER (Positive skær)



### STJC(RL) EXT
93° | TC..
11
16
16×16
25×25
157 | 149 – 154

### SVAC(RL)-DC EXT
90° | VC..
13
10×10
25×25
193 | 186 – 192

### SVGC(RL) EXT
90° | VC..
07
08×08
16×16
194 | 186 – 192

### SVHB(C)(RL) EXT
107°30´ | VB, VC..
11
16
16×16
25×25
172, 195 | 168 – 171, 186 – 192

### SVJB(C)(RL) EXT
93° | VB, VC..
11
13
16
12×12
32×25
173, 196 | 168 – 171, 186 – 192

### SVJC(RL)-DC EXT
93° | VC..
13
10×10
25×25
197 | 186 – 192

### SVPB(C)(RL) EXT
117°30´ | VB, VC..
11
16
16×16
32×25
174, 198 | 168 – 171, 186 – 192

### SVVB(C)N EXT
72°30´ | VB, VC..
11
13
16
12×12
32×25
175, 199 | 168 – 171, 186 – 192

### SVXB(C)(RL) EXT
98° | VB, VC..
11
13
16
12×12
32×25
176, 200 | 168 – 171, 186 – 192

### SWLC(RL) EXT
95° | WC..
06
08
16×16
25×25
215 | 212 – 214

### CKJN(RL) EXT
93° | KN..
16
20×20
32×25
287 | 284 – 286

### C.-SCLC(RL) EXT NEW
95° | CC..
09
12
20
32
75 | 60 – 69

### C.-SDJC(RL) EXT NEW
93° | DC..
11
C3
C5
96 | 86 – 93

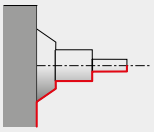
### C.-SDNCN EXT NEW
62°30´ | DC..
11
C4
C5
97 | 86 – 93

### C.-SRDCN EXT NEW
RC..
10
12
C4
C5
130 | 118 – 123

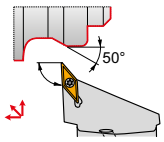
### C.-SVHB(RL) EXT NEW
107°30´ | VB, VC..
16
C4
C6
177, 201 | 168 – 171, 186 – 192

## ISO-DREJNING – UDVENDIGT

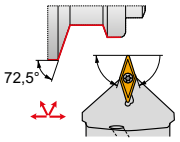
LANGE OG USTABILE KOMPONENTER (Positive skær)



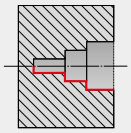
### C.-SVJB(RL) EXT NEW

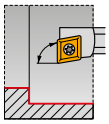
| 93° | VB, VC.. |
|---|---|
|   | 11<br>16 |
| C3 / C6 | |
| 178, 202 | 168 – 171<br>186 – 192 |

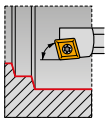
### C.-SVVBN EXT NEW

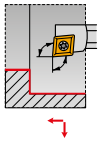
| 72°30´ | VB, VC.. |
|---|---|
|   | 16 |
| C4 / C6 | |
| 179, 203 | 168 – 171<br>186 – 192 |

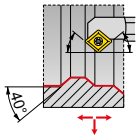
## ISO-DREJNING – INDVENDIG
LANGE OG USTABILE KOMPONENTER (Positive skær)



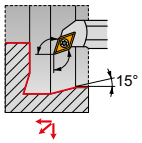
### SCFC(RL) INT
90° | CC..
06

ØDmin 13/16
76 | 60 – 69

### SCKC(RL) INT
75° | CC..
06
09
12

ØDmin 11/40
77 | 60 – 69

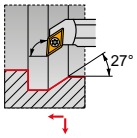
### SCLC(RL) INT
95° | CC..
06
09
12

ØDmin 11/40
78 | 60 – 69

### SCXC(RL) INT
40° | CC..
06


ØDmin 13/20
80 | 60 – 69

### SDQC(RL) INT
107°30´ | DC..
07
11


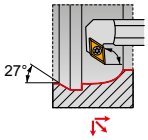
ØDmin 13/40
98 | 86 – 93

### SDUC(RL) INT
93° | DC..
07
11


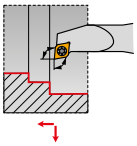
ØDmin 13/40
99 | 86 – 93

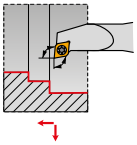
### SDUC(RL)-E INT
93° | DC..
07
11

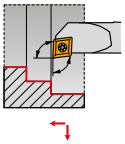

ØDmin 13/40
100 | 86 – 93

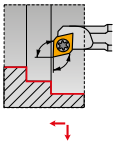
### SDZC(RL) INT
93° | DC..
07
11


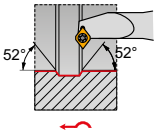
ØDmin 27/65
101 | 86 – 93

### SELP(RL) INT
95° | EP..
05

ØDmin 8/16
111 | 110

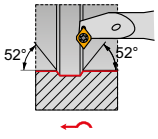
### SELP(RL)-E INT
95° | EP..
05

ØDmin 8/16
112 | 110

### SEUC(RL) INT
93° | EC..
06
08

ØDmin 11/32
108 | 104 – 106

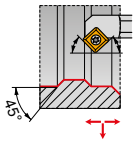
### SEUP(RL) INT
93° | EP..
05

ØDmin 8.3
113 | 110

### SEXP(RL) INT
52°30´ | EP..
05


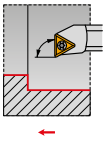
ØDmin 9.5/16
114 | 110

### SEXP(RL)-E INT
52°30´ | EP..
05


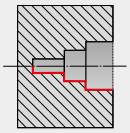
ØDmin 9.5/16
115 | 110

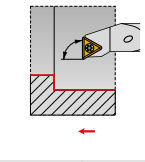
### SSSC(RL) INT
45° | SC..
09


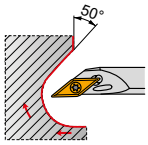
ØDmin 25/32
144 | 134 – 138

### STFC(RL) INT
90° | TC..
06
09
11
16

ØDmin 8.5/40
158 | 149 – 154

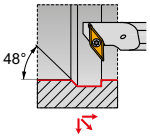
## ISO-DREJNING – INDVENDIG
LANGE OG USTABILE KOMPONENTER (Positive skær)



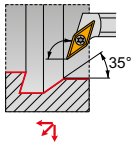
### STFC(RL)-E INT
90° | TC..
06
09
11

ØDmin 8.5 / 20
160 | 149 – 154

### SVJB(RL) INT
93° | VB, VC..
11


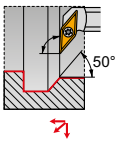
ØDmin 25 / 32
180, 204 | 168 – 171, 186 – 192

### SVLC(RL) INT
95° | VC..
13


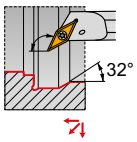
ØDmin 27 / 43
205 | 186 – 192

### SVQB(C)(RL) INT
107°30´ | VB, VC..
11
13
16


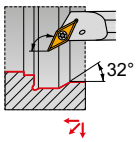
ØDmin 20 / 50
181, 206 | 168 – 171, 186 – 192

### SVUB(C)(RL) INT
93° | VB, VC..
11
13
16


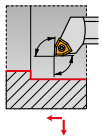
ØDmin 20 / 50
182, 207 | 168 – 171, 186 – 192

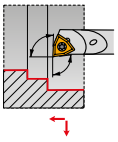
### SVXC(RL) INT
113° | VC..
07


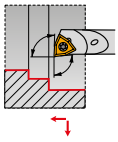
ØDmin 12.5 / 17.5
208 | 186 – 192

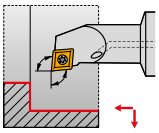
### SVXC(RL)-E INT
113° | VC..
07


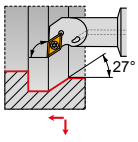
ØDmin 12.5 / 17.5
209 | 186 – 192

### SWLC(RL) INT
95° | WC..
06
08

ØDmin 25 / 40
216 | 212 – 214

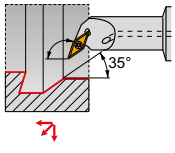
### SWUC(RL) INT
93° | WC..
02

ØDmin 5.8 / 7.8
217 | 212 – 214

### SWUC(RL)-E INT
93° | WC..
02

ØDmin 5.8 / 7.8
218 | 212 – 214

### C.-SCLC(RL) INT NEW
95° | CC..
09

ØDmin C3 / C5
81 | 60 – 69

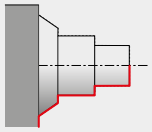
### C.-SDUC(RL) INT NEW
93° | DC..
07
11


ØDmin 20 / 32
102 | 86 – 93

### C.-SVQB(C)(RL) INT NEW
108° | VB, VC..
16


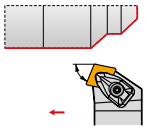
ØDmin 33
183, 210 | 168 – 171, 186 – 192

## ISO-DREJNING – UDVENDIGT
KORTE OG STABILE KOMPONENTER (negative skær)



### DCBN(RL) EXT

75°



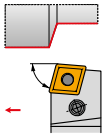
| CN.. |
|---|
| 12 |
| 16 |
| 19 |

20×20
40×40

240 | 222 – 239

### PCBN(RL) EXT

75°



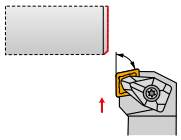
| CN.. |
|---|
| 12 |
| 16 |
| 19 |
| 25 |

20×20
50×50

245 | 222 – 239

### DCKN(RL) EXT

75°



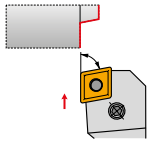
| CN.. |
|---|
| 12 |
| 16 |

20×20
32X32

242 | 222 – 239

### PCKN(RL) EXT

75°



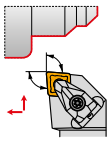
| CN.. |
|---|
| 12 |
| 16 |
| 19 |

20×20
40×40

246 | 222 – 239

### DCLN(RL) EXT

95°



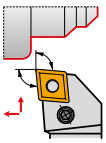
| CN.. |
|---|
| 09 |
| 12 |
| 16 |
| 19 |

16×16
40×40

243 | 222 – 239

### PCLN(RL) EXT

95°



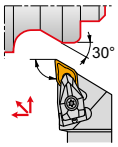
| CN.. |
|---|
| 12 |
| 16 |
| 19 |
| 25 |

20×20
50×50

247 | 222 – 239

### DDJN(RL) EXT

93°



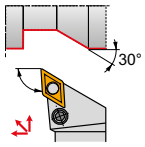

| DN.. |
|---|
| 11 |
| 15 |

20×20
32×32

273 | 260 – 272

### PDJN(RL) EXT

93°



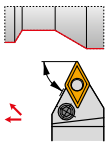

| DN.. |
|---|
| 11 |
| 15 |

20×20
32×32

274 | 260 – 272

### PDNN(RL) EXT

62°30´



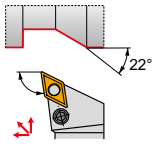
| DN.. |
|---|
| 11 |
| 15 |

20×20
32×25

275 | 260 – 272

### PDXN(RL) EXT

98°

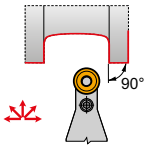



| DN.. |
|---|
| 15 |

20×20
32×25

276 | 260 – 272

### PRDCN EXT

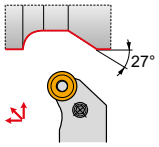



| RC.. |
|---|
| 16 |
| 20 |
| 25 |
| 32 |

32×25
50×50

124 | 118 – 123

### PRSC(RL) EXT

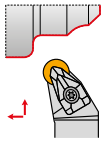



| RC.. |
|---|
| 16 |
| 20 |
| 25 |

32×25
40×40

125 | 118 – 123

### DRSN(RL) EXT

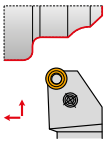


| RN.. |
|---|
| 12 |

25×25

295 | 294

### PRSN(RL) EXT



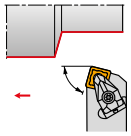
| RN.. |
|---|
| 12 |
| 15 |
| 19 |

25×25
40×40

296 | 294

### DSBN(RL) EXT

75°



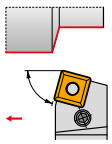
| SN.. |
|---|
| 12 |
| 15 |
| 19 |

20×20
40×40

313 | 300 – 312

### PSBN(RL) EXT

75°

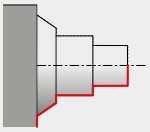


| SN.. |
|---|
| 12 |
| 15 |
| 19 |
| 25 |

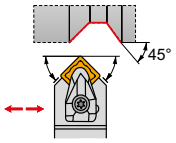
20×20
50×50

318 | 300 – 312

## ISO-DREJNING – UDVENDIGT
KORTE OG STABILE KOMPONENTER (negative skær)



### DSDNN EXT
45°

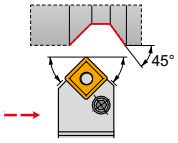



| SN.. |
|---|
| 12 |
| 15 |
| 19 |
| 25 |

20×20
40×40

315 | 300 – 312

### PSDNN EXT
45°

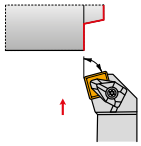



| SN.. |
|---|
| 12 |
| 15 |
| 19 |
| 25 |

20×20
50×50

320 | 300 – 312

### DSKN(RL) EXT
75°

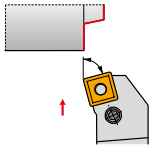


| SN.. |
|---|
| 12 |
| 19 |

25×25
32×32

316 | 300 – 312

### PSKN(RL) EXT
75°

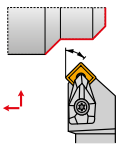


| SN.. |
|---|
| 12 |
| 15 |
| 19 |
| 25 |

20×20
50×50

321 | 300 – 312

### DSSN(RL) EXT
45°

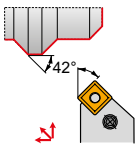


| SN.. |
|---|
| 12 |
| 15 |
| 19 |

20×20
40×40

317 | 300 – 312

### PSSN(RL) EXT
45°

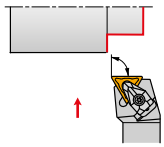



| SN.. |
|---|
| 12 |
| 15 |
| 19 |
| 25 |

20×20
50×50

323 | 300 – 312

### DTFN(RL) EXT
90°

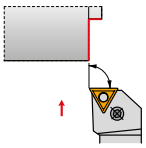


| TN.. |
|---|
| 16 |
| 22 |

20×20
25×25

345 | 334 – 344

### PTFN(RL) EXT
90°

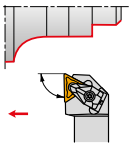


| TN.. |
|---|
| 16 |
| 22 |
| 27 |

16×16
40×40

348 | 334 – 344

### DTGN(RL) EXT
90°

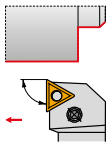


| TN.. |
|---|
| 16 |
| 22 |

20×20
32×25

346 | 334 – 344

### PTGN(RL) EXT
90°

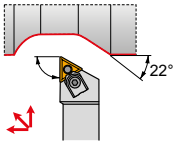


| TN.. |
|---|
| 16 |
| 22 |
| 27 |

16×16
40×40

349 | 334 – 344

### MTJN(RL) EXT
93°

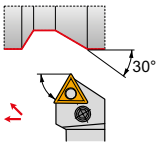



| TN.. |
|---|
| 16 |
| 22 |

16×16
32×32

347 | 334 – 344

### PTTN(RL) EXT
60°

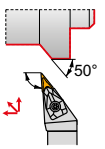



| TN.. |
|---|
| 16 |
| 22 |

20×20
32×25

350 | 334 – 344

### DVJN(RL) EXT
93°

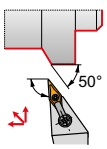



| VN.. |
|---|
| 16 |

20×20
32×25

360 | 356 – 376

### MVJN(RL) EXT
93°

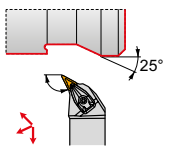



| VN.. |
|---|
| 16 |

20×20
32×25

362 | 356 – 376

### DVPN(RL) EXT
62°30´

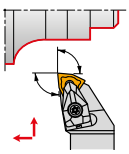



| VN.. |
|---|
| 16 |

20×20
32×25

361 | 356 – 376

### DWLN(RL) EXT
95°

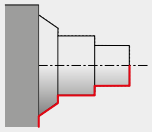


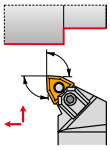
| WN.. |
|---|
| 06 |
| 08 |
| 10 |
| 13 |

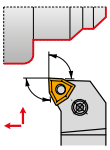
16×16
40×40

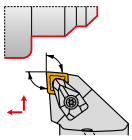
377 | 366 – 376

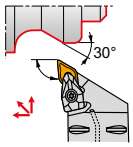
## ISO-DREJNING – UDVENDIGT
KORTE OG STABILE KOMPONENTER (negative skær)



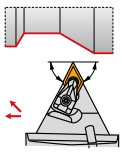
### MWLN(RL) EXT
95° | WN..
08

25×25 – 40×40
379 | 366 – 376

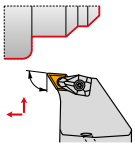
### PWLN(RL) EXT
95° | WN..
06
08

16×16 – 32×25
380 | 366 – 376

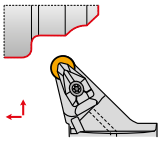
### C.-DCLN(RL) EXT NEW
95° | CN..
12
16
19

C3 – C8
249 | 222 – 239

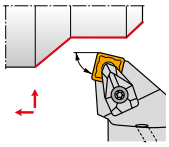
### C.-DDJN(RL) EXT NEW
93° | DN..
11
15


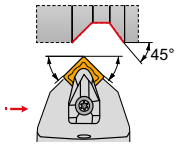
C4 – C6
277 | 260 – 272

### C.-DDNNN EXT NEW
62.5° | DN..
15

C5 – C6
278 | 260 – 272

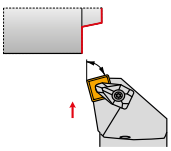
### C.-DDUN(RL) EXT NEW
93° | DN..
15

C5 – C6
279 | 260 – 272

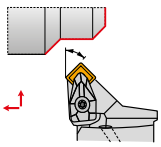
### C.-DRSN(RL) EXT NEW
RN..
12

C6
297 | 294

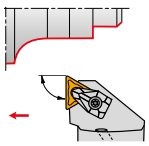
### C.-DSRN(RL) EXT NEW
75° | SN..
12
19

C4 – C6
326 | 300 – 312

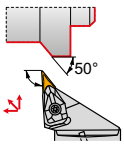
### C.-DSDNN EXT NEW
45° | SN..
12
19


C4 – C6
324 | 300 – 312

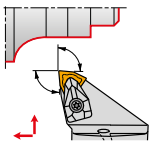
### C.-DSKN(RL) EXT NEW
75° | SN..
12

C4
325 | 300 – 312

### C.-DSSN(RL) EXT NEW
45° | SN..
12

C4 – C5
327 | 300 – 312

### C.-DTJN(RL) EXT NEW
93° | TN..
16

C4 – C5
351 | 334 – 344

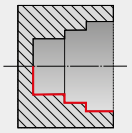
### C.-DVJN(RL) EXT NEW
93° | VN..
16


C4 – C6
363 | 356 – 376

### C.-DWLN(RL) EXT NEW
95° | WN..
06
08

C4 – C6
381 | 366 – 376

## ISO-DREJNING – INDVENDIG

KORTE OG STABILE KOMPONENTER (negative skær)

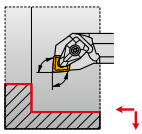


### DCLN(RL) INT

95°

CN..

09
12



ØDmin 32 / 50

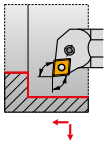
254 | 222 – 239

### PCLN(RL) INT

95°

CN..

09
12
16
19



ØDmin 20 / 80

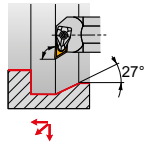
255 | 222 – 239

### DDUN(RL) INT

93°

DN..

11
15




ØDmin 25 / 50

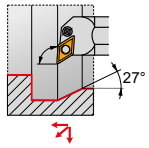
280 | 260 – 272

### PDUN(RL) INT

93°

DN..

11
15




ØDmin 25 / 60

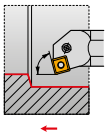
281 | 260 – 272

### PSKN(RL) INT

93°

SN..

11
15



ØDmin 32 / 80

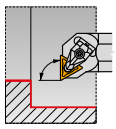
331 | 300 – 312

### DTFN(RL) INT

90°

TN..

16
22



ØDmin 32 / 50

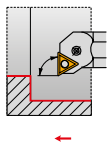
352 | 334 – 344

### PTFN(RL) INT

90°

TN..

16
22



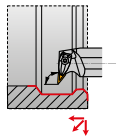
ØDmin 32 / 50

353 | 334 – 344

### DVUN(RL) INT

VN..

16



ØDmin 50

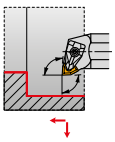
364 | 356 – 376

### DWLN(RL) INT

95°

WN..

06
08



ØDmin 32 / 63

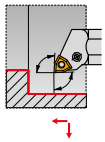
382 | 366 – 376

### PWLN(RL) INT

95°

WN..

06
08



ØDmin 20 / 80

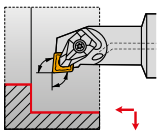
383 | 366 – 376

### C.-DCLN(RL) INT NEW

95°

CN..

09
12
16



ØDmin 25 / 50

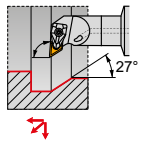
257 | 222 – 239

### C.-DDUN(RL) INT NEW

93°

DN..

11




ØDmin 12

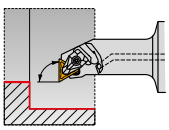
282 | 260 – 272

### C.-DTFN(RL) INT NEW

91°

TN..

16



ØDmin 32

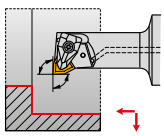
354 | 334 – 344

### C.-DWLN(RL) INT NEW

95°

WN..

06
08

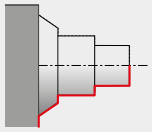


ØDmin 27 / 33

385 | 366 – 376

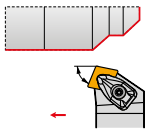
# ISO-DREJNING – GROVBEARBEJDNING – UDVENDIGT

FASTE VÆRKTØJSHOLDERE



## DCBN(RL) EXT

75°



CN..

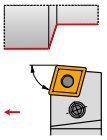
19

40×40

240 | 222 – 239

## PCBN(RL) EXT

75°



CN..

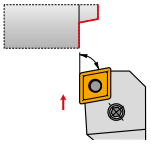
19
25

40×40
50×50

245 | 222 – 239

## PCKN(RL) EXT

75°



CN..

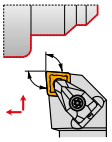
19

40×40

246 | 222 – 239

## DCLN(RL) EXT

95°



CN..

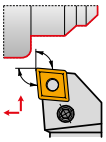
19

40×40

243 | 222 – 239

## PCLN(RL) EXT

95°



CN..

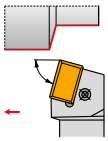
19
25

40×40
50×50

247 | 222 – 239

## PLBN(RL) EXT

75°



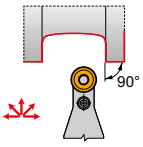
LN..

40
50

60×60

290 | 289

## PRDCN EXT



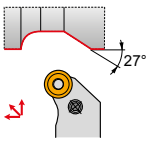

RC..

20
25
32

40×40
50×50

124 | 118 – 123

## PRSC(RL) EXT



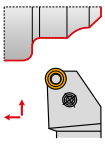

RC..

16
25

40×40

125 | 118 – 123

## PRSN(RL) EXT



RN..

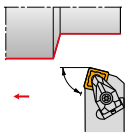
19

40×40

296 | 294

## DSBN(RL) EXT

75°



SN..

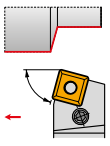
19

40×40

313 | 300 – 312

## PSBN(RL) EXT

75°



SN..

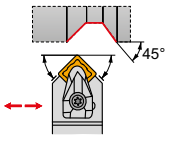
19
25

40×40
50×50

318 | 300 – 312

## DSDNN EXT

45°




SN..

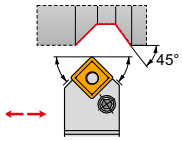
19
25

40×40

315 | 300 – 312

## PSDNN EXT

45°




SN..

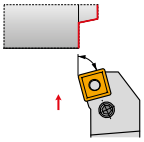
19
25

40×40
50×50

320 | 300 – 312

## PSKN(RL) EXT

75°



SN..

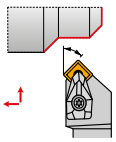
19
25

40×40
50×50

321 | 300 – 312

## DSSN(RL) EXT

45°



SN..

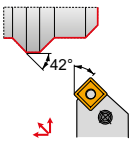
19

40×40

317 | 300 – 312

## PSSN(RL) EXT

45°




SN..

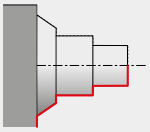
19
25

40×40
50×50

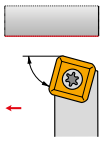
323 | 300 – 312

## ISO-DREJNING – GROVBEARBEJDNING – UDVENDIGT

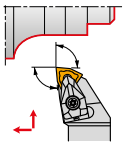
FASTE VÆRKTØJSHOLDERE



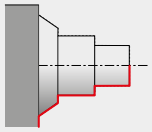
### SSBC(RL) EXT

| 75° | SC.. |
|---|---|
|  | 25<br>38 |
|  40×40<br>60×60 | |
| 139 | 134 – 138 |

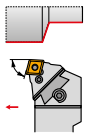
### DWLN(RL) EXT

| 95° | WN.. |
|---|---|
|  | 13 |
|  40×40 | |
| 377 | 366 – 376 |

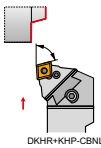
## ISO-DREJNING – GROVBEARBEJDNING – UDVENDIGT
HOVED (KH)



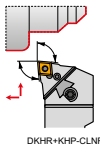
### KHP-CBNR + DKH(RL)

| 75° | CN.. |
|---|---|
|  DKHR+KHP-CBNR | 25 |
| 40×50<br>60×80 | |
| 251, 253 | 222 – 239 |

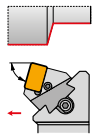
### KHP-CBNL + DKH(RL)

| 75° | CN.. |
|---|---|
|  DKHR+KHP-CBNL | 25 |
| 40×50<br>60×80 | |
| 251, 253 | 222 – 239 |

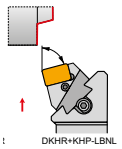
### KHP-CLNR/L + DKH(RL)

| 95° | CN.. |
|---|---|
|  DKHR+KHP-CLNR | 19<br>25 |
| 40×50<br>60×80 | |
| 252, 253 | 222 – 239 |

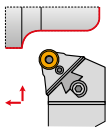
### KHP-LBNR + DKH(RL)

| 75° | LN.. |
|---|---|
|  DKHR+KHP-LBNR | 40 |
| 40×50<br>60×80 | |
| 291, 292 | 289 |

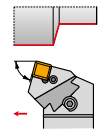
### KHP-LBNL + DKH(RL)

| 75° | LN.. |
|---|---|
|  DKHR+KHP-LBNL | 40 |
| 40×50<br>60×80 | |
| 291, 292 | 289 |

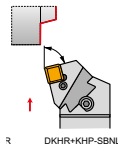
### KHP-RSCR/L + DKH(RL)

| | RC.. |
|---|---|
|  DKHR+KHP-RSCR | 20<br>25<br>32 |
| 40×50<br>60×80 | |
| 131, 132 | 118 – 123 |

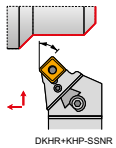
### KHP-SBNR + DKH(RL)

| 75° | SN.. |
|---|---|
|  DKHR+KHP-SBNR | 25 |
| 40×50<br>60×80 | |
| 328, 330 | 300 – 312 |

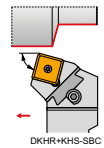
### KHP-SBNL + DKH(RL)

| 75° | SN.. |
|---|---|
|  DKHR+KHP-SBNL | 25 |
| 40×50<br>60×80 | |
| 328, 330 | 300 – 312 |

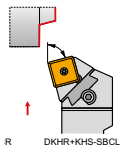
### KHP-SSNR/L + DKH(RL)

| 45° | SN.. |
|---|---|
|  DKHR+KHP-SSNR | 19<br>25 |
| 40×50<br>60×80 | |
| 329, 330 | 300 – 312 |

### KHS-SBCR + DKH(RL)

| 75° | SC.. |
|---|---|
|  DKHR+KHS-SBC | 25<br>38 |
| 40×50<br>60×80 | |
| 142, 143 | 134 – 138 |

### KHS-SBCL + DKH(RL)

| 75° | SC.. |
|---|---|
|  DKHR+KHS-SBCL | 25<br>38 |
| 40×50<br>60×80 | |
| 142, 143 | 134 – 138 |

DORMER PRAMET

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DORMER PRAMET

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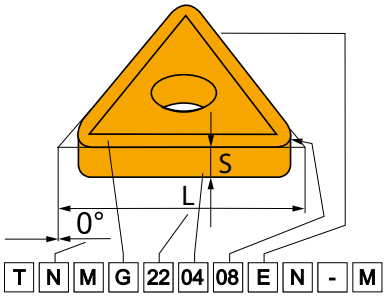



| | 1 | 2 | 3 | 4 |
|---|---|---|---|---|
| ISO | T | N | U | N |
| | T | N | M | G |
| ANSI | T | N | U | |
| | T | N | M | G |

## 1 Skærform

| | | | |
|---|---|---|---|
| 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 Frivinkel for skær

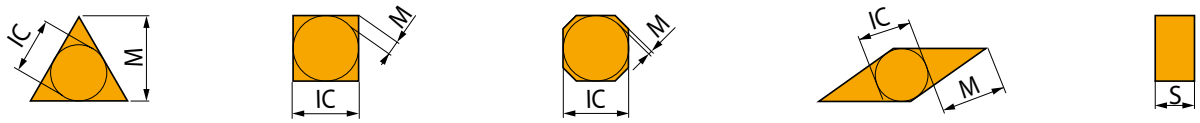
| | | | |
|---|---|---|---|
| A 3° | | B 5° | |
| C 7° | | D 15° | |
| E 20° | | F 25° | |
| G 30° | | N 0° | |
| P 11° | | O Speciel | |

## 4 Skærtype

| | |
|---|---|
| N | |
| R | |
| F | |
| A | |
| M | |
| G | |
| W | 40° – 60° |
| T | |
| Q | |
| U | |
| B | 70° – 90° |
| H | |
| C | |
| J | |
| X | Speciel |

## 3 Tolerancer

| | (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" |

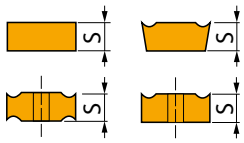


| 5 | 6 | 7 | 8 | 9 | | 10 |
|---|---|---|---|---|---|---|
| 22 | 04 | 08 | | | - | |
| 22 | 04 | 08 | E | N | | M |
| 5 | 6 | 7 | 8 | 9 | | 10 |
| 4 | 3 | 2 | | | - | |
| 4 | 3 | 2 | E | N | | M |

## 5 Skærlængde (skærstørrelse)

| d=IC (mm) | (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 Skærtykkelse



| | 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 Næseradius

| | 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" |



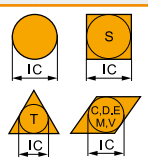
### Runde skær

| d=I.C. | |
|---|---|
| (") | 00 |
| (mm) | M0 |



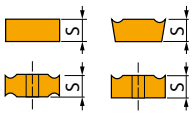
## ANSI

### 5 Indskrevet cirkel




| 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 Skærtykkelse



| 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 Næseradius for skær




| 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 Skærdesign

| | |
|---|---|
| F Skarpe skær | E Afrundede skær |
| T Skær med facet | S Afrundede skær med facet |
| K Skær med dobbelt facet | P Afrundede skær med dobbelt facet |

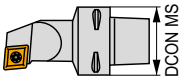
## 9 Tilspændingsretning

| | | | |
|---|---|---|---|
| R | Tilspænding ← | N | Tilspænding → ← Tilspænding |
| L | → Tilspænding | | |

## 10 Spånbryderbetegnelse

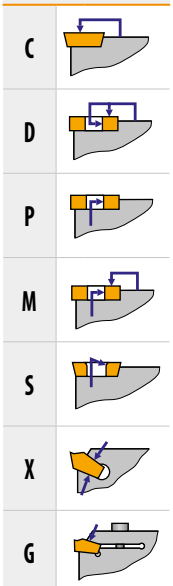
| | | 1 | 2 | 3 | 4 | 5 | 6 | | 7 | 8 | 9 | 10 | 11 | 12 | 13 |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Shank tool | ISO | | P | C | L | N | R | – | 32 | 25 | | | L | 12 | – M |
| PSC | ISO | C4 – | D | C | L | N | R | – | 27 | 050 | | | | – 12 | |
| Shank tool | ANSI | | 2 D | 3 C | 4 L | 5 N | 6 R | – | 7 & 8 16 | | | | 12 4 | 11 D | |

## 1 – Coupling size

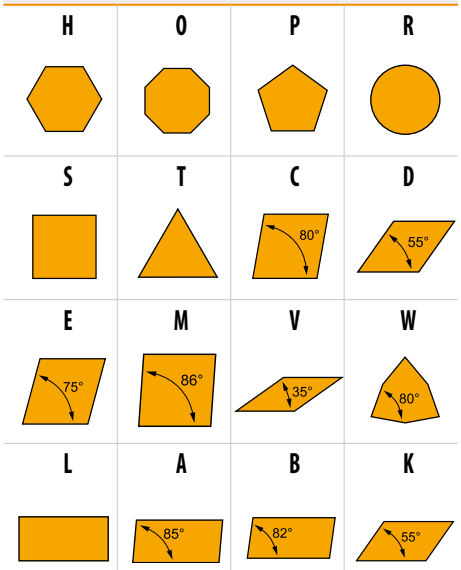



| C | DCON MS |
|---|---|
| C3 | 32 |
| C4 | 40 |
| C5 | 50 |
| C6 | 63 |
| C8 | 80 |

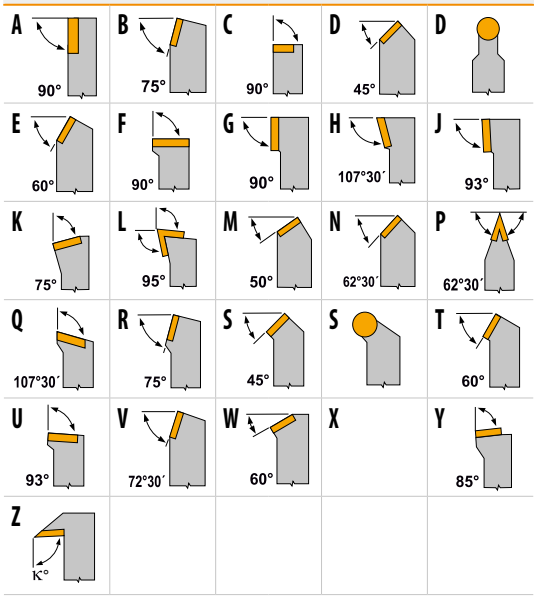
## 2 – Clamping designation




## 3 – Insert shape




## 4 – Holder style – cutting edge angle

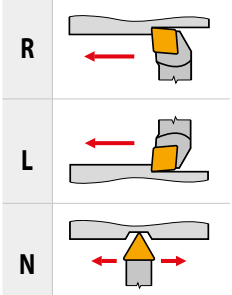



## 5 – Insert clearance angle




| N | B | C | P |
|---|---|---|---|
| 0° | 5° | 7° | 11° |

## 6 – Direction of cut

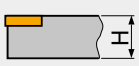



## 7 & 8 – Shank width & Shank height (")

| 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" |

For square shanks, the number is the width or height in terms of 16ths. For rectangular shanks the first digit is the width in terms of 8ths and the second digit is the height in terms of 4ths.

## 7 – Shank height (mm)



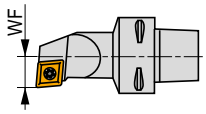

| | | | | | |
|---|---|---|---|---|---|
| 08 | 10 | 12 | 16 | 20 | 25 |
| 32 | 38 | 40 | 45 | 50 | 60 |

## 8 – Shank width (mm)

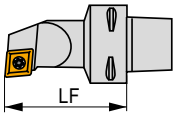



| | | | | | |
|---|---|---|---|---|---|
| 08 | 10 | 12 | 16 | 20 | 25 |
| 32 | 38 | 40 | 45 | 50 | 60 |

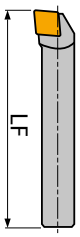
## 9 – Functional width (mm)




## 10 – Functional lenght (mm)




## 11 – Holder total length




| | 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" |

| | |
|---|---|
| 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 | |
| Y | 500 |

| | 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 – Insert cutting edge length (insert size)

| d = I.C. (mm) | d = I.C. (″) | 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 – Manufacturer's designation

| | |
|---|---|
| M | Clamping system "S" with shim |

## 14 – Manufacturer's designation

| | |
|---|---|
| X | Special shank style |
| . . | |
| 93 | Z – style tool setting angle |
| . . | |

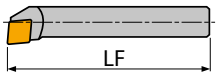
## 15 / 15 – Shank

| | |
|---|---|
| S | Steel shank |
| A | Steel shank with coolant hole |
| E | Tungsten carbide shank with coolant hole |

## 16 / 16 – Shank 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 – Holder total Length




| | 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 | Spec. |

| | 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 | Spec. |
| Y | 500 |

**PATRON**

| 1 | 2 | | 3 | 4 | 5 | 6 | 7 |
|---|---|---|---|---|---|---|---|
| KH | P | – | C | L | N | R | 25 |

**HOLDER**

| 8 | | 6 | 9 | 10 | 11 | |
|---|---|---|---|---|---|---|
| DKH | | R | 50 | 60 | W | |

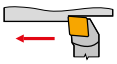
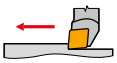
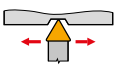
## 1 Patron

## 5 Frivinkel

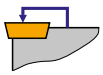
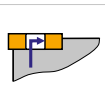
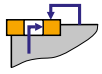
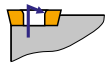
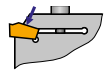



| N | C | P |
|---|---|---|
| 0° | 7° | 11° |

## 6 Skæreretning

| | |
|---|---|
| R |  |
| L |  |
| N |  |

## 2 Fastspændingsbetegnelse

| | |
|---|---|
| C |  |
| D |  |
| P |  |
| M |  |
| S |  |
| X |  |
| G |  |

## 3 Skærform

| | | | |
|---|---|---|---|
| S |  | C |  |
| T |  | D |  |
| R |  | K |  |
| W |  | V |  |
| L |  | X | Speciel |

## 4 Holderstil – skærvinkel

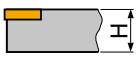
| | | | | |
|---|---|---|---|---|
| A 90° | B 75° | C 90° | D 45° | D |
| E 60° | F 90° | G 90° | H 107°30´ | J 93° |
| K 75° | L 95° | M 50° | N 62°30´ | P 62°30´ |
| Q 107°30´ | R 75° | S 45° | S | T 60° |
| U 93° | V 72°30´ | W 60° | X Special | Y 85° |
| Z K° | | | | |

## 7 Skærlængde (skærstørrelse)

| d = I.C. | | H | O | P | S | T | C | D | E | M | V | W | R | K |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| (mm) | (") | | | | | | | | | | | | | |
| 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 Patronholder

## 9 Skafthøjde (mm)



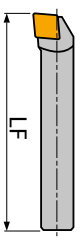

| | | | | | |
|---|---|---|---|---|---|
| 08 | 10 | 12 | 16 | 20 | 25 |
| 32 | 40 | 50 | 60 | 70 | 80 |

## 10 Skaftbredde (mm)

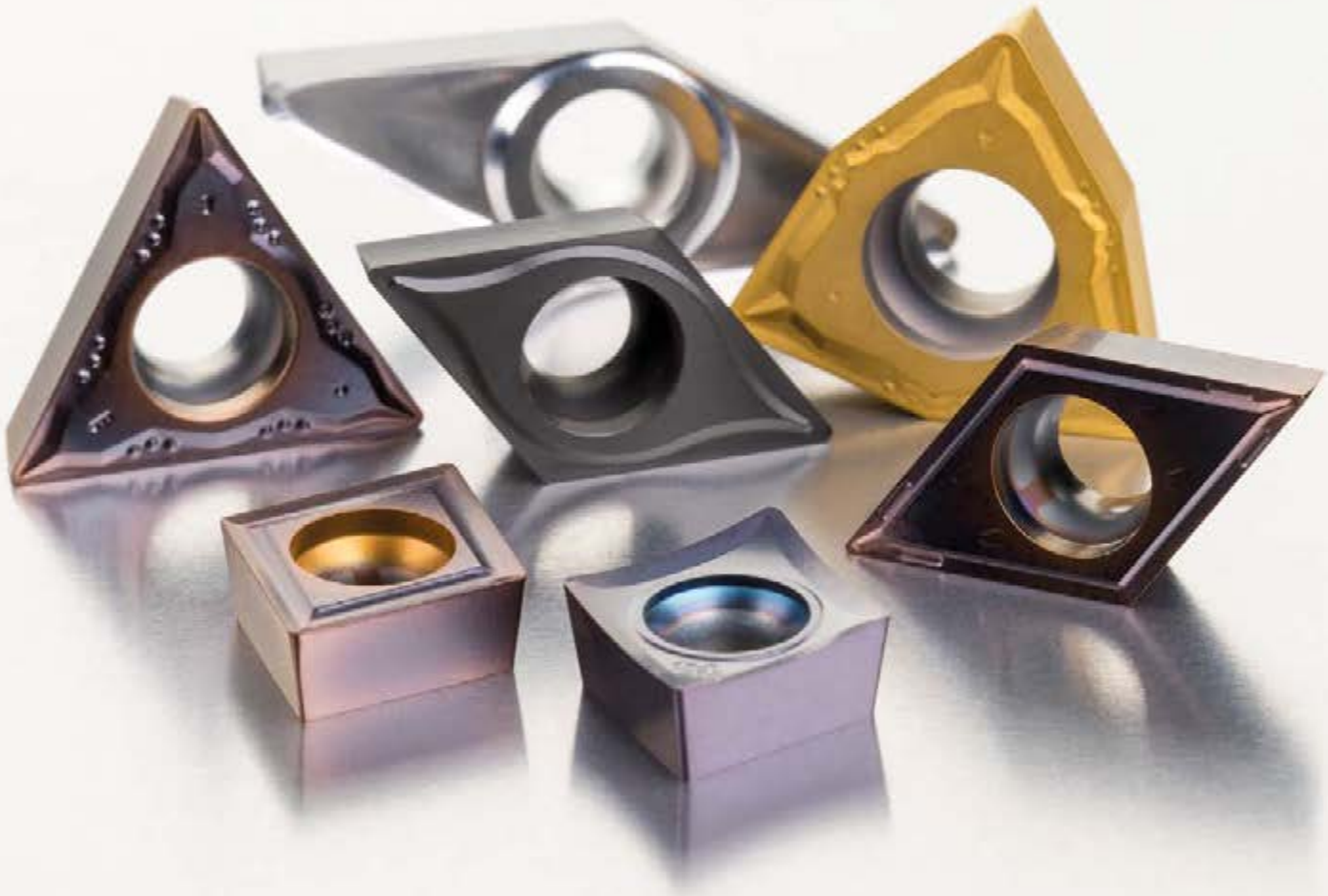



| | | | | | |
|---|---|---|---|---|---|
| 08 | 10 | 12 | 16 | 20 | 25 |
| 32 | 40 | 50 | 60 | 70 | 80 |

## 11 Holderlængde




| | 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 | Spec. |
| Y | 500 |



# POSITIVE INSERTS

# CC

06 / 08 / 09 / 12

## CARBIDE INSERTS

**CCGT**



60

**CCMT**



62

**CCMW**



68

## CBN INSERTS

**CCGW CBN**



69

| MATCH THE RIGHT SIZE (example) | |
|---|---|
| **Insert** | **Tool Holder** |
| CCMT **12**0404E-UR | S32U-SCKCR **12**-A |

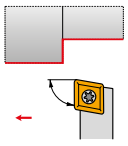
## ISO-DREJNING – UDVENDIGT

### SCAC(RL) EXT

90°

CC..

06
09



08×08
16×16

70

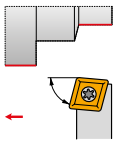
60 – 69

### SCBC(RL) EXT

75°

CC..

09
12



12×12
25×25

71

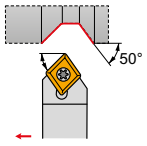
60 – 69

### SCDCR EXT

45°

CC..

06




10×10

72

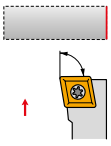
60 – 69

### SCFC(RL) EXT

90°

CC..

06
09



08×08
16×16

73

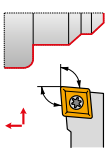
60 – 69

### SCLC(RL) EXT

95°

CC..

06
08
09
12



08×08
25×25

74

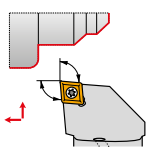
60 – 69

### C.-SCLC(RL) EXT NEW

95°

CC..

09
12



C3
C5

75

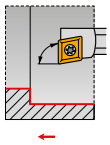
60 – 69

# CC

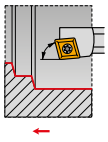
06 / 08 / 09 / 12

## ISO-DREJNING – INDVENDIG

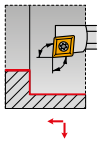
### SCFC(RL) INT

| 90° | CC.. |
|---|---|
|  | 06 |
| ØDmin 13 / 16 | |
| 76 | 60 – 69 |

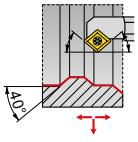
### SCKC(RL) INT

| 75° | CC.. |
|---|---|
|  | 06<br>09<br>12 |
| ØDmin 11 / 40 | |
| 77 | 60 – 69 |

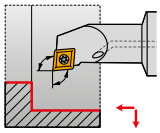
### SCLC(RL) INT

| 95° | CC.. |
|---|---|
|  | 06<br>09<br>12 |
| ØDmin 11 / 40 | |
| 78 | 60 – 69 |

### SCXC(RL) INT

| 40° | CC.. |
|---|---|
|  | 06 |
| ØDmin 13 / 20 | |
| 80 | 60 – 69 |

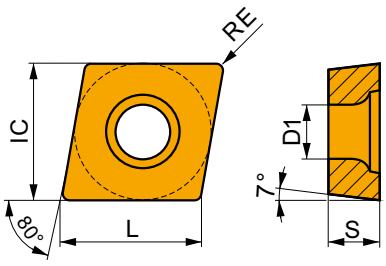
### C.-SCLC(RL) INT NEW

| 95° | CC.. |
|---|---|
|  | 09 |
| ØDmin 20 / 32 | |
| 81 | 60 – 69 |

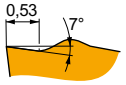
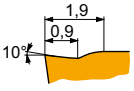
# CCGT

PRAMET

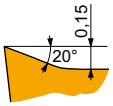
| | IC (mm) | D1 (mm) | L (mm) | S (mm) |
|---|---|---|---|---|
| 0602 | 6.350 | 2.80 | 6.40 | 2.38 |
| 0602-SF3 | 6.350 | 2.80 | 6.40 | 2.58 |
| 0803-AL | 7.940 | 3.40 | 8.10 | 3.43 |
| 0803-SF3 | 7.940 | 3.40 | 8.10 | 3.43 |
| 09T3 | 9.525 | 4.40 | 9.70 | 3.97 |
| 09T3-SF3 | 9.525 | 4.40 | 9.70 | 4.22 |
| 1204 | 12.700 | 5.50 | 12.90 | 4.76 |
| 1204-SF3 | 12.700 | 5.50 | 12.90 | 5.01 |




Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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-geometri med meget positivt design til fin-finish til grov bearbejdning, kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | | | | |
| **CCGT 060202F-AL** | **HF7** | 0.2 | – | – | – | – | – | – | – | – | – | 450 | 0.12 | 1.0 | – | – | – | – | – | – |
| | **T0315** | 0.2 | – | – | – | – | – | – | – | – | – | 645 | 0.12 | 1.0 | – | – | – | – | – | – |
| **CCGT 060204F-AL** | **HF7** | 0.4 | – | – | – | – | – | – | – | – | – | 360 | 0.24 | 1.0 | – | – | – | – | – | – |
| | **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 | – | – | – | – | – | – |
| | **T0315** | 0.4 | – | – | – | – | – | – | – | – | – | 525 | 0.24 | 1.0 | – | – | – | – | – | – |
| **CCGT 09T302F-AL** | **HF7** | 0.2 | – | – | – | – | – | – | – | – | – | 450 | 0.12 | 1.0 | – | – | – | – | – | – |
| | **T0315** | 0.2 | – | – | – | – | – | – | – | – | – | 645 | 0.12 | 1.0 | – | – | – | – | – | – |
| **CCGT 09T304F-AL** | **HF7** | 0.4 | – | – | – | – | – | – | – | – | – | 345 | 0.24 | 1.5 | – | – | – | – | – | – |
| | **T0315** | 0.4 | – | – | – | – | – | – | – | – | – | 495 | 0.24 | 1.5 | – | – | – | – | – | – |
| **CCGT 09T308F-AL** | **HF7** | 0.8 | – | – | – | – | – | – | – | – | – | 315 | 0.48 | 1.5 | – | – | – | – | – | – |
| | **T0315** | 0.8 | – | – | – | – | – | – | – | – | – | 450 | 0.48 | 1.5 | – | – | – | – | – | – |
| **CCGT 120404F-AL** | **HF7** | 0.4 | – | – | – | – | – | – | – | – | – | 330 | 0.24 | 2.4 | – | – | – | – | – | – |
| | **T0315** | 0.4 | – | – | – | – | – | – | – | – | – | 480 | 0.24 | 2.4 | – | – | – | – | – | – |
| **CCGT 120408F-AL** | **HF7** | 0.8 | – | – | – | – | – | – | – | – | – | 300 | 0.48 | 2.4 | – | – | – | – | – | – |
| | **T0315** | 0.8 | – | – | – | – | – | – | – | – | – | 435 | 0.48 | 2.4 | – | – | – | – | – | – |
|  |  | |  | | | | | | | | | | | | | | | | | |
| FF2-geometri med positivt design til finbearbejdning til finishbearbejdning, kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | | | | |
| **CCGT 09T302E-FF2** | **T7325** | 0.2 | 235 | 0.05 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.2 | 345 | 0.05 | 1.0 | – | – | – | 325 | 0.05 | 1.0 | – | – | – | – | – | – | – | – | – |
|  |  | |  | | | | | | | | | | | | | | | | | |
| NF1-geometri med positivt design til finbearbejdning til medium bearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **CCGT 060204E-NF1** | **H07** | 0.4 | – | – | – | 95 | 0.09 | 0.8 | – | – | – | 485 | 0.12 | 0.8 | 45 | 0.07 | 0.6 | – | – | – |
| | **T6310** | 0.4 | 180 | 0.10 | 0.8 | 125 | 0.09 | 0.8 | – | – | – | 540 | 0.12 | 0.8 | 50 | 0.07 | 0.6 | 35 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| | **T7325** | 0.8 | 235 | 0.12 | 0.8 | 180 | 0.11 | 0.8 | – | – | – | – | – | – | 75 | 0.11 | 0.6 | – | – | – |
| **CCGT 09T304E-NF1** | **H07** | 0.4 | – | – | – | 90 | 0.09 | 1.2 | – | – | – | 470 | 0.12 | 1.2 | 45 | 0.07 | 1.0 | – | – | – |
| | **T6310** | 0.4 | 175 | 0.10 | 1.2 | 125 | 0.09 | 1.2 | – | – | – | 525 | 0.12 | 1.2 | 50 | 0.07 | 1.0 | 35 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| | **T7325** | 0.8 | 215 | 0.14 | 1.2 | 165 | 0.13 | 1.2 | – | – | – | – | – | – | 65 | 0.13 | 1.0 | – | – | – |

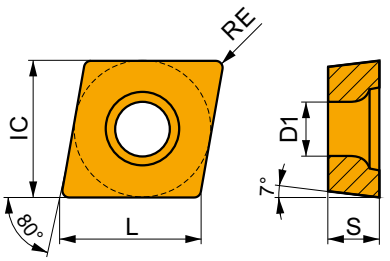
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |  | |  | | | | | | | | | | | | | | | | | |
| SF3-geometri med meget positivt design til finbearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **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 | 0.15 | 1.0 |
| **CCGT 060202E-SF3** | **H07** | 0.2 | – | – | – | 120 | 0.05 | 0.8 | 190 | 0.05 | 0.8 | 605 | 0.06 | 0.8 | 60 | 0.04 | 0.6 | – | – | – |
| | **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 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| **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 | – | – | – |
| | **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 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| **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 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| **CCGT 080304E-SF3** | **H07** | 0.4 | – | – | – | 95 | 0.09 | 1.0 | 150 | 0.10 | 1.0 | 485 | 0.12 | 1.0 | 45 | 0.07 | 0.8 | – | – | – |
| | **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 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| **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 | 0.15 | 1.0 |
| **CCGT 09T302E-SF3** | **H07** | 0.2 | – | – | – | 120 | 0.05 | 0.8 | 190 | 0.05 | 0.8 | 605 | 0.06 | 0.8 | 60 | 0.04 | 0.6 | – | – | – |
| | **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 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| **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 | – | – | – |
| | **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 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| **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 | – | – | – |
| | **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 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| **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 | 0.15 | 1.0 |
| **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 | – | – | – |
| | **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 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
|  |  | |  | | | | | | | | | | | | | | | | | |
| ER-SI geometri med positivt højrehåndet design til finbearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **CCGT 060202ER-SI** | **T8330** | 0.2 | 215 | 0.10 | 0.8 | 125 | 0.09 | 0.8 | 200 | 0.10 | 0.8 | – | – | – | 50 | 0.08 | 0.6 | – | – | – |
| | **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 | – | – | – |
| | **T8330** | 0.4 | 215 | 0.12 | 0.8 | 125 | 0.11 | 0.8 | 200 | 0.12 | 0.8 | – | – | – | 50 | 0.10 | 0.6 | – | – | – |
| | **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 | – | – | – |
| | **T8330** | 0.4 | 195 | 0.17 | 0.8 | 115 | 0.15 | 0.8 | 185 | 0.17 | 0.8 | – | – | – | 45 | 0.15 | 0.6 | – | – | – |
| | **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** | **T8330** | 0.8 | 205 | 0.23 | 1.0 | 120 | 0.21 | 1.0 | 190 | 0.23 | 1.0 | – | – | – | 50 | 0.21 | 0.8 | – | – | – |
| | **T8430** | 0.8 | 230 | 0.24 | 1.0 | 125 | 0.22 | 1.0 | 185 | 0.24 | 1.0 | – | – | – | 45 | 0.22 | 0.8 | – | – | – |
|  |  | |  | | | | | | | | | | | | | | | | | |
| EL-SI geometri med positivt venstrehåndet design til finbearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **CCGT 060202EL-SI** | **T8330** | 0.2 | 215 | 0.10 | 0.8 | 125 | 0.09 | 0.8 | 200 | 0.10 | 0.8 | – | – | – | 50 | 0.08 | 0.6 | – | – | – |
| | **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 | – | – | – |
| | **T8330** | 0.4 | 215 | 0.12 | 0.8 | 125 | 0.11 | 0.8 | 200 | 0.12 | 0.8 | – | – | – | 50 | 0.10 | 0.6 | – | – | – |
| | **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 | – | – | – |
| | **T8330** | 0.4 | 195 | 0.17 | 0.8 | 115 | 0.15 | 0.8 | 185 | 0.17 | 0.8 | – | – | – | 45 | 0.15 | 0.6 | – | – | – |
| | **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** | **T8330** | 0.8 | 205 | 0.23 | 1.0 | 120 | 0.21 | 1.0 | 190 | 0.23 | 1.0 | – | – | – | 50 | 0.21 | 0.8 | – | – | – |
| | **T8430** | 0.8 | 230 | 0.24 | 1.0 | 125 | 0.22 | 1.0 | 185 | 0.24 | 1.0 | – | – | – | 45 | 0.22 | 0.8 | – | – | – |

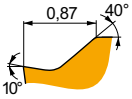
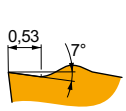
# CCMT

PRAMET

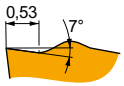
| | IC (mm) | D1 (mm) | L (mm) | S (mm) |
|---|---|---|---|---|
| 0602 | 6.350 | 2.80 | 6.40 | 2.38 |
| 0803 | 7.940 | 3.40 | 8.10 | 3.18 |
| 09T3 | 9.525 | 4.40 | 9.70 | 3.97 |
| 1204 | 12.700 | 5.50 | 12.90 | 4.76 |



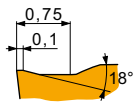

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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-geometri med positivt design for finbearbejdning til færdigbearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | | | | |
| **CCMT 060202E-FF** | **T8315** | 0.2 | ◪ 195 | 0.10 | 1.0 | ◪ 115 | 0.09 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.2 | ■ 185 | 0.10 | 1.0 | ◪ 110 | 0.09 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.2 | ■ 230 | 0.10 | 1.0 | ◪ 125 | 0.09 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.2 | ■ 315 | 0.10 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **CCMT 060204E-FF** | **T8315** | 0.4 | ◪ 195 | 0.12 | 1.0 | ◪ 115 | 0.11 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.4 | ■ 185 | 0.12 | 1.0 | ◪ 110 | 0.11 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.4 | ■ 225 | 0.12 | 1.0 | ◪ 120 | 0.11 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.4 | ■ 310 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **CCMT 09T304E-FF** | **T8315** | 0.4 | ◪ 190 | 0.12 | 1.2 | ◪ 110 | 0.11 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.4 | ■ 185 | 0.12 | 1.2 | ◪ 110 | 0.11 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.4 | ■ 225 | 0.12 | 1.2 | ◪ 120 | 0.11 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.4 | ■ 300 | 0.12 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
|  |   | | | | | | | | | | | | | | | | | | | |
| FF2-geometri med positivt design for finbearbejdning til færdigbearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | | | | |
| **CCMT 060202E-FF2** | **T7325** | 0.2 | ◪ 240 | 0.05 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.2 | ■ 205 | 0.05 | 0.8 | – | – | – | ■ 190 | 0.05 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.2 | ■ 280 | 0.05 | 0.8 | – | – | – | ◪ 230 | 0.05 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.2 | ■ 390 | 0.05 | 0.8 | – | – | – | ◪ 370 | 0.05 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.2 | ■ 350 | 0.05 | 0.8 | – | – | – | ◪ 330 | 0.05 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **TT010** | 0.2 | ■ 345 | 0.05 | 0.5 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **CCMT 060204E-FF2** | **T7325** | 0.4 | ◪ 190 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.4 | ■ 165 | 0.12 | 1.0 | – | – | – | ■ 155 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.4 | ■ 205 | 0.12 | 1.0 | – | – | – | ◪ 170 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.4 | ■ 280 | 0.12 | 1.0 | – | – | – | ◪ 265 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | ■ 255 | 0.12 | 1.0 | – | – | – | ◪ 240 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.4 | ■ 215 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **TT010** | 0.4 | ■ 280 | 0.12 | 0.5 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **CCMT 080302E-FF2** | **T7325** | 0.2 | ◪ 240 | 0.05 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.2 | ■ 205 | 0.05 | 0.8 | – | – | – | ■ 190 | 0.05 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.2 | ■ 280 | 0.05 | 0.8 | – | – | – | ◪ 230 | 0.05 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.2 | ■ 350 | 0.05 | 0.8 | – | – | – | ◪ 330 | 0.05 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **TT010** | 0.2 | ■ 345 | 0.05 | 0.5 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **CCMT 080304E-FF2** | **T7325** | 0.4 | ◪ 190 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.4 | ■ 165 | 0.12 | 1.0 | – | – | – | ■ 155 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.4 | ■ 205 | 0.12 | 1.0 | – | – | – | ◪ 170 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | ■ 255 | 0.12 | 1.0 | – | – | – | ◪ 240 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **TT010** | 0.4 | ■ 350 | 0.06 | 0.5 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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-geometri med positivt design for finbearbejdning til færdigbearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | |
| **CCMT 080308E-FF2** | **T7325** | 0.8 | 205 | 0.17 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.8 | 180 | 0.17 | 1.0 | – | – | – | 170 | 0.17 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.8 | 210 | 0.17 | 1.0 | – | – | – | 175 | 0.17 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 260 | 0.17 | 1.0 | – | – | – | 245 | 0.17 | 1.0 | – | – | – | – | – | – | – | – | – |
| **CCMT 09T304E-FF2** | **T7325** | 0.4 | 190 | 0.12 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.4 | 165 | 0.12 | 1.2 | – | – | – | 155 | 0.12 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.4 | 200 | 0.12 | 1.2 | – | – | – | 165 | 0.12 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.4 | 275 | 0.12 | 1.2 | – | – | – | 260 | 0.12 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 250 | 0.12 | 1.2 | – | – | – | 235 | 0.12 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.4 | 215 | 0.12 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **TT010** | 0.4 | 350 | 0.06 | 0.5 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **CCMT 09T308E-FF2** | **T7325** | 0.8 | 205 | 0.17 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.8 | 175 | 0.17 | 1.2 | – | – | – | 165 | 0.17 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.8 | 205 | 0.17 | 1.2 | – | – | – | 170 | 0.17 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.8 | 285 | 0.17 | 1.2 | – | – | – | 270 | 0.17 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 255 | 0.17 | 1.2 | – | – | – | 240 | 0.17 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **TT010** | 0.8 | 350 | 0.10 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | FM-geometri til fin til halv grov bearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | |
| **CCMT 060202E-FM** | **T7325** | 0.2 | 210 | 0.10 | 1.0 | 160 | 0.09 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 0.2 | 210 | 0.10 | 1.0 | 160 | 0.09 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.2 | 195 | 0.10 | 1.0 | 115 | 0.09 | 1.0 | 185 | 0.10 | 1.0 | 585 | 0.12 | 1.0 | – | – | – | – | – | – |
| | **T8330** | 0.2 | 185 | 0.10 | 1.0 | 110 | 0.09 | 1.0 | 175 | 0.10 | 1.0 | 555 | 0.12 | 1.0 | – | – | – | – | – | – |
| | **T8430** | 0.2 | 230 | 0.10 | 1.0 | 125 | 0.09 | 1.0 | 185 | 0.10 | 1.0 | 630 | 0.12 | 1.0 | – | – | – | – | – | – |
| | **T9315** | 0.2 | 315 | 0.10 | 1.0 | – | – | – | 295 | 0.10 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.2 | 285 | 0.10 | 1.0 | 170 | 0.09 | 1.0 | 270 | 0.10 | 1.0 | – | – | – | – | – | – | – | – | – |
| **CCMT 060204E-FM** | **T7325** | 0.4 | 200 | 0.15 | 1.0 | 155 | 0.15 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 0.4 | 195 | 0.15 | 1.0 | 150 | 0.15 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.4 | 185 | 0.15 | 1.0 | 110 | 0.14 | 1.0 | 175 | 0.15 | 1.0 | 555 | 0.18 | 1.0 | – | – | – | – | – | – |
| | **T8330** | 0.4 | 170 | 0.15 | 1.0 | 100 | 0.14 | 1.0 | 160 | 0.15 | 1.0 | 510 | 0.18 | 1.0 | – | – | – | – | – | – |
| | **T8430** | 0.4 | 205 | 0.15 | 1.0 | 110 | 0.14 | 1.0 | 170 | 0.15 | 1.0 | 570 | 0.18 | 1.0 | – | – | – | – | – | – |
| | **T9315** | 0.4 | 285 | 0.15 | 1.0 | – | – | – | 270 | 0.15 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 250 | 0.15 | 1.0 | 150 | 0.15 | 1.0 | 235 | 0.15 | 1.0 | – | – | – | – | – | – | – | – | – |
| **CCMT 060208E-FM** | **T7325** | 0.8 | 220 | 0.20 | 1.0 | 170 | 0.18 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.8 | 190 | 0.20 | 1.0 | 110 | 0.18 | 1.0 | 180 | 0.20 | 1.0 | 570 | 0.24 | 1.0 | – | – | – | – | – | – |
| | **T8430** | 0.8 | 220 | 0.20 | 1.0 | 120 | 0.18 | 1.0 | 180 | 0.20 | 1.0 | 600 | 0.24 | 1.0 | – | – | – | – | – | – |
| | **T9315** | 0.8 | 300 | 0.20 | 1.0 | – | – | – | 285 | 0.20 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 265 | 0.20 | 1.0 | 155 | 0.18 | 1.0 | 250 | 0.20 | 1.0 | – | – | – | – | – | – | – | – | – |
| **CCMT 09T302E-FM** | **T7325** | 0.2 | 205 | 0.10 | 1.2 | 155 | 0.09 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 0.2 | 205 | 0.10 | 1.2 | 155 | 0.09 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.2 | 190 | 0.10 | 1.2 | 110 | 0.09 | 1.2 | 180 | 0.10 | 1.2 | 570 | 0.12 | 1.2 | – | – | – | – | – | – |
| | **T8330** | 0.2 | 180 | 0.10 | 1.2 | 105 | 0.09 | 1.2 | 170 | 0.10 | 1.2 | 540 | 0.12 | 1.2 | – | – | – | – | – | – |
| | **T8430** | 0.2 | 225 | 0.10 | 1.2 | 120 | 0.09 | 1.2 | 185 | 0.10 | 1.2 | 615 | 0.12 | 1.2 | – | – | – | – | – | – |
| | **T9315** | 0.2 | 310 | 0.10 | 1.2 | – | – | – | 290 | 0.10 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.2 | 275 | 0.10 | 1.2 | 165 | 0.09 | 1.2 | 260 | 0.10 | 1.2 | – | – | – | – | – | – | – | – | – |
| **CCMT 09T304E-FM** | **T7325** | 0.4 | 195 | 0.15 | 1.2 | 150 | 0.15 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 0.4 | 190 | 0.15 | 1.2 | 145 | 0.15 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.4 | 180 | 0.15 | 1.2 | 105 | 0.14 | 1.2 | 170 | 0.15 | 1.2 | 540 | 0.18 | 1.2 | – | – | – | – | – | – |
| | **T8330** | 0.4 | 170 | 0.15 | 1.2 | 100 | 0.14 | 1.2 | 160 | 0.15 | 1.2 | 510 | 0.18 | 1.2 | – | – | – | – | – | – |
| | **T8430** | 0.4 | 200 | 0.15 | 1.2 | 110 | 0.14 | 1.2 | 165 | 0.15 | 1.2 | 555 | 0.18 | 1.2 | – | – | – | – | – | – |
| | **T9315** | 0.4 | 275 | 0.15 | 1.2 | – | – | – | 260 | 0.15 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 245 | 0.15 | 1.2 | 145 | 0.15 | 1.2 | 230 | 0.15 | 1.2 | – | – | – | – | – | – | – | – | – |

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | FM-geometri til fin til halv grov bearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | |
| **CCMT 09T308E-FM** | **T7325** | 0.8 | 215 | 0.20 | 1.2 | 165 | 0.18 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 0.8 | 205 | 0.20 | 1.2 | 155 | 0.18 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.8 | 195 | 0.20 | 1.2 | 115 | 0.18 | 1.2 | 185 | 0.20 | 1.2 | 585 | 0.24 | 1.2 | – | – | – | – | – | – |
| | **T8330** | 0.8 | 185 | 0.20 | 1.2 | 110 | 0.18 | 1.2 | 175 | 0.20 | 1.2 | 555 | 0.24 | 1.2 | – | – | – | – | – | – |
| | **T8430** | 0.8 | 210 | 0.20 | 1.2 | 115 | 0.18 | 1.2 | 175 | 0.20 | 1.2 | 585 | 0.24 | 1.2 | – | – | – | – | – | – |
| | **T9315** | 0.8 | 290 | 0.20 | 1.2 | – | – | – | 275 | 0.20 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 260 | 0.20 | 1.2 | 155 | 0.18 | 1.2 | 245 | 0.20 | 1.2 | – | – | – | – | – | – | – | – | – |
| **CCMT 120404E-FM** | **T7325** | 0.4 | 190 | 0.15 | 1.7 | 145 | 0.15 | 1.7 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 0.4 | 185 | 0.15 | 1.7 | 140 | 0.15 | 1.7 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.4 | 170 | 0.15 | 1.7 | 100 | 0.14 | 1.7 | 160 | 0.15 | 1.7 | 510 | 0.18 | 1.7 | – | – | – | – | – | – |
| | **T8330** | 0.4 | 165 | 0.15 | 1.7 | 95 | 0.14 | 1.7 | 155 | 0.15 | 1.7 | 495 | 0.18 | 1.7 | – | – | – | – | – | – |
| | **T8430** | 0.4 | 195 | 0.15 | 1.7 | 105 | 0.14 | 1.7 | 160 | 0.15 | 1.7 | 540 | 0.18 | 1.7 | – | – | – | – | – | – |
| | **T9315** | 0.4 | 265 | 0.15 | 1.7 | – | – | – | 250 | 0.15 | 1.7 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 240 | 0.15 | 1.7 | 140 | 0.15 | 1.7 | 225 | 0.15 | 1.7 | – | – | – | – | – | – | – | – | – |
| **CCMT 120408E-FM** | **T7325** | 0.8 | 205 | 0.20 | 1.7 | 155 | 0.18 | 1.7 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 0.8 | 200 | 0.20 | 1.7 | 155 | 0.18 | 1.7 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.8 | 190 | 0.20 | 1.7 | 110 | 0.18 | 1.7 | 180 | 0.20 | 1.7 | 570 | 0.24 | 1.7 | – | – | – | – | – | – |
| | **T8330** | 0.8 | 180 | 0.20 | 1.7 | 105 | 0.18 | 1.7 | 170 | 0.20 | 1.7 | 540 | 0.24 | 1.7 | – | – | – | – | – | – |
| | **T8430** | 0.8 | 205 | 0.20 | 1.7 | 110 | 0.18 | 1.7 | 170 | 0.20 | 1.7 | 570 | 0.24 | 1.7 | – | – | – | – | – | – |
| | **T9315** | 0.8 | 280 | 0.20 | 1.7 | – | – | – | 265 | 0.20 | 1.7 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 250 | 0.20 | 1.7 | 150 | 0.18 | 1.7 | 235 | 0.20 | 1.7 | – | – | – | – | – | – | – | – | – |
| **CCMT 120412E-FM** | **T8330** | 1.2 | 175 | 0.27 | 1.7 | 105 | 0.24 | 1.7 | 165 | 0.27 | 1.7 | 525 | 0.32 | 1.7 | – | – | – | – | – | – |
| | **T8430** | 1.2 | 190 | 0.27 | 1.7 | 105 | 0.24 | 1.7 | 155 | 0.27 | 1.7 | 525 | 0.32 | 1.7 | – | – | – | – | – | – |
| | **T9325** | 1.2 | 235 | 0.27 | 1.7 | 140 | 0.24 | 1.7 | 220 | 0.27 | 1.7 | – | – | – | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | FM2 geometri til fin til medium bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **CCMT 080304E-FM2** | **T8330** | 0.4 | 165 | 0.12 | 1.0 | 95 | 0.11 | 1.0 | 155 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.4 | 205 | 0.12 | 1.0 | 110 | 0.11 | 1.0 | 170 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.4 | 280 | 0.12 | 1.0 | – | – | – | 265 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 255 | 0.12 | 1.0 | 150 | 0.11 | 1.0 | 240 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.4 | 215 | 0.12 | 1.0 | 125 | 0.11 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| **CCMT 080308E-FM2** | **T8330** | 0.8 | 180 | 0.17 | 1.0 | 105 | 0.15 | 1.0 | 170 | 0.17 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.8 | 210 | 0.17 | 1.0 | 115 | 0.15 | 1.0 | 175 | 0.17 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 260 | 0.17 | 1.0 | 155 | 0.15 | 1.0 | 245 | 0.17 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **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 | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.4 | 165 | 0.12 | 1.0 | 95 | 0.11 | 1.0 | 155 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.4 | 205 | 0.12 | 1.0 | 110 | 0.11 | 1.0 | 170 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.4 | 280 | 0.12 | 1.0 | – | – | – | 265 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 255 | 0.12 | 1.0 | 150 | 0.11 | 1.0 | 240 | 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 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 0.8 | 205 | 0.17 | 1.0 | 155 | 0.15 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.8 | 180 | 0.17 | 1.0 | 105 | 0.15 | 1.0 | 170 | 0.17 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.8 | 210 | 0.17 | 1.0 | 115 | 0.15 | 1.0 | 175 | 0.17 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.8 | 290 | 0.17 | 1.0 | – | – | – | 275 | 0.17 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 260 | 0.17 | 1.0 | 155 | 0.15 | 1.0 | 245 | 0.17 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.8 | 225 | 0.17 | 1.0 | 135 | 0.15 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| **CCMT 120408E-FM2** | **T7325** | 0.8 | 190 | 0.20 | 1.5 | 145 | 0.18 | 1.5 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.8 | 165 | 0.20 | 1.5 | 95 | 0.18 | 1.5 | 155 | 0.20 | 1.5 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.8 | 190 | 0.20 | 1.5 | 105 | 0.18 | 1.5 | 155 | 0.20 | 1.5 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 235 | 0.20 | 1.5 | 140 | 0.18 | 1.5 | 220 | 0.20 | 1.5 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.8 | 200 | 0.20 | 1.5 | 120 | 0.18 | 1.5 | – | – | – | – | – | – | – | – | – | – | – | – |

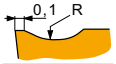
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) | | | | | | | | | | | | | | | | | | |
|  |  | | | | | | | | | | | | | | | | | | | |

NF2-geometri med positivt design til finbearbejdning til halv grov bearbejdning og kontinuerlige snit.

| | | | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **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 | – | – | – |
| | **T7325** | 0.2 | ◪ | 195 | 0.10 | 0.8 | ■ | 150 | 0.09 | 0.8 | | – | – | – | | – | – | – | ■ | 60 | 0.08 | 0.6 | – | – | – |
| | **T8330** | 0.2 | ◪ | 170 | 0.10 | 0.8 | ■ | 100 | 0.09 | 0.8 | ◪ | 160 | 0.10 | 0.8 | ◪ | 510 | 0.12 | 0.8 | ◪ | 40 | 0.08 | 0.6 | – | – | – |
| | **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 | – | – | – |
| | **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** | **H07** | 0.4 | | – | – | – | ◪ | 85 | 0.11 | 0.8 | ◪ | 140 | 0.12 | 0.8 | ◪ | 445 | 0.14 | 0.8 | ■ | 45 | 0.11 | 0.6 | – | – | – |
| | **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 | – | – | – |
| | **T7325** | 0.4 | ◪ | 200 | 0.12 | 0.8 | ■ | 155 | 0.11 | 0.8 | | – | – | – | | – | – | – | ■ | 65 | 0.11 | 0.6 | – | – | – |
| | **T8330** | 0.4 | ◪ | 170 | 0.12 | 0.8 | ■ | 100 | 0.11 | 0.8 | ◪ | 160 | 0.12 | 0.8 | ◪ | 510 | 0.14 | 0.8 | ◪ | 40 | 0.11 | 0.6 | – | – | – |
| | **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 | – | – | – |
| | **T9315** | 0.4 | ◪ | 290 | 0.12 | 0.8 | | – | – | – | ◪ | 275 | 0.12 | 0.8 | | – | – | – | | – | – | – | – | – | – |
| | **T9325** | 0.4 | ◪ | 255 | 0.12 | 0.8 | ■ | 150 | 0.11 | 0.8 | ◪ | 240 | 0.12 | 0.8 | | – | – | – | ◪ | 55 | 0.11 | 0.6 | – | – | – |
| | **T9335** | 0.4 | ◪ | 220 | 0.12 | 0.8 | ■ | 130 | 0.11 | 0.8 | | – | – | – | | – | – | – | ◪ | 45 | 0.11 | 0.6 | – | – | – |
| **CCMT 080304E-NF2** | **T5315** | 0.4 | ◪ | 280 | 0.12 | 1.0 | | – | – | – | ◪ | 265 | 0.12 | 1.0 | | – | – | – | | – | – | – | – | – | – |
| | **T7325** | 0.4 | ◪ | 190 | 0.12 | 1.0 | ■ | 145 | 0.11 | 1.0 | | – | – | – | | – | – | – | ■ | 60 | 0.11 | 0.8 | – | – | – |
| | **T7335** | 0.4 | ◪ | 190 | 0.12 | 1.0 | ■ | 145 | 0.11 | 1.0 | | – | – | – | | – | – | – | ■ | 60 | 0.11 | 0.8 | – | – | – |
| | **T9315** | 0.4 | ◪ | 280 | 0.12 | 1.0 | | – | – | – | ◪ | 265 | 0.12 | 1.0 | | – | – | – | | – | – | – | – | – | – |
| | **T9325** | 0.4 | ◪ | 255 | 0.12 | 1.0 | ■ | 150 | 0.11 | 1.0 | ◪ | 240 | 0.12 | 1.0 | | – | – | – | ◪ | 55 | 0.11 | 0.8 | – | – | – |
| | **T9335** | 0.4 | ◪ | 215 | 0.12 | 1.2 | ■ | 125 | 0.11 | 1.2 | | – | – | – | | – | – | – | ◪ | 45 | 0.11 | 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 | – | – | – |
| | **T5315** | 0.8 | ◪ | 295 | 0.17 | 1.0 | | – | – | – | ◪ | 280 | 0.17 | 1.0 | | – | – | – | | – | – | – | – | – | – |
| | **T7325** | 0.8 | ◪ | 205 | 0.17 | 1.0 | ■ | 155 | 0.15 | 1.0 | | – | – | – | | – | – | – | ■ | 65 | 0.14 | 0.8 | – | – | – |
| | **T7335** | 0.8 | ◪ | 205 | 0.17 | 1.0 | ■ | 155 | 0.15 | 1.0 | | – | – | – | | – | – | – | ■ | 65 | 0.14 | 0.8 | – | – | – |
| | **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 | – | – | – |
| | **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 | – | – | – |
| | **T7325** | 0.4 | ◪ | 190 | 0.12 | 1.2 | ■ | 145 | 0.11 | 1.2 | | – | – | – | | – | – | – | ■ | 60 | 0.11 | 1.0 | – | – | – |
| | **T8330** | 0.4 | ◪ | 165 | 0.12 | 1.2 | ■ | 95 | 0.11 | 1.2 | ◪ | 155 | 0.12 | 1.2 | ◪ | 495 | 0.14 | 1.2 | ◪ | 40 | 0.11 | 1.0 | – | – | – |
| | **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 | – | – | – |
| | **T9315** | 0.4 | ◪ | 275 | 0.12 | 1.2 | | – | – | – | ◪ | 260 | 0.12 | 1.2 | | – | – | – | | – | – | – | – | – | – |
| | **T9325** | 0.4 | ◪ | 250 | 0.12 | 1.2 | ■ | 150 | 0.11 | 1.2 | ◪ | 235 | 0.12 | 1.2 | | – | – | – | ◪ | 55 | 0.11 | 1.0 | – | – | – |
| | **T9335** | 0.4 | ◪ | 215 | 0.12 | 1.2 | ■ | 125 | 0.11 | 1.2 | | – | – | – | | – | – | – | ◪ | 45 | 0.11 | 1.0 | – | – | – |
| **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 | – | – | – |
| | **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 | – | – | – |
| | **T7325** | 0.8 | ◪ | 215 | 0.14 | 1.2 | ■ | 165 | 0.13 | 1.2 | | – | – | – | | – | – | – | ■ | 65 | 0.13 | 1.0 | – | – | – |
| | **T8330** | 0.8 | ◪ | 190 | 0.14 | 1.2 | ■ | 110 | 0.13 | 1.2 | ◪ | 180 | 0.14 | 1.2 | ◪ | 570 | 0.17 | 1.2 | ◪ | 45 | 0.13 | 1.0 | – | – | – |
| | **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 | – | – | – |
| | **T9315** | 0.8 | ◪ | 310 | 0.14 | 1.2 | | – | – | – | ◪ | 290 | 0.14 | 1.2 | | – | – | – | | – | – | – | – | – | – |
| | **T9325** | 0.8 | ◪ | 275 | 0.14 | 1.2 | ■ | 165 | 0.13 | 1.2 | ◪ | 260 | 0.14 | 1.2 | | – | – | – | ◪ | 60 | 0.13 | 1.0 | – | – | – |
| | **T9335** | 0.8 | ◪ | 235 | 0.14 | 1.2 | ■ | 140 | 0.13 | 1.2 | | – | – | – | | – | – | – | ◪ | 50 | 0.13 | 1.0 | – | – | – |



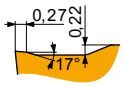
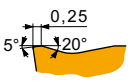
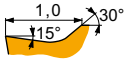



| I.C. | R |
|---|---|
| 6,35 | 1,0 |
| 9,525 | 1,5 |
| 12,7 | 2,5 |

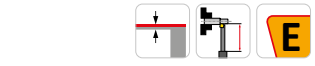
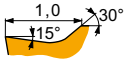
RF-geometri til semi-grov til grov bearbejdning og kontinuerlig til afbrudt snit.

| | | | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **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 | 0.15 | 1.0 |
| | **T7335** | 0.4 | ◪ | 160 | 0.15 | 1.0 | ◪ | 120 | 0.15 | 1.0 | | – | – | – | | – | – | – | | – | – | – | – | – | – |
| | **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 | | – | – | – | | – | – | – | | – | – | – | – | – | – |
| | **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 | 0.15 | 1.0 |
| | **T7335** | 0.8 | ◪ | 165 | 0.20 | 1.5 | ◪ | 125 | 0.18 | 1.5 | | – | – | – | | – | – | – | | – | – | – | – | – | – |
| | **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 | 0.15 | 1.0 |
| | **T7335** | 0.8 | ◪ | 150 | 0.22 | 2.2 | ◪ | 115 | 0.22 | 2.2 | | – | – | – | | – | – | – | | – | – | – | – | – | – |
| | **T9325** | 0.8 | ■ | 195 | 0.22 | 2.2 | ◪ | 115 | 0.22 | 2.2 | ◪ | 185 | 0.22 | 2.2 | | – | – | – | | – | – | – | – | – | – |

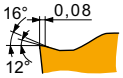
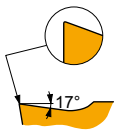
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |  | |  | | | | | | | | | | | | | | | | | |
| RM-geometri til semi-grov til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **CCMT 09T304E-RM** | **T5305** | 0.4 | 260 | 0.27 | 2.2 | – | – | – | 245 | 0.27 | 2.2 | – | – | – | – | – | – | 50 | 0.15 | 1.0 |
| | **T5315** | 0.4 | 230 | 0.27 | 2.2 | – | – | – | 215 | 0.27 | 2.2 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |
| | **T7335** | 0.4 | 155 | 0.27 | 2.2 | 120 | 0.24 | 2.2 | – | – | – | – | – | – | 50 | 0.19 | 1.8 | – | – | – |
| | **T8330** | 0.4 | 140 | 0.27 | 2.2 | 80 | 0.24 | 2.2 | 130 | 0.27 | 2.2 | – | – | – | 35 | 0.19 | 1.8 | 25 | 0.15 | 1.0 |
| | **T8430** | 0.4 | 150 | 0.27 | 2.2 | 80 | 0.24 | 2.2 | 125 | 0.27 | 2.2 | – | – | – | 30 | 0.19 | 1.8 | 25 | 0.15 | 1.0 |
| | **T9315** | 0.4 | 215 | 0.27 | 2.2 | – | – | – | 200 | 0.27 | 2.2 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| | **T9325** | 0.4 | 190 | 0.27 | 2.2 | 110 | 0.24 | 2.2 | 180 | 0.27 | 2.2 | – | – | – | 40 | 0.19 | 1.8 | – | – | – |
| **CCMT 09T308E-RM** | **T5305** | 0.8 | 290 | 0.30 | 2.2 | – | – | – | 275 | 0.30 | 2.2 | – | – | – | – | – | – | 55 | 0.15 | 1.0 |
| | **T5315** | 0.8 | 265 | 0.30 | 2.2 | – | – | – | 250 | 0.30 | 2.2 | – | – | – | – | – | – | 50 | 0.15 | 1.0 |
| | **T7335** | 0.8 | 175 | 0.30 | 2.2 | 135 | 0.27 | 2.2 | – | – | – | – | – | – | 55 | 0.24 | 1.8 | – | – | – |
| | **T8330** | 0.8 | 165 | 0.30 | 2.2 | 95 | 0.27 | 2.2 | 155 | 0.30 | 2.2 | – | – | – | 40 | 0.24 | 1.8 | 30 | 0.15 | 1.0 |
| | **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 | 1.0 |
| | **T9315** | 0.8 | 240 | 0.30 | 2.2 | – | – | – | 225 | 0.30 | 2.2 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |
| | **T9325** | 0.8 | 215 | 0.30 | 2.2 | 125 | 0.27 | 2.2 | 200 | 0.30 | 2.2 | – | – | – | 45 | 0.24 | 1.8 | – | – | – |
| **CCMT 120408E-RM** | **T5305** | 0.8 | 290 | 0.30 | 2.7 | – | – | – | 275 | 0.30 | 2.7 | – | – | – | – | – | – | 55 | 0.15 | 1.0 |
| | **T5315** | 0.8 | 260 | 0.30 | 2.7 | – | – | – | 245 | 0.30 | 2.7 | – | – | – | – | – | – | 50 | 0.15 | 1.0 |
| | **T7335** | 0.8 | 175 | 0.30 | 2.7 | 135 | 0.27 | 2.7 | – | – | – | – | – | – | 55 | 0.24 | 2.2 | – | – | – |
| | **T8330** | 0.8 | 160 | 0.30 | 2.7 | 95 | 0.27 | 2.7 | 150 | 0.30 | 2.7 | – | – | – | 40 | 0.24 | 2.2 | 30 | 0.15 | 1.0 |
| | **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 | 1.0 |
| | **T9315** | 0.8 | 235 | 0.30 | 2.7 | – | – | – | 220 | 0.30 | 2.7 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |
| | **T9325** | 0.8 | 210 | 0.30 | 2.7 | 125 | 0.27 | 2.7 | 195 | 0.30 | 2.7 | – | – | – | 45 | 0.24 | 2.2 | – | – | – |
| **CCMT 120412E-RM** | **T8330** | 1.2 | 165 | 0.33 | 2.7 | 95 | 0.30 | 2.7 | 155 | 0.33 | 2.7 | – | – | – | 40 | 0.23 | 2.2 | 30 | 0.15 | 1.0 |
| | **T8430** | 1.2 | 180 | 0.33 | 2.7 | 95 | 0.30 | 2.7 | 145 | 0.33 | 2.7 | – | – | – | 35 | 0.23 | 2.2 | 30 | 0.15 | 1.0 |
| | **T9315** | 1.2 | 235 | 0.33 | 2.7 | – | – | – | 220 | 0.33 | 2.7 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |
| | **T9325** | 1.2 | 215 | 0.33 | 2.7 | 125 | 0.30 | 2.7 | 200 | 0.33 | 2.7 | – | – | – | 45 | 0.23 | 2.2 | – | – | – |
|  |  | |  | | | | | | | | | | | | | | | | | |
| RM3-geometri til halv grov til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **CCMT 120404E-RM3** | **T7325** | 0.4 | 140 | 0.25 | 2.5 | 105 | 0.25 | 2.5 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.4 | 190 | 0.25 | 2.5 | – | – | – | 180 | 0.25 | 2.5 | – | – | – | – | – | – | 35 | 0.15 | 1.0 |
| | **T9325** | 0.4 | 165 | 0.25 | 2.5 | 95 | 0.25 | 2.5 | 155 | 0.25 | 2.5 | – | – | – | – | – | – | – | – | – |
| **CCMT 120408E-RM3** | **T6310** | 0.8 | 145 | 0.27 | 2.5 | 100 | 0.27 | 2.5 | 115 | 0.27 | 2.5 | – | – | – | – | – | – | 25 | 0.15 | 1.0 |
| | **T7325** | 0.8 | 165 | 0.27 | 2.5 | 125 | 0.27 | 2.5 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.8 | 215 | 0.27 | 2.5 | – | – | – | 200 | 0.27 | 2.5 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| | **T9325** | 0.8 | 195 | 0.27 | 2.5 | 115 | 0.27 | 2.5 | 185 | 0.27 | 2.5 | – | – | – | – | – | – | – | – | – |
| **CCMT 120412E-RM3** | **T7325** | 1.2 | 170 | 0.30 | 2.5 | 130 | 0.27 | 2.5 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9315** | 1.2 | 220 | 0.30 | 2.5 | – | – | – | 205 | 0.30 | 2.5 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
|  |  | |  | | | | | | | | | | | | | | | | | |
| UR-geometri til finbearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | | | | |
| **CCMT 060202E-UR** | **T7325** | 0.2 | 185 | 0.10 | 0.8 | 140 | 0.09 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 0.2 | 185 | 0.10 | 0.8 | 140 | 0.09 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.2 | 170 | 0.10 | 0.8 | 100 | 0.09 | 0.8 | 160 | 0.10 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.2 | 160 | 0.10 | 0.8 | 95 | 0.09 | 0.8 | 150 | 0.10 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.2 | 200 | 0.10 | 0.8 | 110 | 0.09 | 0.8 | 165 | 0.10 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.2 | 275 | 0.10 | 0.8 | – | – | – | 260 | 0.10 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.2 | 250 | 0.10 | 0.8 | 150 | 0.09 | 0.8 | 235 | 0.10 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **TT310** | 0.2 | 275 | 0.10 | 0.5 | 165 | 0.09 | 0.5 | – | – | – | – | – | – | – | – | – | – | – | – |

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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-geometri til finbearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | |
| **CCMT 060204E-UR** | **T5315** | 0.4 | ◪ 245 | 0.15 | 1.0 | – | – | – | ■ 230 | 0.15 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 0.4 | ◪ 170 | 0.15 | 1.0 | ◪ 130 | 0.15 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 0.4 | ◪ 170 | 0.15 | 1.0 | ◪ 130 | 0.15 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.4 | ◪ 160 | 0.15 | 1.0 | ◪ 95 | 0.14 | 1.0 | ■ 150 | 0.15 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.4 | ■ 150 | 0.15 | 1.0 | ◪ 90 | 0.14 | 1.0 | ■ 140 | 0.15 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.4 | ■ 175 | 0.15 | 1.0 | ◪ 95 | 0.14 | 1.0 | ◪ 140 | 0.15 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.4 | ■ 245 | 0.15 | 1.0 | – | – | – | ◪ 230 | 0.15 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | ■ 215 | 0.15 | 1.0 | ◪ 125 | 0.15 | 1.0 | ◪ 200 | 0.15 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **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 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 0.8 | ◪ 190 | 0.20 | 1.0 | ◪ 145 | 0.18 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.8 | ■ 165 | 0.20 | 1.0 | ◪ 95 | 0.18 | 1.0 | ■ 155 | 0.20 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.8 | ■ 185 | 0.20 | 1.0 | ◪ 100 | 0.18 | 1.0 | ◪ 150 | 0.20 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.8 | ■ 255 | 0.20 | 1.0 | – | – | – | ◪ 240 | 0.20 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | ■ 230 | 0.20 | 1.0 | ◪ 135 | 0.18 | 1.0 | ◪ 215 | 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 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.2 | ■ 195 | 0.10 | 1.0 | ◪ 105 | 0.09 | 1.0 | ◪ 160 | 0.10 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **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 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 0.4 | ◪ 170 | 0.15 | 1.2 | ◪ 130 | 0.15 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 0.4 | ◪ 165 | 0.15 | 1.2 | ◪ 125 | 0.15 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.4 | ◪ 155 | 0.15 | 1.2 | ◪ 90 | 0.14 | 1.2 | ■ 145 | 0.15 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.4 | ■ 150 | 0.15 | 1.2 | ◪ 90 | 0.14 | 1.2 | ■ 140 | 0.15 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.4 | ■ 175 | 0.15 | 1.2 | ◪ 95 | 0.14 | 1.2 | ◪ 140 | 0.15 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9310** | 0.4 | ■ 265 | 0.15 | 1.2 | – | – | – | ◪ 250 | 0.15 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.4 | ■ 235 | 0.15 | 1.2 | – | – | – | ◪ 220 | 0.15 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | ■ 215 | 0.15 | 1.2 | ◪ 125 | 0.15 | 1.2 | ◪ 200 | 0.15 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **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 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 0.8 | ◪ 185 | 0.20 | 1.2 | ◪ 140 | 0.18 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 0.8 | ◪ 175 | 0.20 | 1.2 | ◪ 135 | 0.18 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.8 | ◪ 170 | 0.20 | 1.2 | ◪ 100 | 0.18 | 1.2 | ■ 160 | 0.20 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.8 | ■ 160 | 0.20 | 1.2 | ◪ 95 | 0.18 | 1.2 | ■ 150 | 0.20 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.8 | ■ 185 | 0.20 | 1.2 | ◪ 100 | 0.18 | 1.2 | ◪ 150 | 0.20 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9310** | 0.8 | ■ 280 | 0.20 | 1.2 | – | – | – | ◪ 265 | 0.20 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.8 | ■ 250 | 0.20 | 1.2 | – | – | – | ◪ 235 | 0.20 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | ■ 225 | 0.20 | 1.2 | ◪ 135 | 0.18 | 1.2 | ◪ 210 | 0.20 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **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 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 0.4 | ◪ 160 | 0.15 | 1.7 | ◪ 120 | 0.15 | 1.7 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.4 | ■ 140 | 0.15 | 1.7 | ◪ 80 | 0.14 | 1.7 | ■ 130 | 0.15 | 1.7 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.4 | ■ 170 | 0.15 | 1.7 | ◪ 90 | 0.14 | 1.7 | ◪ 135 | 0.15 | 1.7 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.4 | ■ 230 | 0.15 | 1.7 | – | – | – | ◪ 215 | 0.15 | 1.7 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | ■ 205 | 0.15 | 1.7 | ◪ 120 | 0.15 | 1.7 | ◪ 190 | 0.15 | 1.7 | – | – | – | – | – | – | – | – | – |
| **CCMT 120408E-UR** | **T5315** | 0.8 | ◪ 255 | 0.20 | 1.7 | – | – | – | ■ 240 | 0.20 | 1.7 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 0.8 | ◪ 175 | 0.20 | 1.7 | ◪ 135 | 0.18 | 1.7 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 0.8 | ◪ 170 | 0.20 | 1.7 | ◪ 130 | 0.18 | 1.7 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.8 | ■ 155 | 0.20 | 1.7 | ◪ 90 | 0.18 | 1.7 | ■ 145 | 0.20 | 1.7 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.8 | ■ 180 | 0.20 | 1.7 | ◪ 95 | 0.18 | 1.7 | ◪ 145 | 0.20 | 1.7 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.8 | ■ 240 | 0.20 | 1.7 | – | – | – | ◪ 225 | 0.20 | 1.7 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | ■ 215 | 0.20 | 1.7 | ◪ 125 | 0.18 | 1.7 | ◪ 200 | 0.20 | 1.7 | – | – | – | – | – | – | – | – | – |
| **CCMT 120412E-UR** | **T5315** | 1.2 | ◪ 240 | 0.27 | 1.7 | – | – | – | ■ 225 | 0.27 | 1.7 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 1.2 | ◪ 170 | 0.27 | 1.7 | ◪ 130 | 0.24 | 1.7 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8430** | 1.2 | ■ 165 | 0.27 | 1.7 | ◪ 90 | 0.24 | 1.7 | ◪ 135 | 0.27 | 1.7 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 1.2 | ■ 225 | 0.27 | 1.7 | – | – | – | ◪ 210 | 0.27 | 1.7 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | ■ 205 | 0.27 | 1.7 | ◪ 120 | 0.24 | 1.7 | ◪ 190 | 0.27 | 1.7 | – | – | – | – | – | – | – | – | – |

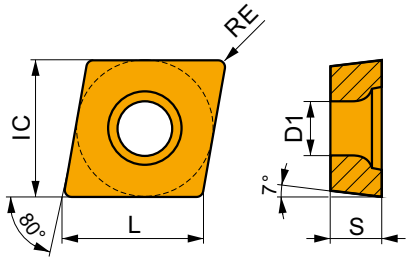
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | W-FM wiper geometri til finbearbejdning med øget tilspænding og forbedret overfladefinish. | | | | | | | | | | | | | | | | | |
| **CCMT 060204W-FM** | **T7325** | 0.4 | 165 | 0.30 | 0.8 | 125 | 0.27 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.4 | 165 | 0.30 | 0.8 | 90 | 0.27 | 0.8 | 135 | 0.30 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.4 | 215 | 0.30 | 0.8 | – | – | – | 200 | 0.30 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 190 | 0.30 | 0.8 | 110 | 0.27 | 0.8 | 180 | 0.30 | 0.8 | – | – | – | – | – | – | – | – | – |
| **CCMT 09T304W-FM** | **T7325** | 0.4 | 165 | 0.30 | 0.8 | 125 | 0.27 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.4 | 145 | 0.30 | 0.8 | 85 | 0.27 | 0.8 | 135 | 0.30 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.4 | 165 | 0.30 | 0.8 | 90 | 0.27 | 0.8 | 135 | 0.30 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.4 | 215 | 0.30 | 0.8 | – | – | – | 200 | 0.30 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 190 | 0.30 | 0.8 | 110 | 0.27 | 0.8 | 180 | 0.30 | 0.8 | – | – | – | – | – | – | – | – | – |
| **CCMT 09T308W-FM** | **T8330** | 0.8 | 155 | 0.40 | 1.0 | 90 | 0.36 | 1.0 | 145 | 0.40 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.8 | 170 | 0.40 | 1.0 | 90 | 0.36 | 1.0 | 135 | 0.40 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.8 | 220 | 0.40 | 1.0 | – | – | – | 205 | 0.40 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 200 | 0.40 | 1.0 | 120 | 0.36 | 1.0 | 190 | 0.40 | 1.0 | – | – | – | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | W-UR wiper geometri til finbearbejdning med øget tilspænding og forbedret overfladefinish. | | | | | | | | | | | | | | | | | |
| **CCMT 060204W-UR** | **TT310** | 0.4 | 255 | 0.15 | 0.5 | 150 | 0.14 | 0.5 | – | – | – | – | – | – | – | – | – | – | – | – |
| **CCMT 09T308W-UR** | **TT310** | 0.8 | 255 | 0.20 | 1.2 | 150 | 0.18 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |

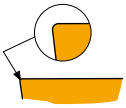
# CCMW

PRAMET

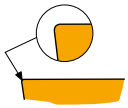
| | IC (mm) | D1 (mm) | L (mm) | S (mm) |
|---|---|---|---|---|
| 0602 | 6.350 | 2.80 | 6.40 | 2.38 |
| 09T3 | 9.525 | 4.40 | 9.70 | 3.97 |
| 1204 | 12.700 | 5.50 | 12.90 | 4.76 |




Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | Til fin til halv grov bearbejdning og kontinuerlig til let afbrudt snit. | | | | | | | | | | | | | | | | | |
| **CCMW 060202** | **T5305** | 0.2 | – | – | – | – | – | – | 230 | 0.08 | 2.0 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |
| | **T6310** | 0.2 | – | – | – | – | – | – | 100 | 0.08 | 2.0 | – | – | – | – | – | – | 25 | 0.15 | 1.0 |
| **CCMW 060204** | **T5305** | 0.4 | – | – | – | – | – | – | 230 | 0.10 | 2.0 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |
| | **T5315** | 0.4 | – | – | – | – | – | – | 195 | 0.10 | 2.0 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| | **T6310** | 0.4 | – | – | – | – | – | – | 95 | 0.10 | 2.0 | – | – | – | – | – | – | 20 | 0.15 | 1.0 |
| **CCMW 09T304** | **T5305** | 0.4 | – | – | – | – | – | – | 215 | 0.10 | 3.0 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |
| | **T5315** | 0.4 | – | – | – | – | – | – | 190 | 0.10 | 3.0 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| | **T6310** | 0.4 | – | – | – | – | – | – | 95 | 0.10 | 3.0 | – | – | – | – | – | – | 20 | 0.15 | 1.0 |
| **CCMW 09T308** | **T5305** | 0.8 | – | – | – | – | – | – | 200 | 0.20 | 3.0 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| | **T5315** | 0.8 | – | – | – | – | – | – | 180 | 0.20 | 3.0 | – | – | – | – | – | – | 35 | 0.15 | 1.0 |
| | **T6310** | 0.8 | – | – | – | – | – | – | 90 | 0.20 | 3.0 | – | – | – | – | – | – | 20 | 0.15 | 1.0 |

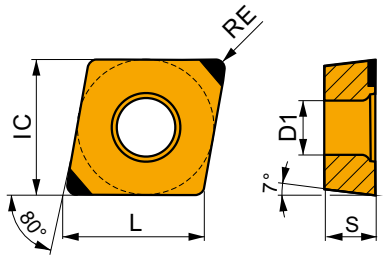
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |  | | E | | | | | | | | | | | | | | | | | |
| | | | Til fin til halv grov bearbejdning og kontinuerlig til let afbrudt snit. | | | | | | | | | | | | | | | | | |
| **CCMW 120404** | **T5305** | 0.4 | – | – | – | – | – | – | 210 | 0.10 | 4.0 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |
| | **T5315** | 0.4 | – | – | – | – | – | – | 185 | 0.10 | 4.0 | – | – | – | – | – | – | 35 | 0.15 | 1.0 |
| | **T6310** | 0.4 | – | – | – | – | – | – | 90 | 0.10 | 4.0 | – | – | – | – | – | – | 20 | 0.15 | 1.0 |
| **CCMW 120408** | **T5305** | 0.8 | – | – | – | – | – | – | 195 | 0.20 | 4.0 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| | **T5315** | 0.8 | – | – | – | – | – | – | 175 | 0.20 | 4.0 | – | – | – | – | – | – | 35 | 0.15 | 1.0 |
| | **T6310** | 0.8 | – | – | – | – | – | – | 90 | 0.20 | 4.0 | – | – | – | – | – | – | 20 | 0.15 | 1.0 |

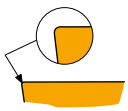
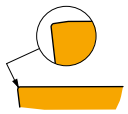
## CCGW CBN

PRAMET

| | IC (mm) | D1 (mm) | L (mm) | S (mm) |
|---|---|---|---|---|
| 0602 | 6.350 | 2.80 | 6.50 | 2.38 |
| 09T3 | 9.525 | 4.50 | 9.70 | 3.97 |




Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |  | | HSC E | | | | | | | | | | | | | | | | | |
| | | | Til færdigbearbejdning. | | | | | | | | | | | | | | | | | |
| **CCGW 060204E-B** | **TB310** | 0.4 | – | – | – | – | – | – | 460 | 0.10 | 0.4 | – | – | – | 120 | 0.07 | 0.3 | 95 | 0.15 | 1.0 |
| **CCGW 09T304E-B** | **TB310** | 0.4 | – | – | – | – | – | – | 460 | 0.10 | 0.4 | – | – | – | 120 | 0.07 | 0.3 | 95 | 0.15 | 1.0 |
|  |  | | HSC S | | | | | | | | | | | | | | | | | |
| | | | Til færdigbearbejdning. | | | | | | | | | | | | | | | | | |
| **CCGW 060204S01020B** | **TB310** | 0.4 | – | – | – | – | – | – | 460 | 0.10 | 0.4 | – | – | – | 120 | 0.07 | 0.3 | 95 | 0.15 | 1.0 |
| **CCGW 09T304S01020B** | **TB310** | 0.4 | – | – | – | – | – | – | 460 | 0.10 | 0.4 | – | – | – | 120 | 0.07 | 0.3 | 95 | 0.15 | 1.0 |

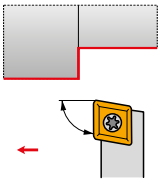
# SCAC(RL) EXT

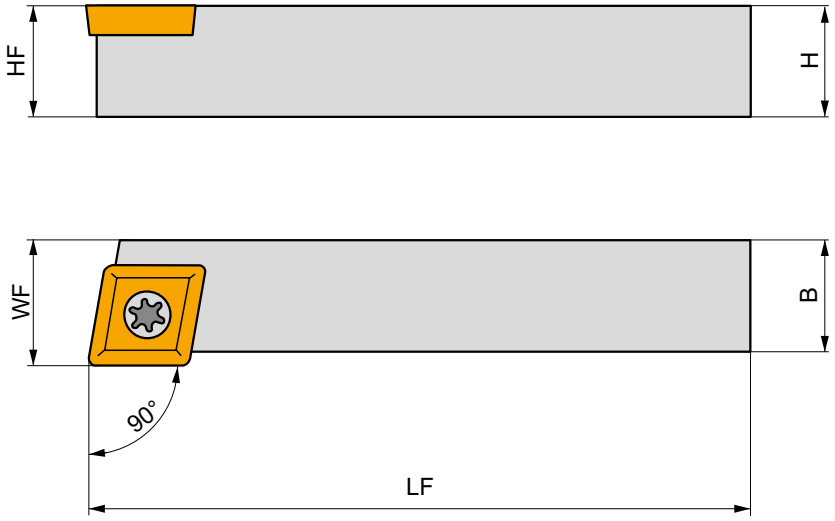
P M K N S H

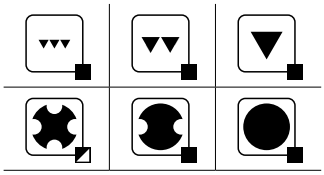
PRAMET

S









| | | H (mm) | B (mm) | HF (mm) | WF (mm) | LF (mm) | LAMS (°) | GAMO (°) | kg | | |
|---|---|---|---|---|---|---|---|---|---|---|---|
| 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 | 0.09 | GI045 | S07 |
| | **SCACR 1212 F 09** | 12 | 12 | 12 | 12.5 | 80 | 0 | 0 | 0.12 | GI041 | S04 |
| | **SCACR 1616 H 09** | 16 | 16 | 16 | 16.5 | 100 | 0 | 0 | 0.22 | GI041 | S04 |
| L | **SCACL 0808 D 06** | 8 | 8 | 8 | 8.5 | 60 | 0 | 0 | 0.07 | 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 1616 H 09** | 16 | 16 | 16 | 16.5 | 100 | 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 |

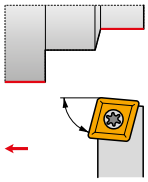
# SCBC(RL) EXT

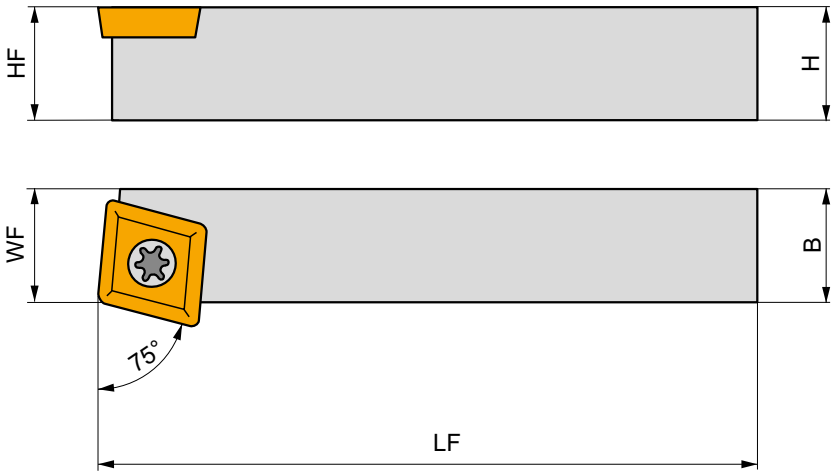
P M K N S H

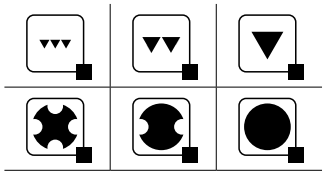
PRAMET

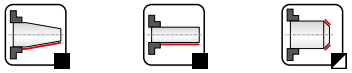
S









| | | H (mm) | B (mm) | HF (mm) | WF (mm) | LF (mm) | LAMS (°) | GAMO (°) | kg | | |
|---|---|---|---|---|---|---|---|---|---|---|---|
| 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 | – |

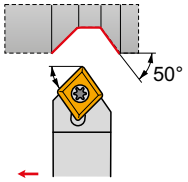
# SCDCR EXT

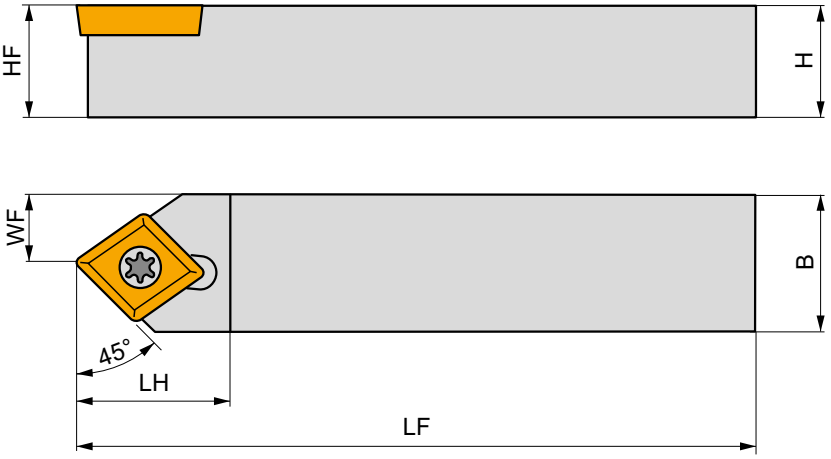
P M K N S H

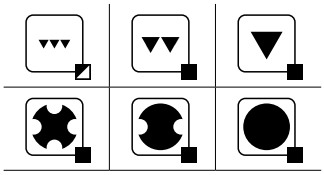
PRAMET

S







| | | 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 | 0.06 | GI045 | SC21 |

| | |
|---|---|
| GI045 | CC.. 0602.. |

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

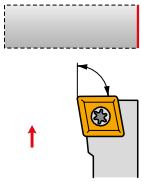
# SCFC(RL) EXT

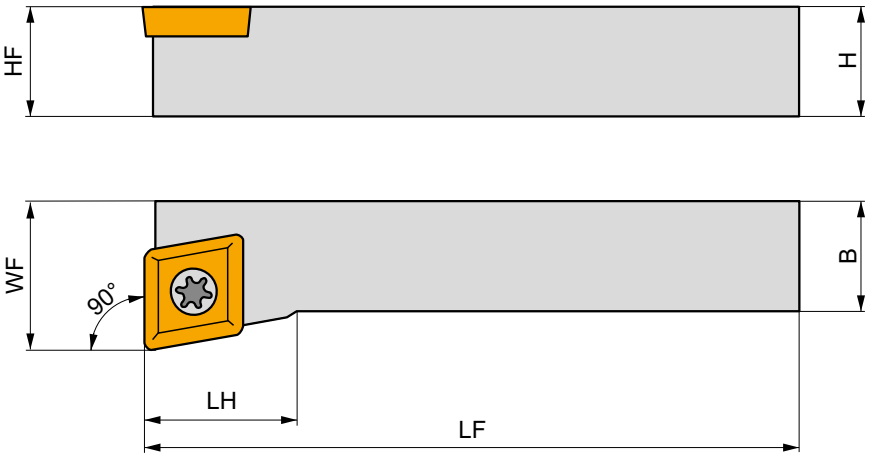
P M K N S H

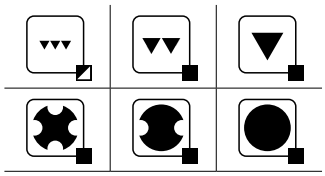
PRAMET

S









| | | 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 | 0.04 | GI045 | S07 |
| | **SCFCR 1010 E 06** | 10 | 10 | 10 | 12 | 70 | 8 | 0 | 0 | 0.07 | GI045 | S07 |
| | **SCFCR 1212 F 09** | 12 | 12 | 12 | 16 | 80 | 16 | 0 | 0 | 0.12 | GI041 | S04 |
| | **SCFCR 1616 H 09** | 16 | 16 | 16 | 20 | 100 | 16 | 0 | 0 | 0.22 | GI041 | S04 |
| L | **SCFCL 0808 D 06** | 8 | 8 | 8 | 10 | 60 | 8 | 0 | 0 | 0.04 | GI045 | S07 |
| | **SCFCL 1010 E 06** | 10 | 10 | 10 | 12 | 70 | 8 | 0 | 0 | 0.06 | GI045 | S07 |
| | **SCFCL 1212 F 09** | 12 | 12 | 12 | 16 | 80 | 16 | 0 | 0 | 0.10 | GI041 | S04 |
| | **SCFCL 1616 H 09** | 16 | 16 | 16 | 20 | 100 | 16 | 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 |

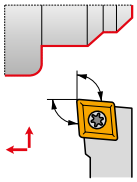
# SCLC(RL) EXT

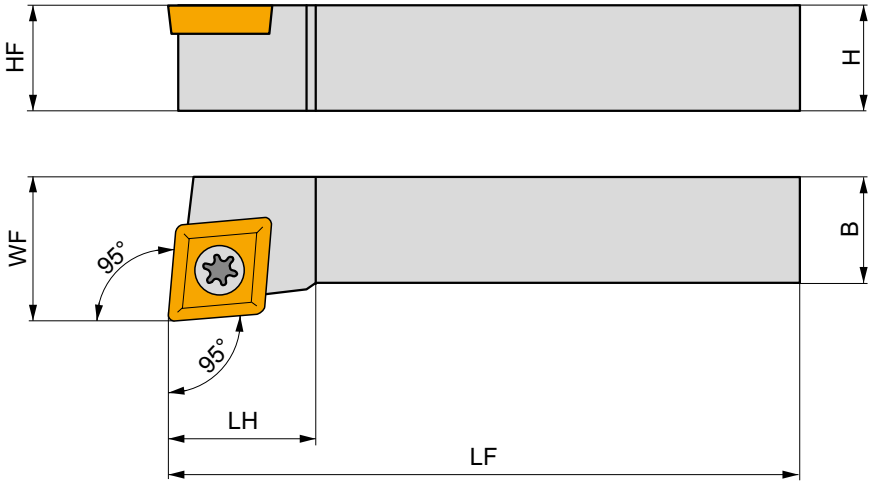
P M K N S H

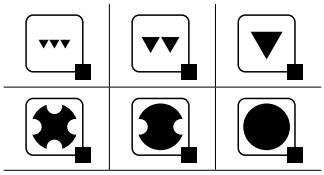
PRAMET

S









| | | H (mm) | B (mm) | HF (mm) | WF (mm) | LF (mm) | LH (mm) | LAMS (°) | GAMO (°) | kg | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| R | SCLCR 0808 D 06 | 8 | 8 | 8 | 10 | 60 | 8 | 0 | 0 | 0.06 | GI045 | S01 |
| | SCLCR 1010 E 06 | 10 | 10 | 10 | 12 | 70 | 8 | 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 | 0.02 | GI232 | SC22 |
| | SCLCR 1616 H 08 | 16 | 16 | 16 | 20 | 100 | 15.2 | 0 | 0 | 0.22 | GI232 | SC22 |
| | SCLCR 1212 F 09 | 12 | 12 | 12 | 16 | 80 | 16 | 0 | 0 | 0.12 | GI041 | S08 |
| | SCLCR 1616 H 09 | 16 | 16 | 16 | 20 | 100 | 16 | 0 | 0 | 0.22 | GI041 | S08 |
| | SCLCR 2020 K 12-M-A | 20 | 20 | 20 | 25 | 125 | 20 | 0 | 0 | 0.44 | GI011 | SC20 |
| | SCLCR 2525 M 12-M-A | 20 | 25 | 20 | 32 | 150 | 20 | 0 | 0 | 0.68 | GI011 | SC20 |
| L | SCLCL 0808 D 06 | 8 | 8 | 8 | 10 | 60 | 8 | 0 | 0 | 0.06 | GI045 | S01 |
| | SCLCL 1010 E 06 | 10 | 10 | 10 | 12 | 70 | 8 | 0 | 0 | 0.06 | GI045 | S01 |
| | SCLCL 1212 F 08 | 12 | 12 | 12 | 16 | 80 | 13.4 | 0 | 0 | 0.03 | GI232 | SC22 |
| | SCLCL 1616 H 08 | 16 | 16 | 16 | 20 | 100 | 15.2 | 0 | 0 | 0.23 | GI232 | SC22 |
| | SCLCL 1212 F 09 | 12 | 12 | 12 | 16 | 80 | 16 | 0 | 0 | 0.10 | GI041 | S08 |
| | SCLCL 1616 H 09 | 16 | 16 | 16 | 20 | 100 | 16 | 0 | 0 | 0.22 | GI041 | S08 |
| | SCLCL 2020 K 12-M-A | 20 | 20 | 20 | 25 | 125 | 20 | 0 | 0 | 0.40 | GI011 | SC20 |
| | SCLCL 2525 M 12-M-A | 25 | 25 | 25 | 32 | 150 | 20 | 0 | 0 | 0.78 | 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 | – |

NEW

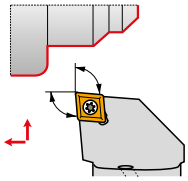
# C.-SCLC(RL) EXT

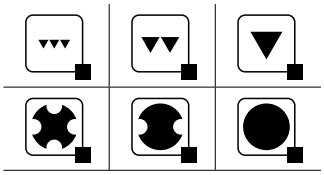
P M K N S H

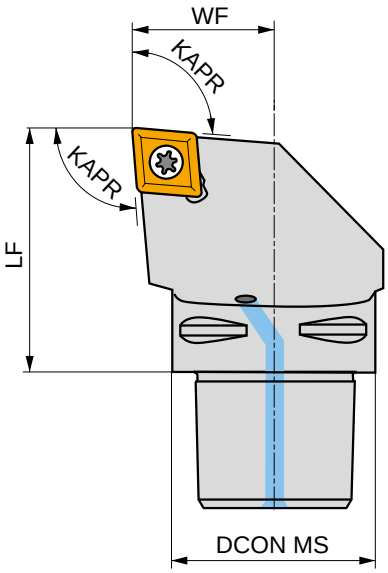
PRAMET

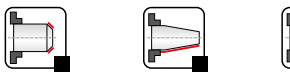
S









| | | 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 |

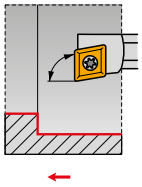
# SCFC(RL) INT

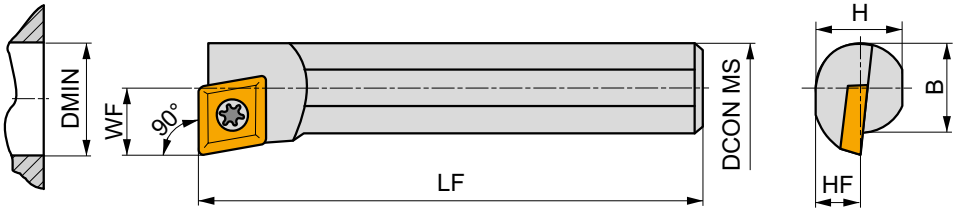
P M K N S H

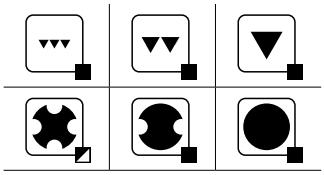
PRAMET

S









| | | 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 | 0.10 | GI045 | S06 |
| | S12K-SCFCL 06 | 12 | 16 | 9 | 11 | 11.5 | 125 | -7 | 0 | 0.14 | GI045 | S06 |

| | |
|---|---|
| GI045 | CC.. 0602.. |

| | | | | | |
|---|---|---|---|---|---|
| S06 | US 2505-T07P | 0.9 | M 2.5 | 5.2 | FLAG T07P |

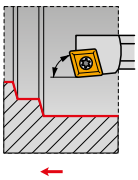
# SCKC(RL) INT

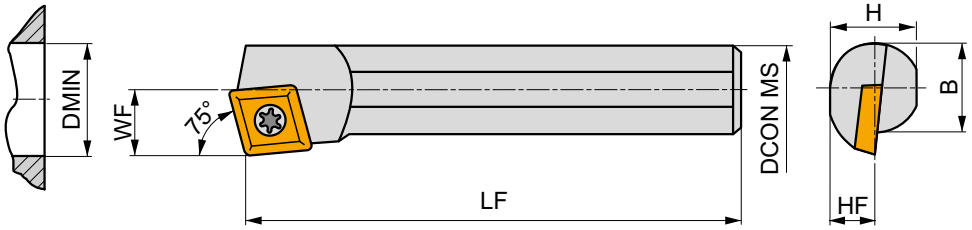
P M K N S H

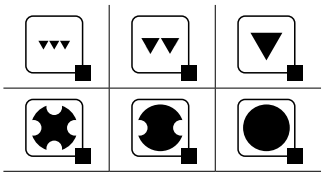
PRAMET

S









| | | 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 | **S08F-SCKCL 06** | 8 | 11 | 6 | 7.2 | 7.6 | 80 | -12 | 0 | 0.03 | GI045 | S02 |
| | **S12K-SCKCL 06** | 12 | 16 | 9 | 11 | 11.5 | 125 | -8 | 0 | 0.11 | GI045 | S02 |
| | **S16M-SCKCL 09-A** | 16 | 20 | 11 | 14.5 | 15 | 150 | -8 | 0 | 0.24 | GI041 | S05 |
| | **S20S-SCKCL 09** | 20 | 25 | 13 | 18.5 | 18.5 | 250 | -5 | 0 | 0.60 | GI041 | S08 |
| | **S25T-SCKCL 09** | 25 | 32 | 17 | 23 | 23 | 300 | -3 | 0 | 1.15 | GI041 | S08 |
| | **S32U-SCKCL 12-A** | 32 | 40 | 22 | 30 | 30 | 350 | -10 | 0 | 2.10 | GI011 | SC20 |

| | |
|---|---|
| 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 | – |

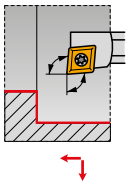
# SCLC(RL) INT

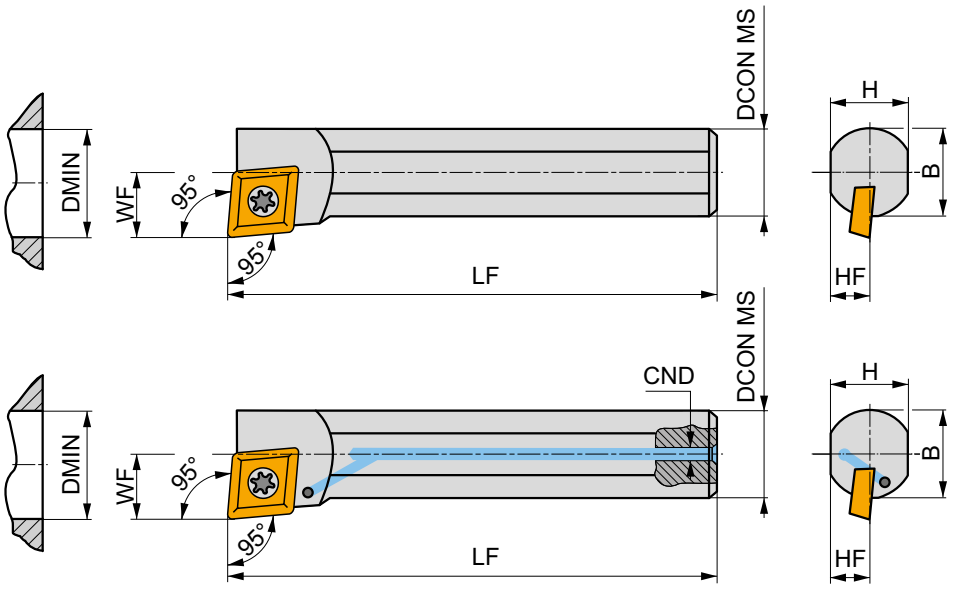
P M K N S H

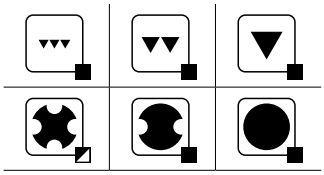
PRAMET

S









| | | 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 | ✓ | 0.06 | GI045 | S02 |
| | S08F-SCLCR 06 | 8 | 11 | 6 | 7.2 | 7.6 | 80 | – | -13 | 0 | – | 0.06 | 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 | – | 0.08 | GI045 | S02 |
| | A12K-SCLCR 06 | 12 | 16 | 9 | 11 | – | 125 | 5 | -8 | 0 | ✓ | 0.11 | GI045 | S01 |
| | S12K-SCLCR 06 | 12 | 16 | 9 | 11 | 11.5 | 125 | – | -8 | 0 | – | 0.13 | 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 | ✓ | 0.38 | GI041 | S08 |
| | S20S-SCLCR 09 | 20 | 25 | 13 | 18 | 18.5 | 250 | – | -5 | 0 | – | 0.62 | 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 | – | 1.10 | 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 | ✓ | 0.06 | 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 | – | 0.26 | GI045 | S01 |
| | A10K-SCLCL 08 | 10 | 12 | 6 | 9 | 9.5 | 125 | 4 | -14 | 0 | ✓ | 0.02 | GI232 | SC22 |
| | A12M-SCLCL 08 | 12 | 16 | 9 | 11 | 11.5 | 150 | 5 | -5 | 0 | ✓ | 0.14 | GI232 | SC22 |

| | | 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 | ✓ | 0.40 | 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 | – | 1.15 | 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 | – | 2.10 | 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 | – |

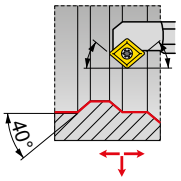
# SCXC(RL) INT

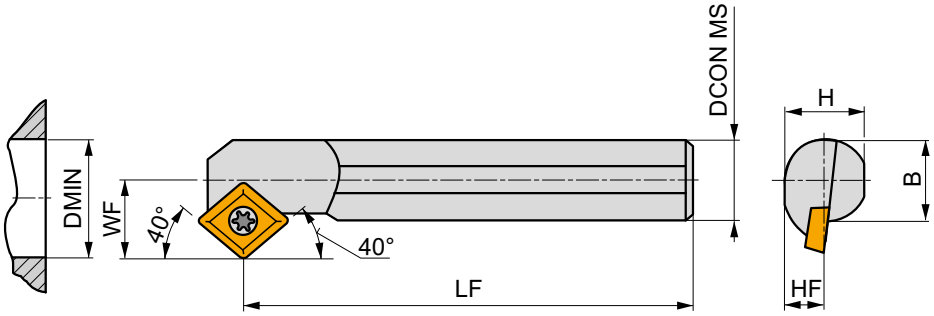
P M K N S H

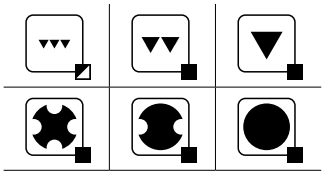
PRAMET

S







| | | 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 | 0.31 | 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 |

NEW

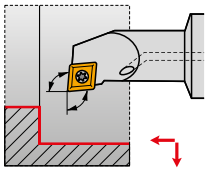
# C.-SCLC(RL) INT

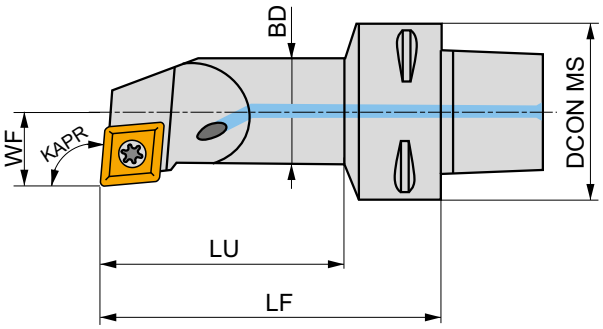
P M K N S H

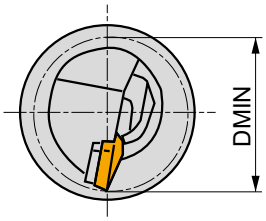
PRAMET

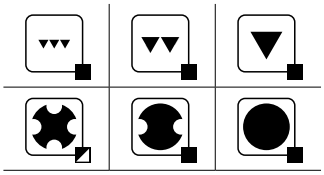
S









| | | 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 | ✓ | 0.62 | 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 |

# CP 05

## CARBIDE INSERTS

**CPGX**

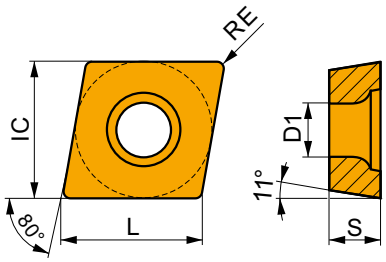


83

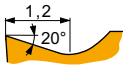
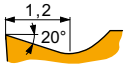
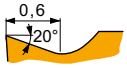
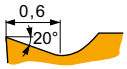
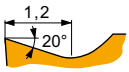
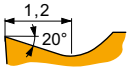
# CPGX

PRAMET

| | 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 |




Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | |  | | | | | | | | | | | | | | | | | |
| FR-JQ positiv geometri med højrehåndet design til finbearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **CPGX 080304FR-JQ** | **TT010** | 0.4 | ■ 350 | 0.06 | 0.5 | ◪ 210 | 0.05 | 0.5 | – | – | – | – | – | – | – | – | – | – | – | – |
|  |  | |  | | | | | | | | | | | | | | | | | |
| FL-JR geometri med positivt venstrehåndet design til finbearbejdning, kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **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 | – | – | – | – | – | – | – | – | – | – | – | – |
|  |  | |  | | | | | | | | | | | | | | | | | |
| FR-JR positiv geometri med højrehåndet design til finbearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **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 | – | – | – | – | – | – | – | – | – | – | – | – |
|  |  | |  | | | | | | | | | | | | | | | | | |
| FL-JR geometri med positivt venstrehåndet design til finbearbejdning, kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **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 | – | – | – | – | – | – | – | – | – | – | – | – |
|  |  | |  | | | | | | | | | | | | | | | | | |
| FR-JZ positiv geometri med højrehåndet design til finbearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **CPGX 060202FR-JZ** | **TT010** | 0.2 | ■ 330 | 0.06 | 0.5 | ◪ 195 | 0.05 | 0.5 | – | – | – | – | – | – | – | – | – | – | – | – |
|  |  | |  | | | | | | | | | | | | | | | | | |
| FL-JZ geometri med positivt venstrehåndet design til finbearbejdning, kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **CPGX 060202FL-JZ** | **TT010** | 0.2 | ■ 330 | 0.06 | 0.5 | ◪ 195 | 0.05 | 0.5 | – | – | – | – | – | – | – | – | – | – | – | – |

# DC

07 / 11 / 15

## CARBIDE INSERTS

**DCGT**



86

**DCMT**



87

**DCMW**



92

## CBN & PCD INSERTS

**DCGW CBN**



92

**DCMW PCD**



93

| MATCH THE RIGHT SIZE (example) | |
|---|---|
| **Insert** | **Tool Holder** |
| DCMT 070204E-UR | SDJCR 0808 D 07 |

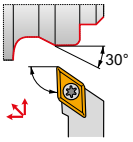
## ISO-DREJNING – UDVENDIGT

### SDJC(RL) EXT

93°

DC..

07
11
15




08×08
25×25

94

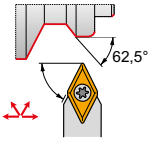
86 – 93

### SDNCN EXT

62°30´

DC..

7
11




08×08
25×25

95

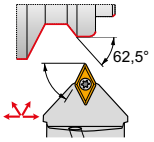
86 – 93

### C.-SDNCN EXT NEW

62°30´

DC..

11




C4
C5

97

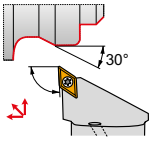
86 – 93

### C.-SDJC(RL) EXT NEW

93°

DC..

11




C3
C5

96

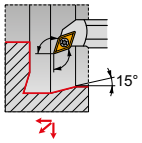
86 – 93

# DC

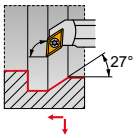
07 / 11 / 15

## ISO-DREJNING – INDVENDIG

### SDQC(RL) INT

| 107°30´ | DC.. |
|---|---|
|  | 07<br>11 |
| ØDmin 13 / 40 | |
| 98 | 86 – 93 |

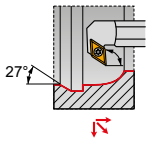
### SDUC(RL) INT

| 93° | DC.. |
|---|---|
|  | 07<br>11 |
| ØDmin 13 / 40 | |
| 99 | 86 – 93 |

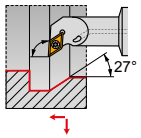
### SDUC(RL)-E INT

| 93° | DC.. |
|---|---|
|  | 07<br>11 |
| ØDmin 13 / 40 | |
| 100 | 86 – 93 |

### SDZC(RL) INT

| 93° | DC.. |
|---|---|
|  | 07<br>11 |
| ØDmin 27 / 65 | |
| 101 | 86 – 93 |

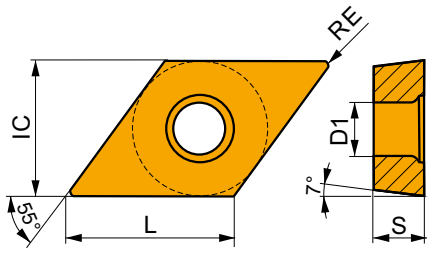
### C.-SDUC(RL) INT NEW

| 93° | DC.. |
|---|---|
|  | 07<br>11 |
| ØDmin 20 / 32 | |
| 102 | 86 – 93 |

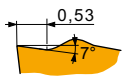
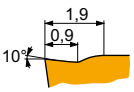
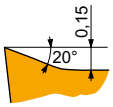
# DCGT

PRAMET

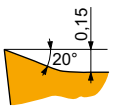
| | IC (mm) | D1 (mm) | L (mm) | S (mm) |
|---|---|---|---|---|
| 0702 | 6.350 | 2.80 | 7.80 | 2.38 |
| 0702-SF3 | 6.350 | 2.80 | 7.80 | 2.58 |
| 11T3 | 9.525 | 4.40 | 11.60 | 3.97 |
| 11T3-SF3 | 9.525 | 4.40 | 11.60 | 4.22 |




Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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 | | | | | | | | | | | | | | | | | |
| AL-geometri med meget positivt design til fin-finish til grov bearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | | | | |
| **DCGT 070202F-AL** | **HF7** | 0.2 | – | – | – | – | – | – | – | – | – | 360 | 0.12 | 1.0 | – | – | – | – | – | – |
| | **T0315** | 0.2 | – | – | – | – | – | – | – | – | – | 510 | 0.12 | 1.0 | – | – | – | – | – | – |
| **DCGT 070204F-AL** | **HF7** | 0.4 | – | – | – | – | – | – | – | – | – | 285 | 0.24 | 1.0 | – | – | – | – | – | – |
| | **T0315** | 0.4 | – | – | – | – | – | – | – | – | – | 420 | 0.24 | 1.0 | – | – | – | – | – | – |
| **DCGT 11T302F-AL** | **HF7** | 0.2 | – | – | – | – | – | – | – | – | – | 345 | 0.12 | 1.5 | – | – | – | – | – | – |
| | **T0315** | 0.2 | – | – | – | – | – | – | – | – | – | 495 | 0.12 | 1.5 | – | – | – | – | – | – |
| **DCGT 11T304F-AL** | **HF7** | 0.4 | – | – | – | – | – | – | – | – | – | 270 | 0.24 | 1.5 | – | – | – | – | – | – |
| | **T0315** | 0.4 | – | – | – | – | – | – | – | – | – | 390 | 0.24 | 1.5 | – | – | – | – | – | – |
| **DCGT 11T308F-AL** | **HF7** | 0.8 | – | – | – | – | – | – | – | – | – | 255 | 0.48 | 1.5 | – | – | – | – | – | – |
| | **T0315** | 0.8 | – | – | – | – | – | – | – | – | – | 360 | 0.48 | 1.5 | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | E | | | | | | | | | | | | | | | | | |
| FF2-geometri med positivt design for finbearbejdning til færdigbearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | | | | |
| **DCGT 11T302E-FF2** | **T7325** | 0.2 | 190 | 0.05 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.2 | 165 | 0.05 | 0.8 | – | – | – | 155 | 0.05 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.2 | 225 | 0.05 | 0.8 | – | – | – | 185 | 0.05 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.2 | 280 | 0.05 | 0.8 | – | – | – | 265 | 0.05 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **TT010** | 0.2 | 275 | 0.05 | 0.5 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | E | | | | | | | | | | | | | | | | | |
| NF1-geometri med positivt design til finbearbejdning til medium bearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **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 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| | **T7325** | 0.8 | 180 | 0.14 | 0.8 | 140 | 0.13 | 0.8 | – | – | – | – | – | – | 55 | 0.13 | 0.6 | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | E | | | | | | | | | | | | | | | | | |
| SF3-geometri med meget positivt design til finbearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **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 | 0.15 | 1.0 |
| **DCGT 070202E-SF3** | **H07** | 0.2 | – | – | – | 95 | 0.05 | 0.8 | 150 | 0.05 | 0.8 | 485 | 0.06 | 0.8 | 45 | 0.04 | 0.6 | – | – | – |
| | **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 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| **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 | – | – | – |
| | **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 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| **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 | 0.15 | 1.0 |

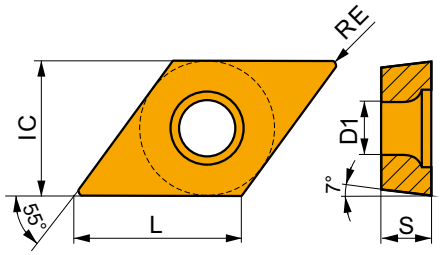
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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-geometri med meget positivt design til finbearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **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 | – | – | – |
| | **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 | 0.15 | 1.0 |
| **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 | – | – | – |
| | **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 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| **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 | – | – | – |
| | **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 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
|  |  | |  | | | | | | | | | | | | | | | | | |
| ER-SI geometri med positivt højrehåndet design til finbearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **DCGT 11T304ER-SI** | **T8330** | 0.4 | 170 | 0.12 | 0.8 | 100 | 0.11 | 0.8 | 160 | 0.12 | 0.8 | – | – | – | 40 | 0.10 | 0.6 | – | – | – |
| | **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** | **T8330** | 0.8 | 170 | 0.22 | 1.0 | 100 | 0.20 | 1.0 | 160 | 0.22 | 1.0 | – | – | – | 40 | 0.18 | 0.8 | – | – | – |
| | **T8430** | 0.8 | 190 | 0.22 | 1.0 | 105 | 0.20 | 1.0 | 155 | 0.22 | 1.0 | – | – | – | 40 | 0.18 | 0.8 | – | – | – |
|  |  | |  | | | | | | | | | | | | | | | | | |
| EL-SI geometri med positivt venstrehåndet design til finbearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **DCGT 11T304EL-SI** | **T8330** | 0.4 | 170 | 0.12 | 0.8 | 100 | 0.11 | 0.8 | 160 | 0.12 | 0.8 | – | – | – | 40 | 0.10 | 0.6 | – | – | – |
| | **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 | – | – | – |

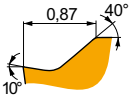
## DCMT

PRAMET

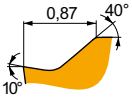
| | IC (mm) | D1 (mm) | L (mm) | S (mm) |
|---|---|---|---|---|
| 0702 | 6.350 | 2.80 | 7.80 | 2.38 |
| 11T3 | 9.525 | 4.40 | 11.60 | 3.97 |
| 1504 | 12.700 | 5.50 | 15.50 | 4.76 |




Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

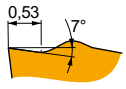
| Product | | RE (mm) | P vc (m/min) | P f (mm/rev) | P ap (mm) | M vc (m/min) | M f (mm/rev) | M ap (mm) | K vc (m/min) | K f (mm/rev) | K ap (mm) | N vc (m/min) | N f (mm/rev) | N ap (mm) | S vc (m/min) | S f (mm/rev) | S ap (mm) | H vc (m/min) | H f (mm/rev) | H ap (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | |  | | | | | | | | | | | | | | | | | |
| FF-geometri med positivt design for finbearbejdning til færdigbearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | | | | |
| **DCMT 11T302E-FF** | **T8315** | 0.2 | 160 | 0.10 | 0.8 | 95 | 0.09 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.2 | 150 | 0.10 | 0.8 | 90 | 0.09 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.2 | 185 | 0.10 | 0.8 | 100 | 0.09 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.2 | 255 | 0.10 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |  | | | | | | | | | | | | | | | | | | | |

FF-geometri med positivt design for finbearbejdning til færdigbearbejdning og kontinuerlige til let afbrudte snit.

| | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **DCMT 11T304E-FF** | **T8315** | 0.4 | 160 | 0.12 | 0.8 | 95 | 0.11 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.4 | 150 | 0.12 | 0.8 | 90 | 0.11 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.4 | 185 | 0.12 | 0.8 | 100 | 0.11 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.4 | 255 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **DCMT 11T308E-FF** | **T8315** | 0.8 | 180 | 0.15 | 0.8 | 105 | 0.14 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.8 | 170 | 0.15 | 0.8 | 100 | 0.14 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.8 | 200 | 0.15 | 0.8 | 110 | 0.14 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.8 | 270 | 0.15 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |

FF2-geometri med positivt design for finbearbejdning til færdigbearbejdning og kontinuerlige til let afbrudte snit.

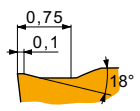
| | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **DCMT 070202E-FF2** | **T7325** | 0.2 | 190 | 0.05 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.2 | 165 | 0.05 | 0.8 | – | – | – | 155 | 0.05 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.2 | 225 | 0.05 | 0.8 | – | – | – | 185 | 0.05 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.2 | 280 | 0.05 | 0.8 | – | – | – | 265 | 0.05 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **TT010** | 0.2 | 275 | 0.05 | 0.5 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **DCMT 070204E-FF2** | **T7325** | 0.4 | 160 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.4 | 135 | 0.12 | 0.8 | – | – | – | 125 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.4 | 170 | 0.12 | 0.8 | – | – | – | 135 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.4 | 230 | 0.12 | 0.8 | – | – | – | 215 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 205 | 0.12 | 0.8 | – | – | – | 190 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| **DCMT 070208E-FF2** | **T7325** | 0.8 | 170 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.8 | 150 | 0.17 | 0.8 | – | – | – | 140 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.8 | 175 | 0.17 | 0.8 | – | – | – | 140 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.8 | 235 | 0.17 | 0.8 | – | – | – | 220 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 215 | 0.17 | 0.8 | – | – | – | 200 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – |
| **DCMT 11T304E-FF2** | **T7325** | 0.4 | 160 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.4 | 135 | 0.12 | 0.8 | – | – | – | 125 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.4 | 170 | 0.12 | 0.8 | – | – | – | 135 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.4 | 230 | 0.12 | 0.8 | – | – | – | 215 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 205 | 0.12 | 0.8 | – | – | – | 190 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.4 | 175 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **TT010** | 0.4 | 280 | 0.06 | 0.5 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **DCMT 11T308E-FF2** | **T7325** | 0.8 | 170 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.8 | 150 | 0.17 | 0.8 | – | – | – | 140 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.8 | 175 | 0.17 | 0.8 | – | – | – | 140 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.8 | 235 | 0.17 | 0.8 | – | – | – | 220 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 215 | 0.17 | 0.8 | – | – | – | 200 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **TT010** | 0.8 | 280 | 0.10 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |



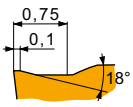
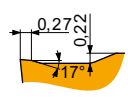

FM-geometri til fin til halv grov bearbejdning og kontinuerlige til let afbrudte snit.

| | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **DCMT 070202E-FM** | **T7325** | 0.2 | 175 | 0.10 | 0.8 | 135 | 0.09 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.2 | 160 | 0.10 | 0.8 | 95 | 0.09 | 0.8 | 150 | 0.10 | 0.8 | 480 | 0.12 | 0.8 | – | – | – | – | – | – |
| | **T8330** | 0.2 | 150 | 0.10 | 0.8 | 90 | 0.09 | 0.8 | 140 | 0.10 | 0.8 | 450 | 0.12 | 0.8 | – | – | – | – | – | – |
| | **T8430** | 0.2 | 185 | 0.10 | 0.8 | 100 | 0.09 | 0.8 | 150 | 0.10 | 0.8 | 510 | 0.12 | 0.8 | – | – | – | – | – | – |
| | **T9315** | 0.2 | 255 | 0.10 | 0.8 | – | – | – | 240 | 0.10 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.2 | 230 | 0.10 | 0.8 | 135 | 0.09 | 0.8 | 215 | 0.10 | 0.8 | – | – | – | – | – | – | – | – | – |

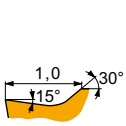
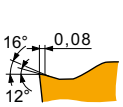
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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-geometri til fin til halv grov bearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | |
| **DCMT 070204E-FM** | **T7325** | 0.4 | 155 | 0.17 | 0.8 | 120 | 0.15 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 0.4 | 155 | 0.17 | 0.8 | 120 | 0.15 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.4 | 160 | 0.12 | 0.8 | 95 | 0.11 | 0.8 | 150 | 0.12 | 0.8 | 480 | 0.14 | 0.8 | – | – | – | – | – | – |
| | **T8330** | 0.4 | 150 | 0.12 | 0.8 | 90 | 0.11 | 0.8 | 140 | 0.12 | 0.8 | 450 | 0.14 | 0.8 | – | – | – | – | – | – |
| | **T8430** | 0.4 | 185 | 0.12 | 0.8 | 100 | 0.11 | 0.8 | 150 | 0.12 | 0.8 | 510 | 0.14 | 0.8 | – | – | – | – | – | – |
| | **T9315** | 0.4 | 255 | 0.12 | 0.8 | – | – | – | 240 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 190 | 0.18 | 0.8 | 110 | 0.16 | 0.8 | 180 | 0.18 | 0.8 | – | – | – | – | – | – | – | – | – |
| **DCMT 11T302E-FM** | **T7325** | 0.2 | 175 | 0.10 | 0.8 | 135 | 0.09 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.2 | 160 | 0.10 | 0.8 | 95 | 0.09 | 0.8 | 150 | 0.10 | 0.8 | 480 | 0.12 | 0.8 | – | – | – | – | – | – |
| | **T8330** | 0.2 | 150 | 0.10 | 0.8 | 90 | 0.09 | 0.8 | 140 | 0.10 | 0.8 | 450 | 0.12 | 0.8 | – | – | – | – | – | – |
| | **T8430** | 0.2 | 185 | 0.10 | 0.8 | 100 | 0.09 | 0.8 | 150 | 0.10 | 0.8 | 510 | 0.12 | 0.8 | – | – | – | – | – | – |
| | **T9315** | 0.2 | 255 | 0.10 | 0.8 | – | – | – | 240 | 0.10 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.2 | 230 | 0.10 | 0.8 | 135 | 0.09 | 0.8 | 215 | 0.10 | 0.8 | – | – | – | – | – | – | – | – | – |
| **DCMT 11T304E-FM** | **T7325** | 0.4 | 155 | 0.17 | 0.8 | 120 | 0.15 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 0.4 | 155 | 0.17 | 0.8 | 120 | 0.15 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.4 | 160 | 0.12 | 0.8 | 95 | 0.11 | 0.8 | 150 | 0.12 | 0.8 | 480 | 0.14 | 0.8 | – | – | – | – | – | – |
| | **T8330** | 0.4 | 135 | 0.17 | 0.8 | 80 | 0.15 | 0.8 | 125 | 0.17 | 0.8 | 405 | 0.20 | 0.8 | – | – | – | – | – | – |
| | **T8430** | 0.4 | 155 | 0.17 | 0.8 | 85 | 0.15 | 0.8 | 130 | 0.17 | 0.8 | 435 | 0.20 | 0.8 | – | – | – | – | – | – |
| | **T9310** | 0.4 | 285 | 0.12 | 0.8 | – | – | – | 270 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.4 | 255 | 0.12 | 0.8 | – | – | – | 240 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 190 | 0.18 | 0.8 | 110 | 0.16 | 0.8 | 180 | 0.18 | 0.8 | – | – | – | – | – | – | – | – | – |
| **DCMT 11T308E-FM** | **T7325** | 0.8 | 185 | 0.17 | 0.8 | 140 | 0.15 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 0.8 | 180 | 0.17 | 0.8 | 140 | 0.15 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.8 | 170 | 0.17 | 0.8 | 100 | 0.15 | 0.8 | 160 | 0.17 | 0.8 | 510 | 0.20 | 0.8 | – | – | – | – | – | – |
| | **T8330** | 0.8 | 165 | 0.17 | 0.8 | 95 | 0.15 | 0.8 | 155 | 0.17 | 0.8 | 495 | 0.20 | 0.8 | – | – | – | – | – | – |
| | **T8430** | 0.8 | 190 | 0.17 | 0.8 | 105 | 0.15 | 0.8 | 155 | 0.17 | 0.8 | 525 | 0.20 | 0.8 | – | – | – | – | – | – |
| | **T9310** | 0.8 | 285 | 0.17 | 0.8 | – | – | – | 270 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.8 | 260 | 0.17 | 0.8 | – | – | – | 245 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 235 | 0.17 | 0.8 | 140 | 0.15 | 0.8 | 220 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – |
| **DCMT 11T312E-FM** | **T8330** | 1.2 | 150 | 0.22 | 1.2 | 90 | 0.22 | 1.2 | 140 | 0.22 | 1.2 | 450 | 0.26 | 1.2 | – | – | – | – | – | – |
| | **T8430** | 1.2 | 175 | 0.22 | 1.2 | 95 | 0.22 | 1.2 | 140 | 0.22 | 1.2 | 480 | 0.26 | 1.2 | – | – | – | – | – | – |
| | **T9315** | 1.2 | 235 | 0.22 | 1.2 | – | – | – | 220 | 0.22 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | 210 | 0.22 | 1.2 | 125 | 0.22 | 1.2 | 195 | 0.22 | 1.2 | – | – | – | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | FM2 geometri til fin til medium bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **DCMT 070204E-FM2** | **T6310** | 0.4 | 135 | 0.12 | 0.8 | 95 | 0.11 | 0.8 | 105 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 0.4 | 160 | 0.12 | 0.8 | 120 | 0.11 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.4 | 135 | 0.12 | 0.8 | 80 | 0.11 | 0.8 | 125 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.4 | 170 | 0.12 | 0.8 | 90 | 0.11 | 0.8 | 135 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.4 | 230 | 0.12 | 0.8 | – | – | – | 215 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 205 | 0.12 | 0.8 | 120 | 0.11 | 0.8 | 190 | 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 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 0.4 | 160 | 0.12 | 0.8 | 120 | 0.11 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.4 | 135 | 0.12 | 0.8 | 80 | 0.11 | 0.8 | 125 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.4 | 170 | 0.12 | 0.8 | 90 | 0.11 | 0.8 | 135 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.4 | 230 | 0.12 | 0.8 | – | – | – | 215 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 205 | 0.12 | 0.8 | 120 | 0.11 | 0.8 | 190 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.4 | 175 | 0.12 | 0.8 | 105 | 0.11 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |  | | | | | | | | | | | | | | | | | | | |
| FM2 geometri til fin til medium bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **DCMT 11T308E-FM2** | **T6310** | 0.8 | 150 | 0.17 | 0.8 | 105 | 0.15 | 0.8 | 120 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 0.8 | 170 | 0.17 | 0.8 | 130 | 0.15 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.8 | 150 | 0.17 | 0.8 | 90 | 0.15 | 0.8 | 140 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.8 | 175 | 0.17 | 0.8 | 95 | 0.15 | 0.8 | 140 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.8 | 235 | 0.17 | 0.8 | – | – | – | 220 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 215 | 0.17 | 0.8 | 125 | 0.15 | 0.8 | 200 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.8 | 180 | 0.17 | 0.8 | 105 | 0.15 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| **DCMT 11T312E-FM2** | **T8430** | 1.2 | 155 | 0.22 | 1.2 | 85 | 0.20 | 1.2 | 130 | 0.22 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | 190 | 0.22 | 1.2 | 110 | 0.20 | 1.2 | 180 | 0.22 | 1.2 | – | – | – | – | – | – | – | – | – |
| **DCMT 150408E-FM2** | **T9315** | 0.8 | 205 | 0.20 | 1.5 | – | – | – | 190 | 0.20 | 1.5 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 185 | 0.20 | 1.5 | 110 | 0.18 | 1.5 | 175 | 0.20 | 1.5 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.8 | 160 | 0.20 | 1.5 | 95 | 0.18 | 1.5 | – | – | – | – | – | – | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| RF-geometri til semi-grov til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **DCMT 11T304E-RF** | **T5315** | 0.4 | 175 | 0.20 | 0.8 | – | – | – | 165 | 0.20 | 0.8 | – | – | – | – | – | – | 35 | 0.15 | 1.0 |
| | **T7335** | 0.4 | 115 | 0.20 | 0.8 | 85 | 0.18 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **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 | 0.15 | 1.0 |
| | **T7335** | 0.8 | 140 | 0.20 | 0.8 | 105 | 0.18 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 175 | 0.20 | 0.8 | 105 | 0.18 | 0.8 | 165 | 0.20 | 0.8 | – | – | – | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| RM-geometri til semi-grov til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **DCMT 11T304E-RM** | **T5305** | 0.4 | 225 | 0.27 | 0.8 | – | – | – | 210 | 0.27 | 0.8 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |
| | **T5315** | 0.4 | 205 | 0.27 | 0.8 | – | – | – | 190 | 0.27 | 0.8 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| | **T7335** | 0.4 | 135 | 0.27 | 0.8 | 105 | 0.24 | 0.8 | – | – | – | – | – | – | 40 | 0.19 | 0.6 | – | – | – |
| | **T8330** | 0.4 | 125 | 0.27 | 0.8 | 75 | 0.24 | 0.8 | 115 | 0.27 | 0.8 | – | – | – | 30 | 0.19 | 0.6 | 25 | 0.15 | 1.0 |
| | **T8430** | 0.4 | 135 | 0.27 | 0.8 | 75 | 0.24 | 0.8 | 110 | 0.27 | 0.8 | – | – | – | 25 | 0.19 | 0.6 | 20 | 0.15 | 1.0 |
| | **T9315** | 0.4 | 185 | 0.27 | 0.8 | – | – | – | 175 | 0.27 | 0.8 | – | – | – | – | – | – | 35 | 0.15 | 1.0 |
| | **T9325** | 0.4 | 165 | 0.27 | 0.8 | 95 | 0.24 | 0.8 | 155 | 0.27 | 0.8 | – | – | – | 35 | 0.19 | 0.6 | – | – | – |
| **DCMT 11T308E-RM** | **T5305** | 0.8 | 270 | 0.27 | 0.8 | – | – | – | 255 | 0.27 | 0.8 | – | – | – | – | – | – | 50 | 0.15 | 1.0 |
| | **T5315** | 0.8 | 240 | 0.27 | 0.8 | – | – | – | 225 | 0.27 | 0.8 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |
| | **T7335** | 0.8 | 165 | 0.27 | 0.8 | 125 | 0.24 | 0.8 | – | – | – | – | – | – | 50 | 0.19 | 0.6 | – | – | – |
| | **T8330** | 0.8 | 150 | 0.27 | 0.8 | 90 | 0.24 | 0.8 | 140 | 0.27 | 0.8 | – | – | – | 35 | 0.19 | 0.6 | 30 | 0.15 | 1.0 |
| | **T8430** | 0.8 | 165 | 0.27 | 0.8 | 90 | 0.24 | 0.8 | 135 | 0.27 | 0.8 | – | – | – | 35 | 0.19 | 0.6 | 25 | 0.15 | 1.0 |
| | **T9315** | 0.8 | 220 | 0.27 | 0.8 | – | – | – | 205 | 0.27 | 0.8 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| | **T9325** | 0.8 | 200 | 0.27 | 0.8 | 120 | 0.24 | 0.8 | 190 | 0.27 | 0.8 | – | – | – | 45 | 0.19 | 0.6 | – | – | – |
| **DCMT 11T312E-RM** | **T7335** | 1.2 | 165 | 0.27 | 1.2 | 125 | 0.24 | 1.2 | – | – | – | – | – | – | 50 | 0.19 | 1.2 | – | – | – |
| | **T8330** | 1.2 | 150 | 0.27 | 1.2 | 90 | 0.24 | 1.2 | 140 | 0.27 | 1.2 | – | – | – | 35 | 0.19 | 1.2 | 30 | 0.15 | 1.0 |
| | **T8430** | 1.2 | 170 | 0.27 | 1.2 | 90 | 0.24 | 1.2 | 135 | 0.27 | 1.2 | – | – | – | 35 | 0.19 | 1.2 | 25 | 0.15 | 1.0 |
| | **T9315** | 1.2 | 225 | 0.27 | 1.2 | – | – | – | 210 | 0.27 | 1.2 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |
| | **T9325** | 1.2 | 200 | 0.27 | 1.2 | 120 | 0.24 | 1.2 | 190 | 0.27 | 1.2 | – | – | – | 45 | 0.19 | 1.2 | – | – | – |
| **DCMT 150408E-RM** | **T8330** | 0.8 | 135 | 0.27 | 1.9 | 80 | 0.24 | 1.9 | 125 | 0.27 | 1.9 | – | – | – | 30 | 0.22 | 1.5 | 25 | 0.15 | 1.0 |
| | **T8430** | 0.8 | 150 | 0.27 | 1.9 | 80 | 0.24 | 1.9 | 125 | 0.27 | 1.9 | – | – | – | 30 | 0.22 | 1.5 | 25 | 0.15 | 1.0 |
| | **T9315** | 0.8 | 200 | 0.27 | 1.9 | – | – | – | 190 | 0.27 | 1.9 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| | **T9325** | 0.8 | 180 | 0.27 | 1.9 | 105 | 0.24 | 1.9 | 170 | 0.27 | 1.9 | – | – | – | 40 | 0.22 | 1.5 | – | – | – |

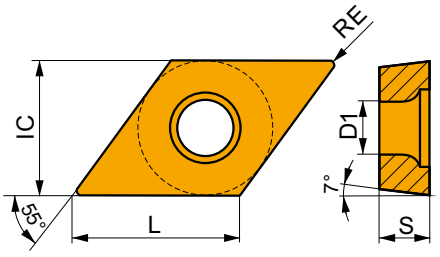
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) | | | | | | | | | | | | | | | | | | |
|  | | | | | | | | | | | | | | | | | | | | |
| |  | | | | | | | | | | | | | | | | | | | |
| UR-geometri til finbearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | | | | |
| **DCMT 070202E-UR** | **T7325** | 0.2 | 150 | 0.10 | 0.8 | 115 | 0.09 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.2 | 135 | 0.10 | 0.8 | 80 | 0.09 | 0.8 | 125 | 0.10 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.2 | 130 | 0.10 | 0.8 | 75 | 0.09 | 0.8 | 120 | 0.10 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.2 | 155 | 0.10 | 0.8 | 85 | 0.09 | 0.8 | 130 | 0.10 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.2 | 220 | 0.10 | 0.8 | – | – | – | 205 | 0.10 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.2 | 200 | 0.10 | 0.8 | 120 | 0.09 | 0.8 | 190 | 0.10 | 0.8 | – | – | – | – | – | – | – | – | – |
| **DCMT 070204E-UR** | **T7325** | 0.4 | 135 | 0.17 | 0.8 | 105 | 0.15 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.4 | 135 | 0.12 | 0.8 | 80 | 0.11 | 0.8 | 125 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.4 | 130 | 0.12 | 0.8 | 75 | 0.11 | 0.8 | 120 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.4 | 155 | 0.12 | 0.8 | 85 | 0.11 | 0.8 | 130 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.4 | 220 | 0.12 | 0.8 | – | – | – | 205 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 165 | 0.18 | 0.8 | 95 | 0.16 | 0.8 | 155 | 0.18 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **TT310** | 0.4 | 210 | 0.12 | 0.8 | 125 | 0.11 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| **DCMT 11T302E-UR** | **T7325** | 0.2 | 150 | 0.10 | 0.8 | 115 | 0.09 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.2 | 130 | 0.10 | 0.8 | 75 | 0.09 | 0.8 | 120 | 0.10 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.2 | 155 | 0.10 | 0.8 | 85 | 0.09 | 0.8 | 130 | 0.10 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.2 | 220 | 0.10 | 0.8 | – | – | – | 205 | 0.10 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.2 | 200 | 0.10 | 0.8 | 120 | 0.09 | 0.8 | 190 | 0.10 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **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 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 0.4 | 135 | 0.17 | 0.8 | 105 | 0.15 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 0.4 | 130 | 0.17 | 0.8 | 100 | 0.15 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.4 | 135 | 0.12 | 0.8 | 80 | 0.11 | 0.8 | 125 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.4 | 130 | 0.12 | 0.8 | 75 | 0.11 | 0.8 | 120 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.4 | 155 | 0.12 | 0.8 | 85 | 0.11 | 0.8 | 130 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.4 | 220 | 0.12 | 0.8 | – | – | – | 205 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 165 | 0.18 | 0.8 | 95 | 0.16 | 0.8 | 155 | 0.18 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **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 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 0.8 | 160 | 0.17 | 0.8 | 120 | 0.15 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 0.8 | 155 | 0.17 | 0.8 | 120 | 0.15 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.8 | 145 | 0.17 | 0.8 | 85 | 0.15 | 0.8 | 135 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.8 | 140 | 0.17 | 0.8 | 80 | 0.15 | 0.8 | 130 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.8 | 165 | 0.17 | 0.8 | 90 | 0.15 | 0.8 | 135 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.8 | 225 | 0.17 | 0.8 | – | – | – | 210 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 200 | 0.17 | 0.8 | 120 | 0.15 | 0.8 | 190 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **TT310** | 0.8 | 225 | 0.17 | 0.8 | 135 | 0.15 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| **DCMT 11T312E-UR** | **T9315** | 1.2 | 205 | 0.22 | 1.2 | – | – | – | 190 | 0.22 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | 180 | 0.22 | 1.2 | 105 | 0.20 | 1.2 | 170 | 0.22 | 1.2 | – | – | – | – | – | – | – | – | – |
|  | | | | | | | | | | | | | | | | | | | | |
| |  | | | | | | | | | | | | | | | | | | | |
| W-FM wiper geometri til finbearbejdning med øget tilspænding og forbedret overfladefinish. | | | | | | | | | | | | | | | | | | | | |
| **DCMX 11T304W-FM** | **T7325** | 0.4 | 130 | 0.30 | 0.8 | 100 | 0.27 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.4 | 115 | 0.30 | 0.8 | 65 | 0.27 | 0.8 | 105 | 0.30 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.4 | 130 | 0.30 | 0.8 | 70 | 0.27 | 0.8 | 105 | 0.30 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.4 | 170 | 0.30 | 0.8 | – | – | – | 160 | 0.30 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 155 | 0.30 | 0.8 | 90 | 0.27 | 0.8 | 145 | 0.30 | 0.8 | – | – | – | – | – | – | – | – | – |
| **DCMX 11T308W-FM** | **T7325** | 0.8 | 140 | 0.40 | 1.0 | 105 | 0.36 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.8 | 130 | 0.40 | 1.0 | 70 | 0.36 | 1.0 | 105 | 0.40 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.8 | 175 | 0.40 | 1.0 | – | – | – | 165 | 0.40 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 160 | 0.40 | 1.0 | 95 | 0.36 | 1.0 | 150 | 0.40 | 1.0 | – | – | – | – | – | – | – | – | – |

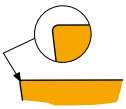
# DCMW

PRAMET

| | 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 |



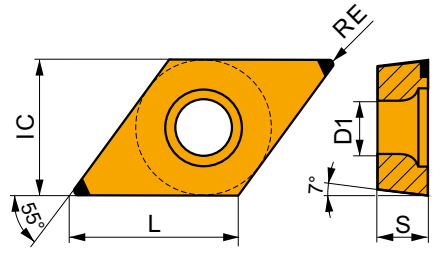

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | E | | | | | | | | | | | | | | | | | |
| | | | Til fin til halv grov bearbejdning og kontinuerlig til let afbrudt snit. | | | | | | | | | | | | | | | | | |
| **DCMW 070202** | **T5305** | 0.2 | – | – | – | – | – | – | 200 | 0.08 | 0.8 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| | **T6310** | 0.2 | – | – | – | – | – | – | 80 | 0.08 | 0.8 | – | – | – | – | – | – | 20 | 0.15 | 1.0 |
| **DCMW 070204** | **T5305** | 0.4 | – | – | – | – | – | – | 195 | 0.10 | 0.8 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| | **T5315** | 0.4 | – | – | – | – | – | – | 175 | 0.10 | 0.8 | – | – | – | – | – | – | 35 | 0.15 | 1.0 |
| | **T6310** | 0.4 | – | – | – | – | – | – | 85 | 0.10 | 0.8 | – | – | – | – | – | – | 20 | 0.15 | 1.0 |
| **DCMW 11T304** | **T5305** | 0.4 | – | – | – | – | – | – | 190 | 0.10 | 1.2 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| | **T5315** | 0.4 | – | – | – | – | – | – | 165 | 0.10 | 1.2 | – | – | – | – | – | – | 35 | 0.15 | 1.0 |
| | **T6310** | 0.4 | – | – | – | – | – | – | 80 | 0.10 | 1.2 | – | – | – | – | – | – | 20 | 0.15 | 1.0 |
| **DCMW 11T308** | **T5305** | 0.8 | – | – | – | – | – | – | 185 | 0.18 | 1.2 | – | – | – | – | – | – | 35 | 0.15 | 1.0 |
| | **T5315** | 0.8 | – | – | – | – | – | – | 160 | 0.18 | 1.2 | – | – | – | – | – | – | 30 | 0.15 | 1.0 |
| | **T6310** | 0.8 | – | – | – | – | – | – | 80 | 0.18 | 1.2 | – | – | – | – | – | – | 20 | 0.15 | 1.0 |

# DCGW CBN

PRAMET

| | IC (mm) | D1 (mm) | L (mm) | S (mm) |
|---|---|---|---|---|
| 11T3 | 9.525 | 4.50 | 11.60 | 3.97 |



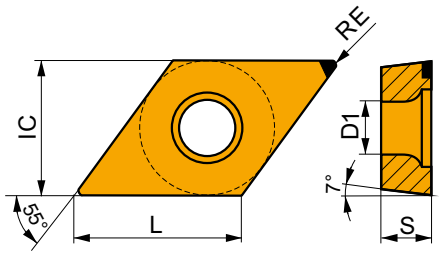

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | HSC | | S | | | | | | | | | | | | | | | |
| | | | Til færdigbearbejdning. | | | | | | | | | | | | | | | | | |
| **DCGW 11T304S01020B** | **TB310** | 0.4 | – | – | – | – | – | – | 370 | 0.10 | 0.4 | – | – | – | 95 | 0.07 | 0.3 | 75 | 0.15 | 1.0 |
| **DCGW 11T308S01020B** | **TB310** | 0.8 | – | – | – | – | – | – | 380 | 0.15 | 0.6 | – | – | – | 100 | 0.11 | 0.5 | 80 | 0.15 | 1.0 |

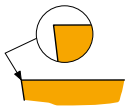
# DCMW PCD

PRAMET

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




Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | HSC F | | | | | | | | | | | | | | | | | |
| | | | Til færdigbearbejdning, høje hastigheder og stabile skæreforhold. | | | | | | | | | | | | | | | | | |
| **DCMW 11T304FN** | **PD1** | 0.4 | – | – | – | – | – | – | – | – | – | ■ 1035 | 0.12 | 0.5 | – | – | – | – | – | – |
| **DCMW 11T308FN** | **PD1** | 0.8 | – | – | – | – | – | – | – | – | – | ■ 1200 | 0.12 | 1.0 | – | – | – | – | – | – |

# SDJC(RL) EXT

P M K N S H

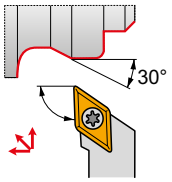
PRAMET

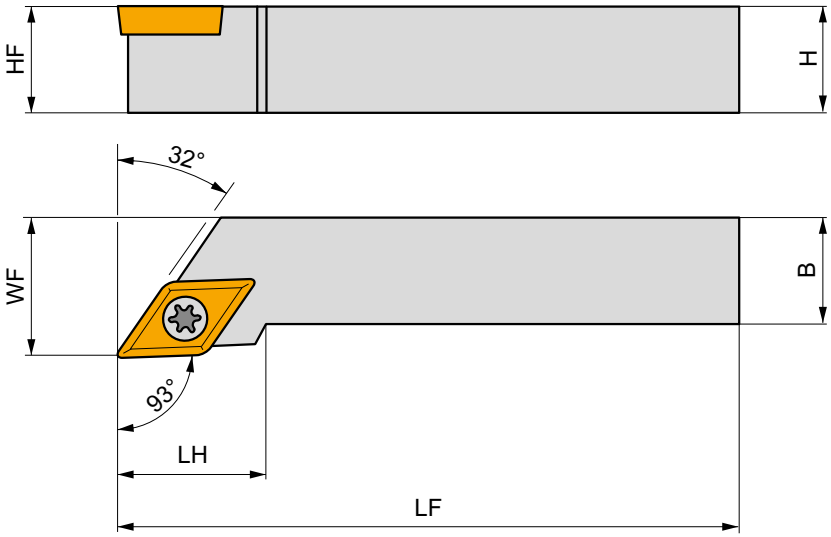
S

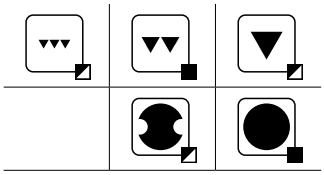


## Ekstern skruelåsværktøjsholder med 93 ° skærevinkel til DC Skær

Ekstern højre / venstre værktøjsholder med 93 ° skærevinkel til skruetype positiv DC .. 07, 11 eller 15 skær. Velegnet til udvendig langsgående drejning med skulder-, kopi-, konisk- og affasedrejning. Fås med skaftstørrelse 08x08 op til 25x25 mm. Krop behandlet for længere levetid på værktøjet.





| | Product | H (mm) | B (mm) | HF (mm) | WF (mm) | LF (mm) | LH (mm) | LAMS (°) | GAMO (°) | kg | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| R | SDJCR 0808 D 07 | 8 | 8 | 8 | 10 | 60 | 14 | 0 | 0 | 0.06 | GI052 | S01 |
| | SDJCR 1010 E 07 | 10 | 10 | 10 | 12 | 70 | 14 | 0 | 0 | 0.06 | GI052 | S01 |
| | SDJCR 1212 F 07 | 12 | 12 | 12 | 16 | 80 | 14 | 0 | 0 | 0.11 | GI052 | S01 |
| | SDJCR 1212 F 11 | 12 | 12 | 12 | 16 | 80 | 20 | 0 | 0 | 0.10 | GI012 | S08 |
| | SDJCR 1616 H 11 | 16 | 16 | 16 | 20 | 100 | 20 | 0 | 0 | 0.22 | GI012 | S08 |
| | SDJCR 2020 K 11-M-A | 20 | 20 | 20 | 25 | 125 | 20 | 0 | 0 | 0.40 | GI012 | SD10 |
| | SDJCR 2525 M 11-M-A | 25 | 25 | 25 | 32 | 150 | 20 | 0 | 0 | 0.74 | GI012 | SD10 |
| | SDJCR 2525 M 15 | 25 | 25 | 25 | 32 | 150 | 28 | 0 | 0 | 0.75 | GI243 | SD11 |
| L | SDJCL 0808 D 07 | 8 | 8 | 8 | 10 | 60 | 14 | 0 | 0 | 0.04 | GI052 | S01 |
| | SDJCL 1010 E 07 | 10 | 10 | 10 | 12 | 70 | 14 | 0 | 0 | 0.08 | GI052 | S01 |
| | SDJCL 1212 F 07 | 12 | 12 | 12 | 16 | 80 | 14 | 0 | 0 | 0.12 | GI052 | S01 |
| | SDJCL 1212 F 11 | 12 | 12 | 12 | 16 | 80 | 20 | 0 | 0 | 0.12 | GI012 | S08 |
| | SDJCL 1616 H 11 | 16 | 16 | 16 | 20 | 100 | 20 | 0 | 0 | 0.20 | GI012 | S08 |
| | SDJCL 2020 K 11-M-A | 20 | 20 | 20 | 25 | 125 | 20 | 0 | 0 | 0.41 | GI012 | SD10 |
| | SDJCL 2525 M 11-M-A | 25 | 25 | 25 | 32 | 150 | 20 | 0 | 0 | 0.74 | GI012 | SD10 |
| | SDJCL 2525 M 15 | 25 | 25 | 25 | 32 | 150 | 28 | 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

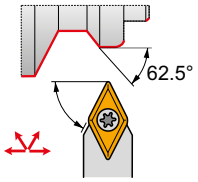
PRAMET

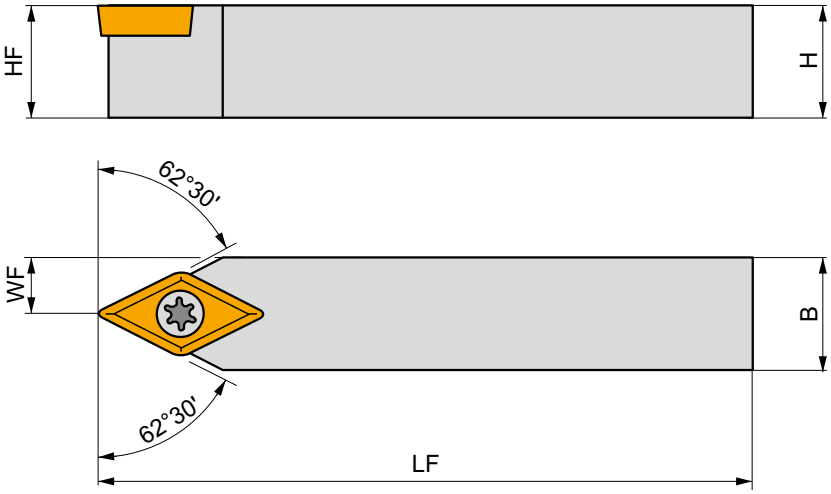
S

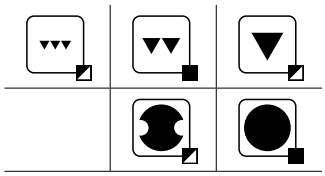


## Ekstern skruelåsværktøjsholder med 62,5 ° skærevinkel til DC .. Skær

Ekstern neutral værktøjsholder med 62,5 ° skærevinkel til skruetype positiv DC .. 07 eller 11 skær. Velegnet til udvendig langsgående drejning uden skulder, kopi, tilspidsning og affasning. Fås med skaftstørrelse 08x08 op til 25x25 mm. Krop behandlet for længere levetid





| | 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 | 0.06 | GI052 | S01 |
| | **SDNCN 1010 E 07** | 10 | 10 | 10 | 5 | 70 | 0 | 0 | 0.08 | GI052 | S01 |
| | **SDNCN 1212 F 07** | 12 | 12 | 12 | 6 | 80 | 0 | 0 | 0.12 | GI052 | S01 |
| | **SDNCN 1212 F 11** | 12 | 12 | 12 | 6 | 80 | 0 | 0 | 0.12 | GI012 | S08 |
| | **SDNCN 1616 H 11** | 16 | 16 | 16 | 8 | 100 | 0 | 0 | 0.18 | 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 | – |

NEW

# C.-SDJC(RL) EXT

P M K N S H

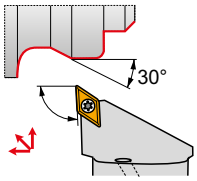
PRAMET

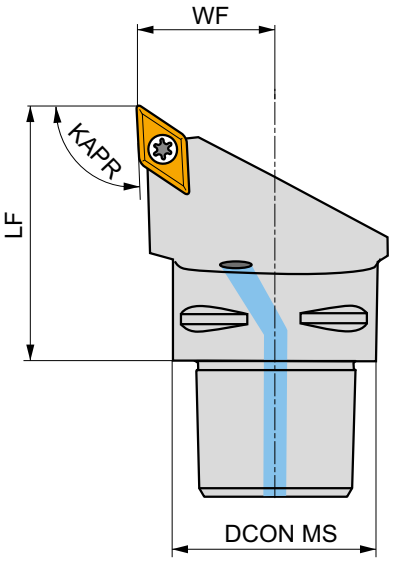
S

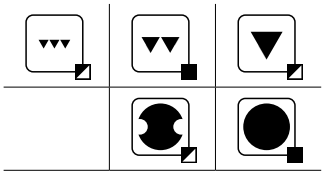


## Eksternt PSC Quick Change-værktøj, skruelås, 93 ° skærevinkel, DC .. Skær

Eksternt højre / venstre værktøj, gennemgående kølevæske, med 93 ° skærevinkel til skruetype positiv DC .. 07, 11 eller 15 skær. Velegnet til udvendig langsgående drejning med skulder-, kopi-, konisk- og affasedrejning. Fås med PSC (Polygon Shank Coupling) størrelse C3 op til C5. Krop behandlet for længere levetid på værktøjet.





| | Product | DCON MS (mm) | WF (mm) | LF (mm) | KAPR (°) | LAMS (°) | GAMO (°) | | kg | | |
|---|---|---|---|---|---|---|---|---|---|---|---|
| R | **C3-SDJCR-22040-11** | 32 | 22 | 40 | 93 | 0 | 0 | ✓ | 0.21 | 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 | ✓ | 0.21 | 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 |

NEW

# C.-SDNCN EXT

P M K N S H

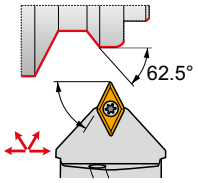
PRAMET

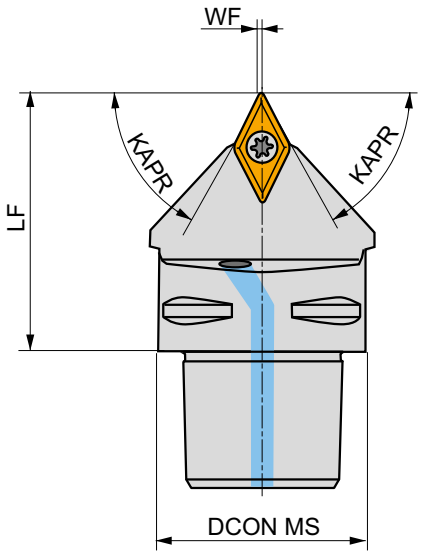
S

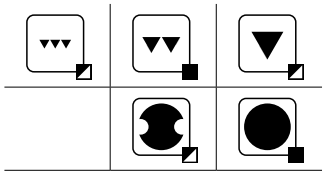


## Eksternt PSC Quick Change-værktøj, skruelås, 62,5 ° skærevinkel, DC .. Skær

Eksternt højre / venstre værktøj, gennemgående kølevæske, med 62,5 ° skærevinkel til skruetype positiv DC .. 11 skær. Velegnet til udvendig langsgående drejning uden skulder, kopi, tilspidsning og affasning. Fås med PSC (Polygon Shank Coupling) størrelse C4 og C5. Krop behandlet for længere levetid på værktøjet.





| | 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

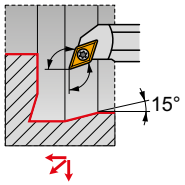
PRAMET

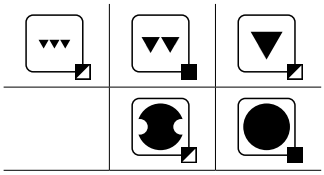
S

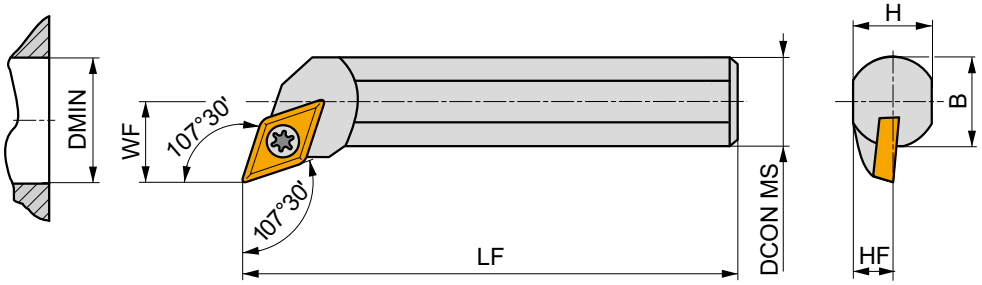


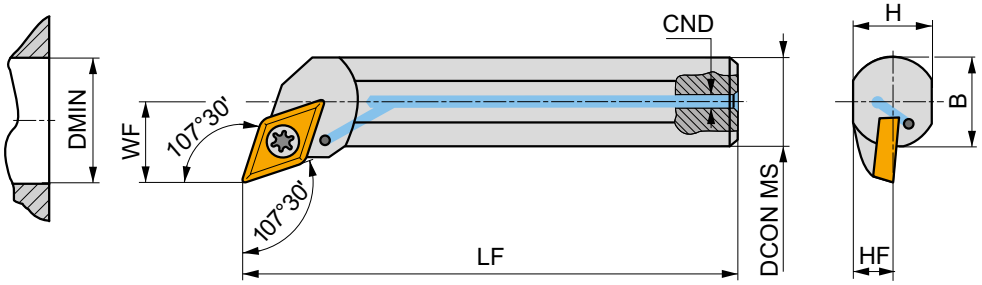
## Intern skruelåsborestang med 107.5 ° skærevinkel til DC .. Skær

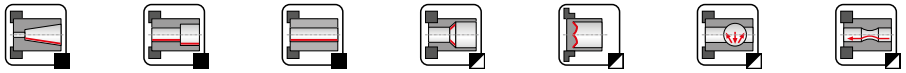
Intern højre / venstre borestang, indvendig kølevæske, 107,5, skærevinkel til skruetype DC .. 07 eller 11 skær. Mindste indvendige drejediameter Ø13 mm. Til indvendig langsgående drejning med skulder, tilspidsing, kopiering og affasning. Ø10 til Ø32 mm skaft fås. Krop behandlet for længere levetid på værktøjet.





| | 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 | ✓ | 0.24 | GI052 | S01 |
| | A20Q-SDQCR 11 | 20 | 25 | 13 | 18 | – | 180 | 8 | -5 | 0 | ✓ | 0.40 | 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 | ✓ | 0.67 | GI012 | S08 |
| | S25T-SDQCR 11 | 25 | 32 | 17 | 23 | 23 | 300 | – | -3 | 0 | – | 1.09 | 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 | ✓ | 0.24 | 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 | ✓ | 1.33 | 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

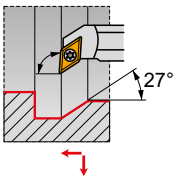
PRAMET

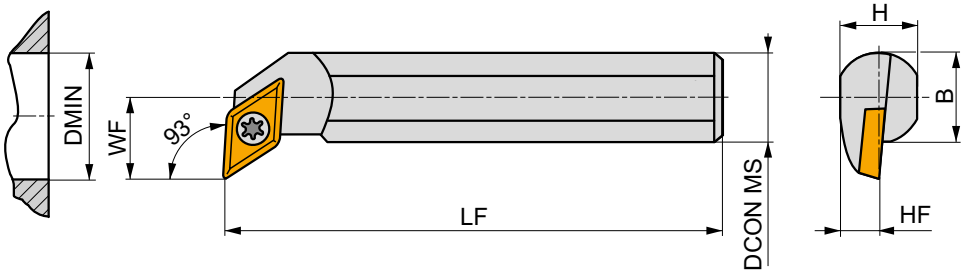
S

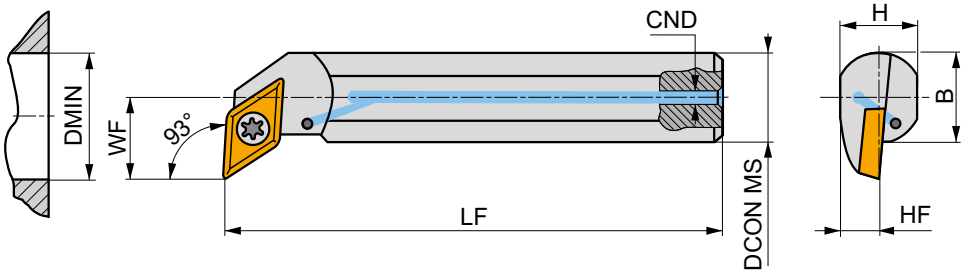


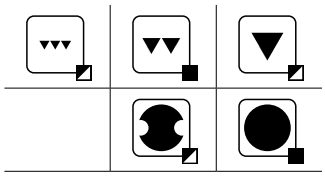
## Intern skruelåsborestang med 93 ° skærevinkel til DC .. Skær

Intern højre / venstre borestang, indvendig kølevæske, 93, skærevinkel til skruetype DC .. 07 eller 11 skær. Mindste indvendige drejediameter Ø13 mm. Til indvendig langsgående drejning med skulder, tilspidsing, kopiering og affasning. Ø10 op til Ø32 mm skaft fås. Krop behandlet for længere levetid på værktøjet.





| | 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 | ✓ | 0.05 | 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 | ✓ | 0.38 | 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 | – | 1.15 | 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 | ✓ | 0.06 | 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 | ✓ | 0.21 | GI052 | S01 |
| | A20Q-SDUCL 11 | 20 | 25 | 13 | 18 | – | 180 | 8 | -3 | 0 | ✓ | 0.38 | 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 | ✓ | 0.67 | GI012 | S08 |
| | S25T-SDUCL 11 | 25 | 32 | 17 | 23 | 23 | 300 | – | -3 | 0 | – | 1.15 | GI012 | S08 |
| | A32S-SDUCL 11-A | 32 | 40 | 22 | 30 | 30 | 250 | 8 | -10 | 0 | ✓ | 1.35 | 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

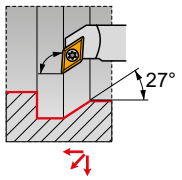
PRAMET

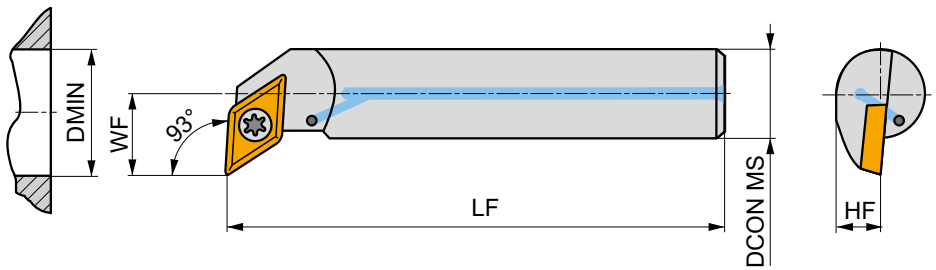
S

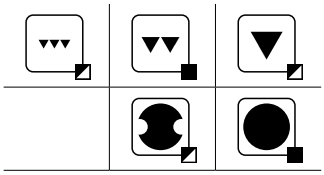


## Indvendig hårdmetal borestang med skruelås, 93 ° skærevinkel til DC .. Skær

Indvendigt højre / venstre hårdmetalborestang, indvendig kølemiddel, 93° skærevinkel for skruetype positiv DC .. 07 skær. Mindste indvendige drejediameter Ø15 mm. Til indvendig langsgående drejning med skulder, tilspidsing, kopiering og affasning. Ø10 op til Ø16 mm skaft fås. Til værktøjsudhæng> 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.. |

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

# SDZC(RL) INT

P M K N S H

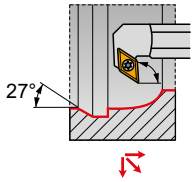
PRAMET

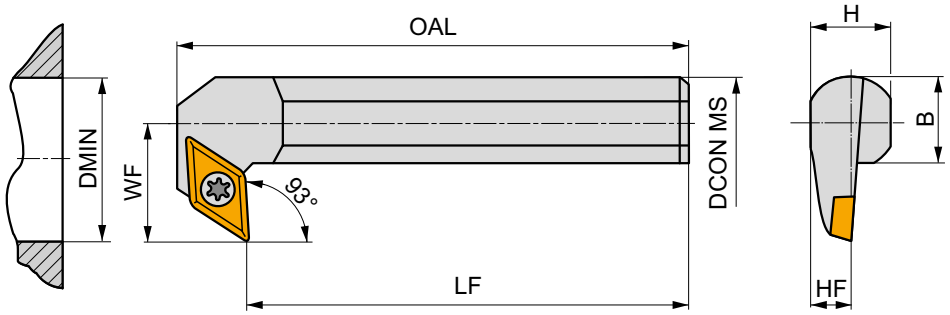
S

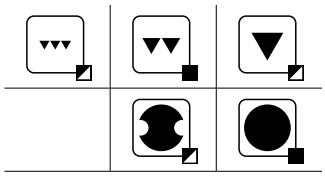


## Intern skruelåsborestang med 93 ° skærevinkel til DC .. Skær

Intern højre / venstre borestang med 93° skærevinkel til skruetype DC .. 07 eller 11 skær. Mindste indvendige drejediameter Ø27 mm. Velegnet til indvendigt længderygsdrejning med skulder, tilspidsning, kopiering og affasning. Fås med skaftstørrelse Ø16 op til Ø40 mm. Krop behandlet for længere levetid på værktøjet.





| | 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 | 0.50 | GI012 | S08 |
| | **S25R-SDZCR 11-93** | 25 | 42 | 27 | 23 | 23 | 200 | 218 | -3 | 0 | 0.83 | GI012 | S08 |
| | **S32S-SDZCR 11-93-A** | 32 | 53 | 35 | 30 | 30 | 250 | 268 | -6 | 0 | 1.64 | 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 | 0.60 | 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 | – |

NEW

# C.-SDUC(RL) INT

P M K N S H

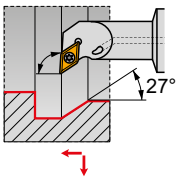
PRAMET

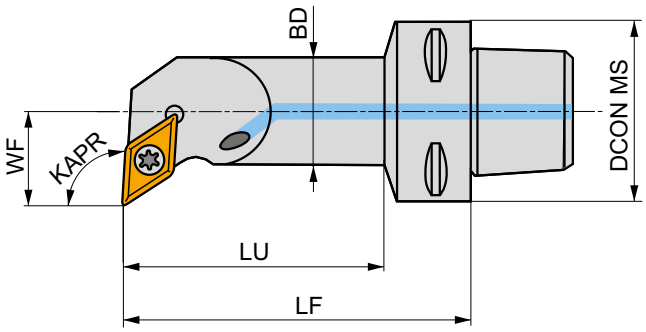
S

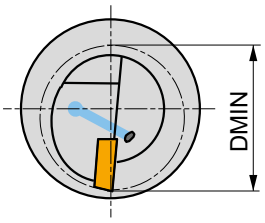


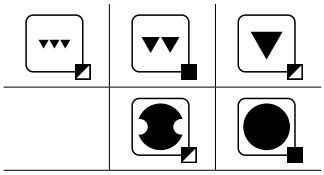
## Int. PSC Hurtig skift værktøj, skruelås, 93 ° skærevinkel, DC .. Skær

Internt højre / venstre værktøj, indvendig kølevæske, med 93° skærevinkel til skruetype DC .. 07 eller 11 skær. Mindste indvendige drejediameter Ø20 mm. Velegnet til en bred vifte af interne drejeprogrammer. PSC-skaft (Polygon Shank Coupling) størrelse C3 op til C5 med valg af længder. Krop behandlet for længere levetid på værktøjet.





| | 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 |

# EC

06 / 08

## CARBIDE INSERTS

**ECGT**



104

**ECMT**



105

**ECMW**



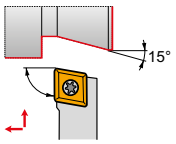
106

| MATCH THE RIGHT SIZE (example) | |
|---|---|
| **Insert** | **Tool Holder** |
| ECMT **06**0204E-FM2 | S08K-SEUCR **06** |

## ISO-DREJNING – UDVENDIGT

**SEGC(RL) EXT**

**90°**




12×12
16×16

107

**EC..**



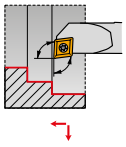
**08**

104 – 106

## ISO-DREJNING – INDVENDIG

**SEUC(RL) INT**

**93°**






11
32

108

**EC..**



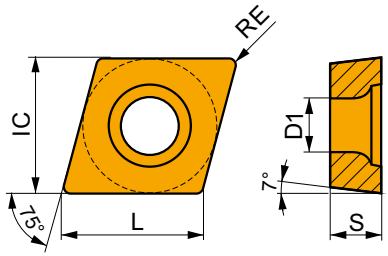
**06**
**08**

104 – 106

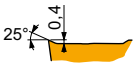
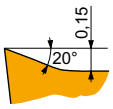
# ECGT

PRAMET

| | IC (mm) | D1 (mm) | L (mm) | S (mm) |
|---|---|---|---|---|
| 0602 | 6.350 | 2.80 | 6.50 | 2.38 |
| 0602-SF3 | 6.350 | 2.80 | 6.50 | 2.58 |
| 0803 | 7.940 | 3.40 | 8.20 | 3.18 |
| 0803-SF3 | 7.940 | 3.40 | 8.20 | 3.43 |



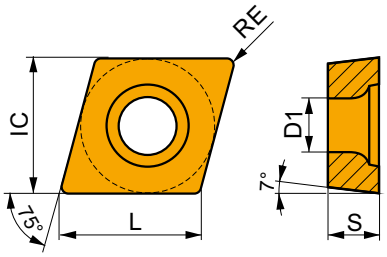

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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-geometri med meget positivt design til finbearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **ECGT 060202E-SF2** | **H07** | 0.2 | – | – | – | 105 | 0.05 | 1.0 | – | – | – | 525 | 0.06 | 1.0 | 50 | 0.04 | 0.8 | – | – | – |
| | **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 | – | – | – |
| | **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 | – | – | – |
| | **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 | – | – | – |
| | **T6310** | 0.4 | 160 | 0.10 | 1.0 | 115 | 0.09 | 1.0 | – | – | – | 480 | 0.12 | 1.0 | 45 | 0.07 | 0.8 | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| SF3-geometri med meget positivt design til finbearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **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 | – | – | – |
| | **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 | 0.15 | 1.0 |
| **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 | – | – | – |
| | **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 | 0.15 | 1.0 |

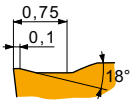
# ECMT

PRAMET

| | 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 |



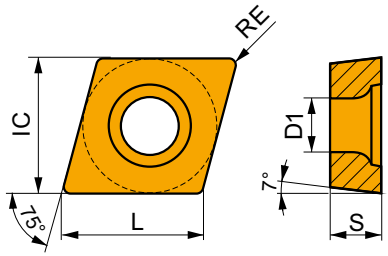

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |   | | U S | | | | | | | | | | | | | | | | | |
| | | | FM2 geometri til fin til medium bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **ECMT 060204E-FM2** | **T7325** | 0.4 | 180 | 0.12 | 0.8 | 140 | 0.11 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.4 | 155 | 0.12 | 0.8 | 90 | 0.11 | 0.8 | 145 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.4 | 205 | 0.12 | 0.8 | 110 | 0.11 | 0.8 | 170 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.4 | 290 | 0.12 | 0.8 | – | – | – | 275 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 255 | 0.12 | 0.8 | 150 | 0.11 | 0.8 | 240 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.4 | 220 | 0.12 | 0.8 | 130 | 0.11 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| **ECMT 080304E-FM2** | **T5315** | 0.4 | 280 | 0.12 | 1.0 | – | – | – | 265 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 0.4 | 170 | 0.12 | 1.0 | 130 | 0.11 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.4 | 150 | 0.12 | 1.0 | 90 | 0.11 | 1.0 | 140 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.4 | 205 | 0.12 | 1.0 | 110 | 0.11 | 1.0 | 170 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.4 | 280 | 0.12 | 1.0 | – | – | – | 265 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 255 | 0.12 | 1.0 | 150 | 0.11 | 1.0 | 240 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.4 | 215 | 0.12 | 1.0 | 125 | 0.11 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| **ECMT 080308E-FM2** | **T7325** | 0.8 | 185 | 0.17 | 1.0 | 140 | 0.15 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.8 | 165 | 0.17 | 1.0 | 95 | 0.15 | 1.0 | 155 | 0.17 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.8 | 210 | 0.17 | 1.0 | 115 | 0.15 | 1.0 | 175 | 0.17 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.8 | 290 | 0.17 | 1.0 | – | – | – | 275 | 0.17 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 260 | 0.17 | 1.0 | 155 | 0.15 | 1.0 | 245 | 0.17 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.8 | 225 | 0.17 | 1.0 | 135 | 0.15 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – |

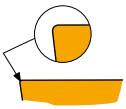
# ECMW

PRAMET

| | 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 |




Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | |  | | | | | | | | | | | | | | | | | |
| | | | Til fin til halv grov bearbejdning og kontinuerlig til let afbrudt snit. | | | | | | | | | | | | | | | | | |
| **ECMW 060204** | **H07** | 0.4 | – | – | – | – | – | – | ■ 100 | 0.10 | 2.0 | – | – | – | – | – | – | – | – | – |
| **ECMW 080304** | **H07** | 0.4 | – | – | – | – | – | – | ■ 100 | 0.10 | 2.5 | – | – | – | – | – | – | – | – | – |
| **ECMW 080308** | **H07** | 0.8 | – | – | – | – | – | – | ■ 95 | 0.18 | 2.5 | – | – | – | – | – | – | – | – | – |

# SEGC(RL) EXT

P M K N S H

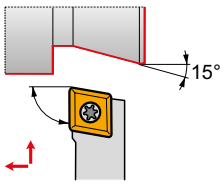
PRAMET

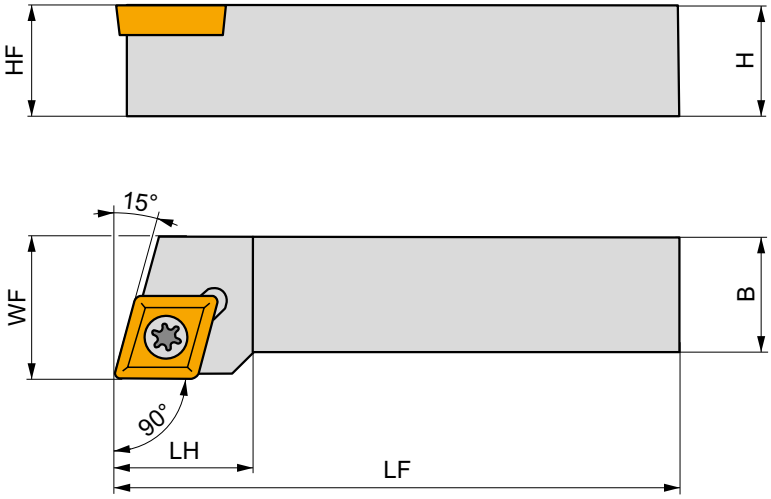
S

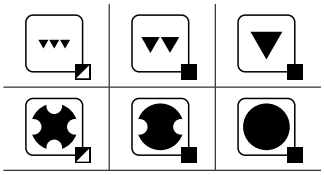


## Ekstern skruelåsværktøjsholder med 90 ° skærevinkel til EC Skær

Ekstern højre / venstre værktøjsholder med 90 ° skærevinkel til skruetype positiv EC .. 08 skær. Velegnet til udvendigt ende og langsgående drejning med skulder, tilspidsning, affasning og endedrejning. Fås med skaftstørrelse 12x12 og 16x16 mm. Krop behandlet for længere levetid på værktøjet.





| | 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 | 0.15 | GI210 | SE08 |
| | SEGCR 1616 H 08 | 16 | 16 | 16 | 20 | 100 | 12 | 0 | 0 | 0.22 | GI210 | SE08 |
| L | SEGCL 1212 N 08 | 12 | 12 | 12 | 16 | 160 | 12 | 0 | 0 | 0.22 | GI210 | SE08 |
| | SEGCL 1616 H 08 | 16 | 16 | 16 | 20 | 100 | 12 | 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

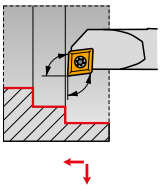
PRAMET

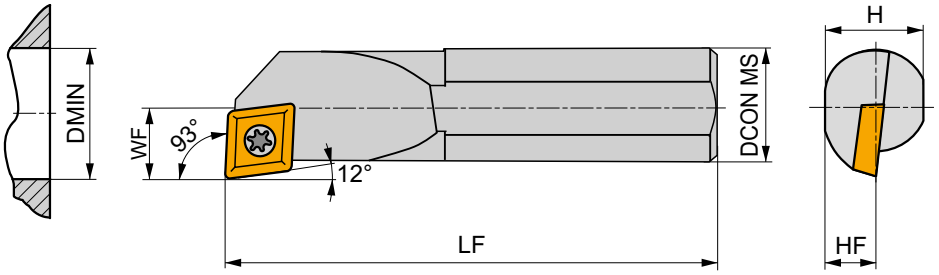
S

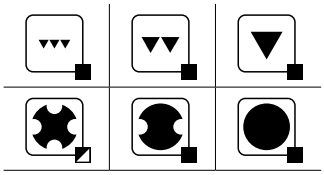


## Intern skruelåsborestang med 93 ° skærevinkel til EC .. Skær

Intern højre / venstre borestang med 93° skærevinkel til skruetype EC .. 06 og 08 skær. Mindste indvendige drejediameter Ø11 mm. Velegnet til indvendig tilspidsning og langsgående drejning med skulder- og affasedrejning. Fås med skaftstørrelse Ø8 op til Ø25 mm. Krop behandlet for længere levetid på værktøjet.







| | 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 |

# EP 05

## CARBIDE INSERTS

**EPGX**



110

**EPMT**

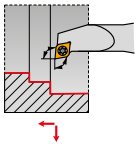


110

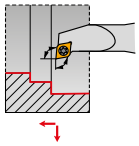
| MATCH THE RIGHT SIZE (example) | |
|---|---|
| **Insert** | **Tool Holder** |
| EPGX **05**0202FR-JZ | S0608H-SELPR **05** |

## ISO-DREJNING – INDVENDIG

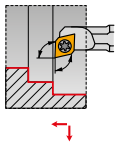
### SELP(RL) INT

| 95° | EP.. |
|---|---|
|  | 05 |
| ØDmin 8 / 16 | |
| 111 | 110 |

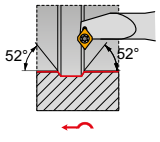
### SELP(RL)-E INT

| 95° | EP.. |
|---|---|
|  | 05 |
| ØDmin 8 / 16 | |
| 112 | 110 |

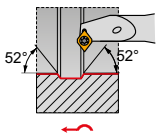
### SEUP(RL) INT

| 93° | EP.. |
|---|---|
|  | 05 |
| ØDmin 8,3 | |
| 113 | 110 |

### SEXP(RL) INT

| 52°30´ | EP.. |
|---|---|
|   | 05 |
| ØDmin 9,5 / 16 | |
| 114 | 110 |

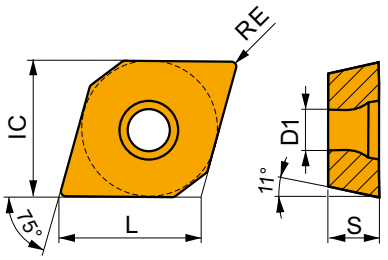
### SEXP(RL)-E INT

| 52°30´ | EP.. |
|---|---|
|   | 05 |
| ØDmin 9,5 / 16 | |
| 115 | 110 |

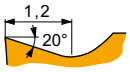
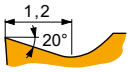
# EPGX

PRAMET

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



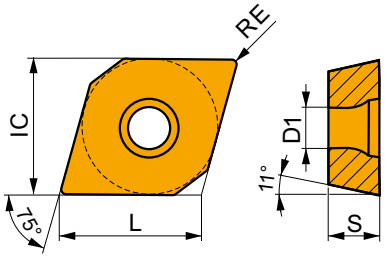

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | |  | | | | | | | | | | | | | | | | | |
| | | | FR-JZ positiv geometri med højrehåndet design til finbearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | |
| **EPGX 050202FR-JZ** | **TT010** | 0.2 | ■ 295 | 0.06 | 0.5 | ◪ 175 | 0.05 | 0.5 | – | – | – | – | – | – | – | – | – | – | – | – |
|  |  | |  | | | | | | | | | | | | | | | | | |
| | | | FL-JZ geometri med positivt venstrehåndet design til finbearbejdning, kontinuerlige snit. | | | | | | | | | | | | | | | | | |
| **EPGX 050202FL-JZ** | **TT010** | 0.2 | ■ 295 | 0.06 | 0.5 | ◪ 175 | 0.05 | 0.5 | – | – | – | – | – | – | – | – | – | – | – | – |

# EPMT

PRAMET

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




Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | |  | | | | | | | | | | | | | | | | | |
| | | | NF2-geometri med positivt design til finbearbejdning til halv grov bearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | |
| **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 | – | – | – |
| | **T7325** | 0.2 | ◪ 215 | 0.07 | 0.8 | ■ 165 | 0.06 | 0.8 | – | – | – | – | – | – | ■ 65 | 0.06 | 0.6 | – | – | – |
| | **T7335** | 0.2 | ◪ 220 | 0.07 | 0.8 | ■ 170 | 0.06 | 0.8 | – | – | – | – | – | – | ■ 70 | 0.06 | 0.6 | – | – | – |
| | **T9315** | 0.2 | ◪ 390 | 0.05 | 0.8 | – | – | – | ◪ 370 | 0.05 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.2 | ◪ 305 | 0.07 | 0.8 | ■ 180 | 0.06 | 0.8 | ◪ 285 | 0.07 | 0.8 | – | – | – | ◪ 65 | 0.06 | 0.6 | – | – | – |
| | **T9335** | 0.2 | ◪ 200 | 0.10 | 0.8 | ■ 120 | 0.09 | 0.8 | – | – | – | – | – | – | ◪ 45 | 0.07 | 0.6 | – | – | – |
| | **TT010** | 0.2 | ◪ 345 | 0.05 | 0.5 | ◪ 205 | 0.05 | 0.5 | – | – | – | – | – | – | – | – | – | – | – | – |

# SELP(RL) INT

P M K N S H

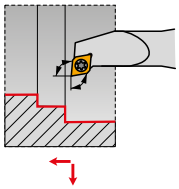
PRAMET

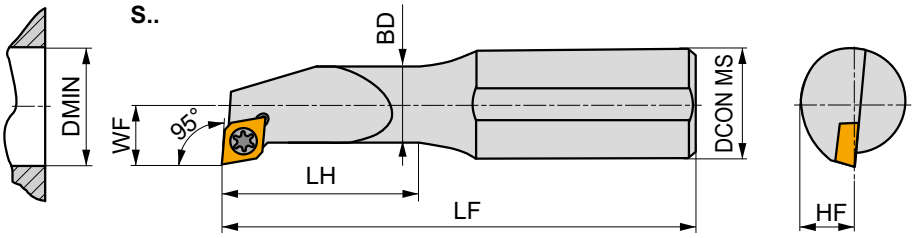
S

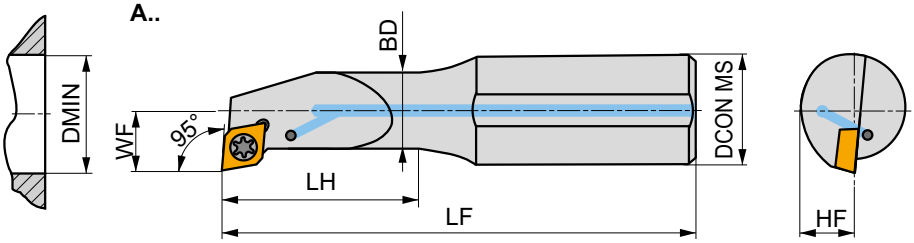


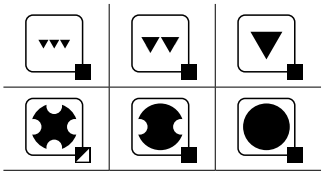
## Intern skruelåsborestang med 95 ° skærevinkel til EP .. Skær

Intern højre / venstre borestang, indvendig kølevæske med 95° skærevinkel til skruetype EP .. 0502 skær. Mindste indvendige drejediameter Ø8 mm. Velegnet til indvendig tilspidsning og langsgående drejning med skulder- og affasedrejning. Ø8 op til Ø16 mm skaft fås. Krop behandlet for længere levetid på værktøjet.







| | 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 | -10 | 0 | – | 0.04 | GI212 | SE21 |
| | S0810J-SELPR 05 | 10 | 11 | 8 | 6 | 110 | 26 | -5 | 0 | – | 0.06 | GI212 | SE22 |
| | S1012K-SELPR 05 | 12 | 13 | 10 | 7 | 125 | 32 | -5 | 0 | – | 0.11 | GI212 | SE22 |
| | A1216M-SELPR 05 | 16 | 16 | 12 | 9 | 150 | 40 | -2 | 0 | ✓ | 0.18 | GI212 | SE22 |
| | S1216M-SELPR 05 | 16 | 16 | 12 | 9 | 150 | 40 | -2 | 0 | – | 0.21 | GI212 | SE22 |
| L | S0608H-SELPL 05 | 8 | 8 | 6 | 4.5 | 100 | 20 | -10 | 0 | – | 0.04 | GI212 | SE21 |
| | S0810J-SELPL 05 | 10 | 11 | 8 | 6 | 110 | 26 | -5 | 0 | – | 0.06 | GI212 | SE22 |
| | S1012K-SELPL 05 | 12 | 13 | 10 | 7 | 125 | 32 | -5 | 0 | – | 0.11 | GI212 | SE22 |
| | S1216M-SELPL 05 | 16 | 16 | 12 | 9 | 150 | 40 | -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

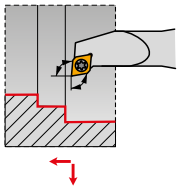
PRAMET

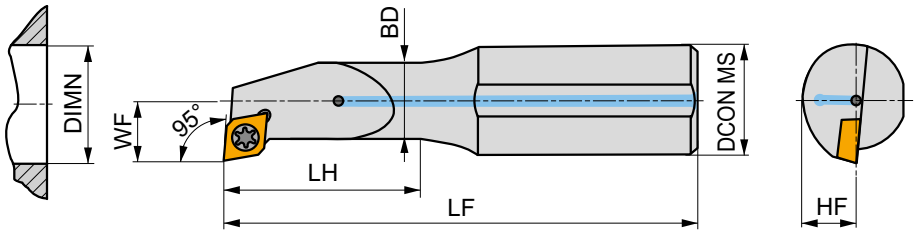
S

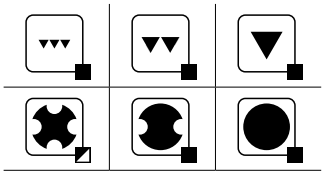


## Indvendig hårdmetal borestang med skruelås, 95 ° skærevinkel til EP .. Skær

Indvendig højre / venstre hårdmetalborestang, indvendig kølevæske, med 95° skærevinkel til skruetype EP .. 0502 skær. Mindste indvendige drejediameter Ø8 mm. Velegnet til indvendig tilspidsning og langsgående drejning med skulder- og affasedrejning. Fås med skaftstørrelse Ø8 op til Ø16 mm. Til værktøjsudhæng> 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 | -10 | 0 | ✓ | 0.06 | GI212 | SE22 |
| | **E0810J-SELPR 05** | 10 | 11 | 8 | 6 | 110 | 36 | -5 | 0 | ✓ | 0.10 | GI212 | SE22 |
| | **E1012K-SELPR 05** | 12 | 13 | 10 | 7 | 125 | 44 | -5 | 0 | ✓ | 0.18 | GI212 | SE22 |
| L | **E0608H-SELPL 05** | 8 | 8 | 6 | 4.5 | 100 | 28 | -10 | 0 | ✓ | 0.06 | GI212 | SE22 |
| | **E0810J-SELPL 05** | 10 | 11 | 8 | 6 | 110 | 36 | -5 | 0 | ✓ | 0.10 | GI212 | SE22 |
| | **E1216M-SELPL 05** | 16 | 16 | 12 | 9 | 150 | 55 | -2 | 0 | ✓ | 0.33 | GI212 | SE22 |

| | |
|---|---|
| GI212 | EP.. 0502.. |

| | | Nm | | | |
|---|---|---|---|---|---|
| SE22 | 28588 | 0.8 | M 2.2 | 5.6 | MA2-8304 |

# SEUP(RL) INT

P M K N S H

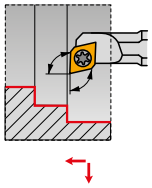
PRAMET

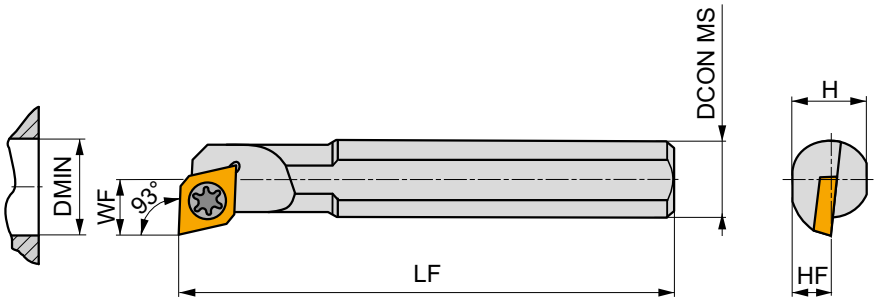
S

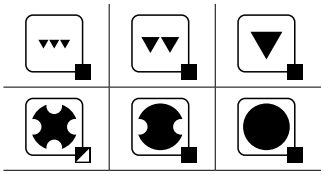


## Intern skruelåsborestang med 93 ° skærevinkel til EP .. Skær

Intern højre / venstre borestang med 93° skærevinkel til skruetype EP .. 0502 skær. Mindste indvendige drejediameter Ø8,3 mm. Velegnet til indvendig tilspidsning og langsgående drejning med skulder- og affasedrejning. Fås med skaftstørrelse Ø6 mm. Krop behandlet for længere levetid på værktøjet.







| | 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 | 0.03 | GI212 | SE21 |
| L | S06H-SEUPL 05 | 6 | 8.3 | 5 | 5.4 | 2.7 | 100 | -7 | 0 | 0.03 | 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

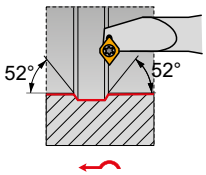
PRAMET

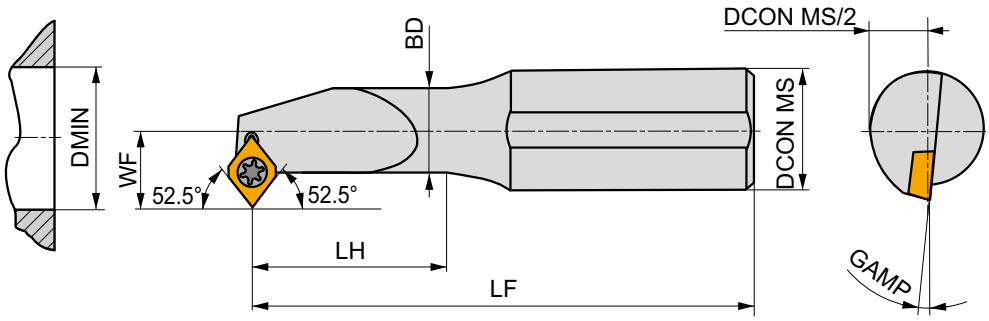
S

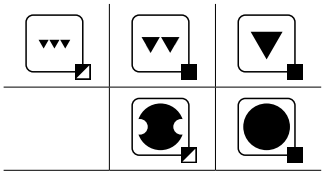


## Intern skruelåsborestang med 52.5 ° skærevinkel til EP .. Skær

Intern højre / venstre borestang, 52,5° skærevinkel til skruetype EP .. 0502 skær. Mindste indvendige drejediameter Ø9,5 mm. Til indvendigt rygfasning, tilspidsning, multi-retningsretning, affasning og langsgående drejning uden skulder. Fås med skaftstørrelse Ø8 op til Ø16mm. Krop behandlet for længere levetid på værktøjet.





| | 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 | -7 | 0.04 | GI212 | SE21 |
| | S0810J-SEXPR 05 | 10 | 11 | 8 | 6 | 110 | 26 | -5 | 0.06 | GI212 | SE22 |
| | S1012K-SEXPR 05 | 12 | 13 | 10 | 7 | 125 | 32 | -5 | 0.11 | GI212 | SE22 |
| | S1216M-SEXPR 05 | 16 | 16 | 12 | 9 | 150 | 40 | -2 | 0.21 | GI212 | SE22 |
| L | S0608H-SEXPL 05 | 8 | 9.5 | 6 | 5.5 | 100 | 20 | -7 | 0.04 | GI212 | SE21 |
| | S0810J-SEXPL 05 | 10 | 11 | 8 | 6 | 110 | 26 | -5 | 0.07 | GI212 | SE22 |
| | S1012K-SEXPL 05 | 12 | 13 | 10 | 7 | 125 | 32 | -5 | 0.11 | GI212 | SE22 |
| | S1216M-SEXPL 05 | 16 | 16 | 12 | 9 | 150 | 40 | -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

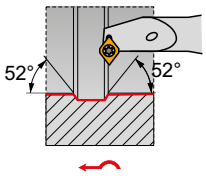
PRAMET

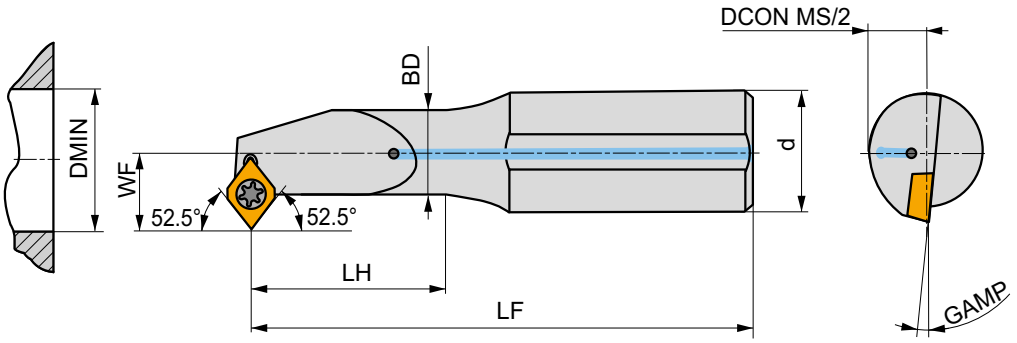
S

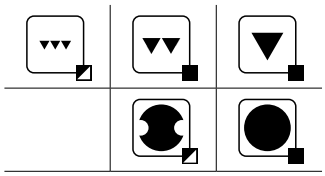


## Indvendig hårdmetal borestang med skruelås, 52,5 ° skærevinkel til EP .. Skær

Intern højre / venstre hårdmetalborestang, indvendig kølevæske, 52,5° skærevinkel til skruetype EP .. 0502 skær. Mindste indvendige drejediameter Ø9,5 mm. Til indvendigt rygfasning, tilspidsning, multi-retningsretning, affasning og langsgående drejning uden skulder. Ø8 til Ø16 mm skaft til rådighed. Til udhæng> 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 | -7 | ✓ | 0.07 | GI212 | SE21 |
| | **E0810J-SEXPR 05** | 10 | 11 | 8 | 6 | 110 | 36 | -5 | ✓ | 0.11 | GI212 | SE22 |
| | **E1012K-SEXPR 05** | 12 | 13 | 10 | 7 | 125 | 44 | -5 | ✓ | 0.16 | GI212 | SE22 |
| | **E1216M-SEXPR 05** | 16 | 16 | 12 | 9 | 150 | 55 | -2 | ✓ | 0.32 | GI212 | SE22 |
| L | **E0608H-SEXPL 05** | 8 | 9.5 | 6 | 5.5 | 100 | 28 | -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 |

# RC

06/ 08/ 12/ 16/ 20/ 25/ 32

## CARBIDE INSERTS

### RCGT



118

### RCMT



118

### RCMW



120

### RCMX



121

## CER INSERTS

### RCGX CER



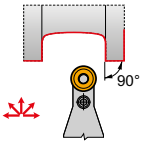
123

**MATCH THE RIGHT SIZE (example)**

| Insert | Tool Holder |
|---|---|
| RCMT 1204MOE-RM3 | SRDCN 3225 P 12-M |

## ISO-DREJNING – UDVENDIGT

### PRDCN EXT



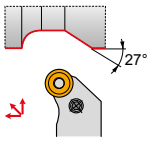

| RC.. |
|---|
| 20 |
| 25 |
| 32 |



40×40 / 50×50

124 | 118 – 123

### PRSC(RL) EXT



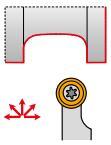

| RC.. |
|---|
| 16 |
| 25 |



40×40

125 | 118 – 123

### SRDC(RL) EXT



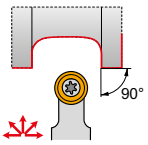
| RC.. |
|---|
| 08 |



20×20 / 32×25

126 | 118 – 123

### SRDCN EXT



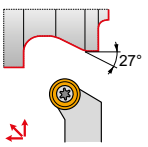

| RC.. |
|---|
| 06 |
| 08 |
| 10 |
| 12 |
| 16 |



12×12 / 32×25

127 | 118 – 123

### SRSC(RL) EXT



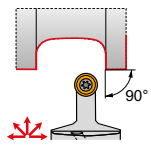

| RC.. |
|---|
| 06 |
| 08 |
| 10 |
| 12 |
| 16 |



12×12 / 32×25

128 | 118 – 123

### C.-SRDCN EXT NEW




| RC.. |
|---|
| 10 |
| 12 |



C4 / C5

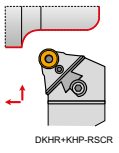
130 | 118 – 123

# RC

06/ 08/ 12/ 16/ 20/ 25/ 32

## ISO-DREJNING – GROVBEARBEJDNING UDVENDIGT

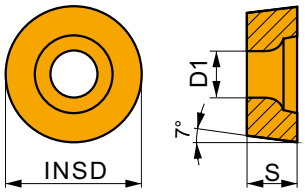
### KHP-RSCR/L + DKH(RL)

| | RC.. |
|---|---|
|  DKHR+KHP-RSCR | 20<br>25<br>32 |
| ■ 40×50<br>60×80 | |
| 131, 132 | 118 – 123 |

# RCGT

PRAMET

| | INSD (mm) | D1 (mm) | S (mm) |
|---|---|---|---|
| 0803 | 8.0 | 3.40 | 3.18 |
| 1003 | 10.0 | 4.40 | 3.18 |



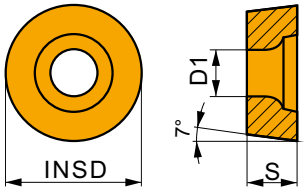

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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-geometri med meget positivt design til fin-finish til grov bearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | | | | |
| **RCGT 0803MOF-AL** | **HF7** | – | – | – | – | – | – | – | – | – | – | – | – | – | 285 | 1.20 | 1.0 | – | – | – | – | – | – |
| | **T0315** | – | – | – | – | – | – | – | – | – | – | – | – | – | 420 | 1.20 | 1.0 | – | – | – | – | – | – |
| **RCGT 1003MOF-AL** | **HF7** | – | – | – | – | – | – | – | – | – | – | – | – | – | 255 | 1.50 | 1.0 | – | – | – | – | – | – |
| | **T0315** | – | – | – | – | – | – | – | – | – | – | – | – | – | 390 | 1.50 | 1.0 | – | – | – | – | – | – |

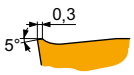
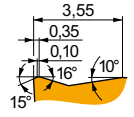
# RCMT

PRAMET

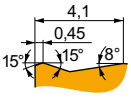
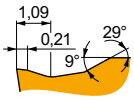
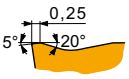
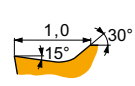
| | INSD (mm) | D1 (mm) | S (mm) |
|---|---|---|---|
| 0602 | 6.0 | 2.80 | 2.38 |
| 0803 | 8.0 | 3.40 | 3.18 |
| 10T3 | 10.0 | 4.40 | 3.97 |
| 1204 | 12.0 | 4.40 | 4.76 |
| 1606 | 16.0 | 5.50 | 6.35 |
| 2006 | 20.0 | 6.50 | 6.35 |
| 2507 | 25.0 | 8.60 | 7.94 |



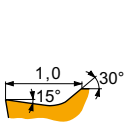

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | |  | | | | | | | | | | | | | | | | | |
| Geometri 37 til semi-grov til tung-grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **RCMT 1606MOS-37** | **T9315** | – | ■ | 165 | 0.60 | 3.0 | – | – | – | ◪ | 155 | 0.60 | 3.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | – | ■ | 145 | 0.60 | 3.0 | – | – | – | ◪ | 135 | 0.60 | 3.0 | – | – | – | – | – | – | – | – | – |
|  |  | |  | | | | | | | | | | | | | | | | | |
| Geometri 371 til semi-grov til tung-grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **RCMT 2006MOS-371** | **T9315** | – | ■ | 145 | 0.80 | 3.0 | – | – | – | ◪ | 135 | 0.80 | 3.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | – | ■ | 125 | 0.80 | 3.0 | – | – | – | ◪ | 115 | 0.80 | 3.0 | – | – | – | – | – | – | – | – | – |

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | |  | | | | | | | | | | | | | | | | | |
| Geometri 372 til semi-grov til tung-grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **RCMT 2507MOS-372** | **T9325** | – | ■ 90 | 0.80 | 3.0 | – | – | – | ◪ 85 | 0.80 | 3.0 | – | – | – | – | – | – | – | – | – |
|  |  | |  | | | | | | | | | | | | | | | | | |
| FM-geometri til fin til halv grov bearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | | | | |
| **RCMT 0602MOE-FM** | **T7325** | – | ◪ 215 | 0.45 | 1.2 | ■ 165 | 0.41 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | – | ■ 190 | 0.45 | 1.2 | ■ 110 | 0.41 | 1.2 | ◪ 180 | 0.45 | 1.2 | ◪ 570 | 0.54 | 1.2 | – | – | – | – | – | – |
| | **T8430** | – | ■ 200 | 0.45 | 1.2 | ■ 110 | 0.41 | 1.2 | ◪ 165 | 0.45 | 1.2 | ◪ 555 | 0.54 | 1.2 | – | – | – | – | – | – |
| | **T9315** | – | ■ 260 | 0.45 | 1.2 | – | – | – | ◪ 245 | 0.45 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9325** | – | ■ 235 | 0.45 | 1.2 | ■ 140 | 0.41 | 1.2 | ◪ 220 | 0.45 | 1.2 | – | – | – | – | – | – | – | – | – |
| **RCMT 0803MOE-FM** | **T7325** | – | ◪ 190 | 0.60 | 1.6 | ■ 145 | 0.54 | 1.6 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | – | ■ 170 | 0.60 | 1.6 | ■ 100 | 0.54 | 1.6 | ◪ 160 | 0.60 | 1.6 | ◪ 510 | 0.72 | 1.6 | – | – | – | – | – | – |
| | **T8430** | – | ■ 175 | 0.60 | 1.6 | ■ 95 | 0.54 | 1.6 | ◪ 140 | 0.60 | 1.6 | ◪ 480 | 0.72 | 1.6 | – | – | – | – | – | – |
| | **T9315** | – | ■ 225 | 0.60 | 1.6 | – | – | – | ◪ 210 | 0.60 | 1.6 | – | – | – | – | – | – | – | – | – |
| | **T9325** | – | ■ 200 | 0.60 | 1.6 | ■ 120 | 0.54 | 1.6 | ◪ 190 | 0.60 | 1.6 | – | – | – | – | – | – | – | – | – |
| **RCMT 10T3MOE-FM** | **T7325** | – | ◪ 185 | 0.65 | 1.7 | ■ 140 | 0.59 | 1.7 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | – | ■ 165 | 0.65 | 1.7 | ■ 95 | 0.59 | 1.7 | ◪ 155 | 0.65 | 1.7 | ◪ 495 | 0.78 | 1.7 | – | – | – | – | – | – |
| | **T8430** | – | ■ 170 | 0.65 | 1.7 | ■ 90 | 0.59 | 1.7 | ◪ 135 | 0.65 | 1.7 | ◪ 465 | 0.78 | 1.7 | – | – | – | – | – | – |
| | **T9315** | – | ■ 220 | 0.65 | 1.7 | – | – | – | ◪ 205 | 0.65 | 1.7 | – | – | – | – | – | – | – | – | – |
| | **T9325** | – | ■ 195 | 0.65 | 1.7 | ■ 115 | 0.59 | 1.7 | ◪ 185 | 0.65 | 1.7 | – | – | – | – | – | – | – | – | – |
| **RCMT 1204MOE-FM** | **T7325** | – | ◪ 175 | 0.70 | 1.8 | ■ 135 | 0.63 | 1.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | – | ■ 160 | 0.70 | 1.8 | ■ 95 | 0.63 | 1.8 | ◪ 150 | 0.70 | 1.8 | ◪ 480 | 0.84 | 1.8 | – | – | – | – | – | – |
| | **T8430** | – | ■ 155 | 0.70 | 1.8 | ■ 85 | 0.63 | 1.8 | ◪ 130 | 0.70 | 1.8 | ◪ 435 | 0.84 | 1.8 | – | – | – | – | – | – |
| | **T9315** | – | ■ 205 | 0.70 | 1.8 | – | – | – | ◪ 190 | 0.70 | 1.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | – | ■ 190 | 0.70 | 1.8 | ■ 110 | 0.63 | 1.8 | ◪ 180 | 0.70 | 1.8 | – | – | – | – | – | – | – | – | – |
|  |  | |  | | | | | | | | | | | | | | | | | |
| RM3-geometri til halv grov til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **RCMT 0803MOE-RM3** | **T7325** | – | ◪ 185 | 0.50 | 1.3 | ◪ 140 | 0.45 | 1.3 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9315** | – | ■ 225 | 0.50 | 1.3 | – | – | – | ◪ 210 | 0.50 | 1.3 | – | – | – | – | – | – | ◪ 45 | 0.15 | 1.0 |
| **RCMT 1204MOE-RM3** | **H07** | – | – | – | – | ◪ 65 | 0.54 | 1.8 | ■ 105 | 0.60 | 1.8 | – | – | – | – | – | – | – | – | – |
| | **T7325** | – | ◪ 165 | 0.60 | 1.8 | ◪ 125 | 0.54 | 1.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | – | ■ 150 | 0.60 | 1.8 | ◪ 90 | 0.54 | 1.8 | ■ 140 | 0.60 | 1.8 | – | – | – | – | – | – | ◪ 30 | 0.15 | 1.0 |
| | **T8430** | – | ■ 150 | 0.60 | 1.8 | ◪ 80 | 0.54 | 1.8 | ◪ 125 | 0.60 | 1.8 | – | – | – | – | – | – | ◪ 25 | 0.15 | 1.0 |
| | **T9315** | – | ■ 205 | 0.60 | 1.8 | – | – | – | ◪ 190 | 0.60 | 1.8 | – | – | – | – | – | – | ◪ 40 | 0.15 | 1.0 |
| **RCMT 1606MOE-RM3** | **T7325** | – | ◪ 160 | 0.65 | 2.0 | ◪ 120 | 0.59 | 2.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | – | ■ 145 | 0.65 | 2.0 | ◪ 85 | 0.59 | 2.0 | ■ 135 | 0.65 | 2.0 | – | – | – | – | – | – | ◪ 25 | 0.15 | 1.0 |
| | **T8430** | – | ■ 145 | 0.65 | 2.0 | ◪ 80 | 0.59 | 2.0 | ◪ 120 | 0.65 | 2.0 | – | – | – | – | – | – | ◪ 25 | 0.15 | 1.0 |
| | **T9315** | – | ■ 195 | 0.65 | 2.0 | – | – | – | ◪ 185 | 0.65 | 2.0 | – | – | – | – | – | – | ◪ 35 | 0.15 | 1.0 |
| **RCMT 2507MOE-RM3** | **H07** | – | – | – | – | ◪ 60 | 0.54 | 3.0 | ■ 95 | 0.60 | 3.0 | – | – | – | – | – | – | – | – | – |
|  |  | |  | | | | | | | | | | | | | | | | | |
| UR-geometri til finbearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | | | | |
| **RCMT 0602MOE-UR** | **T6310** | – | ■ 170 | 0.40 | 1.2 | ◪ 120 | 0.36 | 1.2 | ■ 135 | 0.40 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T7325** | – | ◪ 190 | 0.40 | 1.2 | ◪ 145 | 0.36 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | – | ■ 170 | 0.40 | 1.2 | ◪ 100 | 0.36 | 1.2 | ■ 160 | 0.40 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T8430** | – | ■ 180 | 0.40 | 1.2 | ◪ 95 | 0.36 | 1.2 | ◪ 145 | 0.40 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9315** | – | ■ 240 | 0.40 | 1.2 | – | – | – | ◪ 225 | 0.40 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9325** | – | ■ 215 | 0.40 | 1.2 | ◪ 125 | 0.36 | 1.2 | ◪ 200 | 0.40 | 1.2 | – | – | – | – | – | – | – | – | – |

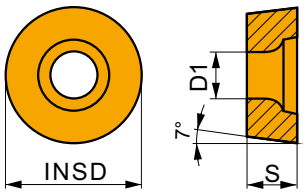
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | HFC E | | | | | | | | | | | | | | | | | |
| | | | UR-geometri til finbearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | |
| **RCMT 0803M0E-UR** | **T6310** | – | 160 | 0.45 | 1.6 | 115 | 0.41 | 1.6 | 125 | 0.45 | 1.6 | – | – | – | – | – | – | – | – | – |
| | **T7325** | – | 180 | 0.45 | 1.6 | 140 | 0.41 | 1.6 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | – | 160 | 0.45 | 1.6 | 95 | 0.41 | 1.6 | 150 | 0.45 | 1.6 | – | – | – | – | – | – | – | – | – |
| | **T8430** | – | 170 | 0.45 | 1.6 | 90 | 0.41 | 1.6 | 135 | 0.45 | 1.6 | – | – | – | – | – | – | – | – | – |
| | **T9315** | – | 220 | 0.45 | 1.6 | – | – | – | 205 | 0.45 | 1.6 | – | – | – | – | – | – | – | – | – |
| | **T9325** | – | 200 | 0.45 | 1.6 | 120 | 0.41 | 1.6 | 190 | 0.45 | 1.6 | – | – | – | – | – | – | – | – | – |
| **RCMT 10T3M0E-UR** | **T6310** | – | 160 | 0.50 | 1.4 | 115 | 0.45 | 1.4 | 125 | 0.50 | 1.4 | – | – | – | – | – | – | – | – | – |
| | **T7325** | – | 175 | 0.50 | 1.4 | 135 | 0.45 | 1.4 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | – | 160 | 0.50 | 1.4 | 95 | 0.45 | 1.4 | 150 | 0.50 | 1.4 | – | – | – | – | – | – | – | – | – |
| | **T8430** | – | 165 | 0.50 | 1.4 | 90 | 0.45 | 1.4 | 135 | 0.50 | 1.4 | – | – | – | – | – | – | – | – | – |
| | **T9315** | – | 215 | 0.50 | 1.4 | – | – | – | 200 | 0.50 | 1.4 | – | – | – | – | – | – | – | – | – |
| | **T9325** | – | 190 | 0.50 | 1.4 | 110 | 0.45 | 1.4 | 180 | 0.50 | 1.4 | – | – | – | – | – | – | – | – | – |
| **RCMT 1204M0E-UR** | **T6310** | – | 150 | 0.55 | 1.8 | 105 | 0.50 | 1.8 | 120 | 0.55 | 1.8 | – | – | – | – | – | – | – | – | – |
| | **T7325** | – | 165 | 0.55 | 1.8 | 125 | 0.50 | 1.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | – | 150 | 0.55 | 1.8 | 90 | 0.50 | 1.8 | 140 | 0.55 | 1.8 | – | – | – | – | – | – | – | – | – |
| | **T8430** | – | 145 | 0.55 | 1.8 | 80 | 0.50 | 1.8 | 120 | 0.55 | 1.8 | – | – | – | – | – | – | – | – | – |
| | **T9315** | – | 200 | 0.55 | 1.8 | – | – | – | 190 | 0.55 | 1.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | – | 180 | 0.55 | 1.8 | 105 | 0.50 | 1.8 | 170 | 0.55 | 1.8 | – | – | – | – | – | – | – | – | – |

# RCMW

PRAMET

| | INSD (mm) | D1 (mm) | S (mm) |
|---|---|---|---|
| 0602 | 6.0 | 2.80 | 2.38 |
| 0803 | 8.0 | 3.40 | 3.18 |
| 10T3 | 10.0 | 4.40 | 3.97 |
| 1204 | 12.0 | 4.40 | 4.76 |



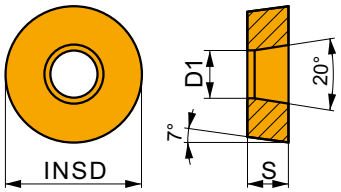

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | HFC E | | | | | | | | | | | | | | | | | |
| | | | Til fin til halv grov bearbejdning og kontinuerlig til let afbrudt snit. | | | | | | | | | | | | | | | | | |
| **RCMW 0602M0** | **T5305** | – | – | – | – | – | – | – | 280 | 0.25 | 0.6 | – | – | – | – | – | – | 55 | 0.15 | 1.0 |
| | **T5315** | – | – | – | – | – | – | – | 250 | 0.25 | 0.6 | – | – | – | – | – | – | 50 | 0.15 | 1.0 |
| **RCMW 0803M0** | **T5305** | – | – | – | – | – | – | – | 255 | 0.30 | 0.8 | – | – | – | – | – | – | 50 | 0.15 | 1.0 |
| | **T5315** | – | – | – | – | – | – | – | 230 | 0.30 | 0.8 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |
| **RCMW 10T3M0** | **T5305** | – | – | – | – | – | – | – | 225 | 0.40 | 1.0 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |
| | **T5315** | – | – | – | – | – | – | – | 200 | 0.40 | 1.0 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| **RCMW 1204M0** | **T5305** | – | – | – | – | – | – | – | 205 | 0.45 | 1.2 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| | **T5315** | – | – | – | – | – | – | – | 190 | 0.45 | 1.2 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |

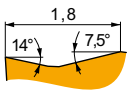
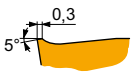
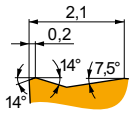
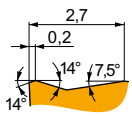
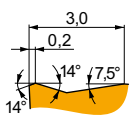
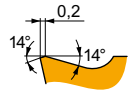
# RCMX

PRAMET

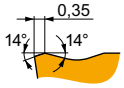
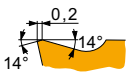
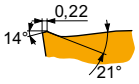
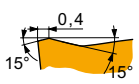
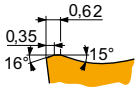
| | INSD (mm) | D1 (mm) | S (mm) |
|---|---|---|---|
| 1003 | 10.0 | 3.60 | 3.18 |
| 1204 | 12.0 | 4.20 | 4.76 |
| 1606 | 16.0 | 5.20 | 6.35 |
| 2006 | 20.0 | 6.50 | 6.35 |
| 2507 | 25.0 | 7.20 | 7.94 |
| 3209 | 32.0 | 9.50 | 9.53 |




Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | HFC E | | | | | | | | | | | | | | | | | |
| Geometri 31 til fin til halv grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **RCMX 1003MOS-31** | **T9325** | – | 165 | 0.50 | 2.0 | 95 | 0.45 | 2.0 | 155 | 0.50 | 2.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | – | 140 | 0.50 | 2.0 | 80 | 0.45 | 2.0 | – | – | – | – | – | – | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | HFC S | | | | | | | | | | | | | | | | | |
| Geometri 37 til semi-grov til tung-grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **RCMX 1606MOS-37** | **T9315** | – | 165 | 0.60 | 3.0 | – | – | – | 155 | 0.60 | 3.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | – | 145 | 0.60 | 3.0 | – | – | – | 135 | 0.60 | 3.0 | – | – | – | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | HFC S | | | | | | | | | | | | | | | | | |
| Geometri 321 til semi-grov til tung-grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **RCMX 1204MOS-321** | **T9315** | – | 130 | 1.00 | 3.0 | – | – | – | 120 | 1.00 | 3.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | – | 120 | 1.00 | 3.0 | – | – | – | 110 | 1.00 | 3.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | – | 105 | 1.00 | 3.0 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | HFC S | | | | | | | | | | | | | | | | | |
| Geometri 331 til semi-grov til tung-grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **RCMX 1606MOS-331** | **T9315** | – | 120 | 1.20 | 3.5 | – | – | – | 110 | 1.20 | 3.5 | – | – | – | – | – | – | – | – | – |
| | **T9325** | – | 105 | 1.20 | 3.5 | – | – | – | 95 | 1.20 | 3.5 | – | – | – | – | – | – | – | – | – |
| | **T9335** | – | 110 | 0.80 | 3.5 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | HFC S | | | | | | | | | | | | | | | | | |
| Geometri 341 til semi-grov til tung-grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **RCMX 2006MOS-341** | **6640** | – | 90 | 1.00 | 3.5 | – | – | – | 85 | 1.00 | 3.5 | – | – | – | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | HFC S | | | | | | | | | | | | | | | | | |
| Geometri 351 til semi-grov til tung-grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **RCMX 2507MOS-351** | **6640** | – | 60 | 1.00 | 3.5 | – | – | – | 55 | 1.00 | 3.5 | – | – | – | – | – | – | – | – | – |

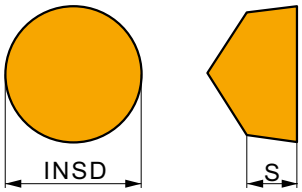
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |  | | HFC S | | | | | | | | | | | | | | | | | |
| | | | Geometri 361 til semi-grov til tung-grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **RCMX 3209M0S-361** | **6640** | – | ■ 50 | 1.40 | 4.5 | – | – | – | ■ 45 | 1.40 | 4.5 | – | – | – | – | – | – | – | – | – |
|  |  | | HFC S | | | | | | | | | | | | | | | | | |
| | | | RF1-geometri til fin til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **RCMX 2006M0-RF1** | **T5305** | – | ◪ 105 | 0.80 | 3.5 | – | – | – | ◪ 95 | 0.80 | 3.5 | – | – | – | – | – | – | – | – | – |
| | **T9310** | – | ■ 105 | 0.80 | 3.5 | – | – | – | ◪ 95 | 0.80 | 3.5 | – | – | – | – | – | – | – | – | – |
| | **T9315** | – | ■ 100 | 0.80 | 3.5 | – | – | – | ◪ 95 | 0.80 | 3.5 | – | – | – | – | – | – | – | – | – |
| | **T9325** | – | ■ 90 | 0.80 | 3.5 | – | – | – | ◪ 85 | 0.80 | 3.5 | – | – | – | – | – | – | – | – | – |
| | **T9335** | – | ■ 110 | 0.80 | 3.5 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **RCMX 2507M0-RF1** | **T8345** | – | ■ 45 | 1.00 | 3.5 | – | – | – | ◪ 40 | 1.00 | 3.5 | – | – | – | – | – | – | – | – | – |
| | **T9310** | – | ■ 95 | 1.00 | 3.5 | – | – | – | ◪ 90 | 1.00 | 3.5 | – | – | – | – | – | – | – | – | – |
| | **T9315** | – | ■ 90 | 1.00 | 3.5 | – | – | – | ◪ 85 | 1.00 | 3.5 | – | – | – | – | – | – | – | – | – |
| | **T9325** | – | ■ 80 | 1.00 | 3.5 | – | – | – | ◪ 75 | 1.00 | 3.5 | – | – | – | – | – | – | – | – | – |
| | **T9335** | – | ■ 65 | 1.00 | 3.5 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
|  |  | | HFC S | | | | | | | | | | | | | | | | | |
| | | | RM1-geometri til fin til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **RCMX 2006M0-RM1** | **T9310** | – | ■ 95 | 1.00 | 3.5 | – | – | – | ◪ 90 | 1.00 | 3.5 | – | – | – | – | – | – | – | – | – |
| | **T9315** | – | ■ 90 | 1.00 | 3.5 | – | – | – | ◪ 85 | 1.00 | 3.5 | – | – | – | – | – | – | – | – | – |
| | **T9325** | – | ■ 80 | 1.00 | 3.5 | – | – | – | ◪ 75 | 1.00 | 3.5 | – | – | – | – | – | – | – | – | – |
| | **T9335** | – | ■ 125 | 0.60 | 3.0 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **RCMX 2507M0-RM1** | **T9310** | – | ■ 95 | 1.00 | 3.5 | – | – | – | ◪ 90 | 1.00 | 3.5 | – | – | – | – | – | – | – | – | – |
| | **T9315** | – | ■ 90 | 1.00 | 3.5 | – | – | – | ◪ 85 | 1.00 | 3.5 | – | – | – | – | – | – | – | – | – |
| | **T9325** | – | ■ 80 | 1.00 | 3.5 | – | – | – | ◪ 75 | 1.00 | 3.5 | – | – | – | – | – | – | – | – | – |
| | **T9335** | – | ■ 80 | 0.60 | 3.0 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
|  |  | | HFC S | | | | | | | | | | | | | | | | | |
| | | | RM2-geometri til semi-grov til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **RCMX 2507M0-RM2** | **T9310** | – | ■ 90 | 1.10 | 3.5 | – | – | – | ◪ 85 | 1.10 | 3.5 | – | – | – | – | – | – | – | – | – |
| | **T9315** | – | ■ 85 | 1.10 | 3.5 | – | – | – | ◪ 80 | 1.10 | 3.5 | – | – | – | – | – | – | – | – | – |
| | **T9325** | – | ■ 75 | 1.10 | 3.5 | – | – | – | ◪ 70 | 1.10 | 3.5 | – | – | – | – | – | – | – | – | – |
| **RCMX 3209M0-RM2** | **T5315** | – | ◪ 95 | 1.00 | 4.5 | – | – | – | ◪ 90 | 1.00 | 4.5 | – | – | – | – | – | – | – | – | – |
| | **T9310** | – | ■ 90 | 1.00 | 4.5 | – | – | – | ◪ 85 | 1.00 | 4.5 | – | – | – | – | – | – | – | – | – |
| | **T9315** | – | ■ 85 | 1.00 | 4.5 | – | – | – | ◪ 80 | 1.00 | 4.5 | – | – | – | – | – | – | – | – | – |
| | **T9325** | – | ■ 75 | 1.00 | 4.5 | – | – | – | ◪ 70 | 1.00 | 4.5 | – | – | – | – | – | – | – | – | – |
| | **T9335** | – | ■ 55 | 1.40 | 4.5 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
|  |  | | HFC P | | | | | | | | | | | | | | | | | |
| | | | RR2 geometri til kraftig hård bearbejdning og kontinuerlige til afbrudte snit. | | | | | | | | | | | | | | | | | |
| **RCMX 3209M0-RR2** | **T9315** | – | ■ 60 | 1.40 | 4.5 | – | – | – | ◪ 55 | 1.40 | 4.5 | – | – | – | – | – | – | ◪ 10 | 0.15 | 1.0 |
| | **T9316** | – | ■ 60 | 1.40 | 4.5 | – | – | – | ◪ 55 | 1.40 | 4.5 | – | – | – | – | – | – | – | – | – |

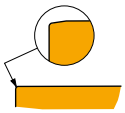
# RCGX CER

PRAMET

| | INSD (mm) | S (mm) |
|---|---|---|
| 0606 | 6.350 | 6.35 |
| 0907 | 9.525 | 7.94 |
| 1207 | 12.700 | 7.94 |




Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | HSC | | K | | | | | | | | | | | | | | | |
| | | | Til bearbejdning med høje hastigheder og kontinuerlige snit. | | | | | | | | | | | | | | | | | |
| **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 | – | – | – | – | – | – | – | – | – |

# PRDCN EXT

P M K N S H

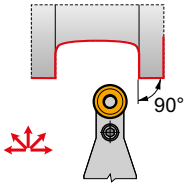
PRAMET

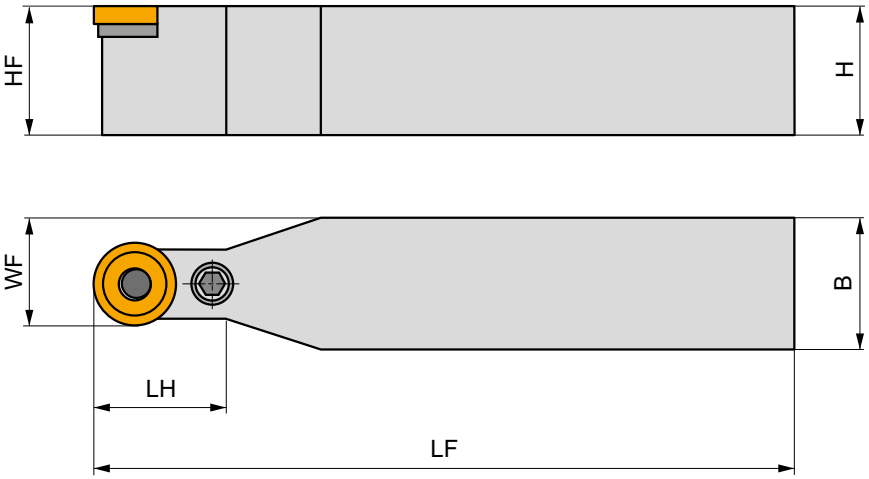
P

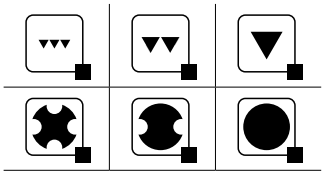


## Holder til værktøjsholder til ekstern brug til rund RC .. Skær

Ekstern neutral værktøjsholder til låseværktøj til positiv RC .. 16 op til 32 skær. Velegnet til udvendigt ende og langsgående drejning uden skulder, kopidrejning op til 90 °, konisk drejning og affasning. Fås med skaftstørrelse 32x25 op til 50x50 mm. Krop behandlet for længere levetid





| | 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 | 32 | 0 | 0 | 0.80 | GI090 | PRP70 |
| | **PRDCN 3232 P 20** | 32 | 32 | 32 | 26 | 170 | 32 | 0 | 0 | 1.30 | GI069 | PRP90 |
| | **PRDCN 4040 S 20** | 40 | 40 | 40 | 30 | 250 | 40 | 0 | 0 | 3.10 | GI069 | PRP90 |
| | **PRDCN 4040 S 25** | 40 | 40 | 40 | 32.5 | 250 | 40 | 0 | 0 | 3.20 | GI122 | PRP80 |
| | **PRDCN 5050 S 32** | 50 | 50 | 50 | 41 | 250 | 50 | 0 | 0 | 3.50 | GI096 | PRP32 |
| | **PRDCN 5050 T 32** | 50 | 50 | 50 | 41 | 300 | 50 | 0 | 0 | 5.12 | GI096 | PRP32 |

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

| | | | | Nm | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| PRP32 | RCU 320600 | PU 10 | US 47 | 8.0 | M 12x1 | 36 | NT 08 | MT 08 | HXK 5 |
| PRP70 | RCU 160300 | PU 07 | US 36 | 6.0 | M 8x1 | 26 | NT 05 | MT 05 | HXK 4 |
| PRP80 | RCU 250600 | PU 08 | US 38 | 8.0 | M 10x1 | 29 | NT 06 | MT 06 | HXK 5 |
| PRP90 | RCU 200400 | PU 09 | US 36 | 6.0 | M 8x1 | 26 | NT 07 | MT 07 | HXK 4 |

# PRSC(RL) EXT

P M K N S H

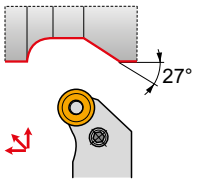
PRAMET

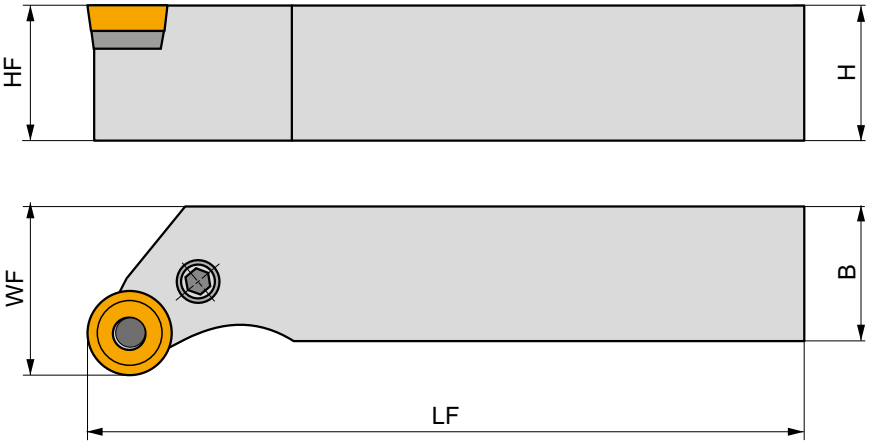
P

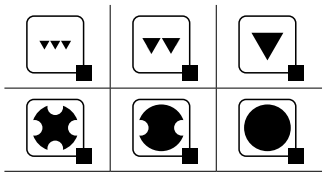


## Ekstern Lever Lock Drejeholder til runde RC .. Skær

Ekstern højre / venstre hånd værktøjsholder til positiv RC .. 16 op til 25 skær. Velegnet til udvendigt ende og langsgående drejning uden skulder, kopidrejning op til 27 °, konisk drejning, inklusive endekopiering. Fås med skaftstørrelse 32x25 op til 40x40 mm. Krop behandlet for længere levetid





| | 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 | 0.90 | GI090 | PRP70 |
| | PRSCR 4040 R 16 | 40 | 40 | 40 | 50 | 200 | 0 | 0 | 2.38 | GI090 | PRP70 |
| | PRSCR 3232 P 20 | 32 | 32 | 32 | 40 | 170 | 0 | 0 | 1.40 | GI069 | PRP90 |
| | PRSCR 4040 S 25 | 40 | 40 | 40 | 50 | 250 | 0 | 0 | 3.40 | GI122 | PRP80 |
| L | PRSCL 3225 P 16 | 32 | 25 | 32 | 32 | 170 | 0 | 0 | 0.90 | GI090 | PRP70 |
| | PRSCL 4040 R 16 | 40 | 40 | 40 | 50 | 200 | 0 | 0 | 2.38 | GI090 | PRP70 |
| | PRSCL 3232 P 20 | 32 | 32 | 32 | 40 | 170 | 0 | 0 | 1.32 | GI069 | PRP90 |
| | PRSCL 4040 S 25 | 40 | 40 | 40 | 50 | 250 | 0 | 0 | 3.40 | GI122 | PRP80 |

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

| | | | | Nm | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| PRP70 | RCU 160300 | PU 07 | US 36 | 6.0 | M 8x1 | 26 | NT 05 | MT 05 | HXK 4 |
| PRP80 | RCU 250600 | PU 08 | US 38 | 8.0 | M 10x1 | 29 | NT 06 | MT 06 | HXK 5 |
| PRP90 | RCU 200400 | PU 09 | US 36 | 6.0 | M 8x1 | 26 | NT 07 | MT 07 | HXK 4 |

# SRDC(RL) EXT

P M K N S H

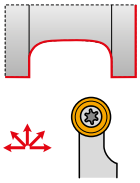
PRAMET

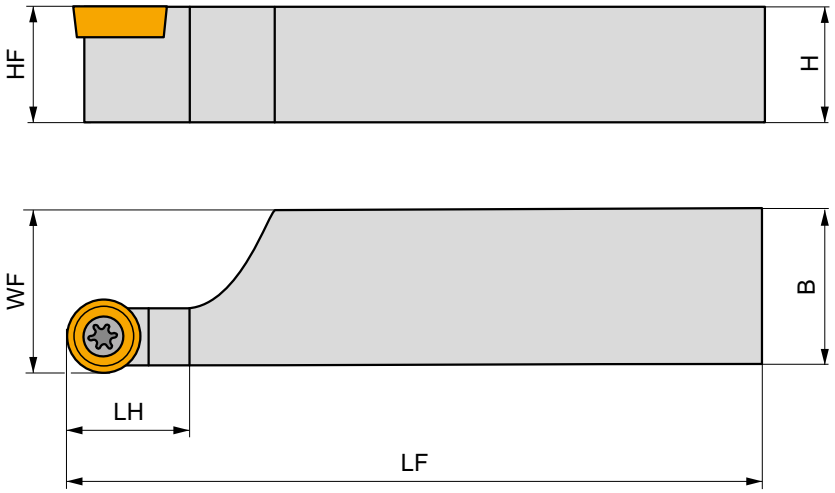
S

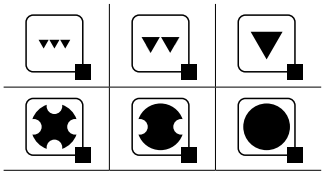


## Ekstern skruelåsværktøjsholder til rund RC .. skær

Ekstern højre / venstre værktøjsholder til skruetype positiv RC .. 08 skær. Velegnet til udvendigt ende og langsgående drejning uden skulder, tilspidsning og affasning. Fås med skaftstørrelse 20x20 op til 32x25 mm. Krop behandlet for længere værktøjslevetid.







| | 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 | 0.36 | GI051 | SR21 |
| | SRDCR 2525 M 08-A | 25 | 25 | 25 | 25.5 | 150 | 20 | 0 | 0 | 0.66 | GI051 | SR21 |
| | SRDCR 3225 P 08-A | 32 | 25 | 32 | 25.5 | 170 | 20 | 0 | 0 | 0.95 | GI051 | SR21 |
| L | SRDCL 2020 K 08-A | 20 | 20 | 20 | 20.5 | 125 | 20 | 0 | 0 | 0.37 | GI051 | SR21 |
| | SRDCL 2525 M 08-A | 25 | 25 | 25 | 25.5 | 150 | 20 | 0 | 0 | 0.66 | GI051 | SR21 |
| | SRDCL 3225 P 08-A | 32 | 25 | 32 | 25.5 | 170 | 20 | 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

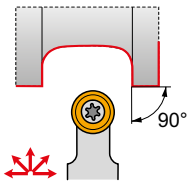
PRAMET

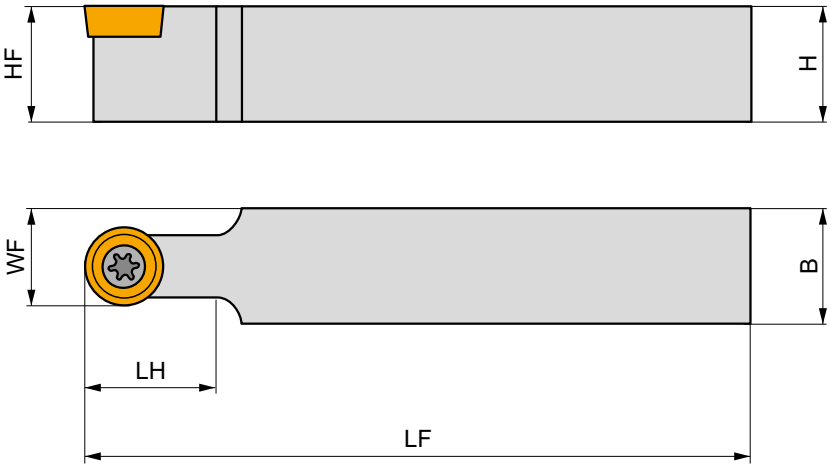
S

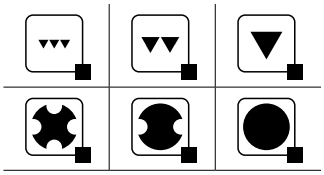


## Ekstern skruelåsværktøjsholder til rund RC .. Skær

Ekstern neutral værktøjsholder til skruetype positiv RC .. 06 op til 16 skær. Velegnet til udvendigt ende og langsgående drejning uden skulder, kopi, tilspidsning og affasning. Fås med skaftstørrelse 12x12 op til 32x25 mm. Krop behandlet for længere levetid





| | Product | H (mm) | B (mm) | HF (mm) | WF (mm) | LF (mm) | LH (mm) | LAMS (°) | GAMO (°) | kg | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| N | **SRDCN 1212 F 06** | 12 | 12 | 12 | 9 | 80 | 12 | 0 | 0 | 0.10 | GI054 | S01 |
| | **SRDCN 1616 H 06** | 16 | 16 | 16 | 11 | 100 | 12 | 0 | 0 | 0.20 | GI054 | S01 |
| | **SRDCN 2020 K 08** | 20 | 20 | 20 | 14 | 125 | 20 | 0 | 0 | 0.38 | GI051 | S03 |
| | **SRDCN 2020 K 1003-M-A** | 20 | 20 | 20 | 15 | 125 | 25 | 0 | 0 | 0.40 | GI064 | SR10 |
| | **SRDCN 2020 K 10-M-A** | 20 | 20 | 20 | 15 | 125 | 25 | 0 | 0 | 0.40 | GI013 | SR10 |
| | **SRDCN 2525 M 10-M-A** | 25 | 25 | 25 | 17.5 | 150 | 25 | 0 | 0 | 0.68 | GI013 | SR10 |
| | **SRDCN 2525 M 12-M-A** | 25 | 25 | 25 | 18.5 | 150 | 30 | 0 | 0 | 0.68 | GI014 | SR12 |
| | **SRDCN 3225 P 10-M** | 32 | 25 | 32 | 17.5 | 170 | 25 | 0 | 0 | 0.90 | GI013 | SR10 |
| | **SRDCN 3225 P 12-M** | 32 | 25 | 32 | 18.5 | 170 | 30 | 0 | 0 | 0.90 | GI014 | SR12 |
| | **SRDCN 3225 P 16-M** | 32 | 25 | 32 | 20.5 | 170 | 32 | 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

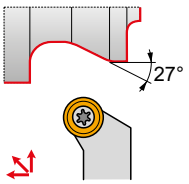
PRAMET

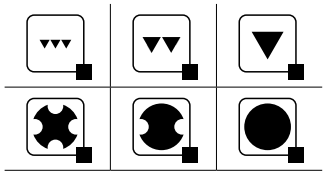
S

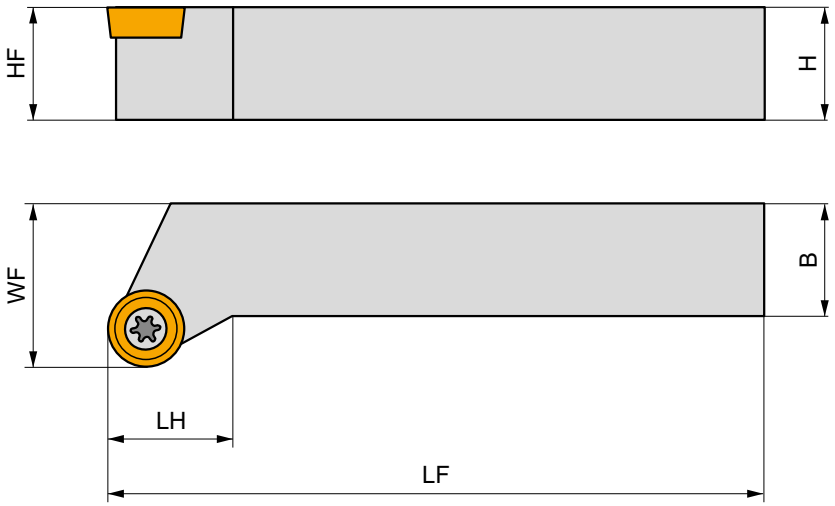


## Ekstern skruelåsværktøjsholder til rund RC .. skær

Ekstern højre / venstre værktøjsholder til skruetype positiv RC .. 06 op til 16 skær. Velegnet til udvendigt ende og langsgående drejning uden skulder, kopi, tilspidsning og affasning. Fås med skaftstørrelse 12x12 op til 32x25 mm. Krop behandlet for længere værktøjslevetid.








| | Product | H (mm) | B (mm) | HF (mm) | WF (mm) | LF (mm) | LH (mm) | LAMS (°) | GAMO (°) | kg | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| R | SRSCR 1212 F 06 | 12 | 12 | 12 | 16 | 80 | 12 | 0 | 0 | 0.09 | GI054 | S01 |
| | SRSCR 1616 H 06 | 16 | 16 | 16 | 20 | 100 | 12 | 0 | 0 | 0.22 | GI054 | S01 |
| | SRSCR 2020 K 08 | 20 | 20 | 20 | 25 | 125 | 20 | 0 | 0 | 0.45 | GI051 | S03 |
| | SRSCR 2020 K 10-M-A | 20 | 20 | 20 | 25 | 125 | 20 | 0 | 0 | 0.45 | GI013 | SR10 |
| | SRSCR 2525 M 10-M-A | 25 | 25 | 25 | 32 | 150 | 20 | 0 | 0 | 0.75 | GI013 | SR10 |
| | SRSCR 3225 P 10-M | 32 | 25 | 32 | 32 | 170 | 20 | 0 | 0 | 1.06 | GI013 | SR10 |
| | SRSCR 2525 M 12-M-A | 25 | 25 | 25 | 32 | 150 | 20 | 0 | 0 | 0.75 | GI014 | SR12 |
| | SRSCR 3225 P 12-M | 32 | 25 | 32 | 32 | 170 | 20 | 0 | 0 | 1.07 | GI014 | SR12 |
| | SRSCR 3225 P 16-M | 32 | 25 | 32 | 32 | 170 | 20 | 0 | 0 | 1.10 | GI161 | SR16 |
| L | SRSCL 1212 F 06 | 12 | 12 | 12 | 16 | 80 | 12 | 0 | 0 | 0.10 | GI054 | S01 |
| | SRSCL 1616 H 06 | 16 | 16 | 16 | 20 | 100 | 12 | 0 | 0 | 0.22 | GI054 | S01 |
| | SRSCL 2020 K 08 | 20 | 20 | 20 | 25 | 125 | 20 | 0 | 0 | 0.45 | GI051 | S03 |
| | SRSCL 2020 K 10-M-A | 20 | 20 | 20 | 25 | 125 | 20 | 0 | 0 | 0.45 | GI013 | SR10 |
| | SRSCL 2525 M 10-M-A | 25 | 25 | 25 | 32 | 150 | 20 | 0 | 0 | 0.75 | GI013 | SR10 |
| | SRSCL 3225 P 10-M | 32 | 25 | 32 | 32 | 170 | 20 | 0 | 0 | 1.06 | GI013 | SR10 |
| | SRSCL 2525 M 12-M-A | 25 | 25 | 25 | 32 | 150 | 20 | 0 | 0 | 0.75 | GI014 | SR12 |
| | SRSCL 3225 P 12-M | 32 | 25 | 32 | 32 | 170 | 20 | 0 | 0 | 1.07 | GI014 | SR12 |
| | SRSCL 3225 P 16-M | 32 | 25 | 32 | 32 | 170 | 20 | 0 | 0 | 1.10 | GI161 | SR16 |

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

|  |  |  |  |  |  |  |  |  |
|---|---|---|---|---|---|---|---|---|
| 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 |

NEW

# C.-SRDCN EXT

P M K N S H

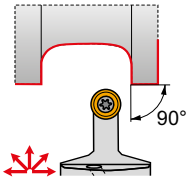
PRAMET

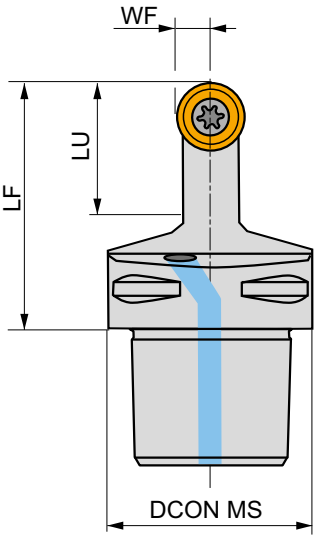
S

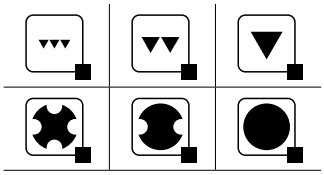


## Eksternt PSC Quick Change Tool, skruelås til RC .. Skær

Eksternt neutralt værktøj indvendig kølevæske til skruetype positiv RC .. 10 op til 12 skær. Velegnet til udvendigt ende og langsgående drejning uden skulder, kopi, tilspidsning og affasning. Fås med PSC (Polygon Shank Coupling) størrelse C4 og C5. Krop behandlet for længere levetid





| | 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)

P M K

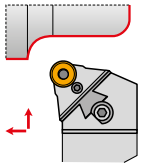
PRAMET

P

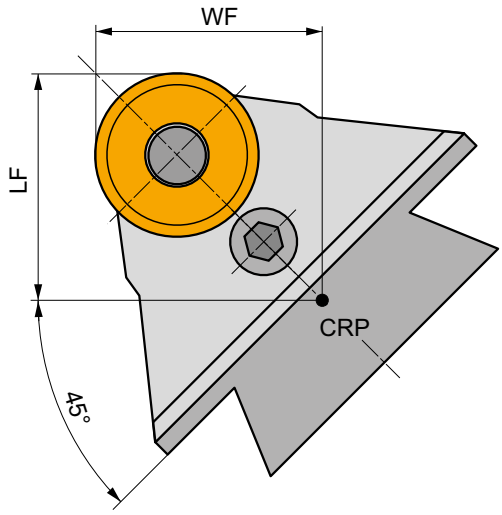


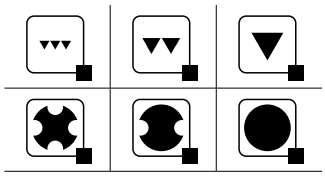
## Modulær KHP-drejekassette til RC .. skær

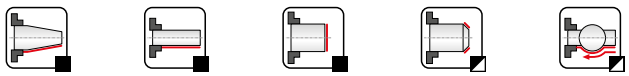
Drejeholder højre / venstre håndlås drejepatron til montering på DKH værktøjsholderskaft. Velegnet til kraftig langsgående drejning uden hjørne, plandrejning, tilspidsning og affasning med positiv RC .. 20 op til 32 skær. Værktøjsholder behandlet for længere værktøjslevetid.



DKHR+KHP-RSCR





| | Product | WF (mm) | LF (mm) | LAMS (°) | GAMO (°) | kg | | |
|---|---|---|---|---|---|---|---|---|
| R | **KHP-RSCR 20** | 35 | 45 | 0 | 0 | 1.25 | GI069 | PRP90 |
| | **KHP-RSCR 25** | 35 | 45 | 0 | 0 | 1.30 | GI122 | PRP80 |
| | **KHP-RSCR 32** | 35 | 45 | 0 | 0 | 1.30 | GI096 | PRP32 |
| | **KHP-RSCL 20** | 35 | 45 | 0 | 0 | 1.30 | GI069 | PRP90 |
| | **KHP-RSCL 25** | 35 | 45 | 0 | 0 | 1.30 | GI122 | PRP80 |
| | **KHP-RSCL 32** | 35 | 45 | 0 | 0 | 1.30 | GI096 | PRP32 |

| | |
|---|---|
| GI069 | RCMX 2006M0 |
| GI096 | RCMX 3209M0 |
| GI122 | RCMX 2507M0 |

| | | | | Nm | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| PRP32 | RCU 320600 | PU 10 | US 47 | 8.0 | M 12x1 | 36 | NT 08 | MT 08 | HXK 5 |
| PRP80 | RCU 250600 | PU 08 | US 38 | 8.0 | M 10x1 | 29 | NT 06 | MT 06 | HXK 5 |
| PRP90 | RCU 200400 | PU 09 | US 36 | 6.0 | M 8x1 | 26 | NT 07 | MT 07 | HXK 4 |

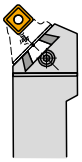
# DKH(RL)

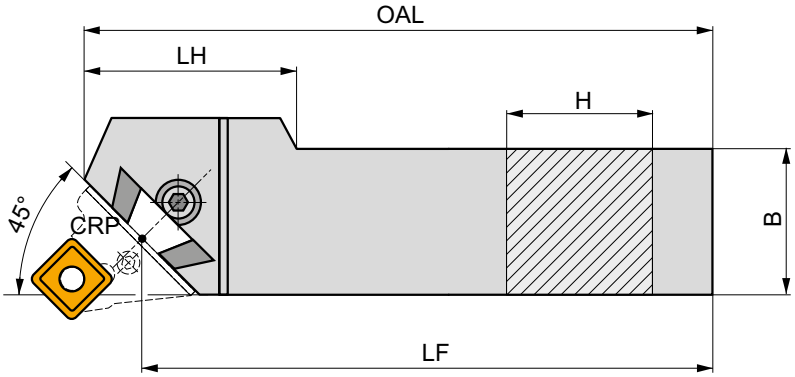
PRAMET

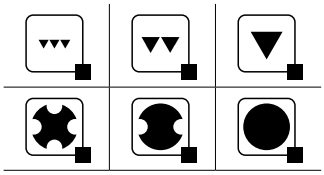


## Eksternt værktøjsholderskaft til KHP / KHS tung drejening

Drejeholder højre / venstre modulære værktøjsskaft til KHP / KHS patroner. Velegnet til tunge drejeprogrammer. Fås med skaftstørrelse 40x50 op til 60x80 mm. Krop behandlet for længere levetid





| | Product | H (mm) | B (mm) | LF (mm) | OAL (mm) | LH (mm) | kg | | |
|---|---|---|---|---|---|---|---|---|---|
| R | **DKHR 4050 V** | 40 | 50 | 400 | 425 | 100 | 7.10 | GI098 | DKH10 |
| | **DKHR 5060 W** | 50 | 60 | 450 | 475 | 110 | 11.30 | GI098 | DKH10 |
| | **DKHR 6080 W-A** | 60 | 80 | 450 | 485 | 90 | 19.65 | GI098 | DKH10 |
| L | **DKHL 4050 V** | 40 | 50 | 400 | 425 | 100 | 7.10 | GI098 | DKH10 |
| | **DKHL 5060 W** | 50 | 60 | 450 | 475 | 110 | 11.30 | GI098 | DKH10 |
| | **DKHL 6080 W-A** | 60 | 80 | 450 | 485 | 90 | 19.28 | GI098 | DKH10 |

| | | |
|---|---|---|
| GI098 | KHP | KHS |

| | | |
|---|---|---|
| DKH10 | SR 14 | HXK 10 |

# SC

09/ 12/ 25/ 38

## CARBIDE INSERTS

**SCGT**



134

**SCMT**



135

**SCMW**



138

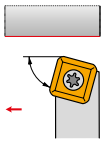
**MATCH THE RIGHT SIZE (example)**

| Insert | Tool Holder |
|---|---|
| SCMT 120408E-RM | SSDCN 2020 K 12-M-A |

## ISO-DREJNING – UDVENDIGT

### SSBC(RL) EXT

75°



SC..

09
12
25
38

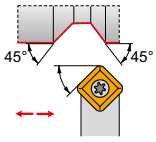
12×12
60×60

139

134 – 138

### SSDCN EXT

45°




SC..

09
12

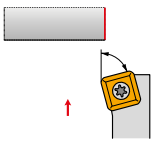
12×12
25×25

140

134 – 138

### SSKC(RL) EXT

75°



SC..

09
12

12×12
25×25

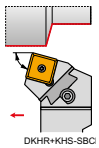
141

134 – 138

## ISO-DREJNING – GROVBEARBEJDNING UDVENDIGT

### KHS-SBCR + DKH(RL)

75°




SC..

25
38

40×50
60×80

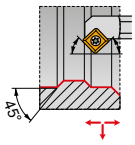
142, 143

134 – 138

## ISO-DREJNING – INDVENDIG

### SSSC(RL) INT

45°




SC..

09




25
32

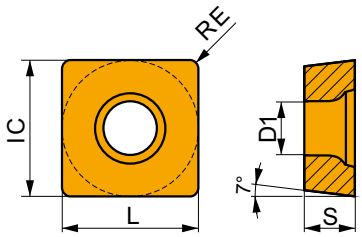
144

134 – 138

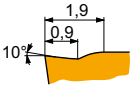
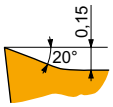
# SCGT

PRAMET

| | IC (mm) | D1 (mm) | L (mm) | S (mm) |
|---|---|---|---|---|
| 09T3 | 9.525 | 4.40 | 9.53 | 3.97 |
| 09T3-SF3 | 9.525 | 4.40 | 9.53 | 4.22 |
| 1204 | 12.700 | 5.50 | 12.70 | 4.76 |



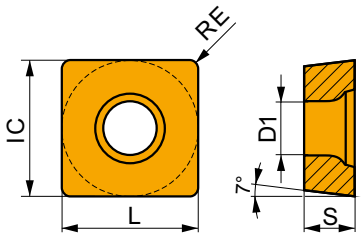

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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-geometri med meget positivt design til fin-finish til grov bearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | | | | |
| **SCGT 120408F-AL** | **HF7** | 0.8 | – | – | – | – | – | – | – | – | – | ■ 315 | 0.48 | 2.0 | – | – | – | – | – | – |
| | **T0315** | 0.8 | – | – | – | – | – | – | – | – | – | ■ 465 | 0.48 | 2.0 | – | – | – | – | – | – |
|  |  | |  | | | | | | | | | | | | | | | | | |
| NF1-geometri med positivt design til finbearbejdning til medium bearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **SCGT 09T308E-NF1** | **H07** | 0.8 | – | – | – | ◪ 100 | 0.13 | 1.2 | – | – | – | ◪ 510 | 0.17 | 1.2 | ■ 50 | 0.13 | 1.0 | – | – | – |
| | **T6310** | 0.8 | ■ 200 | 0.14 | 1.2 | ■ 140 | 0.13 | 1.2 | – | – | – | ◪ 600 | 0.17 | 1.2 | ■ 60 | 0.13 | 1.0 | ◪ 40 | 0.15 | 1.0 |
| | **T7325** | 0.8 | ◪ 225 | 0.14 | 1.2 | ■ 175 | 0.13 | 1.2 | – | – | – | – | – | – | ■ 70 | 0.13 | 1.0 | – | – | – |
| **SCGT 120408E-NF1** | **H07** | 0.8 | – | – | – | ◪ 90 | 0.16 | 1.4 | – | – | – | ◪ 455 | 0.22 | 1.4 | ■ 45 | 0.16 | 1.1 | – | – | – |
| | **T6310** | 0.8 | ■ 180 | 0.18 | 1.4 | ■ 125 | 0.16 | 1.4 | – | – | – | ◪ 540 | 0.22 | 1.4 | ■ 50 | 0.16 | 1.1 | ◪ 35 | 0.15 | 1.0 |
| | **T7325** | 0.8 | ◪ 205 | 0.18 | 1.4 | ■ 155 | 0.16 | 1.4 | – | – | – | – | – | – | ■ 65 | 0.16 | 1.1 | – | – | – |
|  |  | |  | | | | | | | | | | | | | | | | | |
| SF3-geometri med meget positivt design til finbearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **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 | – | – | – |
| | **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 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| **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 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |

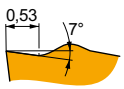
# SCMT

PRAMET

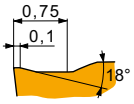
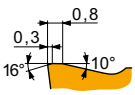
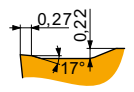
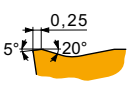
| | IC (mm) | D1 (mm) | L (mm) | S (mm) |
|---|---|---|---|---|
| 09T3 | 9.525 | 4.40 | 9.53 | 3.97 |
| 1204 | 12.700 | 5.50 | 12.70 | 4.76 |
| 2509 | 25.400 | 8.70 | 25.40 | 9.53 |
| 3809 | 38.100 | 8.70 | 38.10 | 9.53 |



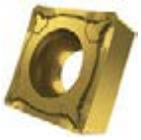
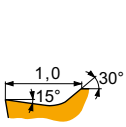
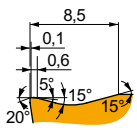
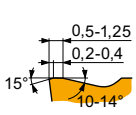
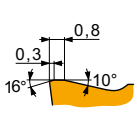

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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-geometri med positivt design for finbearbejdning til færdigbearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | | | | |
| **SCMT 09T304E-FF2** | **T8430** | 0.4 | 210 | 0.12 | 1.2 | – | – | – | 175 | 0.12 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 260 | 0.12 | 1.2 | – | – | – | 245 | 0.12 | 1.2 | – | – | – | – | – | – | – | – | – |
| **SCMT 09T308E-FF2** | **T8330** | 0.8 | 185 | 0.17 | 1.2 | – | – | – | 175 | 0.17 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.8 | 220 | 0.17 | 1.2 | – | – | – | 180 | 0.17 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 265 | 0.17 | 1.2 | – | – | – | 250 | 0.17 | 1.2 | – | – | – | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| FM-geometri til fin til halv grov bearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | | | | |
| **SCMT 09T304E-FM** | **T7325** | 0.4 | 205 | 0.15 | 1.2 | 155 | 0.15 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 0.4 | 200 | 0.15 | 1.2 | 155 | 0.15 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.4 | 190 | 0.15 | 1.2 | 110 | 0.14 | 1.2 | 180 | 0.15 | 1.2 | 570 | 0.18 | 1.2 | – | – | – | – | – | – |
| | **T8330** | 0.4 | 180 | 0.15 | 1.2 | 105 | 0.14 | 1.2 | 170 | 0.15 | 1.2 | 540 | 0.18 | 1.2 | – | – | – | – | – | – |
| | **T8430** | 0.4 | 210 | 0.15 | 1.2 | 115 | 0.14 | 1.2 | 175 | 0.15 | 1.2 | 585 | 0.18 | 1.2 | – | – | – | – | – | – |
| | **T9315** | 0.4 | 290 | 0.15 | 1.2 | – | – | – | 275 | 0.15 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 260 | 0.15 | 1.2 | 155 | 0.15 | 1.2 | 245 | 0.15 | 1.2 | – | – | – | – | – | – | – | – | – |
| **SCMT 09T308E-FM** | **T7325** | 0.8 | 225 | 0.20 | 1.2 | 175 | 0.18 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 0.8 | 215 | 0.20 | 1.2 | 165 | 0.18 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.8 | 205 | 0.20 | 1.2 | 120 | 0.18 | 1.2 | 190 | 0.20 | 1.2 | 615 | 0.24 | 1.2 | – | – | – | – | – | – |
| | **T8330** | 0.8 | 195 | 0.20 | 1.2 | 115 | 0.18 | 1.2 | 185 | 0.20 | 1.2 | 585 | 0.24 | 1.2 | – | – | – | – | – | – |
| | **T8430** | 0.8 | 225 | 0.20 | 1.2 | 120 | 0.18 | 1.2 | 185 | 0.20 | 1.2 | 615 | 0.24 | 1.2 | – | – | – | – | – | – |
| | **T9315** | 0.8 | 305 | 0.20 | 1.2 | – | – | – | 285 | 0.20 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 275 | 0.20 | 1.2 | 165 | 0.18 | 1.2 | 260 | 0.20 | 1.2 | – | – | – | – | – | – | – | – | – |
| **SCMT 120404E-FM** | **T7325** | 0.4 | 195 | 0.15 | 1.6 | 150 | 0.15 | 1.6 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.4 | 185 | 0.15 | 1.6 | 110 | 0.14 | 1.6 | 175 | 0.15 | 1.6 | 555 | 0.18 | 1.6 | – | – | – | – | – | – |
| | **T8330** | 0.4 | 170 | 0.15 | 1.6 | 100 | 0.14 | 1.6 | 160 | 0.15 | 1.6 | 510 | 0.18 | 1.6 | – | – | – | – | – | – |
| | **T8430** | 0.4 | 205 | 0.15 | 1.6 | 110 | 0.14 | 1.6 | 170 | 0.15 | 1.6 | 570 | 0.18 | 1.6 | – | – | – | – | – | – |
| | **T9315** | 0.4 | 280 | 0.15 | 1.6 | – | – | – | 265 | 0.15 | 1.6 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 250 | 0.15 | 1.6 | 150 | 0.15 | 1.6 | 235 | 0.15 | 1.6 | – | – | – | – | – | – | – | – | – |
| **SCMT 120408E-FM** | **T7325** | 0.8 | 215 | 0.20 | 1.6 | 165 | 0.18 | 1.6 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 0.8 | 210 | 0.20 | 1.6 | 160 | 0.18 | 1.6 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.8 | 200 | 0.20 | 1.6 | 120 | 0.18 | 1.6 | 190 | 0.20 | 1.6 | 600 | 0.24 | 1.6 | – | – | – | – | – | – |
| | **T8330** | 0.8 | 190 | 0.20 | 1.6 | 110 | 0.18 | 1.6 | 180 | 0.20 | 1.6 | 570 | 0.24 | 1.6 | – | – | – | – | – | – |
| | **T8430** | 0.8 | 220 | 0.20 | 1.6 | 120 | 0.18 | 1.6 | 180 | 0.20 | 1.6 | 600 | 0.24 | 1.6 | – | – | – | – | – | – |
| | **T9315** | 0.8 | 300 | 0.20 | 1.6 | – | – | – | 285 | 0.20 | 1.6 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 265 | 0.20 | 1.6 | 155 | 0.18 | 1.6 | 250 | 0.20 | 1.6 | – | – | – | – | – | – | – | – | – |
| **SCMT 120412E-FM** | **T7325** | 1.2 | 210 | 0.27 | 1.6 | 160 | 0.24 | 1.6 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 1.2 | 185 | 0.27 | 1.6 | 110 | 0.24 | 1.6 | 175 | 0.27 | 1.6 | 555 | 0.32 | 1.6 | – | – | – | – | – | – |
| | **T8430** | 1.2 | 200 | 0.27 | 1.6 | 110 | 0.24 | 1.6 | 165 | 0.27 | 1.6 | 555 | 0.32 | 1.6 | – | – | – | – | – | – |
| | **T9315** | 1.2 | 275 | 0.27 | 1.6 | – | – | – | 260 | 0.27 | 1.6 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | 245 | 0.27 | 1.6 | 145 | 0.24 | 1.6 | 230 | 0.27 | 1.6 | – | – | – | – | – | – | – | – | – |

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | FM2 geometri til fin til medium bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **SCMT 09T304E-FM2** | **T7325** | 0.4 | ◩ 200 | 0.12 | 1.0 | ◩ 155 | 0.11 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.4 | ■ 220 | 0.12 | 1.0 | ◩ 120 | 0.11 | 1.0 | ◩ 180 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | ■ 265 | 0.12 | 1.0 | ◩ 155 | 0.11 | 1.0 | ◩ 250 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| **SCMT 09T308E-FM2** | **T8330** | 0.8 | ■ 190 | 0.17 | 1.0 | ◩ 110 | 0.15 | 1.0 | ■ 180 | 0.17 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.8 | ■ 225 | 0.17 | 1.0 | ◩ 120 | 0.15 | 1.0 | ◩ 185 | 0.17 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.8 | ■ 305 | 0.17 | 1.0 | – | – | – | ◩ 285 | 0.17 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | ■ 270 | 0.17 | 1.0 | ◩ 160 | 0.15 | 1.0 | ◩ 255 | 0.17 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.8 | ■ 235 | 0.17 | 1.0 | ◩ 140 | 0.15 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | RF-geometri til semi-grov til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **SCMT 09T308E-RF** | **T5315** | 0.8 | ◩ 255 | 0.20 | 1.5 | – | – | – | ■ 240 | 0.20 | 1.5 | – | – | – | – | – | – | ◩ 50 | 0.15 | 1.0 |
| | **T7335** | 0.8 | ◩ 170 | 0.20 | 1.5 | ◩ 130 | 0.18 | 1.5 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **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 | 0.15 | 1.0 |
| | **T7335** | 0.8 | ◩ 160 | 0.22 | 2.2 | ◩ 120 | 0.22 | 2.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | ■ 205 | 0.22 | 2.2 | ◩ 120 | 0.22 | 2.2 | ◩ 190 | 0.22 | 2.2 | – | – | – | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | RM-geometri til semi-grov til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **SCMT 09T308E-RM** | **T5315** | 0.8 | ◩ 275 | 0.30 | 2.0 | – | – | – | ■ 260 | 0.30 | 2.0 | – | – | – | – | – | – | ◩ 55 | 0.15 | 1.0 |
| | **T7335** | 0.8 | ◩ 190 | 0.30 | 2.0 | ■ 145 | 0.27 | 2.0 | – | – | – | – | – | – | ◩ 60 | 0.24 | 1.6 | – | – | – |
| | **T8330** | 0.8 | ■ 175 | 0.30 | 2.0 | ■ 105 | 0.27 | 2.0 | ■ 165 | 0.30 | 2.0 | – | – | – | ◩ 40 | 0.24 | 1.6 | ◩ 35 | 0.15 | 1.0 |
| | **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 | 1.0 |
| | **T9315** | 0.8 | ■ 255 | 0.30 | 2.0 | – | – | – | ◩ 240 | 0.30 | 2.0 | – | – | – | – | – | – | ◩ 50 | 0.15 | 1.0 |
| | **T9325** | 0.8 | ■ 230 | 0.30 | 2.0 | ■ 135 | 0.27 | 2.0 | ◩ 215 | 0.30 | 2.0 | – | – | – | ◩ 50 | 0.24 | 1.6 | – | – | – |
| **SCMT 120408E-RM** | **T5305** | 0.8 | ◩ 305 | 0.30 | 2.3 | – | – | – | ■ 285 | 0.30 | 2.3 | – | – | – | – | – | – | ◩ 60 | 0.15 | 1.0 |
| | **T5315** | 0.8 | ◩ 275 | 0.30 | 2.3 | – | – | – | ■ 260 | 0.30 | 2.3 | – | – | – | – | – | – | ◩ 55 | 0.15 | 1.0 |
| | **T7335** | 0.8 | ◩ 185 | 0.30 | 2.3 | ■ 140 | 0.27 | 2.3 | – | – | – | – | – | – | ◩ 60 | 0.24 | 1.8 | – | – | – |
| | **T8330** | 0.8 | ■ 175 | 0.30 | 2.3 | ■ 105 | 0.27 | 2.3 | ■ 165 | 0.30 | 2.3 | – | – | – | ◩ 40 | 0.24 | 1.8 | ◩ 35 | 0.15 | 1.0 |
| | **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 | 1.0 |
| | **T9315** | 0.8 | ■ 250 | 0.30 | 2.3 | – | – | – | ◩ 235 | 0.30 | 2.3 | – | – | – | – | – | – | ◩ 50 | 0.15 | 1.0 |
| | **T9325** | 0.8 | ■ 225 | 0.30 | 2.3 | ■ 135 | 0.27 | 2.3 | ◩ 210 | 0.30 | 2.3 | – | – | – | ◩ 50 | 0.24 | 1.8 | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | RM3-geometri til halv grov til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **SCMT 120408E-RM3** | **T6310** | 0.8 | ■ 155 | 0.27 | 2.3 | ◩ 110 | 0.27 | 2.3 | ■ 125 | 0.27 | 2.3 | – | – | – | – | – | – | ◩ 30 | 0.15 | 1.0 |
| | **T8330** | 0.8 | ■ 155 | 0.27 | 2.3 | ◩ 90 | 0.27 | 2.3 | ■ 145 | 0.27 | 2.3 | – | – | – | – | – | – | ◩ 30 | 0.15 | 1.0 |
| | **T8430** | 0.8 | ■ 170 | 0.27 | 2.3 | ◩ 90 | 0.27 | 2.3 | ◩ 135 | 0.27 | 2.3 | – | – | – | – | – | – | ◩ 25 | 0.15 | 1.0 |
| | **T9315** | 0.8 | ■ 225 | 0.27 | 2.3 | – | – | – | ◩ 210 | 0.27 | 2.3 | – | – | – | – | – | – | ◩ 45 | 0.15 | 1.0 |
| | **T9325** | 0.8 | ■ 205 | 0.27 | 2.3 | ◩ 120 | 0.27 | 2.3 | ◩ 190 | 0.27 | 2.3 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.8 | ■ 175 | 0.27 | 2.3 | ◩ 105 | 0.27 | 2.3 | – | – | – | – | – | – | – | – | – | – | – | – |
| **SCMT 120412E-RM3** | **T7325** | 1.2 | ◩ 175 | 0.30 | 2.3 | ◩ 135 | 0.27 | 2.3 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | ■ 205 | 0.30 | 2.3 | ◩ 120 | 0.27 | 2.3 | ◩ 190 | 0.30 | 2.3 | – | – | – | – | – | – | – | – | – |

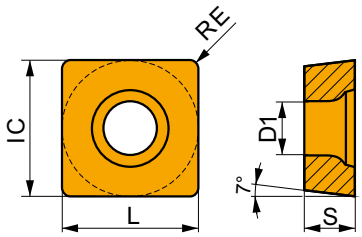
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) | | | | | | | | | | | | | | | | | | |
| | | | E | | | | | | | | | | | | | | | | | |
| | | | UR-geometri til finbearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | |
| **SCMT 09T304E-UR** | **T7325** | 0.4 | 175 | 0.15 | 1.2 | 135 | 0.15 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.4 | 155 | 0.15 | 1.2 | 90 | 0.14 | 1.2 | 145 | 0.15 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.4 | 180 | 0.15 | 1.2 | 95 | 0.14 | 1.2 | 145 | 0.15 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.4 | 250 | 0.15 | 1.2 | – | – | – | 235 | 0.15 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 225 | 0.15 | 1.2 | 135 | 0.15 | 1.2 | 210 | 0.15 | 1.2 | – | – | – | – | – | – | – | – | – |
| **SCMT 09T308E-UR** | **T5315** | 0.8 | 280 | 0.20 | 1.2 | – | – | – | 265 | 0.20 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 0.8 | 195 | 0.20 | 1.2 | 150 | 0.18 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.8 | 170 | 0.20 | 1.2 | 100 | 0.18 | 1.2 | 160 | 0.20 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.8 | 190 | 0.20 | 1.2 | 105 | 0.18 | 1.2 | 155 | 0.20 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.8 | 260 | 0.20 | 1.2 | – | – | – | 245 | 0.20 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 235 | 0.20 | 1.2 | 140 | 0.18 | 1.2 | 220 | 0.20 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **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 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 0.8 | 185 | 0.20 | 1.6 | 140 | 0.18 | 1.6 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.8 | 165 | 0.20 | 1.6 | 95 | 0.18 | 1.6 | 155 | 0.20 | 1.6 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.8 | 185 | 0.20 | 1.6 | 100 | 0.18 | 1.6 | 150 | 0.20 | 1.6 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.8 | 260 | 0.20 | 1.6 | – | – | – | 245 | 0.20 | 1.6 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 230 | 0.20 | 1.6 | 135 | 0.18 | 1.6 | 215 | 0.20 | 1.6 | – | – | – | – | – | – | – | – | – |
| **SCMT 120412E-UR** | **T8330** | 1.2 | 160 | 0.27 | 1.6 | 95 | 0.24 | 1.6 | 150 | 0.27 | 1.6 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 1.2 | 175 | 0.27 | 1.6 | 95 | 0.24 | 1.6 | 140 | 0.27 | 1.6 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | 215 | 0.27 | 1.6 | 125 | 0.24 | 1.6 | 200 | 0.27 | 1.6 | – | – | – | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | P | | | | | | | | | | | | | | | | | |
| | | | DR4 geometri til hård til ekstra hård bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **SCMT 380932E-DR4** | **T9335** | 3.2 | 50 | 1.33 | 16.0 | 30 | 1.20 | 16.0 | – | – | – | – | – | – | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | P | | | | | | | | | | | | | | | | | |
| | | | OR geometri til grov til meget grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **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 | – | – | – |
| | **T9325** | 2.4 | 90 | 1.00 | 10.0 | 50 | 0.90 | 10.0 | 85 | 1.00 | 10.0 | – | – | – | 20 | 0.70 | 8.0 | – | – | – |
| | **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 | – | – | – |
| | **T9226** | 3.2 | 65 | 1.20 | 18.0 | 35 | 1.08 | 18.0 | 60 | 1.20 | 18.0 | – | – | – | 10 | 1.08 | 9.9 | – | – | – |
| | **T9315** | 3.2 | 85 | 1.20 | 18.0 | – | – | – | 80 | 1.20 | 18.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 3.2 | 80 | 1.20 | 18.0 | 45 | 1.08 | 18.0 | 75 | 1.20 | 18.0 | – | – | – | 15 | 1.08 | 9.9 | – | – | – |
| | **T9335** | 3.2 | 60 | 1.20 | 18.0 | 35 | 1.08 | 18.0 | – | – | – | – | – | – | 10 | 1.08 | 9.9 | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | P | | | | | | | | | | | | | | | | | |
| | | | SR-geometri til hård til meget hård bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **SCMT 250924E-SR** | **T9325** | 2.4 | 70 | 1.00 | 14.0 | 40 | 0.90 | 14.0 | 65 | 1.00 | 14.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 2.4 | 60 | 1.00 | 14.0 | 35 | 0.90 | 14.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| **SCMT 380932E-SR** | **T9335** | 3.2 | 50 | 1.30 | 20.0 | 30 | 1.30 | 20.0 | – | – | – | – | – | – | – | – | – | – | – | – |

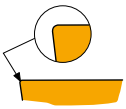
# SCMW

PRAMET

| | 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 |




Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | |  Til fin til halv grov bearbejdning og kontinuerlig til let afbrudt snit. | | | | | | | | | | | | | | | | | |
| **SCMW 09T304** | **T5305** | 0.4 | – | – | – | – | – | – | 240 | 0.10 | 2.0 | – | – | – | – | – | – | 50 | 0.15 | 1.0 |
| | **T5315** | 0.4 | – | – | – | – | – | – | 205 | 0.10 | 2.0 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| **SCMW 09T308** | **T5305** | 0.8 | – | – | – | – | – | – | 220 | 0.20 | 2.0 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |
| | **T5315** | 0.8 | – | – | – | – | – | – | 190 | 0.20 | 2.0 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| **SCMW 120408** | **T5305** | 0.8 | – | – | – | – | – | – | 205 | 0.20 | 4.0 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| | **T5315** | 0.8 | – | – | – | – | – | – | 185 | 0.20 | 4.0 | – | – | – | – | – | – | 35 | 0.15 | 1.0 |

# SSBC(RL) EXT

P M K N S H

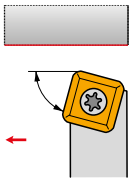
PRAMET

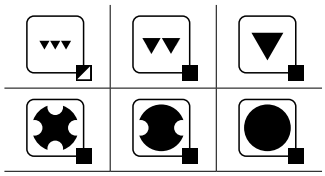
S

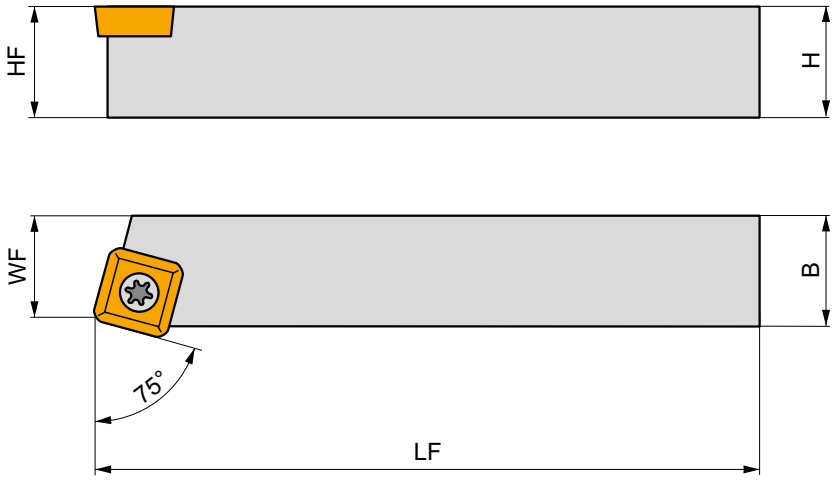


## Ekstern skruelåsværktøjsholder med 75 ° skærevinkel til SC .. Skær

Ekstern højre / venstre værktøjsholder til skruetype positiv SC .. 09 op til 38 skær. Velegnet til udvendig langsgående drejning uden skulder, konisk drejning. Fås med skaftstørrelse 12x12 op til 60x60 mm. Krop behandlet for længere levetid på værktøjet.












| | Product | H (mm) | B (mm) | HF (mm) | WF (mm) | LF (mm) | LAMS (°) | GAMO (°) | 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 | 0.47 | 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

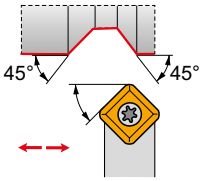
PRAMET

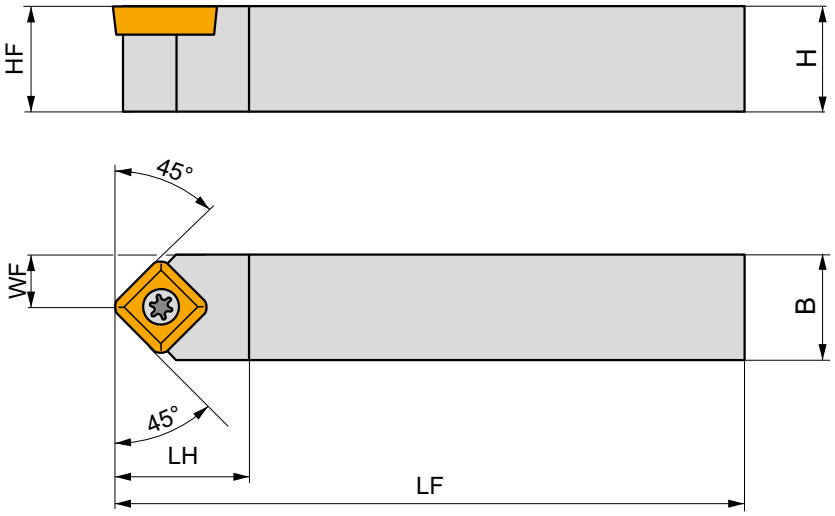
S

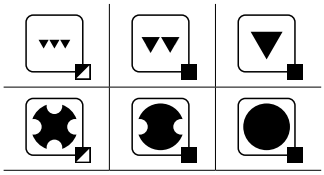


## Ekstern skruelåsværktøjsholder med 45 ° skærevinkel til SC .. Skær

Ekstern neutral værktøjsholder til skruetype positive SC .. 09 eller 12 skær. Velegnet til udvendig langsgående drejning uden skulder, kopi, tilspidsning og affasning. Fås med skaftstørrelse 12x12 op til 25x25 mm. Krop behandlet for længere levetid





| | 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 | 0.12 | 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 | 0.42 | 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

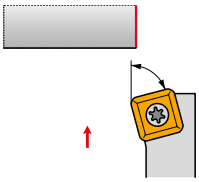
PRAMET

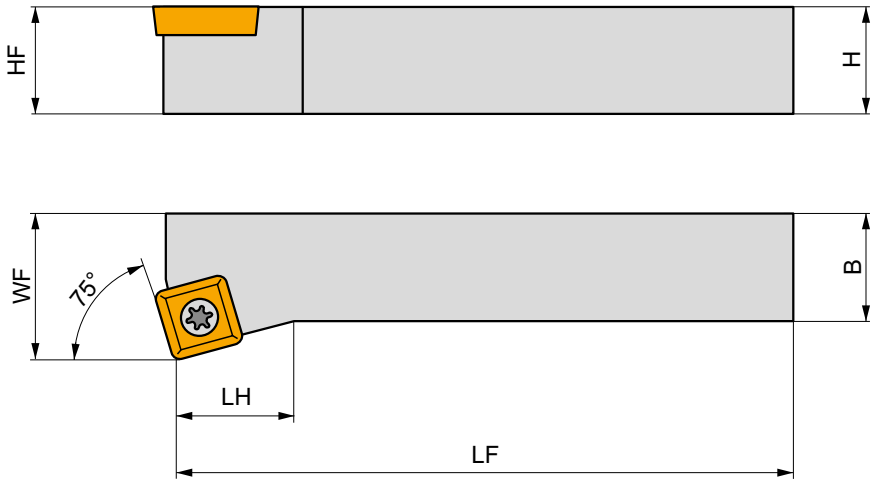
S

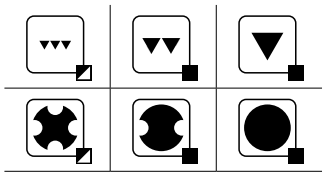


## Ekst. Skruelåsværktøjsholder, 75 ° ( endedrejning ) Skærevinkel til SC .. Skær

Ekstern højre / venstre værktøjsholder til skruetype positiv SC .. 09 op til 12 skær. Velegnet til udvendigt endedrejning uden skulder og afkørsel. Fås med skaftstørrelse 12x12 op til 25x25 mm. Krop behandlet for længere værktøjslevetid.







| | Product | H (mm) | B (mm) | HF (mm) | WF (mm) | LF (mm) | LH (mm) | LAMS (°) | GAMO (°) | kg | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| R | **SSKCR 1212 F 09** | 12 | 12 | 12 | 16 | 80 | 32 | 0 | 0 | 0.10 | GI053 | S08 |
| | **SSKCR 1616 H 09** | 16 | 16 | 16 | 20 | 100 | 32 | 0 | 0 | 0.25 | GI053 | S08 |
| | **SSKCR 2020 K 12-M-A** | 20 | 20 | 20 | 25 | 125 | 36 | 0 | 0 | 0.75 | GI015 | SS20 |
| | **SSKCR 2525 M 12-M-A** | 25 | 25 | 25 | 32 | 150 | 36 | 0 | 0 | 0.75 | GI015 | SS20 |
| L | **SSKCL 1212 F 09** | 12 | 12 | 12 | 16 | 80 | 32 | 0 | 0 | 0.10 | GI053 | S08 |
| | **SSKCL 1616 H 09** | 16 | 16 | 16 | 20 | 100 | 32 | 0 | 0 | 0.22 | GI053 | S08 |
| | **SSKCL 2020 K 12-M-A** | 20 | 20 | 20 | 25 | 125 | 36 | 0 | 0 | 0.45 | GI015 | SS20 |
| | **SSKCL 2525 M 12-M-A** | 25 | 25 | 25 | 32 | 150 | 36 | 0 | 0 | 0.80 | 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 |

# KHS-SBC(RL)

P M K

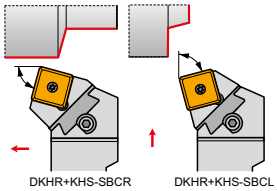
PRAMET

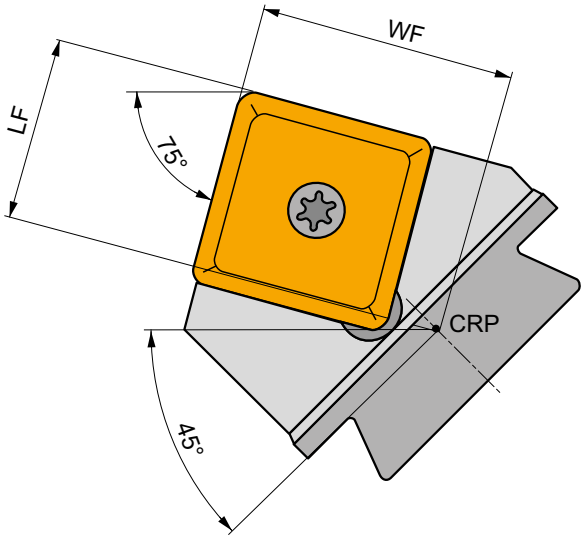
S

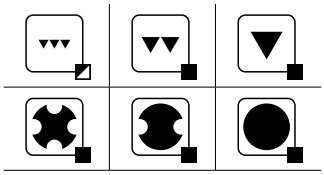


## Modulær KHP drejeholder, 75 ° skærevinkel til SC .. Skær

Drejeholder højre / venstre håndlås drejepatron, 75 ° skærevinkel, til montering på DKH værktøjsholderskaft. Velegnet til kraftig langsgående drejning uden hjørne, plandrejning, konisk drejning med fasning med negativ SC .. 25 skær. Værktøjsholder behandlet for længere værktøjslevetid.





| | 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 | 1.50 | 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 |

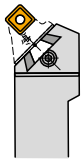
# DKH(RL)

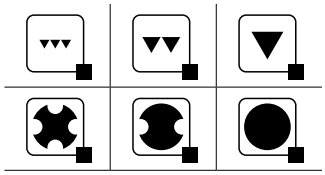
PRAMET

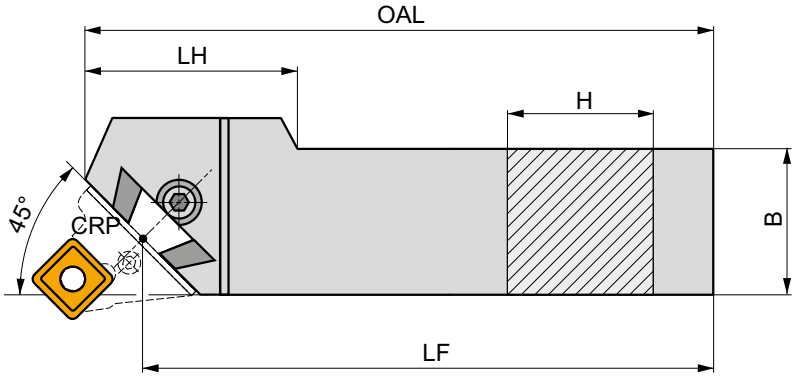


## Eksternt værktøjsholderskaft til KHP / KHS tung drejening

Drejeholder højre / venstre modulære værktøjsskaft til KHP / KHS patroner. Velegnet til tunge drejeprogrammer. Fås med skaftstørrelse 40x50 op til 60x80 mm. Krop behandlet for længere levetid








| | Product | H (mm) | B (mm) | LF (mm) | OAL (mm) | LH (mm) | kg | | |
|---|---|---|---|---|---|---|---|---|---|
| R | **DKHR 4050 V** | 40 | 50 | 400 | 425 | 100 | 7.10 | GI098 | DKH10 |
| | **DKHR 5060 W** | 50 | 60 | 450 | 475 | 110 | 11.30 | GI098 | DKH10 |
| | **DKHR 6080 W-A** | 60 | 80 | 450 | 485 | 90 | 19.65 | GI098 | DKH10 |
| L | **DKHL 4050 V** | 40 | 50 | 400 | 425 | 100 | 7.10 | GI098 | DKH10 |
| | **DKHL 5060 W** | 50 | 60 | 450 | 475 | 110 | 11.30 | GI098 | DKH10 |
| | **DKHL 6080 W-A** | 60 | 80 | 450 | 485 | 90 | 19.28 | GI098 | DKH10 |

| | | |
|---|---|---|
| GI098 | KHP | KHS |

| | | |
|---|---|---|
| DKH10 | SR 14 | HXK 10 |

# SSSC(RL) INT

P M K N S H

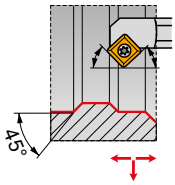
PRAMET

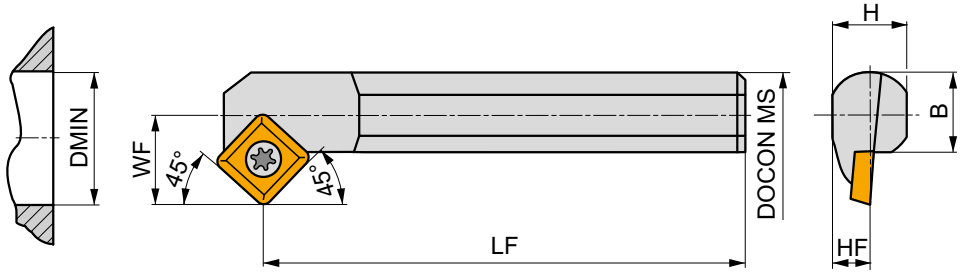
S

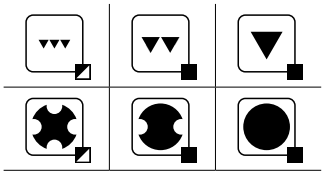


## Intern skruelåsborestang med 45 ° skærevinkel til SC .. Skær

Intern højre / venstre borestang med 45° skærevinkel til skruetype SC .. 09 skær. Mindste indvendige drejediameter Ø25 mm. Til indvendigt rygfasning, tilspidsning, multi-retningsretning, affasning og langsgående drejning uden skulder. Fås med skaftstørrelse Ø20 op til Ø25 mm. Krop behandlet for længere levetid på værktøjet.





| | 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 | 1.15 | 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 | 1.11 | GI053 | S04 |

| | |
|---|---|
| GI053 | SC.. 09T3.. |

| | | Nm | | | |
|---|---|---|---|---|---|
| S04 | US 3510-T15P | 3.0 | M 3.5 | 10.6 | FLAG T15P |

# SP

09/ 12/ 15/ 19/ 25

## CARBIDE INSERTS

**SPMR**



146

**SPUN**



146

## CER INSERTS

**SPGN CER**

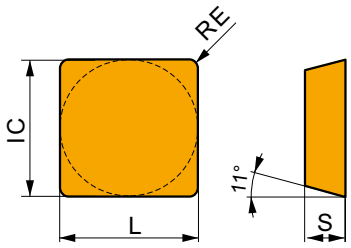


147

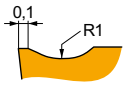
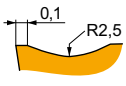
# SPMR

PRAMET

| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 0903 | 9.525 | 9.53 | 3.18 |
| 1203 | 12.700 | 12.70 | 3.18 |



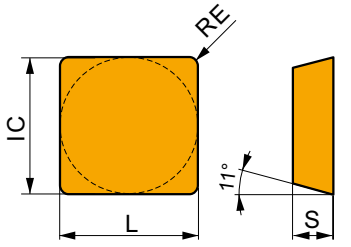

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | |  | | | | | | | | | | | | | | | | | |
| | | | Geometri 46 til finbearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **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 | – | – | – | – | – | – | – | – | – |
|  |  | |  | | | | | | | | | | | | | | | | | |
| | | | Geometri 48 til fin til halv grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **SPMR 120304E-48** | **T9325** | 0.4 | ■ 170 | 0.22 | 2.2 | ◪ 100 | 0.22 | 2.2 | ◪ 160 | 0.22 | 2.2 | – | – | – | – | – | – | – | – | – |
| | **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 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | ■ 205 | 0.22 | 2.2 | ◪ 120 | 0.22 | 2.2 | ◪ 190 | 0.22 | 2.2 | – | – | – | – | – | – | – | – | – |
| | **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 | – | – | – | – | – | – | – | – | – |

# SPUN

PRAMET

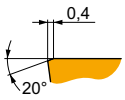
| | IC (mm) | L (mm) | M (mm) | S (mm) |
|---|---|---|---|---|
| 1203 | 12.700 | 12.70 | 2 | 3.18 |
| 1504 | 15.875 | 15.88 | 3 | 4.76 |
| 1904 | 19.050 | 19.05 | 3 | 4.76 |
| 2506 | 25.400 | 25.40 | 4 | 6.35 |




Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | |  | | | | | | | | | | | | | | | | | |
| | | | Til fin til halv grov bearbejdning og kontinuerlig til let afbrudt snit. | | | | | | | | | | | | | | | | | |
| **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 | – | – | – | – | – | – | – | – | – |

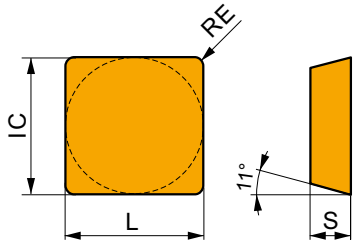
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |  | | E | | | | | | | | | | | | | | | | | |
| Til fin til halv grov bearbejdning og kontinuerlig til let afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **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 | – | – | – | – | – | – | – | – | – |
|  |   | | S | | | | | | | | | | | | | | | | | |
| Til fin til halv grov bearbejdning og kontinuerlig til let afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **SPUN 250620S** | **6640** | 2.0 | 80 | 0.40 | 12.0 | – | – | – | 75 | 0.40 | 12.0 | – | – | – | – | – | – | – | – | – |

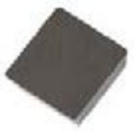
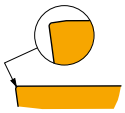
## SPGN CER

PRAMET

| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 1203 | 12.700 | 12.70 | 3.18 |




Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |  | | HSC | | T | | | | | | | | | | | | | | | |
| Til bearbejdning med høje hastigheder og kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **SPGN 120308 T01020** | **TC100** | 0.8 | – | – | – | – | – | – | 530 | 0.20 | 1.5 | – | – | – | – | – | – | – | – | – |

# TC

06/ 09/ 11/16

## CARBIDE INSERTS

**TCGT**



149

**TCMT**



150

**TCMW**



154

## CBN INSERTS

**TCGW CBN**



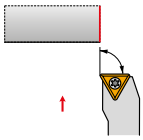
154

| MATCH THE RIGHT SIZE (example) | |
|---|---|
| **Insert** | **Tool Holder** |
| TCMT 110204E-FF2 | STFCR 1616 H 11 |

## ISO-DREJNING – UDVENDIGT

**STFC(RL) EXT**

90° | TC..



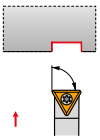
11
16

16×16
25×25

155 | 149 – 154

**STFC(RL)-A EXT**

90° | TC..



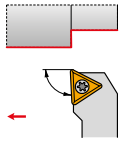
11

20×20

156 | 149 – 154

**STJC(RL) EXT**

93° | TC..



11
16

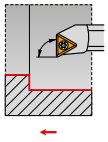
16×16
25×25

157 | 149 – 154

## ISO-DREJNING – INDVENDIG

**STFC(RL) INT**

90° | TC..



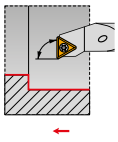
06
09
11
16

ØDmin 8,5
40

158 | 149 – 154

**STFC(RL)-E INT**

90° | TC..



06
09
11

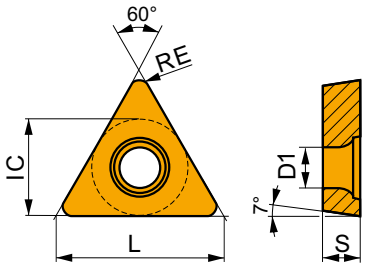
ØDmin 8,5
20

160 | 149 – 154

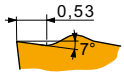
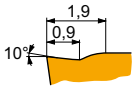
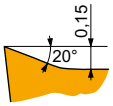
# TCGT

PRAMET

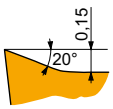
| | IC (mm) | D1 (mm) | L (mm) | S (mm) |
|---|---|---|---|---|
| 06T1 | 3.970 | 2.20 | 6.90 | 1.98 |
| 0902 | 5.560 | 2.50 | 9.60 | 2.38 |
| 1102 | 6.350 | 2.80 | 11.00 | 2.38 |
| 1102-SF3 | 6.350 | 2.80 | 11.00 | 2.58 |
| 16T3 | 9.525 | 4.40 | 16.50 | 3.97 |
| 16T3-SF3 | 9.525 | 4.40 | 16.50 | 4.22 |




Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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-geometri med meget positivt design til fin-finish til grov bearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | | | | |
| **TCGT 090202F-AL** | **HF7** | 0.2 | – | – | – | – | – | – | – | – | – | ■ 375 | 0.12 | 1.0 | – | – | – | – | – | – |
| | **T0315** | 0.2 | – | – | – | – | – | – | – | – | – | ■ 555 | 0.12 | 1.0 | – | – | – | – | – | – |
| **TCGT 090204F-AL** | **HF7** | 0.4 | – | – | – | – | – | – | – | – | – | ■ 300 | 0.24 | 1.0 | – | – | – | – | – | – |
| | **T0315** | 0.4 | – | – | – | – | – | – | – | – | – | ■ 450 | 0.24 | 1.0 | – | – | – | – | – | – |
| **TCGT 110202F-AL** | **HF7** | 0.2 | – | – | – | – | – | – | – | – | – | ■ 360 | 0.12 | 1.5 | – | – | – | – | – | – |
| | **T0315** | 0.2 | – | – | – | – | – | – | – | – | – | ■ 525 | 0.12 | 1.5 | – | – | – | – | – | – |
| **TCGT 110204F-AL** | **HF7** | 0.4 | – | – | – | – | – | – | – | – | – | ■ 285 | 0.24 | 1.5 | – | – | – | – | – | – |
| | **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 | – | – | – | – | – | – |
| | **T0315** | 0.4 | – | – | – | – | – | – | – | – | – | ■ 405 | 0.24 | 2.4 | – | – | – | – | – | – |
| **TCGT 16T308F-AL** | **HF7** | 0.8 | – | – | – | – | – | – | – | – | – | ■ 255 | 0.48 | 2.4 | – | – | – | – | – | – |
| | **T0315** | 0.8 | – | – | – | – | – | – | – | – | – | ■ 360 | 0.48 | 2.4 | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| FF2-geometri med positivt design for finbearbejdning til færdigbearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | | | | |
| **TCGT 06T102E-FF2** | **T8330** | 0.2 | ■ 175 | 0.05 | 0.8 | – | – | – | ■ 165 | 0.05 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.2 | ■ 235 | 0.05 | 0.8 | – | – | – | ◪ 190 | 0.05 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **TT010** | 0.2 | ■ 295 | 0.05 | 0.5 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **TCGT 090202E-FF2** | **TT010** | 0.2 | ■ 295 | 0.05 | 0.5 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| NF1-geometri med positivt design til finbearbejdning til medium bearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **TCGT 110204E-NF1** | **H07** | 0.4 | – | – | – | ◪ 80 | 0.09 | 0.8 | – | – | – | ◪ 415 | 0.12 | 0.8 | ■ 40 | 0.08 | 0.6 | – | – | – |
| | **T6310** | 0.4 | ■ 155 | 0.10 | 0.8 | ■ 110 | 0.09 | 0.8 | – | – | – | ◪ 465 | 0.12 | 0.8 | ■ 45 | 0.08 | 0.6 | ◪ 30 | 0.15 | 1.0 |
| | **T7325** | 0.4 | ◪ 180 | 0.10 | 0.8 | ■ 140 | 0.09 | 0.8 | – | – | – | – | – | – | ■ 55 | 0.08 | 0.6 | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| SF3-geometri med meget positivt design til finbearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **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 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| **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 | – | – | – |
| | **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 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |  | | | | | | | | | | | | | | | | | | | |

SF3-geometri med meget positivt design til finbearbejdning og kontinuerlige snit.

| | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **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 | – | – | – |
| | **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 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| **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 | – | – | – |
| | **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 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| **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 | 0.15 | 1.0 |




ER-SI geometri med positivt højrehåndet design til finbearbejdning og kontinuerlige snit.

| | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **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 | – | – | – |
| | **T8330** | 0.2 | 180 | 0.10 | 0.8 | 105 | 0.09 | 0.8 | 170 | 0.10 | 0.8 | – | – | – | 45 | 0.08 | 0.6 | – | – | – |
| | **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** | **T8330** | 0.4 | 180 | 0.12 | 0.8 | 105 | 0.11 | 0.8 | 170 | 0.12 | 0.8 | – | – | – | 45 | 0.10 | 0.6 | – | – | – |
| | **T8430** | 0.4 | 225 | 0.12 | 0.8 | 120 | 0.11 | 0.8 | 185 | 0.12 | 0.8 | – | – | – | 45 | 0.10 | 0.6 | – | – | – |



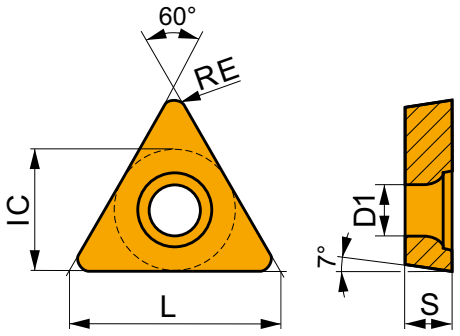

EL-SI geometri med positivt venstrehåndet design til finbearbejdning og kontinuerlige snit.

| | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **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 | – | – | – |
| | **T8330** | 0.2 | 180 | 0.10 | 0.8 | 105 | 0.09 | 0.8 | 170 | 0.10 | 0.8 | – | – | – | 45 | 0.08 | 0.6 | – | – | – |
| | **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 | – | – | – |
| | **T8330** | 0.4 | 180 | 0.12 | 0.8 | 105 | 0.11 | 0.8 | 170 | 0.12 | 0.8 | – | – | – | 45 | 0.10 | 0.6 | – | – | – |
| | **T8430** | 0.4 | 225 | 0.12 | 0.8 | 120 | 0.11 | 0.8 | 185 | 0.12 | 0.8 | – | – | – | 45 | 0.10 | 0.6 | – | – | – |

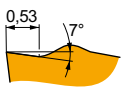
## TCMT

PRAMET

| | 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 |



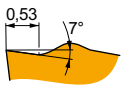

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |  | | | | | | | | | | | | | | | | | | | |

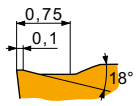
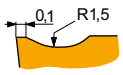
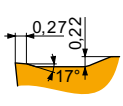
FF2-geometri med positivt design for finbearbejdning til færdigbearbejdning og kontinuerlige til let afbrudte snit.

| | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **TCMT 06T102E-FF2** | **T8330** | 0.2 | 175 | 0.05 | 0.8 | – | – | – | 165 | 0.05 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.2 | 235 | 0.05 | 0.8 | – | – | – | 190 | 0.05 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.2 | 335 | 0.05 | 0.8 | – | – | – | 315 | 0.05 | 0.8 | – | – | – | – | – | – | – | – | – |

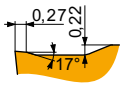
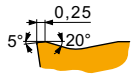
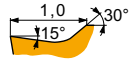
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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-geometri med positivt design for finbearbejdning til færdigbearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | | | | |
| **TCMT 06T104E-FF2** | **T7325** | 0.4 | 170 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.4 | 145 | 0.12 | 0.8 | – | – | – | 135 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.4 | 180 | 0.12 | 0.8 | – | – | – | 145 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.4 | 245 | 0.12 | 0.8 | – | – | – | 230 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 220 | 0.12 | 0.8 | – | – | – | 205 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| **TCMT 090204E-FF2** | **T5315** | 0.4 | 240 | 0.12 | 1.0 | – | – | – | 225 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 0.4 | 165 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.4 | 140 | 0.12 | 1.0 | – | – | – | 130 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.4 | 175 | 0.12 | 1.0 | – | – | – | 140 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.4 | 240 | 0.12 | 1.0 | – | – | – | 225 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 215 | 0.12 | 1.0 | – | – | – | 200 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| **TCMT 110204E-FF2** | **T7325** | 0.4 | 170 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.4 | 145 | 0.12 | 0.8 | – | – | – | 135 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.4 | 180 | 0.12 | 0.8 | – | – | – | 145 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.4 | 245 | 0.12 | 0.8 | – | – | – | 230 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 220 | 0.12 | 0.8 | – | – | – | 205 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.4 | 185 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **TCMT 110208E-FF2** | **T7325** | 0.8 | 180 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.8 | 155 | 0.17 | 0.8 | – | – | – | 145 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.8 | 185 | 0.17 | 0.8 | – | – | – | 150 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.8 | 250 | 0.17 | 0.8 | – | – | – | 235 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 225 | 0.17 | 0.8 | – | – | – | 210 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – |
| **TCMT 16T304E-FF2** | **T7325** | 0.4 | 170 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.4 | 145 | 0.12 | 0.8 | – | – | – | 135 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.4 | 180 | 0.12 | 0.8 | – | – | – | 145 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.4 | 245 | 0.12 | 0.8 | – | – | – | 230 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 220 | 0.12 | 0.8 | – | – | – | 205 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.4 | 185 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **TT010** | 0.4 | 295 | 0.06 | 0.5 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **TCMT 16T308E-FF2** | **T7325** | 0.8 | 180 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.8 | 155 | 0.17 | 0.8 | – | – | – | 145 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.8 | 185 | 0.17 | 0.8 | – | – | – | 150 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.8 | 250 | 0.17 | 0.8 | – | – | – | 235 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 225 | 0.17 | 0.8 | – | – | – | 210 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.8 | 195 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| FM-geometri til fin til halv grov bearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | | | | |
| **TCMT 110202E-FM** | **T7325** | 0.2 | 185 | 0.10 | 0.8 | 140 | 0.09 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 0.2 | 185 | 0.10 | 0.8 | 140 | 0.09 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.2 | 170 | 0.10 | 0.8 | 100 | 0.09 | 0.8 | 160 | 0.10 | 0.8 | 510 | 0.12 | 0.8 | – | – | – | – | – | – |
| | **T8330** | 0.2 | 160 | 0.10 | 0.8 | 95 | 0.09 | 0.8 | 150 | 0.10 | 0.8 | 480 | 0.12 | 0.8 | – | – | – | – | – | – |
| | **T8430** | 0.2 | 195 | 0.10 | 0.8 | 105 | 0.09 | 0.8 | 160 | 0.10 | 0.8 | 540 | 0.12 | 0.8 | – | – | – | – | – | – |
| | **T9315** | 0.2 | 270 | 0.10 | 0.8 | – | – | – | 255 | 0.10 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.2 | 245 | 0.10 | 0.8 | 145 | 0.09 | 0.8 | 230 | 0.10 | 0.8 | – | – | – | – | – | – | – | – | – |
| **TCMT 110204E-FM** | **T7325** | 0.4 | 160 | 0.19 | 0.8 | 120 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 0.4 | 155 | 0.19 | 0.8 | 120 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.4 | 170 | 0.12 | 0.8 | 100 | 0.11 | 0.8 | 160 | 0.12 | 0.8 | 510 | 0.14 | 0.8 | – | – | – | – | – | – |
| | **T8330** | 0.4 | 160 | 0.12 | 0.8 | 95 | 0.11 | 0.8 | 150 | 0.12 | 0.8 | 480 | 0.14 | 0.8 | – | – | – | – | – | – |
| | **T8430** | 0.4 | 195 | 0.12 | 0.8 | 105 | 0.11 | 0.8 | 160 | 0.12 | 0.8 | 540 | 0.14 | 0.8 | – | – | – | – | – | – |
| | **T9315** | 0.4 | 270 | 0.12 | 0.8 | – | – | – | 255 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 205 | 0.18 | 0.8 | 120 | 0.16 | 0.8 | 190 | 0.18 | 0.8 | – | – | – | – | – | – | – | – | – |

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | FM-geometri til fin til halv grov bearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | |
| **TCMT 110208E-FM** | **T7325** | 0.8 | 195 | 0.17 | 0.8 | 150 | 0.15 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.8 | 175 | 0.17 | 0.8 | 105 | 0.15 | 0.8 | 165 | 0.17 | 0.8 | 525 | 0.20 | 0.8 | – | – | – | – | – | – |
| | **T8430** | 0.8 | 200 | 0.17 | 0.8 | 110 | 0.15 | 0.8 | 165 | 0.17 | 0.8 | 555 | 0.20 | 0.8 | – | – | – | – | – | – |
| | **T9315** | 0.8 | 275 | 0.17 | 0.8 | – | – | – | 260 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 250 | 0.17 | 0.8 | 150 | 0.15 | 0.8 | 235 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – |
| **TCMT 16T304E-FM** | **T7325** | 0.4 | 150 | 0.19 | 1.7 | 115 | 0.17 | 1.7 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 0.4 | 145 | 0.19 | 1.7 | 110 | 0.17 | 1.7 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.4 | 155 | 0.12 | 1.7 | 90 | 0.11 | 1.7 | 145 | 0.12 | 1.7 | 465 | 0.14 | 1.7 | – | – | – | – | – | – |
| | **T8330** | 0.4 | 150 | 0.12 | 1.7 | 90 | 0.11 | 1.7 | 140 | 0.12 | 1.7 | 450 | 0.14 | 1.7 | – | – | – | – | – | – |
| | **T8430** | 0.4 | 180 | 0.12 | 1.7 | 95 | 0.11 | 1.7 | 145 | 0.12 | 1.7 | 495 | 0.14 | 1.7 | – | – | – | – | – | – |
| | **T9315** | 0.4 | 250 | 0.12 | 1.7 | – | – | – | 235 | 0.12 | 1.7 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 190 | 0.18 | 1.7 | 110 | 0.16 | 1.7 | 180 | 0.18 | 1.7 | – | – | – | – | – | – | – | – | – |
| **TCMT 16T308E-FM** | **T7325** | 0.8 | 180 | 0.17 | 1.7 | 140 | 0.15 | 1.7 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 0.8 | 175 | 0.17 | 1.7 | 135 | 0.15 | 1.7 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.8 | 170 | 0.17 | 1.7 | 100 | 0.15 | 1.7 | 160 | 0.17 | 1.7 | 510 | 0.20 | 1.7 | – | – | – | – | – | – |
| | **T8330** | 0.8 | 160 | 0.17 | 1.7 | 95 | 0.15 | 1.7 | 150 | 0.17 | 1.7 | 480 | 0.20 | 1.7 | – | – | – | – | – | – |
| | **T8430** | 0.8 | 185 | 0.17 | 1.7 | 100 | 0.15 | 1.7 | 150 | 0.17 | 1.7 | 510 | 0.20 | 1.7 | – | – | – | – | – | – |
| | **T9315** | 0.8 | 255 | 0.17 | 1.7 | – | – | – | 240 | 0.17 | 1.7 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 230 | 0.17 | 1.7 | 135 | 0.15 | 1.7 | 215 | 0.17 | 1.7 | – | – | – | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | FM2 geometri til fin til medium bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **TCMT 110204E-FM2** | **T8330** | 0.4 | 145 | 0.12 | 0.8 | 85 | 0.11 | 0.8 | 135 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.4 | 180 | 0.12 | 0.8 | 95 | 0.11 | 0.8 | 145 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 220 | 0.12 | 0.8 | 130 | 0.11 | 0.8 | 205 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| **TCMT 110208E-FM2** | **T8330** | 0.8 | 155 | 0.17 | 0.8 | 90 | 0.15 | 0.8 | 145 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.8 | 185 | 0.17 | 0.8 | 100 | 0.15 | 0.8 | 150 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 225 | 0.17 | 0.8 | 135 | 0.15 | 0.8 | 210 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.8 | 195 | 0.17 | 0.8 | 115 | 0.15 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| **TCMT 16T308E-FM2** | **T7325** | 0.8 | 170 | 0.20 | 1.0 | 130 | 0.18 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.8 | 145 | 0.20 | 1.0 | 85 | 0.18 | 1.0 | 135 | 0.20 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.8 | 170 | 0.20 | 1.0 | 90 | 0.18 | 1.0 | 135 | 0.20 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 205 | 0.20 | 1.0 | 120 | 0.18 | 1.0 | 190 | 0.20 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.8 | 175 | 0.20 | 1.0 | 105 | 0.18 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | RF-geometri til semi-grov til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **TCMT 16T308E-RF** | **T9325** | 0.8 | 175 | 0.20 | 1.5 | 105 | 0.18 | 1.5 | 165 | 0.20 | 1.5 | – | – | – | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | RM-geometri til semi-grov til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **TCMT 16T308E-RM** | **T5305** | 0.8 | 265 | 0.27 | 1.9 | – | – | – | 250 | 0.27 | 1.9 | – | – | – | – | – | – | 50 | 0.15 | 1.0 |
| | **T5315** | 0.8 | 235 | 0.27 | 1.9 | – | – | – | 220 | 0.27 | 1.9 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |
| | **T7335** | 0.8 | 155 | 0.27 | 1.9 | 120 | 0.24 | 1.9 | – | – | – | – | – | – | 50 | 0.19 | 1.5 | – | – | – |
| | **T8330** | 0.8 | 145 | 0.27 | 1.9 | 85 | 0.24 | 1.9 | 135 | 0.27 | 1.9 | – | – | – | 35 | 0.19 | 1.5 | 25 | 0.15 | 1.0 |
| | **T8430** | 0.8 | 165 | 0.27 | 1.9 | 90 | 0.24 | 1.9 | 135 | 0.27 | 1.9 | – | – | – | 35 | 0.19 | 1.5 | 25 | 0.15 | 1.0 |
| | **T9315** | 0.8 | 215 | 0.27 | 1.9 | – | – | – | 200 | 0.27 | 1.9 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| | **T9325** | 0.8 | 195 | 0.27 | 1.9 | 115 | 0.24 | 1.9 | 185 | 0.27 | 1.9 | – | – | – | 40 | 0.19 | 1.5 | – | – | – |

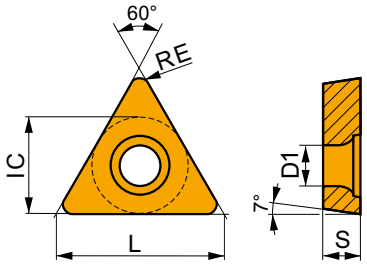
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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-geometri til semi-grov til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **TCMT 16T312E-RM** | **T5305** | 1.2 | ◪ 280 | 0.27 | 1.9 | | – | – | – | ■ 265 | 0.27 | 1.9 | – | – | – | – | – | – | ◪ 55 | 0.15 | 1.0 |
| | **T5315** | 1.2 | ◪ 250 | 0.27 | 1.9 | | – | – | – | ■ 235 | 0.27 | 1.9 | – | – | – | – | – | – | ◪ 50 | 0.15 | 1.0 |
| | **T8330** | 1.2 | ■ 150 | 0.27 | 1.9 | ■ 90 | 0.24 | 1.9 | ■ 140 | 0.27 | 1.9 | – | – | – | ◪ 35 | 0.19 | 1.5 | ◪ 30 | 0.15 | 1.0 |
| | **T8430** | 1.2 | ■ 170 | 0.27 | 1.9 | ■ 90 | 0.24 | 1.9 | ◪ 135 | 0.27 | 1.9 | – | – | – | ◪ 35 | 0.19 | 1.5 | ◪ 25 | 0.15 | 1.0 |
| | **T9315** | 1.2 | ■ 225 | 0.27 | 1.9 | | – | – | – | ◪ 210 | 0.27 | 1.9 | – | – | – | – | – | – | ◪ 45 | 0.15 | 1.0 |
| | **T9325** | 1.2 | ■ 205 | 0.27 | 1.9 | ■ 120 | 0.24 | 1.9 | ◪ 190 | 0.27 | 1.9 | – | – | – | ◪ 45 | 0.19 | 1.5 | | – | – | – |
|  |   | |  | | | | | | | | | | | | | | | | | |
| | | | RM3-geometri til halv grov til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **TCMT 16T304E-RM3** | **T6310** | 0.4 | ■ 110 | 0.25 | 2.0 | ◪ 75 | 0.25 | 2.0 | ■ 85 | 0.25 | 2.0 | – | – | – | – | – | – | ◪ 20 | 0.15 | 1.0 |
| | **T7325** | 0.4 | ◪ 125 | 0.25 | 2.0 | ◪ 95 | 0.25 | 2.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.4 | ■ 110 | 0.25 | 2.0 | ◪ 65 | 0.25 | 2.0 | ■ 100 | 0.25 | 2.0 | – | – | – | – | – | – | ◪ 20 | 0.15 | 1.0 |
| | **T8430** | 0.4 | ■ 120 | 0.25 | 2.0 | ◪ 65 | 0.25 | 2.0 | ◪ 95 | 0.25 | 2.0 | – | – | – | – | – | – | ◪ 20 | 0.15 | 1.0 |
| | **T9315** | 0.4 | ■ 165 | 0.25 | 2.0 | | – | – | ◪ 155 | 0.25 | 2.0 | – | – | – | – | – | – | ◪ 30 | 0.15 | 1.0 |
| | **T9325** | 0.4 | ■ 145 | 0.25 | 2.0 | ◪ 85 | 0.25 | 2.0 | ◪ 135 | 0.25 | 2.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.4 | ■ 125 | 0.25 | 2.0 | ◪ 75 | 0.25 | 2.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| **TCMT 16T308E-RM3** | **T6310** | 0.8 | ■ 125 | 0.27 | 2.0 | ◪ 90 | 0.27 | 2.0 | ■ 100 | 0.27 | 2.0 | – | – | – | – | – | – | ◪ 25 | 0.15 | 1.0 |
| | **T7325** | 0.8 | ◪ 145 | 0.27 | 2.0 | ◪ 110 | 0.27 | 2.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.8 | ■ 125 | 0.27 | 2.0 | ◪ 75 | 0.27 | 2.0 | ■ 115 | 0.27 | 2.0 | – | – | – | – | – | – | ◪ 25 | 0.15 | 1.0 |
| | **T8430** | 0.8 | ■ 135 | 0.27 | 2.0 | ◪ 75 | 0.27 | 2.0 | ◪ 110 | 0.27 | 2.0 | – | – | – | – | – | – | ◪ 20 | 0.15 | 1.0 |
| | **T9315** | 0.8 | ■ 185 | 0.27 | 2.0 | | – | – | ◪ 175 | 0.27 | 2.0 | – | – | – | – | – | – | ◪ 35 | 0.15 | 1.0 |
| | **T9325** | 0.8 | ■ 170 | 0.27 | 2.0 | ◪ 100 | 0.27 | 2.0 | ◪ 160 | 0.27 | 2.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.8 | ■ 145 | 0.27 | 2.0 | ◪ 85 | 0.27 | 2.0 | – | – | – | – | – | – | – | – | – | – | – | – |
|  |   | |  | | | | | | | | | | | | | | | | | |
| | | | UR-geometri til finbearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | |
| **TCMT 110204E-UR** | **T7325** | 0.4 | ◪ 135 | 0.19 | 0.8 | ◪ 105 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.4 | ■ 135 | 0.12 | 0.8 | ◪ 80 | 0.11 | 0.8 | ■ 125 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.4 | ■ 170 | 0.12 | 0.8 | ◪ 90 | 0.11 | 0.8 | ◪ 135 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.4 | ■ 235 | 0.12 | 0.8 | | – | – | ◪ 220 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | ■ 175 | 0.18 | 0.8 | ◪ 105 | 0.16 | 0.8 | ◪ 165 | 0.18 | 0.8 | – | – | – | – | – | – | – | – | – |
| **TCMT 16T304E-UR** | **T7325** | 0.4 | ◪ 135 | 0.19 | 0.8 | ◪ 105 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.4 | ■ 135 | 0.12 | 0.8 | ◪ 80 | 0.11 | 0.8 | ■ 125 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.4 | ■ 170 | 0.12 | 0.8 | ◪ 90 | 0.11 | 0.8 | ◪ 135 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.4 | ■ 235 | 0.12 | 0.8 | | – | – | ◪ 220 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | ■ 175 | 0.18 | 0.8 | ◪ 105 | 0.16 | 0.8 | ◪ 165 | 0.18 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **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 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 0.8 | ◪ 170 | 0.17 | 0.8 | ◪ 130 | 0.15 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.8 | ■ 150 | 0.17 | 0.8 | ◪ 90 | 0.15 | 0.8 | ■ 140 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.8 | ■ 175 | 0.17 | 0.8 | ◪ 95 | 0.15 | 0.8 | ◪ 140 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.8 | ■ 240 | 0.17 | 0.8 | | – | – | ◪ 225 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | ■ 215 | 0.17 | 0.8 | ◪ 125 | 0.15 | 0.8 | ◪ 200 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – |

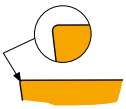
# TCMW

PRAMET

| | 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 |



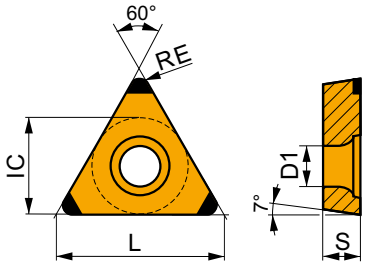

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | E | | | | | | | | | | | | | | | | | |
| Til fin til halv grov bearbejdning og kontinuerlig til let afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **TCMW 110204** | **T5305** | 0.4 | – | – | – | – | – | – | 200 | 0.10 | 1.2 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| | **T5315** | 0.4 | – | – | – | – | – | – | 180 | 0.10 | 1.2 | – | – | – | – | – | – | 35 | 0.15 | 1.0 |
| **TCMW 16T304** | **T5305** | 0.4 | – | – | – | – | – | – | 195 | 0.10 | 1.5 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| | **T5315** | 0.4 | – | – | – | – | – | – | 175 | 0.10 | 1.5 | – | – | – | – | – | – | 35 | 0.15 | 1.0 |
| | **T6310** | 0.4 | – | – | – | – | – | – | 85 | 0.10 | 1.5 | – | – | – | – | – | – | 20 | 0.15 | 1.0 |
| **TCMW 16T308** | **T5305** | 0.8 | – | – | – | – | – | – | 190 | 0.18 | 1.5 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| | **T5315** | 0.8 | – | – | – | – | – | – | 165 | 0.18 | 1.5 | – | – | – | – | – | – | 35 | 0.15 | 1.0 |
| | **T6310** | 0.8 | – | – | – | – | – | – | 85 | 0.18 | 1.5 | – | – | – | – | – | – | 20 | 0.15 | 1.0 |

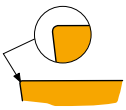
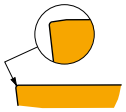
# TCGW CBN

PRAMET

| | IC (mm) | D1 (mm) | L (mm) | S (mm) |
|---|---|---|---|---|
| 1102 | 6.350 | 2.90 | 11.00 | 2.38 |




Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | HSC | | E | | | | | | | | | | | | | | | |
| Til færdigbearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **TCGW 110204E-C** | **TB310** | 0.4 | – | – | – | – | – | – | 390 | 0.10 | 0.4 | – | – | – | 100 | 0.07 | 0.3 | 80 | 0.15 | 1.0 |
|  |  | | HSC | | S | | | | | | | | | | | | | | | |
| Til færdigbearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **TCGW 110204S01020C** | **TB310** | 0.4 | – | – | – | – | – | – | 390 | 0.10 | 0.4 | – | – | – | 100 | 0.07 | 0.3 | 80 | 0.15 | 1.0 |
| **TCGW 110208S01020C** | **TB310** | 0.8 | – | – | – | – | – | – | 400 | 0.15 | 0.6 | – | – | – | 105 | 0.11 | 0.5 | 85 | 0.15 | 1.0 |

# STFC(RL) EXT

P M K N S H

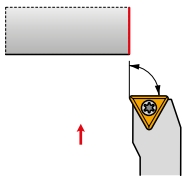
PRAMET

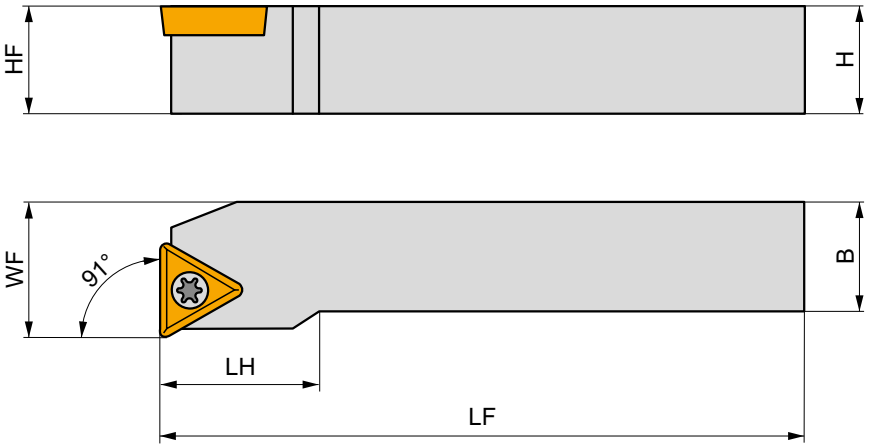
S

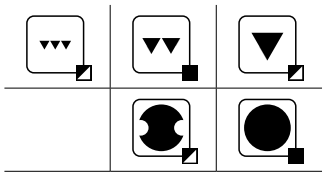


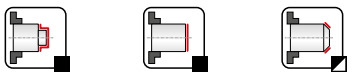
## Ekst. Skruelåsværktøjsholder, 91° ( endedrejning ) Skærevinkel til TC .. Skær

Ekstern højre / venstre værktøjsholder til skruetype positiv TC .. 11 op til 16 skær. Velegnet til udvendigt endedrejning med skulder- og affasedrejning. Fås med skaftstørrelse 16x16 op til 25x25 mm. Krop behandlet for længere levetid på værktøjet.







| | Product | H (mm) | B (mm) | HF (mm) | WF (mm) | LF (mm) | LH (mm) | LAMS (°) | GAMO (°) | kg | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| R | **STFCR 1616 H 11** | 16 | 16 | 16 | 20 | 100 | 18 | 0 | 0 | 0.20 | GI056 | S01 |
| | **STFCR 2020 K 16-M-A** | 20 | 20 | 20 | 25 | 125 | 25 | 0 | 0 | 0.40 | GI016 | ST10 |
| | **STFCR 2525 M 16-M-A** | 25 | 25 | 25 | 32 | 150 | 25 | 0 | 0 | 0.76 | GI016 | ST10 |
| L | **STFCL 1616 H 11** | 16 | 16 | 16 | 20 | 100 | 18 | 0 | 0 | 0.22 | GI056 | S01 |
| | **STFCL 2020 K 16-M-A** | 20 | 20 | 20 | 25 | 125 | 25 | 0 | 0 | 0.40 | GI016 | ST10 |
| | **STFCL 2525 M 16-M-A** | 25 | 25 | 25 | 32 | 150 | 25 | 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

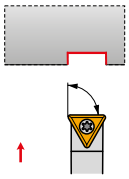
PRAMET

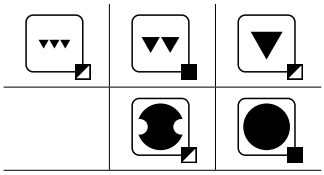
S

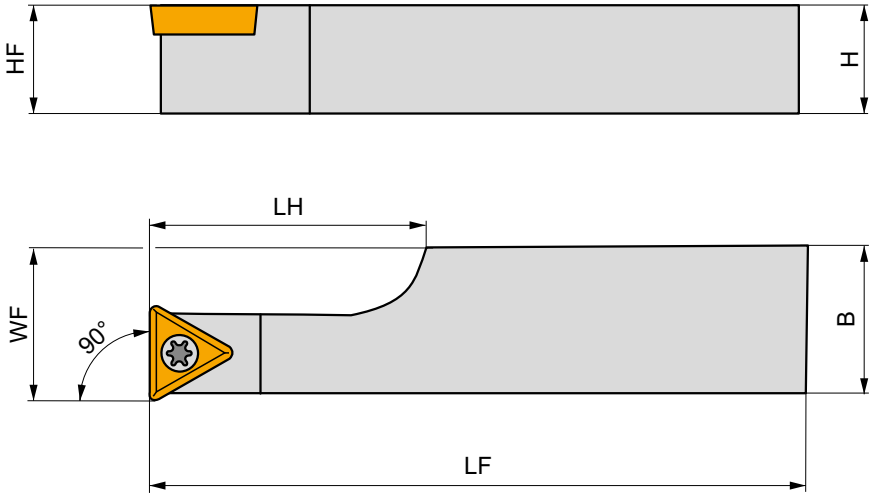


## Ekst. Skruelåsværktøjsholder, 90 ° ( endedrejning ) Skærevinkel til TC .. Skær

Ekstern højre / venstre værktøjsholder til skruetype positiv TC .. 11 skær. Velegnet til venstre og højre sidet udvendigt ende, der drejer med skulder og affasning. Fås med skaftstørrelse 20x20 mm. Krop behandlet for længere levetid på værktøjet.










| | 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 | 0.52 | 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 | M 2.5 | 6.5 | PT-8001 |

# STJC(RL) EXT

P M K N S H

PRAMET

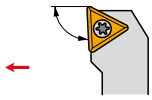
S

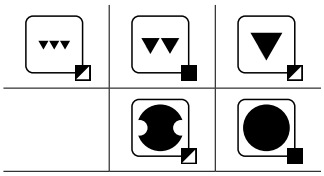


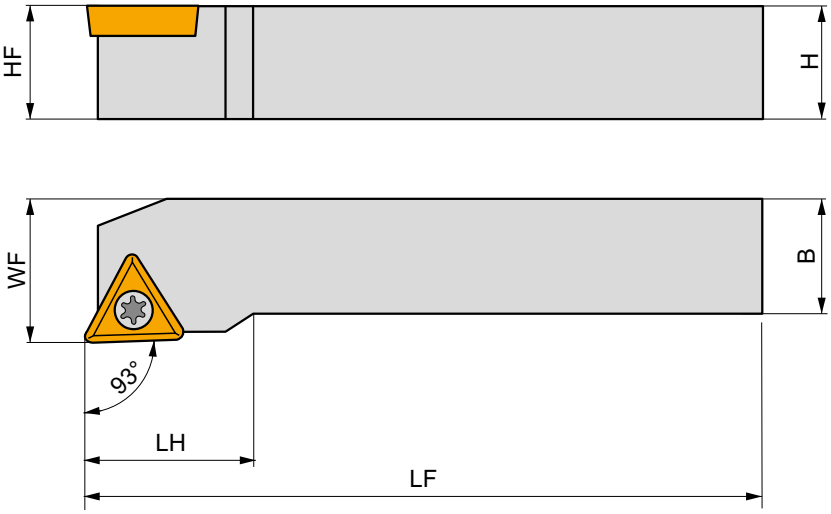
## Ekstern skruelåsværktøjsholder med 95 ° skærevinkel til TC .. Skær

Ekstern højre / venstre værktøjsholder til skruetype positiv TC .. 11 op til 16 skær. Velegnet til udvendig langsgående drejning med skulder-, konisk- og affasedrejning. Fås med skaftstørrelse 16x16 op til 25x25 mm. Krop behandlet for længere levetid på værktøjet.












| | 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 | 0.23 | GI056 | S01 |
| | **STJCR 2020 K 16-M-A** | 20 | 20 | 20 | 25 | 125 | 25 | 0 | 0 | 0.44 | GI016 | ST10 |
| | **STJCR 2525 M 16-M-A** | 25 | 25 | 25 | 32 | 150 | 25 | 0 | 0 | 0.76 | GI016 | ST10 |
| L | **STJCL 1616 H 11** | 16 | 16 | 16 | 20 | 100 | 18 | 0 | 0 | 0.22 | GI056 | S01 |
| | **STJCL 2020 K 16-M-A** | 20 | 20 | 20 | 25 | 125 | 25 | 0 | 0 | 0.43 | GI016 | ST10 |
| | **STJCL 2525 M 16-M-A** | 25 | 25 | 25 | 32 | 150 | 25 | 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 |

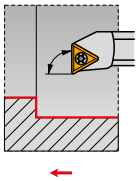
# STFC(RL) INT

P M K N S H

PRAMET

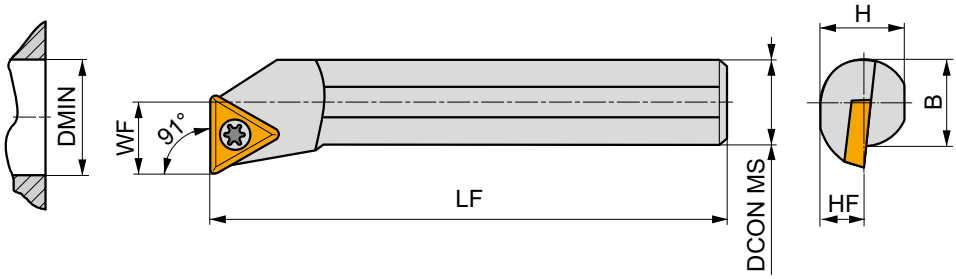
S

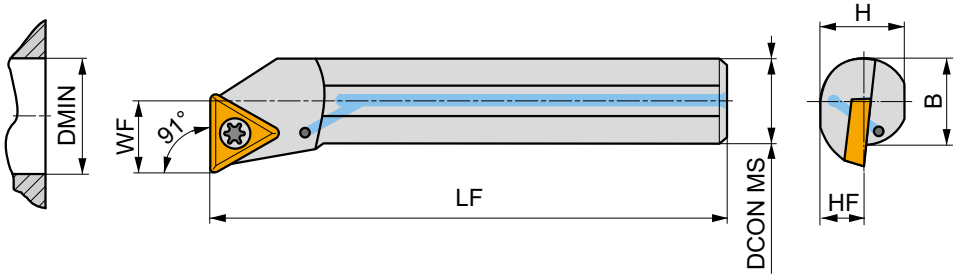


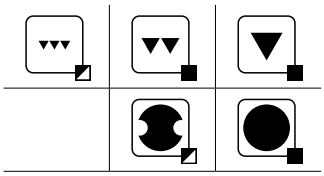


## Intern skruelåsborestang med 91 ° skærevinkel til TC .. Skær

Intern højre / venstre borestang, indvendig kølevæske, 91° skærevinkel til skruetype TC .. 06 op til 16 skær. Mindste indvendige drejediameter Ø8,5 mm. Velegnet til indvendig tilspidsning og langsgående drejning med skulder- og affasedrejning. Ø6 til Ø32 mm skaft fås. Krop behandlet for længere levetid på værktøjet.





| | 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 | ✓ | 0.03 | GI217 | ST12 |
| | A08H-STFCR 06 | 8 | 11 | 5.9 | 7 | – | 100 | -10 | 0 | ✓ | 0.04 | 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 | ✓ | 0.27 | 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 | ✓ | 0.54 | 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 | ✓ | 0.67 | GI016 | S08 |
| | S25T-STFCR 16 | 25 | 32 | 17 | 23 | 23 | 300 | -3 | 0 | – | 1.15 | GI016 | S08 |
| | A32S-STFCR 16 | 32 | 40 | 22 | 30 | 30 | 250 | -10 | 0 | ✓ | 1.36 | 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 | – | 0.25 | 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 | – | 1.15 | 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

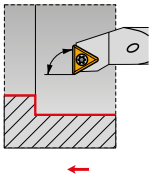
PRAMET

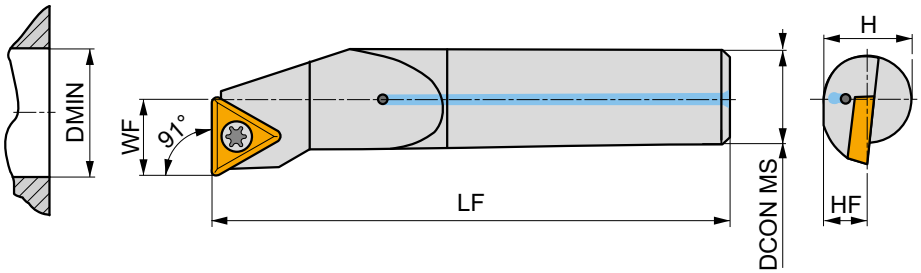
S

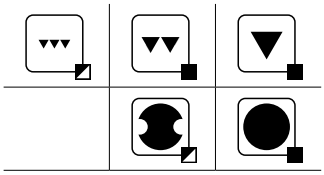


## Indvendig hårdmetal borestang med skruelås, 91 ° skærevinkel til TC .. Skær

Intern højre / venstre hårdmetalborestang, indvendig kølemiddel, med 91° skærevinkel til skruetype TC .. 06 op til 11 skær. Mindste indvendige drejediameter Ø8,5 mm. Til indvendig konisk og langsgående drejning med drejning af skulder og affasning. Fås med skaftstørrelse Ø6 op til Ø16 mm. Til værktøjsudhæng> 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 |

# TP

09/ 11/ 16

## CARBIDE INSERTS

### TPGX



162

### TPMR



163

### TPUN



164

## CER INSERTS

### TPGN CER

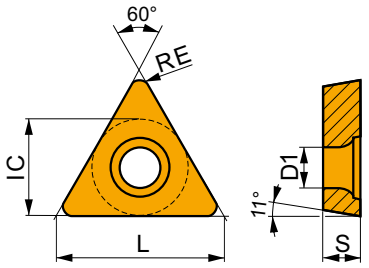


164

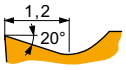
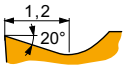
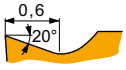
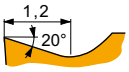
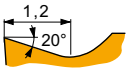
# TPGX

PRAMET

| | 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 |



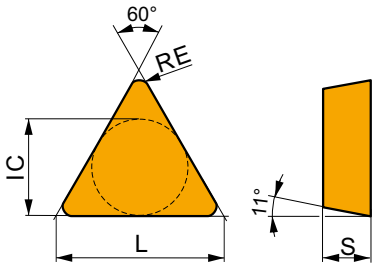

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | |  | | | | | | | | | | | | | | | | | |
| | | | FR-JQ geometri med positivt højrehåndet design til finbearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | |
| **TPGX 110204FR-JQ** | **TT010** | 0.4 | ■ 295 | 0.06 | 0.5 | ◪ 175 | 0.05 | 0.5 | – | – | – | – | – | – | – | – | – | – | – | – |
|  |  | |  | | | | | | | | | | | | | | | | | |
| | | | FL-JQ geometri med positivt venstrehåndet design til finbearbejdning, kontinuerlige snit. | | | | | | | | | | | | | | | | | |
| **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 | – | – | – | – | – | – | – | – | – | – | – | – |
|  |  | |  | | | | | | | | | | | | | | | | | |
| | | | FL-JR geometri med positivt venstrehåndet design til finbearbejdning, kontinuerlige snit. | | | | | | | | | | | | | | | | | |
| **TPGX 16T304FL-JR** | **TT010** | 0.4 | ■ 295 | 0.06 | 0.5 | ◪ 175 | 0.05 | 0.5 | – | – | – | – | – | – | – | – | – | – | – | – |
|  |  | |  | | | | | | | | | | | | | | | | | |
| | | | FR-JZ positiv geometri med højrehåndet design til finbearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | |
| **TPGX 090202FR-JZ** | **TT010** | 0.2 | ■ 280 | 0.06 | 0.5 | ◪ 165 | 0.05 | 0.5 | – | – | – | – | – | – | – | – | – | – | – | – |
|  |  | |  | | | | | | | | | | | | | | | | | |
| | | | FL-JZ geometri med positivt venstrehåndet design til finbearbejdning, kontinuerlige snit. | | | | | | | | | | | | | | | | | |
| **TPGX 090202FL-JZ** | **TT010** | 0.2 | ■ 280 | 0.06 | 0.5 | ◪ 165 | 0.05 | 0.5 | – | – | – | – | – | – | – | – | – | – | – | – |

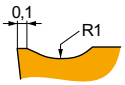
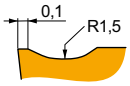
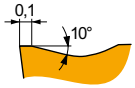
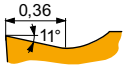
# TPMR

PRAMET

| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 1103 | 6.350 | 11.00 | 3.18 |
| 1603 | 9.525 | 16.50 | 3.18 |



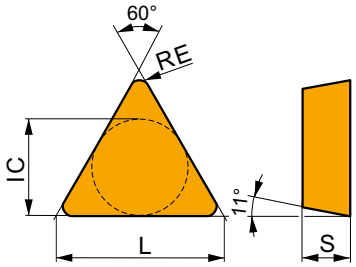

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | |  | | | | | | | | | | | | | | | | | |
| Geometri 46 til finbearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **TPMR 110304E-46** | **6640** | 0.4 | 140 | 0.15 | 1.0 | 80 | 0.14 | 1.0 | 130 | 0.15 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 175 | 0.15 | 1.0 | 105 | 0.15 | 1.0 | 165 | 0.15 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **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 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 205 | 0.15 | 1.0 | 120 | 0.15 | 1.0 | 190 | 0.15 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.8 | 180 | 0.15 | 1.0 | 105 | 0.15 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – |
|  |  | |  | | | | | | | | | | | | | | | | | |
| Geometri 47 til fin til halv grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **TPMR 160304E-47** | **6640** | 0.4 | 120 | 0.20 | 1.5 | 70 | 0.18 | 1.5 | 110 | 0.20 | 1.5 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 150 | 0.20 | 1.5 | 90 | 0.18 | 1.5 | 140 | 0.20 | 1.5 | – | – | – | – | – | – | – | – | – |
| | **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 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 175 | 0.20 | 1.5 | 105 | 0.18 | 1.5 | 165 | 0.20 | 1.5 | – | – | – | – | – | – | – | – | – |
| | **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 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.2 | 160 | 0.20 | 1.5 | 95 | 0.18 | 1.5 | – | – | – | – | – | – | – | – | – | – | – | – |
|  |  | |  | | | | | | | | | | | | | | | | | |
| Geometri 61 til færdigbearbejdning med moderat skærehastighed og skæredybde og kontinuerlige til afbrudte snit. | | | | | | | | | | | | | | | | | | | | |
| **TPMR 160308E-61** | **T9325** | 0.8 | 135 | 0.35 | 1.8 | 80 | 0.32 | 1.8 | 125 | 0.35 | 1.8 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.8 | 120 | 0.35 | 1.8 | 70 | 0.32 | 1.8 | – | – | – | – | – | – | – | – | – | – | – | – |
|  |  | |  | | | | | | | | | | | | | | | | | |
| PF2-geometri til finbearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **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 | – | – | – | – | – | – | – | – | – | – | – | – |

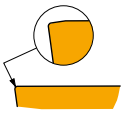
# TPUN

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 |



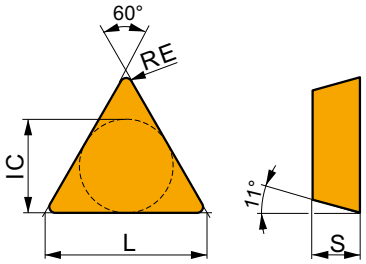

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | E | | | | | | | | | | | | | | | | | |
| Til fin til halv grov bearbejdning og kontinuerlig til let afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **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 | – | – | – | – | – | – | – | – | – |
|  |  | | S | | | | | | | | | | | | | | | | | |
| Til fin til halv grov bearbejdning og kontinuerlig til let afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **TPUN 270616S** | **6640** | 1.6 | 60 | 0.30 | 7.0 | – | – | – | 55 | 0.30 | 7.0 | – | – | – | – | – | – | – | – | – |
| **TPUN 330620S** | **6640** | 2.0 | 65 | 0.30 | 5.0 | – | – | – | 60 | 0.30 | 5.0 | – | – | – | – | – | – | – | – | – |

# TPGN CER

PRAMET

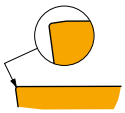
| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 1103 | 6.350 | 11.00 | 3.18 |
| 1603 | 9.525 | 16.50 | 3.18 |




Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | HSC | | T | | | | | | | | | | | | | | | |
| Til bearbejdning med høje hastigheder og kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **TPGN 110304 T01020** | **TC100** | 0.4 | – | – | – | – | – | – | 460 | 0.10 | 1.5 | – | – | – | – | – | – | – | – | – |
| **TPGN 110308 T01020** | **TC100** | 0.8 | – | – | – | – | – | – | 425 | 0.20 | 1.5 | – | – | – | – | – | – | – | – | – |

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |  | | HSC | | T | | | | | | | | | | | | | | | |
| | | | Til bearbejdning med høje hastigheder og kontinuerlige snit. | | | | | | | | | | | | | | | | | |
| **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 | – | – | – | – | – | – | – | – | – |

# VB



## CARBIDE INSERTS

### VBMT



168

## CBN INSERTS

### VBGW CBN



171

**MATCH THE RIGHT SIZE (example)**

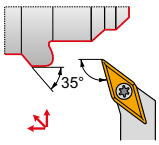
| Insert | Tool Holder |
|---|---|
| VBMT 160408E-FM | SVHCR 2020 K 16-M-A |

## ISO-DREJNING – UDVENDIGT

### SVHB(C)(RL) EXT

107°30´

VB, VC..: 11, 16



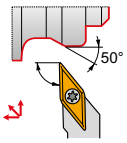

16×16 / 25×25

172 | 168 – 171, 186 – 192

### SVJB(C)(RL) EXT

93°

VB, VC..: 11, 13, 16



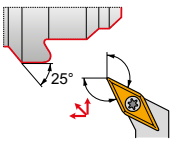

12×12 / 32×25

173 | 168 – 171, 186 – 192

### SVPB(C)(RL) EXT

117°30´

VB, VC..: 11, 16



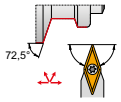

16×16 / 32×25

174 | 168 – 171, 186 – 192

### SVVB(C)N EXT

72°30´

VB, VC..: 11, 13, 16



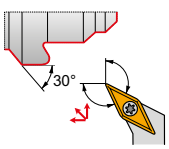

12×12 / 32×25

175 | 168 – 171, 186 – 192

### SVXB(C)(RL) EXT

98°

VB, VC..: 11, 13, 16



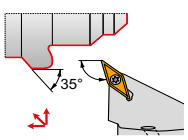

12×12 / 32×25

176 | 168 – 171, 186 – 192

### C.-SVHB(RL) EXT NEW

107°30´

VB, VC..: 16



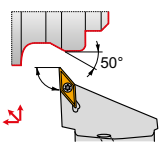

C4 / C6

177 | 168 – 171, 186 – 192

### C.-SVJB(RL) EXT NEW

93°

VB, VC..: 11, 16



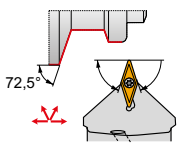

C3 / C6

178 | 168 – 171, 186 – 192

### C.-SVVBN EXT NEW

72°30´

VB, VC..: 16




C4 / C6

179 | 168 – 171, 186 – 192

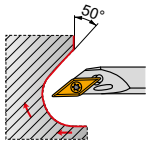
# VB



## ISO-DREJNING – INDVENDIG

### SVJB(RL) INT

93°







25 / 32

VB, VC..



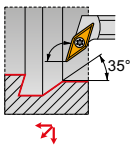
11

180

168 – 171
186 – 192

### SVQB(C)(RL) INT

107°30´







20 / 50

VB, VC..



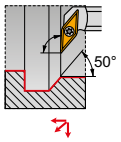
11
13
16

181

168 – 171
186 – 192

### SVUB(C)(RL) INT

93°







20 / 50

VB, VC..



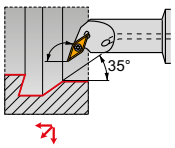
11
13
16

182

168 – 171
186 – 192

### C.-SVQB(C)(RL) INT NEW

108°







33

VB, VC..



16

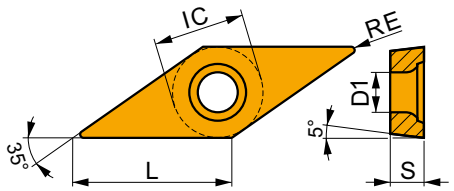
183

168 – 171
186 – 192

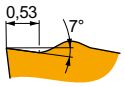
# VBMT

PRAMET

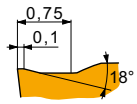
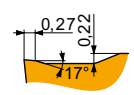
| | IC (mm) | D1 (mm) | L (mm) | S (mm) |
|---|---|---|---|---|
| 1102 | 6.350 | 2.80 | 11.10 | 2.38 |
| 1103 | 6.350 | 2.80 | 11.10 | 3.18 |
| 1604 | 9.525 | 4.40 | 16.60 | 4.76 |



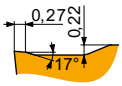
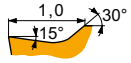

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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-geometri med positivt design for finbearbejdning til færdigbearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | | | | |
| **VBMT 160404E-FF2** | **T7325** | 0.4 | 145 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.4 | 125 | 0.12 | 0.8 | – | – | – | 115 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.4 | 150 | 0.12 | 0.8 | – | – | – | 125 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.4 | 215 | 0.12 | 0.8 | – | – | – | 200 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 190 | 0.12 | 0.8 | – | – | – | 180 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.4 | 160 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| FM-geometri til fin til halv grov bearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | | | | |
| **VBMT 110302E-FM** | **T7325** | 0.2 | 160 | 0.10 | 0.8 | 120 | 0.09 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.2 | 145 | 0.10 | 0.8 | 85 | 0.09 | 0.8 | 135 | 0.10 | 0.8 | 435 | 0.12 | 0.8 | – | – | – | – | – | – |
| | **T8330** | 0.2 | 135 | 0.10 | 0.8 | 80 | 0.09 | 0.8 | 125 | 0.10 | 0.8 | 405 | 0.12 | 0.8 | – | – | – | – | – | – |
| | **T8430** | 0.2 | 170 | 0.10 | 0.8 | 90 | 0.09 | 0.8 | 135 | 0.10 | 0.8 | 465 | 0.12 | 0.8 | – | – | – | – | – | – |
| | **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 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 0.4 | 135 | 0.19 | 0.8 | 105 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.4 | 145 | 0.12 | 0.8 | 85 | 0.11 | 0.8 | 135 | 0.12 | 0.8 | 435 | 0.14 | 0.8 | – | – | – | – | – | – |
| | **T8330** | 0.4 | 140 | 0.12 | 0.8 | 80 | 0.11 | 0.8 | 130 | 0.12 | 0.8 | 420 | 0.14 | 0.8 | – | – | – | – | – | – |
| | **T8430** | 0.4 | 170 | 0.12 | 0.8 | 90 | 0.11 | 0.8 | 135 | 0.12 | 0.8 | 465 | 0.14 | 0.8 | – | – | – | – | – | – |
| | **T9315** | 0.4 | 235 | 0.12 | 0.8 | – | – | – | 220 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 175 | 0.19 | 0.8 | 105 | 0.17 | 0.8 | 165 | 0.19 | 0.8 | – | – | – | – | – | – | – | – | – |
| **VBMT 110308E-FM** | **T7325** | 0.8 | 170 | 0.17 | 0.8 | 130 | 0.15 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.8 | 150 | 0.17 | 0.8 | 90 | 0.15 | 0.8 | 140 | 0.17 | 0.8 | 450 | 0.20 | 0.8 | – | – | – | – | – | – |
| | **T8430** | 0.8 | 175 | 0.17 | 0.8 | 95 | 0.15 | 0.8 | 140 | 0.17 | 0.8 | 480 | 0.20 | 0.8 | – | – | – | – | – | – |
| | **T9315** | 0.8 | 240 | 0.17 | 0.8 | – | – | – | 225 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 215 | 0.17 | 0.8 | 125 | 0.15 | 0.8 | 200 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – |
| **VBMT 160402E-FM** | **T7325** | 0.2 | 150 | 0.10 | 1.2 | 115 | 0.09 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.2 | 130 | 0.10 | 1.2 | 75 | 0.09 | 1.2 | 120 | 0.10 | 1.2 | 390 | 0.12 | 1.2 | – | – | – | – | – | – |
| | **T8430** | 0.2 | 165 | 0.10 | 1.2 | 90 | 0.09 | 1.2 | 135 | 0.10 | 1.2 | 450 | 0.12 | 1.2 | – | – | – | – | – | – |
| | **T9315** | 0.2 | 230 | 0.10 | 1.2 | – | – | – | 215 | 0.10 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.2 | 205 | 0.10 | 1.2 | 120 | 0.09 | 1.2 | 190 | 0.10 | 1.2 | – | – | – | – | – | – | – | – | – |
| **VBMT 160404E-FM** | **T5315** | 0.4 | 225 | 0.12 | 1.2 | – | – | – | 210 | 0.12 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 0.4 | 130 | 0.19 | 1.2 | 100 | 0.17 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 0.4 | 130 | 0.19 | 1.2 | 100 | 0.17 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.4 | 140 | 0.12 | 1.2 | 80 | 0.11 | 1.2 | 130 | 0.12 | 1.2 | 420 | 0.14 | 1.2 | – | – | – | – | – | – |
| | **T8330** | 0.4 | 135 | 0.12 | 1.2 | 80 | 0.11 | 1.2 | 125 | 0.12 | 1.2 | 405 | 0.14 | 1.2 | – | – | – | – | – | – |
| | **T8430** | 0.4 | 165 | 0.12 | 1.2 | 90 | 0.11 | 1.2 | 135 | 0.12 | 1.2 | 450 | 0.14 | 1.2 | – | – | – | – | – | – |
| | **T9315** | 0.4 | 225 | 0.12 | 1.2 | – | – | – | 210 | 0.12 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 165 | 0.19 | 1.2 | 95 | 0.17 | 1.2 | 155 | 0.19 | 1.2 | – | – | – | – | – | – | – | – | – |

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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-geometri til fin til halv grov bearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | |
| **VBMT 160408E-FM** | **T5315** | 0.8 | 235 | 0.17 | 1.2 | – | – | – | 220 | 0.17 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 0.8 | 165 | 0.17 | 1.2 | 125 | 0.15 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 0.8 | 160 | 0.17 | 1.2 | 120 | 0.15 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.8 | 150 | 0.17 | 1.2 | 90 | 0.15 | 1.2 | 140 | 0.17 | 1.2 | 450 | 0.20 | 1.2 | – | – | – | – | – | – |
| | **T8330** | 0.8 | 145 | 0.17 | 1.2 | 85 | 0.15 | 1.2 | 135 | 0.17 | 1.2 | 435 | 0.20 | 1.2 | – | – | – | – | – | – |
| | **T8430** | 0.8 | 170 | 0.17 | 1.2 | 90 | 0.15 | 1.2 | 135 | 0.17 | 1.2 | 465 | 0.20 | 1.2 | – | – | – | – | – | – |
| | **T9310** | 0.8 | 255 | 0.17 | 1.2 | – | – | – | 240 | 0.17 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.8 | 230 | 0.17 | 1.2 | – | – | – | 215 | 0.17 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 205 | 0.17 | 1.2 | 120 | 0.15 | 1.2 | 190 | 0.17 | 1.2 | – | – | – | – | – | – | – | – | – |
| **VBMT 160412E-FM** | **T7325** | 1.2 | 160 | 0.22 | 1.2 | 120 | 0.22 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 1.2 | 140 | 0.22 | 1.2 | 80 | 0.22 | 1.2 | 130 | 0.22 | 1.2 | 420 | 0.26 | 1.2 | – | – | – | – | – | – |
| | **T8430** | 1.2 | 155 | 0.22 | 1.2 | 85 | 0.22 | 1.2 | 130 | 0.22 | 1.2 | 435 | 0.26 | 1.2 | – | – | – | – | – | – |
| | **T9315** | 1.2 | 215 | 0.22 | 1.2 | – | – | – | 200 | 0.22 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | 195 | 0.22 | 1.2 | 115 | 0.22 | 1.2 | 185 | 0.22 | 1.2 | – | – | – | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | FM2 geometri til fin til medium bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **VBMT 160404E-FM2** | **T6310** | 0.4 | 120 | 0.12 | 1.2 | 85 | 0.11 | 1.2 | 95 | 0.12 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 0.4 | 140 | 0.12 | 1.2 | 105 | 0.11 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.4 | 125 | 0.12 | 1.2 | 75 | 0.11 | 1.2 | 115 | 0.12 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.4 | 145 | 0.12 | 1.2 | 80 | 0.11 | 1.2 | 120 | 0.12 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.4 | 200 | 0.12 | 1.2 | – | – | – | 190 | 0.12 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 185 | 0.12 | 1.2 | 110 | 0.11 | 1.2 | 175 | 0.12 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.4 | 155 | 0.12 | 1.2 | 90 | 0.11 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| **VBMT 160408E-FM2** | **T6310** | 0.8 | 125 | 0.20 | 1.2 | 90 | 0.18 | 1.2 | 100 | 0.20 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 0.8 | 145 | 0.20 | 1.2 | 110 | 0.18 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.8 | 125 | 0.20 | 1.2 | 75 | 0.18 | 1.2 | 115 | 0.20 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.8 | 140 | 0.20 | 1.2 | 75 | 0.18 | 1.2 | 115 | 0.20 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.8 | 195 | 0.20 | 1.2 | – | – | – | 185 | 0.20 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 175 | 0.20 | 1.2 | 105 | 0.18 | 1.2 | 165 | 0.20 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.8 | 150 | 0.20 | 1.2 | 90 | 0.18 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| **VBMT 160412E-FM2** | **T8430** | 1.2 | 145 | 0.22 | 1.2 | 80 | 0.20 | 1.2 | 120 | 0.22 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 1.2 | 195 | 0.22 | 1.2 | – | – | – | 185 | 0.22 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | 175 | 0.22 | 1.2 | 105 | 0.20 | 1.2 | 165 | 0.22 | 1.2 | – | – | – | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | RM-geometri til semi-grov til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **VBMT 160404E-RM** | **T5305** | 0.4 | 270 | 0.12 | 1.2 | – | – | – | 255 | 0.12 | 1.2 | – | – | – | – | – | – | 50 | 0.15 | 1.0 |
| | **T5315** | 0.4 | 235 | 0.12 | 1.2 | – | – | – | 220 | 0.12 | 1.2 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |
| | **T7335** | 0.4 | 140 | 0.18 | 1.2 | 105 | 0.16 | 1.2 | – | – | – | – | – | – | 45 | 0.16 | 1.0 | – | – | – |
| | **T8330** | 0.4 | 140 | 0.12 | 1.2 | 80 | 0.11 | 1.2 | 130 | 0.12 | 1.2 | – | – | – | 35 | 0.11 | 1.0 | 25 | 0.15 | 1.0 |
| | **T8430** | 0.4 | 170 | 0.12 | 1.2 | 90 | 0.11 | 1.2 | 135 | 0.12 | 1.2 | – | – | – | 35 | 0.11 | 1.0 | 25 | 0.15 | 1.0 |
| | **T9315** | 0.4 | 235 | 0.12 | 1.2 | – | – | – | 220 | 0.12 | 1.2 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |
| | **T9325** | 0.4 | 170 | 0.20 | 1.2 | 100 | 0.18 | 1.2 | 160 | 0.20 | 1.2 | – | – | – | 35 | 0.18 | 1.0 | – | – | – |
| **VBMT 160408E-RM** | **T5305** | 0.8 | 285 | 0.17 | 1.2 | – | – | – | 270 | 0.17 | 1.2 | – | – | – | – | – | – | 55 | 0.15 | 1.0 |
| | **T5315** | 0.8 | 250 | 0.17 | 1.2 | – | – | – | 235 | 0.17 | 1.2 | – | – | – | – | – | – | 50 | 0.15 | 1.0 |
| | **T7335** | 0.8 | 155 | 0.20 | 1.2 | 120 | 0.18 | 1.2 | – | – | – | – | – | – | 50 | 0.18 | 1.0 | – | – | – |
| | **T8330** | 0.8 | 150 | 0.17 | 1.2 | 90 | 0.15 | 1.2 | 140 | 0.17 | 1.2 | – | – | – | 35 | 0.12 | 1.0 | 30 | 0.15 | 1.0 |
| | **T8430** | 0.8 | 175 | 0.17 | 1.2 | 95 | 0.15 | 1.2 | 140 | 0.17 | 1.2 | – | – | – | 35 | 0.12 | 1.0 | 30 | 0.15 | 1.0 |
| | **T9315** | 0.8 | 240 | 0.17 | 1.2 | – | – | – | 225 | 0.17 | 1.2 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |
| | **T9325** | 0.8 | 200 | 0.20 | 1.2 | 120 | 0.18 | 1.2 | 190 | 0.20 | 1.2 | – | – | – | 45 | 0.18 | 1.0 | – | – | – |

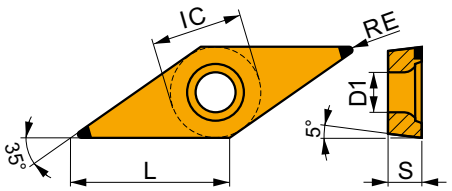
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |  | |  | | | | | | | | | | | | | | | | | |
| RM-geometri til semi-grov til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **VBMT 160412E-RM** | **T7335** | 1.2 | 150 | 0.27 | 1.2 | 115 | 0.24 | 1.2 | – | – | – | – | – | – | 45 | 0.19 | 1.0 | – | – | – |
| | **T8330** | 1.2 | 140 | 0.27 | 1.2 | 80 | 0.24 | 1.2 | 130 | 0.27 | 1.2 | – | – | – | 35 | 0.19 | 1.0 | 25 | 0.15 | 1.0 |
| | **T8430** | 1.2 | 155 | 0.27 | 1.2 | 85 | 0.24 | 1.2 | 130 | 0.27 | 1.2 | – | – | – | 30 | 0.19 | 1.0 | 25 | 0.15 | 1.0 |
| | **T9315** | 1.2 | 210 | 0.27 | 1.2 | – | – | – | 195 | 0.27 | 1.2 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| | **T9325** | 1.2 | 185 | 0.27 | 1.2 | 110 | 0.24 | 1.2 | 175 | 0.27 | 1.2 | – | – | – | 40 | 0.19 | 1.0 | – | – | – |
|  |  | |  | | | | | | | | | | | | | | | | | |
| UR-geometri til finbearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | | | | |
| **VBMT 110202E-UR** | **TT310** | 0.2 | 195 | 0.10 | 0.8 | 115 | 0.09 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| **VBMT 110204E-UR** | **T7325** | 0.4 | 120 | 0.19 | 0.8 | 90 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.4 | 120 | 0.12 | 0.8 | 70 | 0.11 | 0.8 | 110 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.4 | 145 | 0.12 | 0.8 | 80 | 0.11 | 0.8 | 120 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.4 | 200 | 0.12 | 0.8 | – | – | – | 190 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 150 | 0.19 | 0.8 | 90 | 0.17 | 0.8 | 140 | 0.19 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **TT310** | 0.4 | 195 | 0.12 | 0.8 | 115 | 0.11 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| **VBMT 160402E-UR** | **T8330** | 0.2 | 115 | 0.10 | 1.2 | 65 | 0.09 | 1.2 | 105 | 0.10 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **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 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 0.4 | 115 | 0.19 | 1.2 | 85 | 0.17 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.4 | 115 | 0.12 | 1.2 | 65 | 0.11 | 1.2 | 105 | 0.12 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.4 | 140 | 0.12 | 1.2 | 75 | 0.11 | 1.2 | 115 | 0.12 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9310** | 0.4 | 215 | 0.12 | 1.2 | – | – | – | 200 | 0.12 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.4 | 190 | 0.12 | 1.2 | – | – | – | 180 | 0.12 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 145 | 0.18 | 1.2 | 85 | 0.16 | 1.2 | 135 | 0.18 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **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 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 0.8 | 140 | 0.17 | 1.2 | 105 | 0.15 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.8 | 125 | 0.17 | 1.2 | 75 | 0.15 | 1.2 | 115 | 0.17 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.8 | 145 | 0.17 | 1.2 | 80 | 0.15 | 1.2 | 120 | 0.17 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9310** | 0.8 | 220 | 0.17 | 1.2 | – | – | – | 205 | 0.17 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.8 | 200 | 0.17 | 1.2 | – | – | – | 190 | 0.17 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 180 | 0.17 | 1.2 | 105 | 0.15 | 1.2 | 170 | 0.17 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **TT310** | 0.8 | 200 | 0.17 | 1.2 | 120 | 0.15 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| **VBMT 160412E-UR** | **T7325** | 1.2 | 135 | 0.22 | 1.2 | 105 | 0.20 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 1.2 | 120 | 0.22 | 1.2 | 70 | 0.20 | 1.2 | 110 | 0.22 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 1.2 | 135 | 0.22 | 1.2 | 75 | 0.20 | 1.2 | 110 | 0.22 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9310** | 1.2 | 205 | 0.22 | 1.2 | – | – | – | 190 | 0.22 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 1.2 | 185 | 0.22 | 1.2 | – | – | – | 175 | 0.22 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | 170 | 0.22 | 1.2 | 100 | 0.20 | 1.2 | 160 | 0.22 | 1.2 | – | – | – | – | – | – | – | – | – |

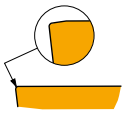
# VBGW CBN

PRAMET

| | IC (mm) | D1 (mm) | L (mm) | S (mm) |
|---|---|---|---|---|
| 1604 | 9.525 | 4.50 | 16.00 | 4.76 |




Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | HSC | | S | | | | | | | | | | | | | | | |
| | | | Til færdigbearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | |
| **VBGW 160404S01020B** | **TB310** | 0.4 | – | – | – | – | – | – | ◪ 340 | 0.10 | 0.4 | – | – | – | ◪ 90 | 0.07 | 0.3 | ■ 70 | 0.15 | 1.0 |
| **VBGW 160408S01020B** | **TB310** | 0.8 | – | – | – | – | – | – | ◪ 350 | 0.15 | 0.6 | – | – | – | ◪ 90 | 0.11 | 0.5 | ■ 70 | 0.15 | 1.0 |

# SVHB(C)(RL) EXT

P M K N S H

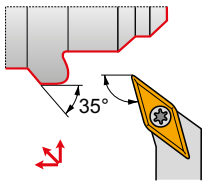
PRAMET

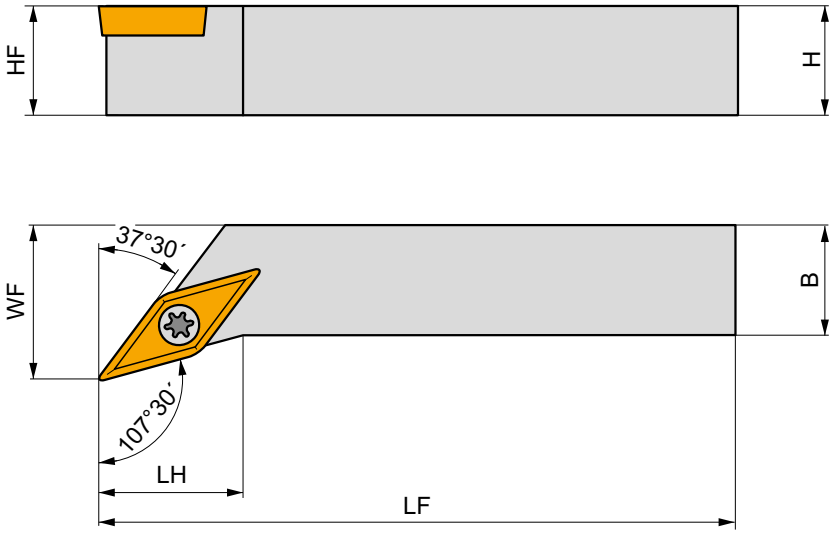
S

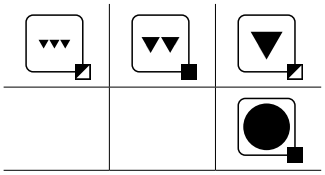


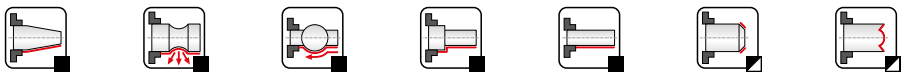
## Ekstern skruelåsværktøjsholder med 107.5 ° skærevinkel til VB/VC.. Skær

Ekstern højre / venstre værktøjsholder til skruetype positive VB .. 11 eller 16 og VC .. 11 eller 16 skær. Velegnet til udvendigt ende og langsgående drejning med skulder, tilspidsning, ende og længdekopi, der drejer op til 35 ° og affasning. Fås med skaftstørrelse 16x16 op til 25x25 mm. Krop behandlet for længere levetid på værktøjet.





| | 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 | 0.21 | GI194 | S01 |
| | **SVHCR 2020 K 16-M-A** | 20 | 20 | 20 | 25 | 125 | 20 | 0 | 0 | 0.40 | GI017 | SV10 |
| | **SVHCR 2525 M 16-M-A** | 25 | 25 | 25 | 32 | 150 | 20 | 0 | 0 | 0.68 | GI017 | SV10 |
| L | **SVHBL 1616 H 11** | 16 | 16 | 16 | 20 | 100 | 14 | 0 | 0 | 0.19 | GI194 | S01 |
| | **SVHCL 2020 K 16-M-A** | 20 | 20 | 20 | 25 | 125 | 20 | 0 | 0 | 0.40 | GI017 | SV10 |
| | **SVHCL 2525 M 16-M-A** | 25 | 25 | 25 | 32 | 150 | 20 | 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

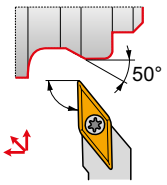
PRAMET

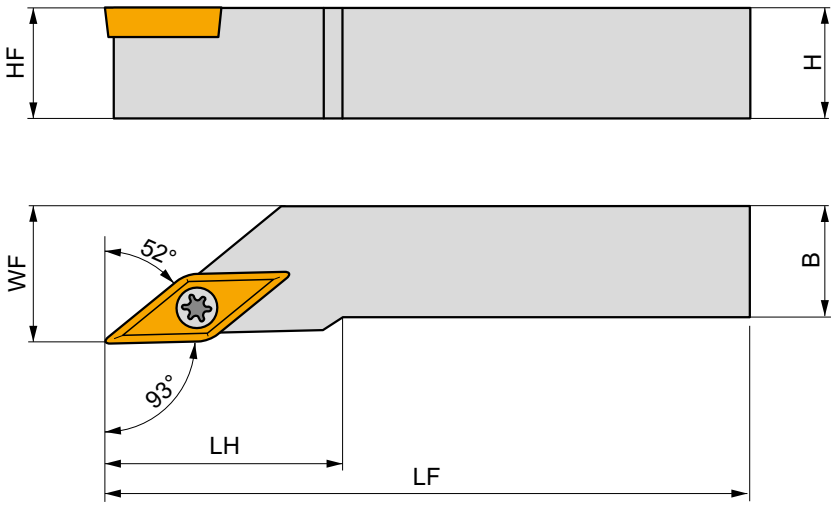
S

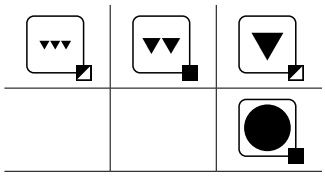


## Ekstern skruelåsværktøjsholder med 93 ° skærevinkel til VB/VC.. Skær

Ekstern højre / venstre værktøjsholder til skruetype positiv VB .. 11 eller 16 og VC .. 11 op til 16 skær. Velegnet til udvendig langsgående drejning med skulder, tilspidsning, kopidrejning op til 50 ° og affasning. Fås med skaftstørrelse 12x12 op til 32x25 mm. Krop behandlet for længere levetid på værktøjet.





| | 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 | 0.09 | GI194 | S01 |
| | SVJBR 1616 H 11 | 16 | 16 | 16 | 20 | 100 | 20 | 0 | 0 | 0.20 | GI194 | S01 |
| | SVJCR 1212 N 13 | 12 | 12 | 12 | 16 | 160 | 27 | 0 | 0 | 0.19 | GI211 | SV21 |
| | SVJCR 1616 H 13 | 16 | 16 | 16 | 20 | 100 | 30 | 0 | 0 | 0.20 | GI211 | SV21 |
| | SVJCR 2020 K 13 | 20 | 20 | 20 | 25 | 125 | 30 | 0 | 0 | 0.37 | GI211 | SV22 |
| | SVJCR 2525 M 13 | 25 | 25 | 25 | 32 | 150 | 30 | 0 | 0 | 0.67 | GI211 | SV22 |
| | SVJCR 2020 K 16-M-A | 20 | 20 | 20 | 25 | 125 | 28 | 0 | 0 | 0.35 | GI017 | SV10 |
| | SVJCR 2525 M 16-M-A | 25 | 25 | 25 | 32 | 150 | 32 | 0 | 0 | 0.68 | GI017 | SV10 |
| | SVJCR 3225 P 16-M-A | 32 | 25 | 32 | 32 | 170 | 32 | 0 | 0 | 0.99 | GI017 | SV10 |
| L | SVJBL 1212 F 11 | 12 | 12 | 12 | 16 | 80 | 20 | 0 | 0 | 0.09 | GI194 | S01 |
| | SVJBL 1616 H 11 | 16 | 16 | 16 | 20 | 100 | 20 | 0 | 0 | 0.19 | GI194 | S01 |
| | SVJCL 1212 N 13 | 12 | 12 | 12 | 16 | 160 | 27 | 0 | 0 | 0.19 | GI211 | SV21 |
| | SVJCL 1616 H 13 | 16 | 16 | 16 | 20 | 100 | 30 | 0 | 0 | 0.20 | GI211 | SV21 |
| | SVJCL 2020 K 13 | 20 | 20 | 20 | 25 | 125 | 30 | 0 | 0 | 0.37 | GI211 | SV22 |
| | SVJCL 2525 M 13 | 25 | 25 | 25 | 32 | 150 | 30 | 0 | 0 | 0.67 | GI211 | SV22 |
| | SVJCL 2020 K 16-M-A | 20 | 20 | 20 | 25 | 125 | 28 | 0 | 0 | 0.40 | GI017 | SV10 |
| | SVJCL 2525 M 16-M-A | 25 | 25 | 25 | 32 | 150 | 32 | 0 | 0 | 0.70 | GI017 | SV10 |
| | SVJCL 3225 P 16-M-A | 32 | 25 | 32 | 32 | 170 | 32 | 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

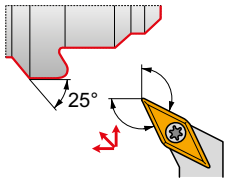
PRAMET

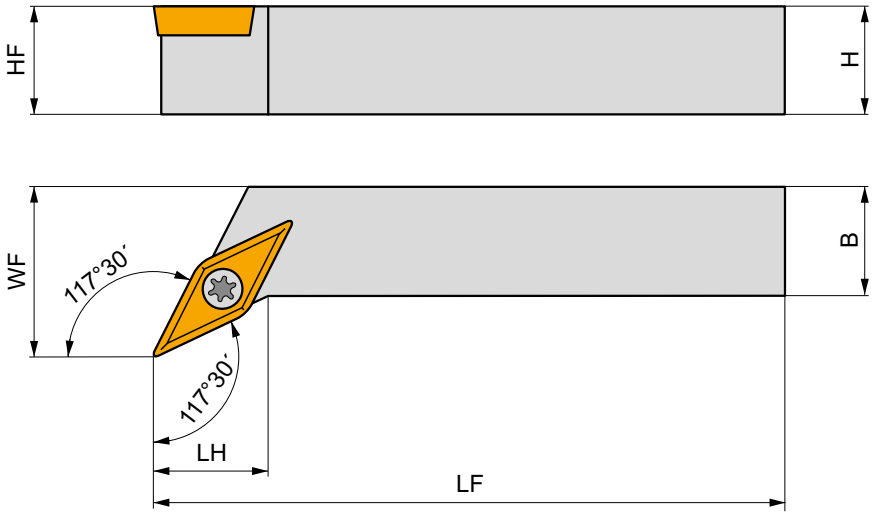
S

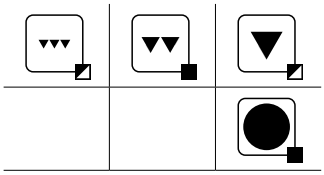


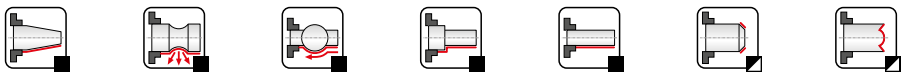
## Ekstern skruelåsværktøjsholder med 117.5 ° skærevinkel til VB/VC.. Skær

Ekstern højre / venstre værktøjsholder til skruetype positive VB .. 11 eller 16 og VC .. 11 eller 16 skær. Velegnet til udvendigt ende og langsgående drejning med skulder, tilspidsning, ansigtskopi, der drejer op til 25 ° og affasning. Fås med skaftstørrelse 16x16 op til 32x25 mm. Krop behandlet for længere levetid på værktøjet.





| | 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 | 0.20 | GI194 | S01 |
| | SVPBR 2020 K 11 | 20 | 20 | 20 | 25 | 125 | 12 | 0 | 0 | 0.41 | GI194 | S01 |
| | SVPCR 2020 K 16-M-A | 20 | 20 | 20 | 25 | 125 | 20 | 0 | 0 | 0.40 | GI017 | SV10 |
| | SVPCR 2525 M 16-M-A | 25 | 25 | 25 | 32 | 150 | 25 | 0 | 0 | 0.75 | GI017 | SV10 |
| | SVPCR 3225 P 16-M-A | 32 | 25 | 32 | 32 | 170 | 25 | 0 | 0 | 1.10 | GI017 | SV10 |
| L | SVPBL 1616 H 11 | 16 | 16 | 16 | 20 | 100 | 12 | 0 | 0 | 0.20 | GI194 | S01 |
| | SVPBL 2020 K 11 | 20 | 20 | 20 | 25 | 125 | 12 | 0 | 0 | 0.39 | GI194 | S01 |
| | SVPCL 2020 K 16-M-A | 20 | 20 | 20 | 25 | 125 | 20 | 0 | 0 | 0.70 | GI017 | SV10 |
| | SVPCL 2525 M 16-M-A | 25 | 25 | 25 | 32 | 150 | 25 | 0 | 0 | 0.70 | GI017 | SV10 |
| | SVPCL 3225 P 16-M-A | 32 | 25 | 32 | 32 | 170 | 25 | 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

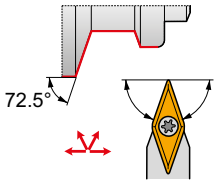
PRAMET

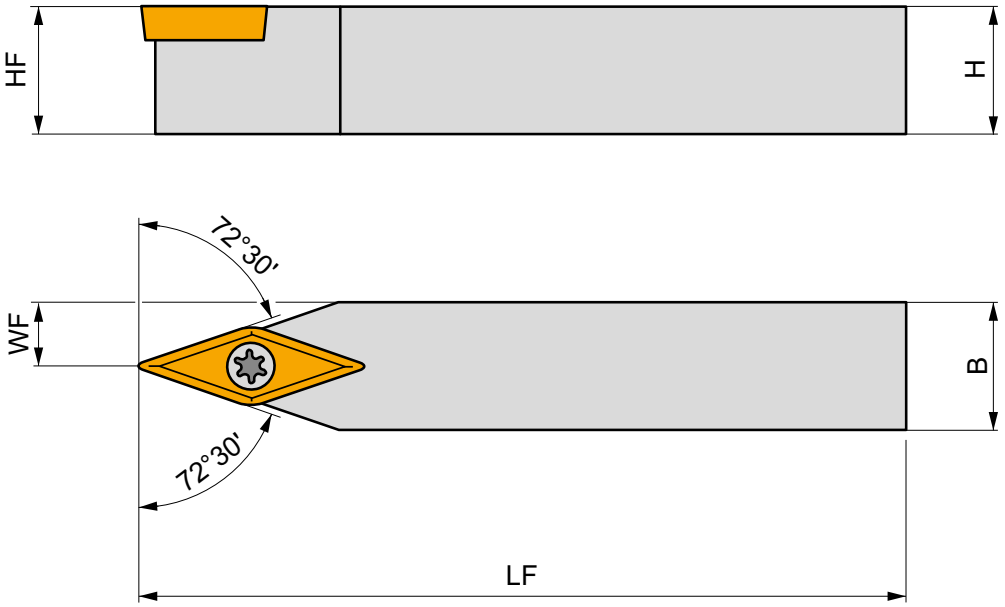
S

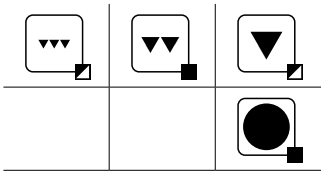


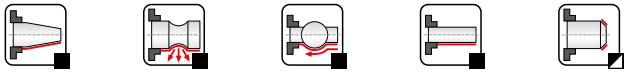
## Ekstern skruelåsværktøjsholder, 72,5 ° skærevinkel til VB / VC .. Skær

Ekstern neutral værktøjsholder til skruetype positiv VB .. 11 eller 16 og VC .. 11 op til 16 skær. Velegnet til udvendig langsgående drejning uden skulder, tilspidsning, kopidrejning op til 72,5 ° og affasning. Fås med skaftstørrelse 12x12 op til 32x25 mm. Krop behandlet for længere levetid





| | 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 | 0.11 | GI194 | S01 |
| | **SVVBN 1616 H 11** | 16 | 16 | 16 | 8 | 100 | – | 0 | 0 | 0.18 | GI194 | S01 |
| | **SVVBN 2020 K 11** | 20 | 20 | 20 | 10 | 125 | – | 0 | 0 | 0.38 | 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 | 0.68 | GI017 | SV10 |
| | **SVVCN 3225 P 16-M-A** | 32 | 25 | 32 | 12.5 | 170 | – | 0 | 0 | 0.98 | 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

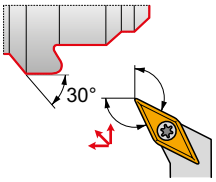
PRAMET

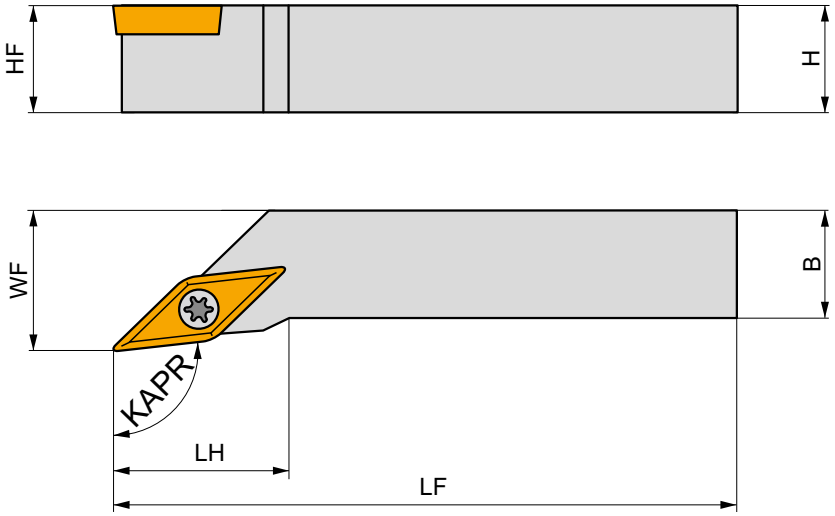
S

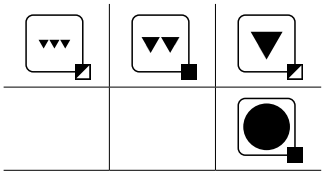


## Ekstern skruelåsværktøjsholder med 98/113 ° skærevinkel til VB/VC.. Skær

Ekstern højre / venstre værktøjsholder til skruetype positiv VB .. 11 eller 16 og VC .. 11 op til 16 skær. Velegnet til udvendig langsgående drejning med skulder, tilspidsning, kopidrejning op til 30 ° og affasning. Fås med skaftstørrelse 12x12 op til 32x25 mm. Krop behandlet for længere levetid på værktøjet.





| | 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 | 98 | 0 | 0 | 0.09 | GI194 | SO1 |
| | **SVXBR 1616 H 11** | 16 | 16 | 16 | 20 | 100 | 14 | 98 | 0 | 0 | 0.19 | GI194 | SO1 |
| | **SVXCR 2020 K 13** | 20 | 20 | 20 | 25 | 125 | 12 | 113 | 0 | 0 | 0.38 | GI211 | SV22 |
| | **SVXCR 2020 K 16-M-A** | 20 | 20 | 20 | 25 | 125 | 28 | 98 | 0 | 0 | 0.41 | GI017 | SV10 |
| | **SVXCR 2525 M 16-M-A** | 25 | 25 | 25 | 32 | 150 | 32 | 98 | 0 | 0 | 0.68 | GI017 | SV10 |
| | **SVXCR 3225 P 16-M-A** | 32 | 25 | 32 | 32 | 170 | 32 | 98 | 0 | 0 | 1.00 | GI017 | SV10 |
| L | **SVXBL 1212 F 11** | 12 | 12 | 12 | 16 | 80 | 20 | 98 | 0 | 0 | 0.09 | GI194 | SO1 |
| | **SVXBL 1616 H 11** | 16 | 16 | 16 | 20 | 100 | 14 | 98 | 0 | 0 | 0.19 | GI194 | SO1 |
| | **SVXCL 2020 K 13** | 20 | 20 | 20 | 25 | 125 | 12 | 113 | 0 | 0 | 0.38 | GI211 | SV22 |
| | **SVXCL 2020 K 16-M-A** | 20 | 20 | 20 | 25 | 125 | 28 | 98 | 0 | 0 | 0.38 | GI017 | SV10 |
| | **SVXCL 2525 M 16-M-A** | 25 | 25 | 25 | 32 | 150 | 32 | 98 | 0 | 0 | 0.69 | GI017 | SV10 |
| | **SVXCL 3225 P 16-M-A** | 32 | 25 | 32 | 32 | 170 | 32 | 98 | 0 | 0 | 0.99 | GI017 | SV10 |

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

| | | Nm | | | | | | |
|---|---|---|---|---|---|---|---|---|
| SO1 | 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 |

NEW

# C.-SVHB(RL) EXT

P M K N S H

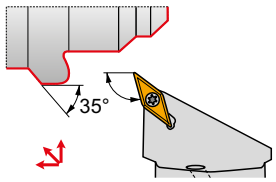
PRAMET

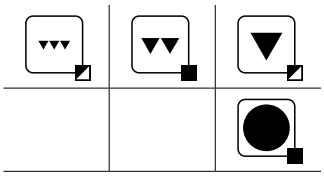
S

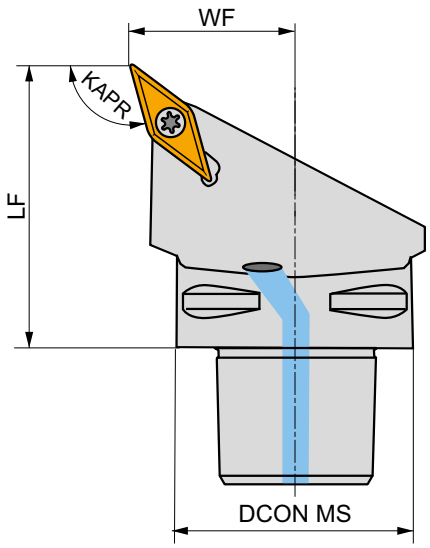


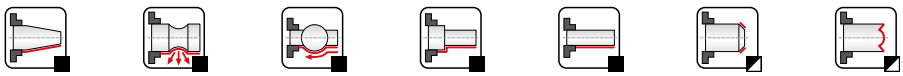
## Ekst. PSC Quick Change, skruelås, 107,5 ° skærevinkel, VB / VC .. skær

Eksternt højre / venstre værktøj, gennemgåendekølevæske, til skruetype positive VB .. 16 og VC .. 16 skær. Velegnet til udvendig langsgående drejning med skulder, tilspidsning, kopidrejning op til 35 ° og affasning. Fås med PSC (Polygon Shank Coupling) størrelse C4 op til C6. Krop behandlet for længere levetid på værktøjet.





| | 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 |

NEW

# C.-SVJB(RL) EXT

P M K N S H

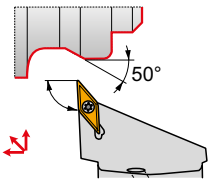
PRAMET

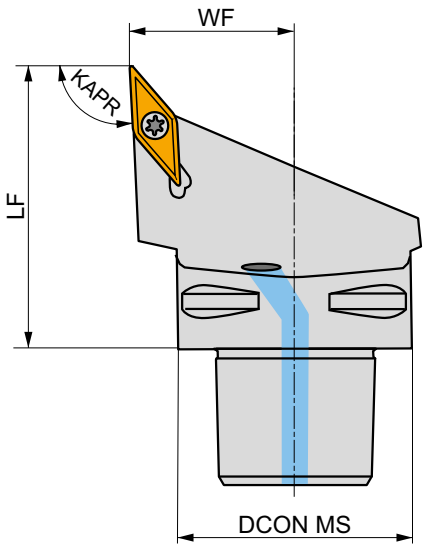
S

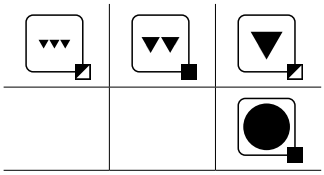


## Ekst. PSC Hurtig skift værktøj, skruelås, 93 ° skærevinkel til VB / VC .. skær

Eksternt højre / venstre værktøj gennemgående kølevæske til skruetype positiv VB .. 11 eller 16 og VC .. 11 op til 16 skær. Velegnet til udvendig langsgående drejning med skulder, tilspidsning, kopidrejning op til 50 ° og affasning. Fås med PSC (Polygon Shank Coupling) størrelse C3 op til C6. Krop behandlet for længere levetid på værktøjet.





| | 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 | ✓ | 0.35 | 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 |

NEW

# C.-SVVBN EXT

P M K N S H

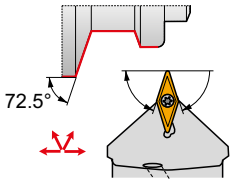
PRAMET

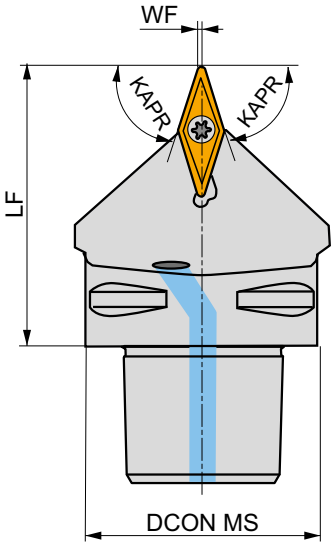
S

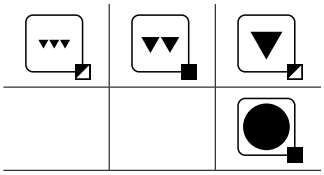


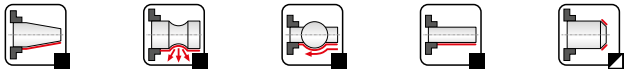
## Ekst. PSC Quick Change Tool, skruelås, 72,5 ° skærevinkel, VB / VC .. Skær

Eksternt neutralt værktøj indvendig kølevæske til skruetype positive VB .. 16 og VC .. 16 skær. Velegnet til udvendig langsgående drejning uden skulder, tilspidsning, kopidrejning op til 72,5 ° og affasning. Fås med PSC (Polygon Shank Coupling) størrelse C4 op til C6. Krop behandlet for længere levetid





| | 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

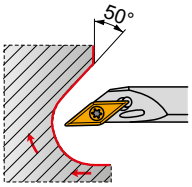
PRAMET

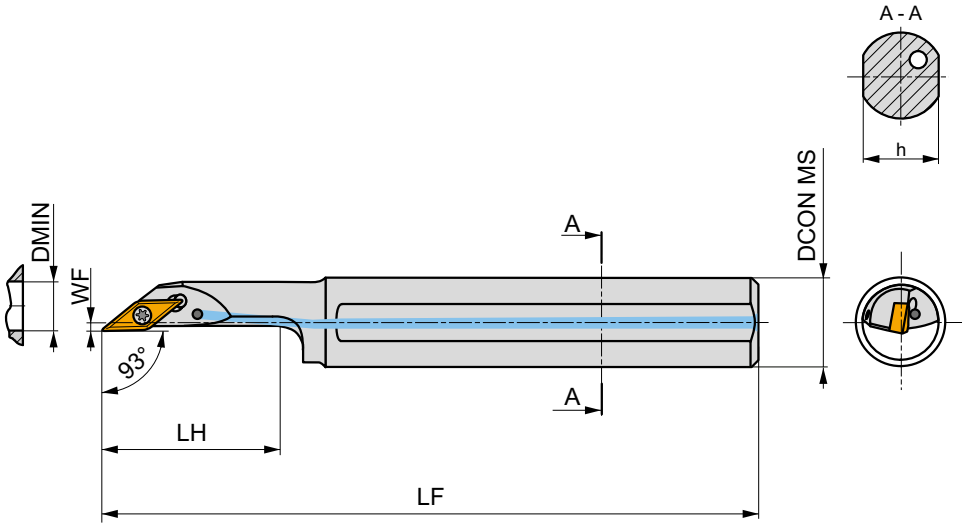
S

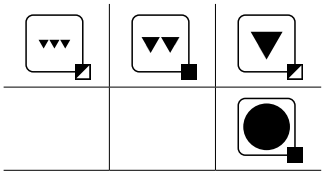


## Intern skruelåsborestang med 93 ° skærevinkel til VB/VC .. Skær

Intern højre / venstre borestang, indvendig kølevæske, med 93° skærevinkel til skrue type VB .. 11 og VC .. 11. Mindste indvendige drejediameter Ø25 mm. Velegnet til endekopi, der bliver under 50°. Fås med skaftstørrelse Ø20 og Ø25 mm. Krop behandlet for længere levetid på værktøjet.





| | 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 | -5 | -5 | ✓ | 0.44 | GI194 | S07 |
| | A25S-SVJBR 11 | 25 | 32 | 3.5 | 23 | 250 | 50 | -5 | -5 | ✓ | 0.82 | GI194 | S07 |
| L | A20R-SVJBL 11 | 20 | 25 | 2 | 18 | 200 | 40 | -5 | -5 | ✓ | 0.42 | GI194 | S07 |
| | A25S-SVJBL 11 | 25 | 32 | 3.5 | 23 | 250 | 50 | -5 | -5 | ✓ | 0.82 | GI194 | S07 |

| | | |
|---|---|---|
| GI194 | VB.. 1103.. | VC.. 1103.. |

| | | | | | |
|---|---|---|---|---|---|
| S07 | US 2506-T07P | 0.9 Nm | M 2.5 | 6.3 | FLAG T07P |

# SVQB(C)(RL) INT

P M K N S H

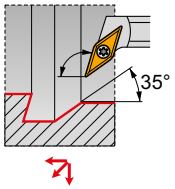
PRAMET

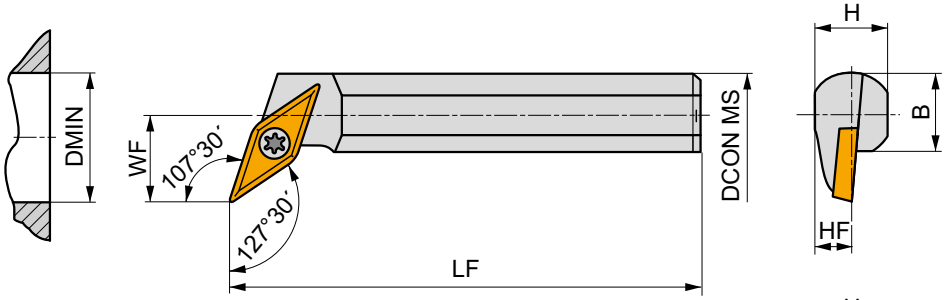
S

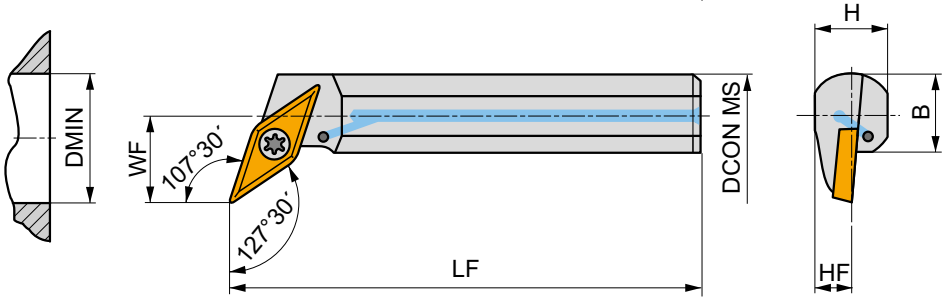


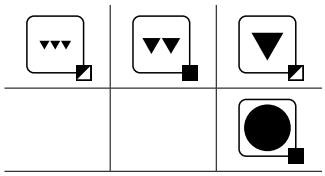
## Intern skruelåsborestang med 107.5 ° skærevinkel til VB/VC .. Skær

Intern højre / venstre borestang, indvendig kølevæske med 107,5 107 skærevinkel til skruetype VB ../ VC .. 11 og 16 skær. Mindste indvendige drejediameter Ø20 mm. Velegnet til en bred vifte af interne drejeoperationer. Fås med skaftstørrelse Ø16 op til Ø40 mm.





| | 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 | ✓ | 0.58 | GI194 | S01 |
| | A16R-SVQCR 13 | 16 | 21 | 11 | 15 | 15 | 200 | -6 | 0 | ✓ | 0.30 | 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 | – | 1.10 | 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 | ✓ | 0.33 | GI194 | S01 |
| | A20S-SVQBL 11 | 20 | 25 | 13 | 18 | 18.5 | 250 | -4 | 0 | ✓ | 0.58 | 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 | – | 1.09 | 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

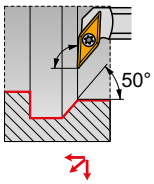
PRAMET

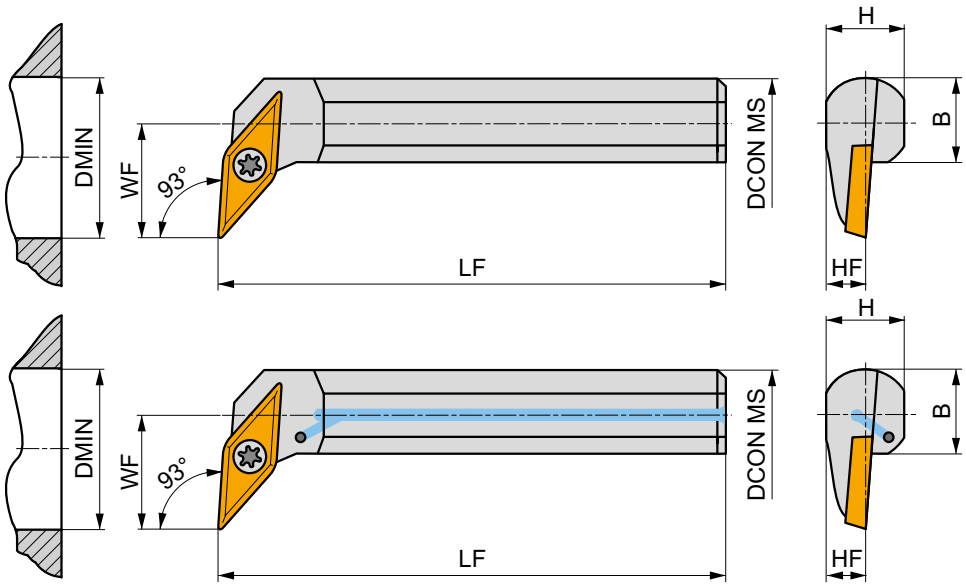
S

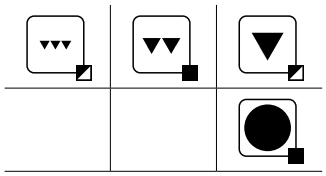


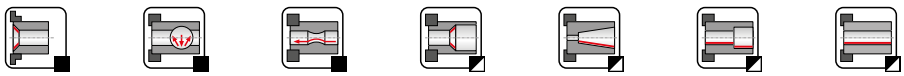
## Intern skruelåsborestang med 93 ° skærevinkel til VB/VC .. Skær

Intern højre / venstre borestang, indvendig kølevæske med 93° skærevinkel til skruetype VB ../ VC .. 11 og 16 skær. Mindste indvendige drejediameter Ø20 mm. Til en bred vifte af interne drejeoperationer og kopiering under 50 under. Ø16 op til Ø40 mm skaft fås. Krop behandlet for længere levetid på værktøjet.





| | 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 | ✓ | 0.34 | GI194 | S01 |
| | A20S-SVUBR 11 | 20 | 25 | 13 | 18 | 18.8 | 250 | -4 | 0 | ✓ | 0.58 | GI194 | S01 |
| | A20S-SVUCR 13 | 20 | 25 | 13 | 19 | 18.5 | 250 | -4 | 2 | ✓ | 0.40 | 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 | ✓ | 1.70 | GI211 | SV22 |
| | S25T-SVUCR 16 | 25 | 32 | 17 | 23 | 23 | 300 | -7 | 0 | – | 1.10 | 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 | ✓ | 0.34 | GI194 | S01 |
| | A20S-SVUBL 11 | 20 | 25 | 13 | 18 | 18.5 | 250 | -4 | 0 | ✓ | 0.58 | 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 | ✓ | 1.70 | GI211 | SV22 |
| | S25T-SVUCL 16 | 25 | 32 | 17 | 23 | 23 | 300 | -7 | 0 | – | 1.10 | 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 |

NEW

# C.-SVQB(RL) INT

P M K N S H

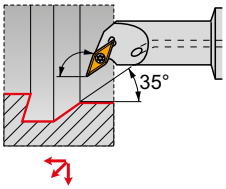
PRAMET

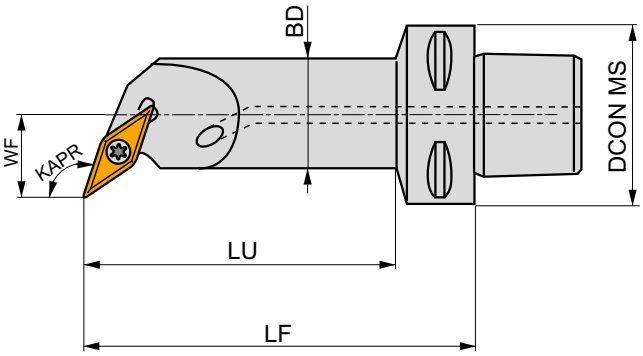
S

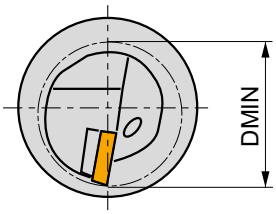


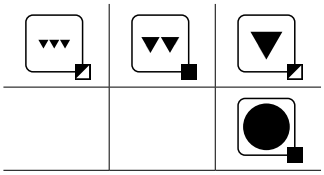
## Int. PSC Hurtig skift værktøj, skruelås, 107,5 ° skærevinkel, VB / VC .. Skær

Internt højre / venstre hånd, indvendig kølevæske, med 107,5° skærevinkel til skruetype VB .. 16 eller VC .. 16 skær. Mindste indvendige drejediameter Ø33 mm. Velegnet til en bred vifte af interne drejeoperationer. PSC-skaft (Polygon Shank Coupling) størrelse C4 og C5 med valg af længder. Krop behandlet for længere levetid på værktøjet.





| | 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.. |

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

# VC

07/ 11/ 13/ 16

## CARBIDE INSERTS

### VCGT



186

### VCGW



189

### VCGX



189

### VCMT



190

### VCMW



191

## PCD INSERTS

### VCMW PCD

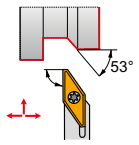


192

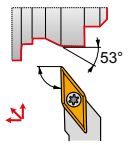
| MATCH THE RIGHT SIZE (example) | |
|---|---|
| **Insert** | **Tool Holder** |
| VCGT **07**0204E-FF2 | SVGCR 1010 M **07** |

## ISO-DREJNING – UDVENDIGT

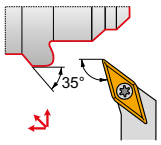
### SVAC(RL)-DC EXT

| 90° | VC.. |
|---|---|
|  | 13 |
| 10×10<br>25×25 | |
| 193 | 186 – 192 |

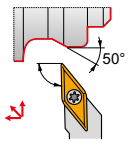
### SVGC(RL) EXT

| 90° | VC.. |
|---|---|
|  | 07 |
| 08×08<br>16×16 | |
| 194 | 186 – 192 |

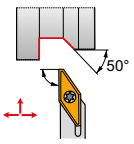
### SVHB(C)(RL) EXT

| 107°30´ | VB, VC.. |
|---|---|
|  | 11<br>16 |
| 16×16<br>25×25 | |
| 195 | 168 – 171<br>186 – 192 |

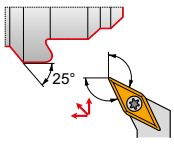
### SVJB(C)(RL) EXT

| 93° | VB, VC.. |
|---|---|
|  | 11<br>13<br>16 |
| 12×12<br>32×25 | |
| 196 | 168 – 171<br>186 – 192 |

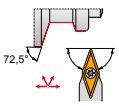
### SVJC(RL)-DC EXT

| 93° | VC.. |
|---|---|
|  | 13 |
| 10×10<br>25×25 | |
| 197 | 186 – 192 |

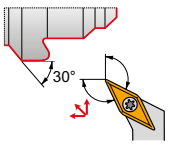
### SVPB(C)(RL) EXT

| 117°30´ | VB, VC.. |
|---|---|
|  | 11<br>16 |
| 16×16<br>32×25 | |
| 198 | 168 – 171<br>186 – 192 |

### SVVB(C)N EXT

| 72°30´ | VB, VC.. |
|---|---|
|  | 11<br>13<br>16 |
| 12×12<br>32×25 | |
| 199 | 168 – 171<br>186 – 192 |

### SVXB(C)(RL) EXT

| 98° | VB, VC.. |
|---|---|
|  | 11<br>13<br>16 |
| 12×12<br>32×25 | |
| 200 | 168 – 171<br>186 – 192 |

# VC

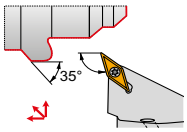
07/ 11/ 13/ 16

## C.-SVHB(RL) EXT NEW

107°30´

VB, VC..

16




C4 / C6

201

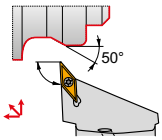
168 – 171
186 – 192

## C.-SVJB(RL) EXT NEW

93°

VB, VC..

11
16




C3 / C6

202

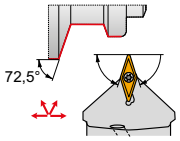
168 – 171
186 – 192

## C.-SVVBN EXT NEW

72°30´

VB, VC..

16




C4 / C6

203

168 – 171
186 – 192

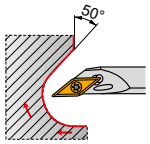
## ISO-DREJNING – INDVENDIG

## SVJB(RL) INT

93°

VB, VC..

11




ØDmin

25 / 32

204

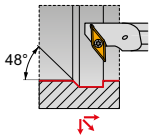
168 – 171
186 – 192

## SVLC(RL) INT

95°

VC..

13




ØDmin

27 / 43

205

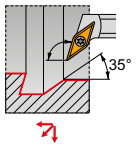
186 – 192

## SVQB(C)(RL) INT

107°30´

VB, VC..

11
13
16




ØDmin

20 / 50

206

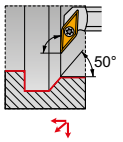
168 – 171
186 – 192

## SVUB(C)(RL) INT

93°

VB, VC..

11
13
16




ØDmin

20 / 50

207

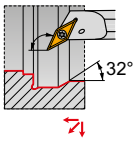
168 – 171
186 – 192

## SVXC(RL) INT

113°

VC..

07




ØDmin

12,5 / 17,5

208

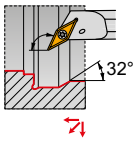
186 – 192

## SVXC(RL)-E INT

113°

VC..

07




ØDmin

12,5 / 17,5

209

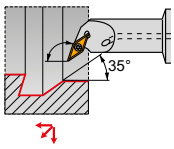
186 – 192

## C.-SVQB(C)(RL) INT NEW

108°

VB, VC..

16




ØDmin

33

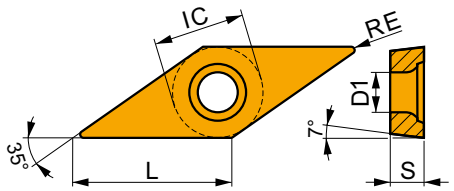
210

168 – 171
186 – 192

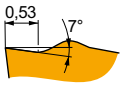
# VCGT

PRAMET

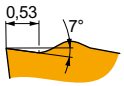
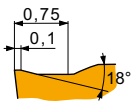
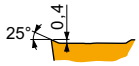
| | IC (mm) | D1 (mm) | L (mm) | S (mm) |
|---|---|---|---|---|
| 0702 | 3.970 | 2.20 | 6.90 | 2.38 |
| 1102-SF3 | 6.350 | 2.80 | 11.10 | 2.58 |
| 1103 | 6.350 | 2.80 | 11.10 | 3.18 |
| 1103-SF3 | 6.350 | 2.80 | 11.10 | 3.43 |
| 1303 | 7.940 | 3.40 | 13.80 | 3.18 |
| 1303-AL | 7.940 | 3.40 | 13.80 | 3.43 |
| 1303-SF3 | 7.940 | 3.40 | 13.80 | 3.43 |
| 1604 | 9.525 | 4.40 | 16.60 | 4.76 |
| 1604-SF3 | 9.525 | 4.40 | 16.60 | 5.01 |



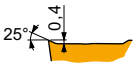
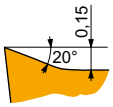

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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-geometri med meget positivt design til fin-finish til grov bearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | | | | |
| **VCGT 070202F-AL** | **HF7** | 0.2 | – | – | – | – | – | – | – | – | – | 315 | 0.12 | 1.0 | – | – | – | – | – | – |
| **VCGT 110302F-AL** | **HF7** | 0.2 | – | – | – | – | – | – | – | – | – | 300 | 0.12 | 1.5 | – | – | – | – | – | – |
| | **T0315** | 0.2 | – | – | – | – | – | – | – | – | – | 465 | 0.12 | 0.8 | – | – | – | – | – | – |
| **VCGT 110304F-AL** | **HF7** | 0.4 | – | – | – | – | – | – | – | – | – | 240 | 0.24 | 1.5 | – | – | – | – | – | – |
| | **T0315** | 0.4 | – | – | – | – | – | – | – | – | – | 375 | 0.24 | 0.8 | – | – | – | – | – | – |
| **VCGT 130302F-AL** | **HF7** | 0.2 | – | – | – | – | – | – | – | – | – | 285 | 0.12 | 1.7 | – | – | – | – | – | – |
| | **T0315** | 0.2 | – | – | – | – | – | – | – | – | – | 420 | 0.12 | 1.7 | – | – | – | – | – | – |
| **VCGT 130304F-AL** | **HF7** | 0.4 | – | – | – | – | – | – | – | – | – | 240 | 0.24 | 1.7 | – | – | – | – | – | – |
| | **T0315** | 0.4 | – | – | – | – | – | – | – | – | – | 345 | 0.24 | 1.7 | – | – | – | – | – | – |
| **VCGT 130308F-AL** | **HF7** | 0.8 | – | – | – | – | – | – | – | – | – | 210 | 0.48 | 1.7 | – | – | – | – | – | – |
| | **T0315** | 0.8 | – | – | – | – | – | – | – | – | – | 315 | 0.48 | 1.7 | – | – | – | – | – | – |
| **VCGT 160402F-AL** | **HF7** | 0.2 | – | – | – | – | – | – | – | – | – | 285 | 0.12 | 2.4 | – | – | – | – | – | – |
| | **T0315** | 0.2 | – | – | – | – | – | – | – | – | – | 420 | 0.12 | 2.4 | – | – | – | – | – | – |
| **VCGT 160404F-AL** | **HF7** | 0.4 | – | – | – | – | – | – | – | – | – | 225 | 0.24 | 2.4 | – | – | – | – | – | – |
| | **T0315** | 0.4 | – | – | – | – | – | – | – | – | – | 330 | 0.24 | 2.4 | – | – | – | – | – | – |
| **VCGT 160408F-AL** | **HF7** | 0.8 | – | – | – | – | – | – | – | – | – | 210 | 0.48 | 2.4 | – | – | – | – | – | – |
| | **T0315** | 0.8 | – | – | – | – | – | – | – | – | – | 300 | 0.48 | 2.4 | – | – | – | – | – | – |
| **VCGT 160412F-AL** | **HF7** | 1.2 | – | – | – | – | – | – | – | – | – | 180 | 0.72 | 2.4 | – | – | – | – | – | – |
| | **T0315** | 1.2 | – | – | – | – | – | – | – | – | – | 270 | 0.72 | 2.4 | – | – | – | – | – | – |
|  |  | |  | | | | | | | | | | | | | | | | | |
| FF2-geometri med positivt design for finbearbejdning til færdigbearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | | | | |
| **VCGT 070202E-FF2** | **T8315** | 0.2 | 150 | 0.05 | 0.8 | – | – | – | 140 | 0.05 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.2 | 145 | 0.05 | 0.8 | – | – | – | 135 | 0.05 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **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 | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.4 | 120 | 0.12 | 0.8 | – | – | – | 110 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **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 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 0.2 | 165 | 0.05 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.2 | 140 | 0.05 | 1.0 | – | – | – | 130 | 0.05 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.2 | 185 | 0.05 | 1.0 | – | – | – | 150 | 0.05 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.2 | 265 | 0.05 | 1.0 | – | – | – | 250 | 0.05 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.2 | 240 | 0.05 | 1.0 | – | – | – | 225 | 0.05 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **TT010** | 0.2 | 240 | 0.05 | 0.5 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | FF2-geometri med positivt design for finbearbejdning til færdigbearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | |
| **VCGT 130304E-FF2** | **T5315** | 0.4 | ◪ 195 | 0.12 | 1.0 | – | – | – | ■ 185 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 0.4 | ◪ 135 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.4 | ■ 115 | 0.12 | 1.0 | – | – | – | ■ 105 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.4 | ■ 140 | 0.12 | 1.0 | – | – | – | ◪ 115 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.4 | ■ 195 | 0.12 | 1.0 | – | – | – | ◪ 185 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | ■ 175 | 0.12 | 1.0 | – | – | – | ◪ 165 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **TT010** | 0.4 | ■ 245 | 0.06 | 0.5 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **VCGT 130308E-FF2** | **T7325** | 0.8 | ◪ 145 | 0.17 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.8 | ■ 200 | 0.17 | 1.0 | – | – | – | ◪ 190 | 0.17 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | ■ 180 | 0.17 | 1.0 | – | – | – | ◪ 170 | 0.17 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **TT010** | 0.8 | ■ 245 | 0.10 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | FM2 geometri til fin til medium bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **VCGT 130308E-FM2** | **T8330** | 0.8 | ■ 125 | 0.17 | 1.0 | ◪ 75 | 0.15 | 1.0 | ■ 115 | 0.17 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.8 | ■ 145 | 0.17 | 1.0 | ◪ 80 | 0.15 | 1.0 | ◪ 120 | 0.17 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | ■ 180 | 0.17 | 1.0 | ◪ 105 | 0.15 | 1.0 | ◪ 170 | 0.17 | 1.0 | – | – | – | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | NF2-geometri med positivt design til finbearbejdning til halv grov bearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | |
| **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 | – | – | – |
| | **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 | – | – | – |
| | **T7325** | 0.2 | ◪ 150 | 0.07 | 1.0 | ■ 115 | 0.06 | 1.0 | – | – | – | – | – | – | ■ 45 | 0.06 | 0.8 | – | – | – |
| | **T7335** | 0.2 | ◪ 150 | 0.07 | 1.0 | ■ 115 | 0.06 | 1.0 | – | – | – | – | – | – | ■ 45 | 0.06 | 0.8 | – | – | – |
| | **T9315** | 0.2 | ◪ 200 | 0.10 | 1.0 | – | – | – | ◪ 190 | 0.10 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.2 | ◪ 210 | 0.07 | 1.0 | ■ 125 | 0.06 | 1.0 | ◪ 195 | 0.07 | 1.0 | – | – | – | ◪ 45 | 0.06 | 0.8 | – | – | – |
| | **T9335** | 0.2 | ◪ 155 | 0.10 | 1.0 | ■ 90 | 0.09 | 1.0 | – | – | – | – | – | – | ◪ 30 | 0.07 | 0.8 | – | – | – |
| | **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 | – | – | – |
| | **T5315** | 0.4 | ◪ 195 | 0.12 | 1.0 | – | – | – | ◪ 185 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **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 | – | – | – |
| | **T7325** | 0.4 | ◪ 135 | 0.12 | 1.0 | ■ 105 | 0.11 | 1.0 | – | – | – | – | – | – | ■ 40 | 0.08 | 0.8 | – | – | – |
| | **T7335** | 0.4 | ◪ 135 | 0.12 | 1.0 | ■ 105 | 0.11 | 1.0 | – | – | – | – | – | – | ■ 40 | 0.08 | 0.8 | – | – | – |
| | **T9315** | 0.4 | ◪ 210 | 0.10 | 1.0 | – | – | – | ◪ 195 | 0.10 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | ◪ 175 | 0.12 | 1.0 | ■ 105 | 0.11 | 1.0 | ◪ 165 | 0.12 | 1.0 | – | – | – | ◪ 35 | 0.08 | 0.8 | – | – | – |
| | **T9335** | 0.4 | ◪ 150 | 0.12 | 1.0 | ■ 90 | 0.11 | 1.0 | – | – | – | – | – | – | ◪ 30 | 0.11 | 0.8 | – | – | – |
| | **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 | – | – | – | – | – | – | – | – | – |
| | **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 | – | – | – |
| | **T7325** | 0.8 | ◪ 145 | 0.17 | 1.0 | ■ 110 | 0.15 | 1.0 | – | – | – | – | – | – | ■ 45 | 0.12 | 0.8 | – | – | – |
| | **T7335** | 0.8 | ◪ 140 | 0.17 | 1.0 | ■ 105 | 0.15 | 1.0 | – | – | – | – | – | – | ■ 45 | 0.12 | 0.8 | – | – | – |
| | **T9315** | 0.8 | ◪ 200 | 0.17 | 1.0 | – | – | – | ◪ 190 | 0.17 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | ◪ 180 | 0.17 | 1.0 | ■ 105 | 0.15 | 1.0 | ◪ 170 | 0.17 | 1.0 | – | – | – | ◪ 40 | 0.12 | 0.8 | – | – | – |
| | **T9335** | 0.8 | ◪ 155 | 0.18 | 1.0 | ■ 90 | 0.16 | 1.0 | – | – | – | – | – | – | ◪ 30 | 0.16 | 0.8 | – | – | – |
| | **TT010** | 0.8 | ◪ 245 | 0.10 | 0.8 | ◪ 145 | 0.09 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | SF2-geometri med meget positivt design til finbearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | |
| **VCGT 130301E-SF2** | **H07** | 0.1 | – | – | – | ◪ 80 | 0.05 | 1.0 | – | – | – | ◪ 405 | 0.06 | 1.0 | ■ 40 | 0.04 | 0.8 | – | – | – |
| | **T6310** | 0.1 | ◪ 140 | 0.05 | 1.0 | ■ 100 | 0.05 | 1.0 | – | – | – | ◪ 420 | 0.06 | 1.0 | ■ 40 | 0.04 | 0.8 | – | – | – |

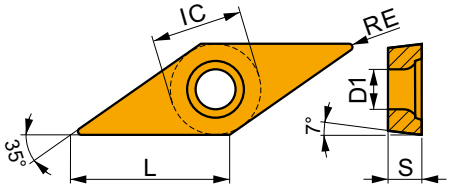
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |  | |  | | | | | | | | | | | | | | | | | |
| SF2-geometri med meget positivt design til finbearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **VCGT 130302E-SF2** | **H07** | 0.2 | – | – | – | 80 | 0.05 | 1.0 | – | – | – | 405 | 0.06 | 1.0 | 40 | 0.04 | 0.8 | – | – | – |
| | **HF7** | 0.2 | – | – | – | 90 | 0.05 | 1.0 | – | – | – | 450 | 0.06 | 1.0 | – | – | – | – | – | – |
| | **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 | – | – | – |
| | **HF7** | 0.4 | – | – | – | 75 | 0.09 | 1.0 | – | – | – | 375 | 0.12 | 1.0 | – | – | – | – | – | – |
| | **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** | **H07** | 0.8 | – | – | – | 75 | 0.09 | 1.0 | – | – | – | 390 | 0.12 | 1.0 | 35 | 0.08 | 0.8 | – | – | – |
| | **HF7** | 0.8 | – | – | – | 85 | 0.09 | 1.0 | – | – | – | 435 | 0.12 | 1.0 | – | – | – | – | – | – |
| | **T6310** | 0.8 | 145 | 0.10 | 1.0 | 100 | 0.09 | 1.0 | – | – | – | 435 | 0.12 | 1.0 | 40 | 0.08 | 0.8 | – | – | – |
|  |  | |  | | | | | | | | | | | | | | | | | |
| SF3-geometri med meget positivt design til finbearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **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 | – | – | – |
| | **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 | 0.15 | 1.0 |
| **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 | 0.15 | 1.0 |
| **VCGT 110201E-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 | 0.15 | 1.0 |
| **VCGT 110202E-SF3** | **H07** | 0.2 | – | – | – | 80 | 0.05 | 0.8 | 130 | 0.05 | 0.8 | 415 | 0.06 | 0.8 | 40 | 0.04 | 0.6 | – | – | – |
| | **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 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| **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 | – | – | – |
| | **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 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| **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 | 0.15 | 1.0 |
| **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 | 0.15 | 1.0 |
| **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 | 0.15 | 1.0 |
| **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 | – | – | – |
| | **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 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| **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 | – | – | – |
| | **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 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| **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 | – | – | – |
| | **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 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| **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 | 0.15 | 1.0 |
| **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 | – | – | – |
| | **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 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| **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 | – | – | – |
| | **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 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| **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 | – | – | – |
| | **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 | 0.15 | 1.0 |

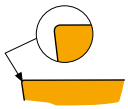
# VCGW

PRAMET

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



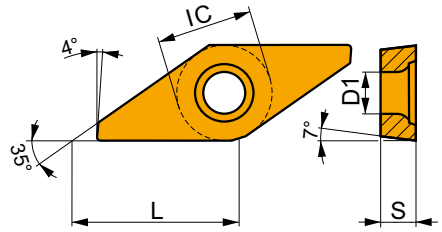

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | |  Til fin til halv grov bearbejdning og kontinuerlig til let afbrudt snit. | | | | | | | | | | | | | | | | | |
| **VCGW 130302** | **T5305** | 0.2 | – | – | – | – | – | – | ■ 170 | 0.08 | 1.3 | – | – | – | – | – | – | ◪ 35 | 0.15 | 1.0 |
| **VCGW 130304** | **T5305** | 0.4 | – | – | – | – | – | – | ■ 165 | 0.10 | 1.3 | – | – | – | – | – | – | ◪ 35 | 0.15 | 1.0 |
| **VCGW 130308** | **T5305** | 0.8 | – | – | – | – | – | – | ■ 160 | 0.18 | 1.3 | – | – | – | – | – | – | ◪ 30 | 0.15 | 1.0 |

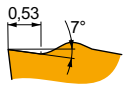
# VCGX

PRAMET

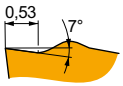
| | IC (mm) | D1 (mm) | L (mm) | S (mm) |
|---|---|---|---|---|
| 1303 | 7.940 | 3.40 | 13.80 | 3.18 |




Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | |  FR-FF2 geometri med positivt højrehåndet design til fin til finish bearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | |
| **VCGX 130300FR-FF2** | **T6310** | 0.0 | ■ | 140 | 0.05 | 1.0 | – | – | – | ■ | 110 | 0.05 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.0 | ◪ | 150 | 0.05 | 1.0 | – | – | – | ■ | 140 | 0.05 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **TT010** | 0.0 | ■ | 240 | 0.05 | 0.5 | – | – | – | | – | – | – | – | – | – | – | – | – | – | – | – |
| **VCGX 130301FR-FF2** | **T6310** | 0.1 | ■ | 140 | 0.05 | 1.0 | – | – | – | ■ | 110 | 0.05 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.1 | ◪ | 150 | 0.05 | 1.0 | – | – | – | ■ | 140 | 0.05 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **TT010** | 0.1 | ■ | 240 | 0.05 | 0.5 | – | – | – | | – | – | – | – | – | – | – | – | – | – | – | – |

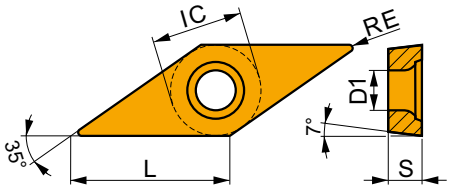
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|    | | | | | | | | | | | | | | | | | | | |
| FL-FF2 geometri med positivt venstrehåndet design til finbearbejdning til færdigbearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | | | |
| **VCGX 130300FL-FF2** | **T6310** | 0.0 | 140 | 0.05 | 1.0 | – | – | – | 110 | 0.05 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.0 | 150 | 0.05 | 1.0 | – | – | – | 140 | 0.05 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **TT010** | 0.0 | 240 | 0.05 | 0.5 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **VCGX 130301FL-FF2** | **T6310** | 0.1 | 140 | 0.05 | 1.0 | – | – | – | 110 | 0.05 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.1 | 150 | 0.05 | 1.0 | – | – | – | 140 | 0.05 | 1.0 | – | – | – | – | – | – | – | – | – |

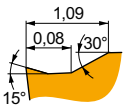
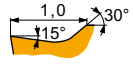
# VCMT

PRAMET

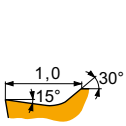
| | IC (mm) | D1 (mm) | L (mm) | S (mm) |
|---|---|---|---|---|
| 1103 | 6.350 | 2.80 | 11.10 | 3.18 |
| 1604 | 9.525 | 4.40 | 16.60 | 4.76 |




Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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-geometri til fin til halv grov bearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | | | |
| **VCMT 160404E-FM** | **T7325** | 0.4 | 125 | 0.19 | 1.2 | 95 | 0.17 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.4 | 130 | 0.12 | 1.2 | 75 | 0.11 | 1.2 | 120 | 0.12 | 1.2 | 390 | 0.14 | 1.2 | – | – | – | – | – | – |
| | **T8430** | 0.4 | 150 | 0.12 | 1.2 | 80 | 0.11 | 1.2 | 125 | 0.12 | 1.2 | 420 | 0.14 | 1.2 | – | – | – | – | – | – |
| | **T9315** | 0.4 | 210 | 0.12 | 1.2 | – | – | – | 195 | 0.12 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 155 | 0.19 | 1.2 | 90 | 0.17 | 1.2 | 145 | 0.19 | 1.2 | – | – | – | – | – | – | – | – | – |
| **VCMT 160408E-FM** | **T7325** | 0.8 | 155 | 0.17 | 1.2 | 120 | 0.15 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.8 | 135 | 0.17 | 1.2 | 80 | 0.15 | 1.2 | 125 | 0.17 | 1.2 | 405 | 0.20 | 1.2 | – | – | – | – | – | – |
| | **T8430** | 0.8 | 155 | 0.17 | 1.2 | 85 | 0.15 | 1.2 | 130 | 0.17 | 1.2 | 435 | 0.20 | 1.2 | – | – | – | – | – | – |
| | **T9315** | 0.8 | 220 | 0.17 | 1.2 | – | – | – | 205 | 0.17 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 195 | 0.17 | 1.2 | 115 | 0.15 | 1.2 | 185 | 0.17 | 1.2 | – | – | – | – | – | – | – | – | – |
|    | | | | | | | | | | | | | | | | | | | |
| UR-geometri til finbearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | | | |
| **VCMT 110304E-UR** | **T7325** | 0.4 | 110 | 0.19 | 0.8 | 85 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.4 | 110 | 0.12 | 0.8 | 65 | 0.11 | 0.8 | 100 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.4 | 135 | 0.12 | 0.8 | 75 | 0.11 | 0.8 | 110 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.4 | 190 | 0.12 | 0.8 | – | – | – | 180 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 140 | 0.19 | 0.8 | 80 | 0.17 | 0.8 | 130 | 0.19 | 0.8 | – | – | – | – | – | – | – | – | – |
| **VCMT 110308E-UR** | **T7325** | 0.8 | 140 | 0.17 | 0.8 | 105 | 0.15 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.8 | 125 | 0.17 | 0.8 | 75 | 0.15 | 0.8 | 115 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.8 | 140 | 0.17 | 0.8 | 75 | 0.15 | 0.8 | 115 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.8 | 195 | 0.17 | 0.8 | – | – | – | 185 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 175 | 0.17 | 0.8 | 105 | 0.15 | 0.8 | 165 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – |

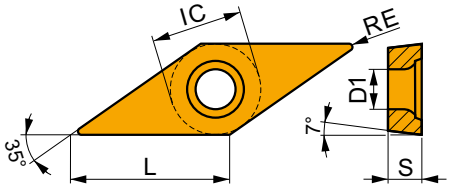
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) | | | | | | | | | | | | | | | | | | |
| | UR-geometri til finbearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | | | |
| **VCMT 160404E-UR** | **T7325** | 0.4 | 110 | 0.19 | 1.2 | 85 | 0.17 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.4 | 110 | 0.12 | 1.2 | 65 | 0.11 | 1.2 | 100 | 0.12 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.4 | 130 | 0.12 | 1.2 | 70 | 0.11 | 1.2 | 105 | 0.12 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.4 | 180 | 0.12 | 1.2 | – | – | – | 170 | 0.12 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 135 | 0.19 | 1.2 | 80 | 0.17 | 1.2 | 125 | 0.19 | 1.2 | – | – | – | – | – | – | – | – | – |
| **VCMT 160408E-UR** | **T7325** | 0.8 | 135 | 0.17 | 1.2 | 105 | 0.15 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.8 | 115 | 0.17 | 1.2 | 65 | 0.15 | 1.2 | 105 | 0.17 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.8 | 135 | 0.17 | 1.2 | 75 | 0.15 | 1.2 | 110 | 0.17 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.8 | 190 | 0.17 | 1.2 | – | – | – | 180 | 0.17 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 170 | 0.17 | 1.2 | 100 | 0.15 | 1.2 | 160 | 0.17 | 1.2 | – | – | – | – | – | – | – | – | – |

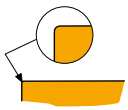
# VCMW

PRAMET

| | 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 |



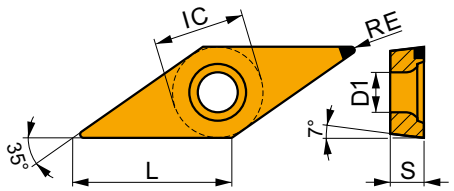

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) | | | | | | | | | | | | | | | | | | |
| | Til fin til halv grov bearbejdning og kontinuerlig til let afbrudt snit. | | | | | | | | | | | | | | | | | | | |
| **VCMW 110302** | **T5305** | 0.2 | – | – | – | – | – | – | 170 | 0.08 | 1.2 | – | – | – | – | – | – | 35 | 0.15 | 1.0 |
| | **T5315** | 0.2 | – | – | – | – | – | – | 145 | 0.08 | 1.2 | – | – | – | – | – | – | 30 | 0.15 | 1.0 |
| | **T6310** | 0.2 | – | – | – | – | – | – | 70 | 0.08 | 1.2 | – | – | – | – | – | – | 15 | 0.15 | 1.0 |
| **VCMW 110304** | **T5305** | 0.4 | – | – | – | – | – | – | 165 | 0.10 | 1.2 | – | – | – | – | – | – | 35 | 0.15 | 1.0 |
| | **T5315** | 0.4 | – | – | – | – | – | – | 145 | 0.10 | 1.2 | – | – | – | – | – | – | 30 | 0.15 | 1.0 |
| | **T6310** | 0.4 | – | – | – | – | – | – | 70 | 0.10 | 1.2 | – | – | – | – | – | – | 15 | 0.15 | 1.0 |
| **VCMW 160404** | **T5305** | 0.4 | – | – | – | – | – | – | 165 | 0.10 | 1.5 | – | – | – | – | – | – | 35 | 0.15 | 1.0 |
| | **T5315** | 0.4 | – | – | – | – | – | – | 140 | 0.10 | 1.5 | – | – | – | – | – | – | 30 | 0.15 | 1.0 |
| | **T6310** | 0.4 | – | – | – | – | – | – | 70 | 0.10 | 1.5 | – | – | – | – | – | – | 15 | 0.15 | 1.0 |
| **VCMW 160408** | **T5305** | 0.8 | – | – | – | – | – | – | 155 | 0.18 | 1.5 | – | – | – | – | – | – | 30 | 0.15 | 1.0 |
| | **T5315** | 0.8 | – | – | – | – | – | – | 135 | 0.18 | 1.5 | – | – | – | – | – | – | 25 | 0.15 | 1.0 |
| | **T6310** | 0.8 | – | – | – | – | – | – | 70 | 0.18 | 1.5 | – | – | – | – | – | – | 15 | 0.15 | 1.0 |

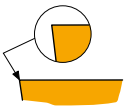
# VCMW PCD

PRAMET

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




Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | HSC F | | | | | | | | | | | | | | | | | |
| PCD skær til finish til halv grov bearbejdning, høje hastigheder og stabile skæreforhold. | | | | | | | | | | | | | | | | | | | | |
| **VCMW 160404FN** | **PD1** | 0.4 | – | – | – | – | – | – | – | – | – | 900 | 0.12 | 0.5 | – | – | – | – | – | – |
| **VCMW 160408FN** | **PD1** | 0.8 | – | – | – | – | – | – | – | – | – | 1050 | 0.12 | 1.0 | – | – | – | – | – | – |

# SVAC(RL)-DC EXT

P M K N S H

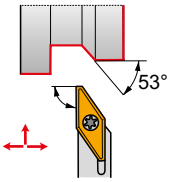
PRAMET

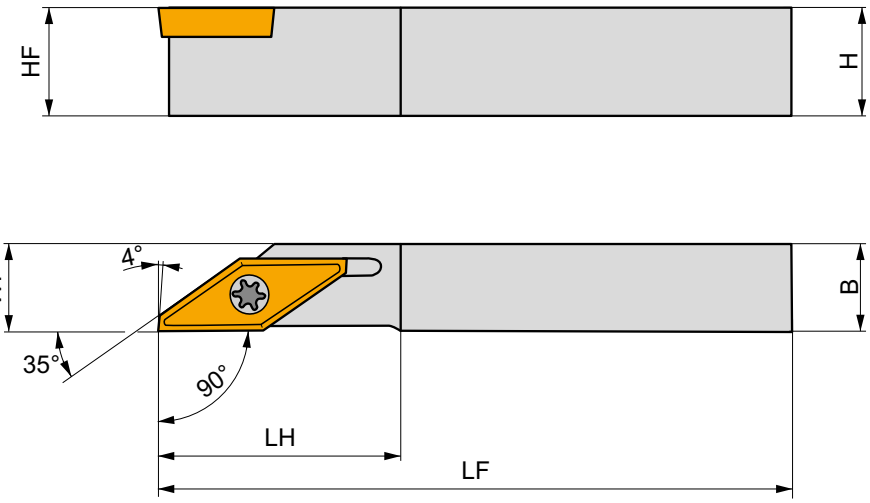
S

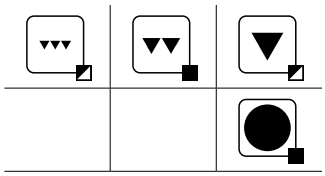


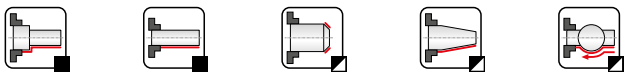
## Ekstern skruelåsværktøjsholder med 90 ° skærevinkel til VCGX 13 Skær

Ekstern højre / venstre hånd værktøjsholder til skruetype positive VCGX 13 skær. Velegnet til udvendigt ende og langsgående drejning med skulder, tilspidsning, kopidrejning op til 50 ° og affasning. Fås med skaftstørrelse 10x10 op til 25x25 mm. Krop behandlet for længere levetid på værktøjet.





| | 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 | 0.12 | GI222 | SV20 |
| | SVACR 1212 L 13-DC | 12 | 12 | 12 | 12 | 140 | 25 | 0 | 0 | 0.17 | GI222 | SV20 |
| | SVACR 1616 M 13-DC | 16 | 16 | 16 | 16 | 150 | 25 | 0 | 0 | 0.29 | GI222 | SV20 |
| | SVACR 2020 M 13-DC | 20 | 20 | 20 | 20 | 150 | 25 | 0 | 0 | 0.46 | GI222 | SV20 |
| | SVACR 2525 M 13-DC | 25 | 25 | 25 | 25 | 150 | 25 | 0 | 0 | 0.67 | GI222 | SV20 |
| L | SVACL 1010 L 13-DC | 10 | 10 | 10 | 10 | 140 | 25 | 0 | 0 | 0.10 | GI222 | SV20 |
| | SVACL 1212 L 13-DC | 12 | 12 | 12 | 12 | 140 | 25 | 0 | 0 | 0.19 | GI222 | SV20 |
| | SVACL 1616 M 13-DC | 16 | 16 | 16 | 16 | 150 | 25 | 0 | 0 | 0.29 | GI222 | SV20 |
| | SVACL 2020 M 13-DC | 20 | 20 | 20 | 20 | 150 | 25 | 0 | 0 | 0.43 | GI222 | SV20 |
| | SVACL 2525 M 13-DC | 25 | 25 | 25 | 25 | 150 | 25 | 0 | 0 | 0.67 | GI222 | SV20 |

| | |
|---|---|
| GI222 | VCGX 1303.. |

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

# SVGC(RL) EXT

P M K N S H

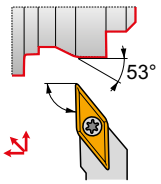
PRAMET

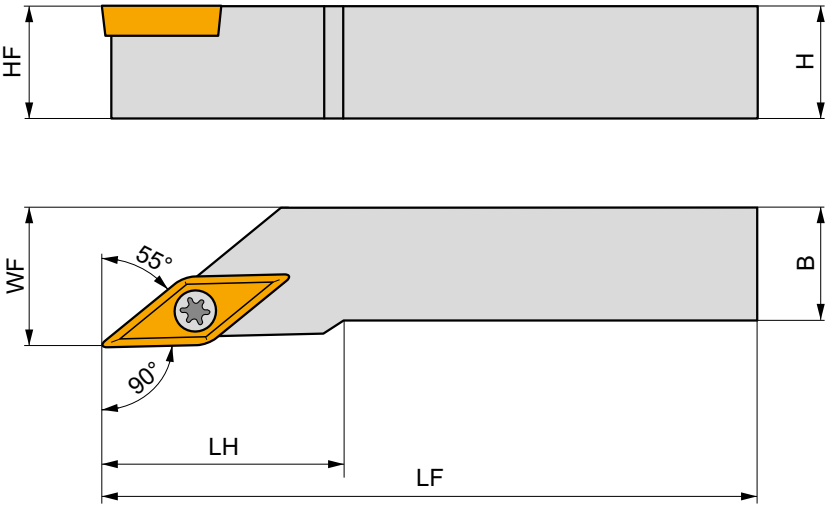
S

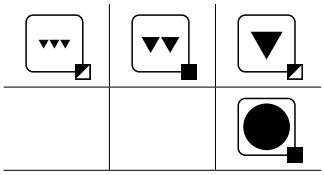


## Ekstern skruelåsværktøjsholder med 90 ° skærevinkel til VC.. Skær

Ekstern højre / venstre værktøjsholder til skruetype positiv VC .. 07 skær. Velegnet til udvendig langsgående drejning med skulder, tilspidsning, kopidrejning op til 53 ° og affasning. Fås med skaftstørrelse 08x08 op til 16x16 mm. Krop behandlet for længere levetid på værktøjet.





| | Product | H (mm) | B (mm) | HF (mm) | WF (mm) | LF (mm) | LH (mm) | LAMS (°) | GAMO (°) | kg | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| R | SVGCR 0808 K 07 | 8 | 8 | 8 | 8.5 | 125 | 15 | 0 | 0 | 0.07 | GI234 | SV23 |
| | SVGCR 1010 M 07 | 10 | 10 | 10 | 10.5 | 150 | 15 | 0 | 0 | 0.13 | GI234 | SV23 |
| | SVGCR 1212 M 07 | 12 | 12 | 12 | 12.5 | 150 | 18 | 0 | 0 | 0.17 | GI234 | SV23 |
| | SVGCR 1616 P 07 | 16 | 16 | 16 | 16.3 | 170 | 23 | 0 | 0 | 0.33 | GI234 | SV23 |
| L | SVGCL 0808 K 07 | 8 | 8 | 8 | 8.5 | 125 | 15 | 0 | 0 | 0.07 | GI234 | SV23 |
| | SVGCL 1010 M 07 | 10 | 10 | 10 | 10.5 | 150 | 15 | 0 | 0 | 0.13 | GI234 | SV23 |
| | SVGCL 1212 M 07 | 12 | 12 | 12 | 12.5 | 150 | 18 | 0 | 0 | 0.17 | GI234 | SV23 |
| | SVGCL 1616 P 07 | 16 | 16 | 16 | 16.3 | 170 | 23 | 0 | 0 | 0.33 | GI234 | SV23 |

| | |
|---|---|
| GI234 | VC.. 0702.. |

| | | Nm | | | |
|---|---|---|---|---|---|
| SV23 | DVF 3584 | 0.6 | M 2 | 5.5 | DMD 1650 |

# SVHB(C)(RL) EXT

P M K N S H

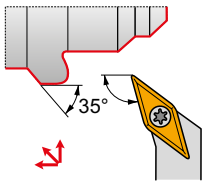
PRAMET

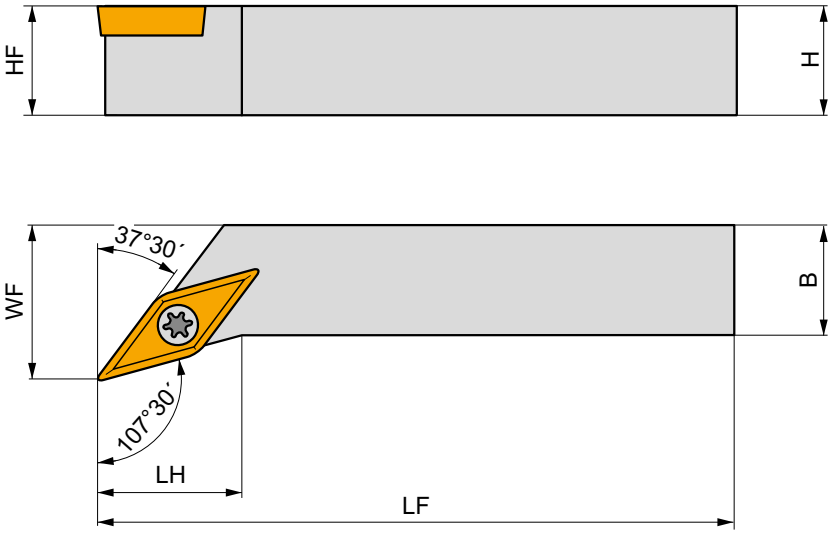
S

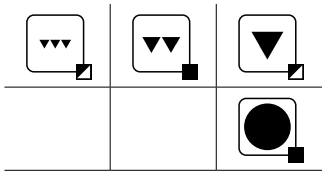


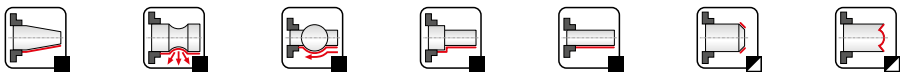
## Ekstern skruelåsværktøjsholder med 107.5 ° skærevinkel til VB/VC.. Skær

Ekstern højre / venstre værktøjsholder til skruetype positive VB .. 11 eller 16 og VC .. 11 eller 16 skær. Velegnet til udvendigt ende og langsgående drejning med skulder, tilspidsning, ende og længdekopi, der drejer op til 35 ° og affasning. Fås med skaftstørrelse 16x16 op til 25x25 mm. Krop behandlet for længere levetid på værktøjet.





| | 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 | 0.21 | GI194 | S01 |
| R | **SVHCR 2020 K 16-M-A** | 20 | 20 | 20 | 25 | 125 | 20 | 0 | 0 | 0.40 | GI017 | SV10 |
| R | **SVHCR 2525 M 16-M-A** | 25 | 25 | 25 | 32 | 150 | 20 | 0 | 0 | 0.68 | GI017 | SV10 |
| L | **SVHBL 1616 H 11** | 16 | 16 | 16 | 20 | 100 | 14 | 0 | 0 | 0.19 | GI194 | S01 |
| L | **SVHCL 2020 K 16-M-A** | 20 | 20 | 20 | 25 | 125 | 20 | 0 | 0 | 0.40 | GI017 | SV10 |
| L | **SVHCL 2525 M 16-M-A** | 25 | 25 | 25 | 32 | 150 | 20 | 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

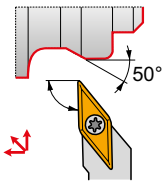
PRAMET

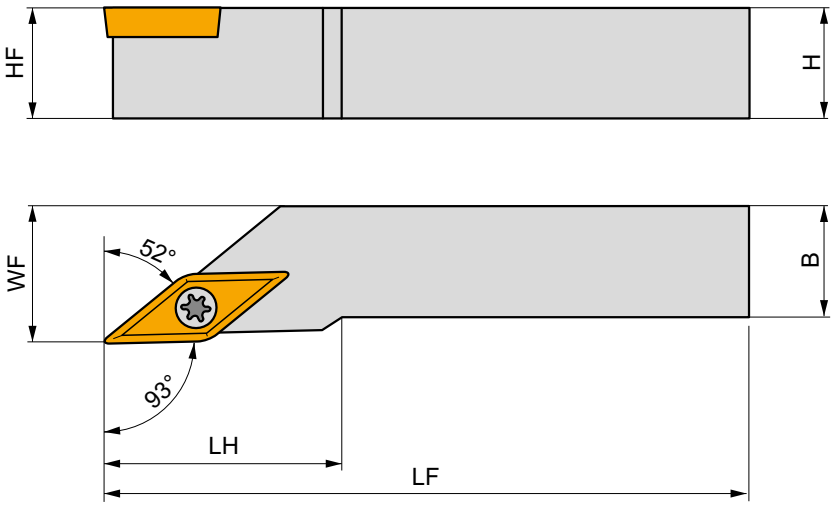
S

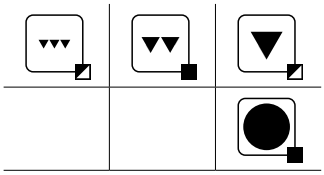


## Ekstern skruelåsværktøjsholder med 93 ° skærevinkel til VB/VC.. Skær

Ekstern højre / venstre værktøjsholder til skruetype positiv VB .. 11 eller 16 og VC .. 11 op til 16 skær. Velegnet til udvendig langsgående drejning med skulder, tilspidsning, kopidrejning op til 50 ° og affasning. Fås med skaftstørrelse 12x12 op til 32x25 mm. Krop behandlet for længere levetid på værktøjet.





| | 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 | 0.09 | GI194 | S01 |
| | SVJBR 1616 H 11 | 16 | 16 | 16 | 20 | 100 | 20 | 0 | 0 | 0.20 | GI194 | S01 |
| | SVJCR 1212 N 13 | 12 | 12 | 12 | 16 | 160 | 27 | 0 | 0 | 0.19 | GI211 | SV21 |
| | SVJCR 1616 H 13 | 16 | 16 | 16 | 20 | 100 | 30 | 0 | 0 | 0.20 | GI211 | SV21 |
| | SVJCR 2020 K 13 | 20 | 20 | 20 | 25 | 125 | 30 | 0 | 0 | 0.37 | GI211 | SV22 |
| | SVJCR 2525 M 13 | 25 | 25 | 25 | 32 | 150 | 30 | 0 | 0 | 0.67 | GI211 | SV22 |
| | SVJCR 2020 K 16-M-A | 20 | 20 | 20 | 25 | 125 | 28 | 0 | 0 | 0.35 | GI017 | SV10 |
| | SVJCR 2525 M 16-M-A | 25 | 25 | 25 | 32 | 150 | 32 | 0 | 0 | 0.68 | GI017 | SV10 |
| | SVJCR 3225 P 16-M-A | 32 | 25 | 32 | 32 | 170 | 32 | 0 | 0 | 0.99 | GI017 | SV10 |
| L | SVJBL 1212 F 11 | 12 | 12 | 12 | 16 | 80 | 20 | 0 | 0 | 0.09 | GI194 | S01 |
| | SVJBL 1616 H 11 | 16 | 16 | 16 | 20 | 100 | 20 | 0 | 0 | 0.19 | GI194 | S01 |
| | SVJCL 1212 N 13 | 12 | 12 | 12 | 16 | 160 | 27 | 0 | 0 | 0.19 | GI211 | SV21 |
| | SVJCL 1616 H 13 | 16 | 16 | 16 | 20 | 100 | 30 | 0 | 0 | 0.20 | GI211 | SV21 |
| | SVJCL 2020 K 13 | 20 | 20 | 20 | 25 | 125 | 30 | 0 | 0 | 0.37 | GI211 | SV22 |
| | SVJCL 2525 M 13 | 25 | 25 | 25 | 32 | 150 | 30 | 0 | 0 | 0.67 | GI211 | SV22 |
| | SVJCL 2020 K 16-M-A | 20 | 20 | 20 | 25 | 125 | 28 | 0 | 0 | 0.40 | GI017 | SV10 |
| | SVJCL 2525 M 16-M-A | 25 | 25 | 25 | 32 | 150 | 32 | 0 | 0 | 0.70 | GI017 | SV10 |
| | SVJCL 3225 P 16-M-A | 32 | 25 | 32 | 32 | 170 | 32 | 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 |

# SVJC(RL)-DC EXT

P M K N S H

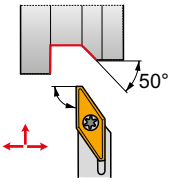
PRAMET

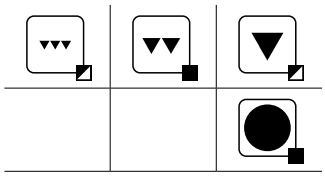
S

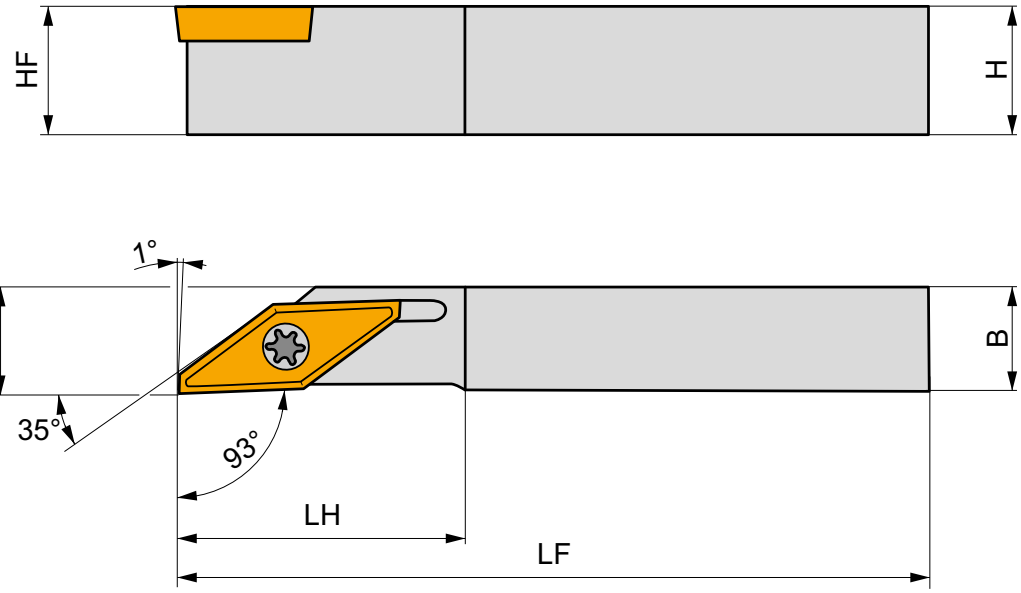


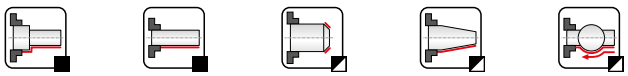
## Ekstern skruelåsværktøjsholder med 93 ° skærevinkel til VCGX 13 Skær

Ekstern højre / venstre hånd værktøjsholder til skruetype positive VCGX 13 skær. Velegnet til udvendigt ende og langsgående drejning med skulder, tilspidsning, kopidrejning op til 50 ° og affasning. Fås med skaftstørrelse 10x10 op til 25x25 mm. Krop behandlet for længere levetid på værktøjet.





| | Product | H (mm) | B (mm) | HF (mm) | WF (mm) | LF (mm) | LH (mm) | LAMS (°) | GAMO (°) | kg | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| R | **SVJCR 1010 L 13-DC** | 10 | 10 | 10 | 0 | 140 | 25 | 0 | 0 | 0.12 | GI222 | SV20 |
| | **SVJCR 1212 L 13-DC** | 12 | 12 | 12 | 0 | 140 | 25 | 0 | 0 | 0.17 | GI222 | SV20 |
| | **SVJCR 1616 M 13-DC** | 16 | 16 | 16 | 0 | 150 | 25 | 0 | 0 | 0.29 | GI222 | SV20 |
| | **SVJCR 2020 M 13-DC** | 20 | 20 | 20 | 0 | 150 | 25 | 0 | 0 | 0.45 | GI222 | SV20 |
| | **SVJCR 2525 M 13-DC** | 25 | 25 | 25 | 0 | 150 | 25 | 0 | 0 | 0.68 | GI222 | SV20 |
| L | **SVJCL 1010 L 13-DC** | 10 | 10 | 10 | 0 | 140 | 25 | 0 | 0 | 0.12 | GI222 | SV20 |
| | **SVJCL 1212 L 13-DC** | 12 | 12 | 12 | 0 | 140 | 25 | 0 | 0 | 0.17 | GI222 | SV20 |
| | **SVJCL 1616 M 13-DC** | 16 | 16 | 16 | 0 | 150 | 25 | 0 | 0 | 0.30 | GI222 | SV20 |
| | **SVJCL 2020 M 13-DC** | 20 | 20 | 20 | 0 | 150 | 25 | 0 | 0 | 0.47 | GI222 | SV20 |
| | **SVJCL 2525 M 13-DC** | 25 | 25 | 25 | 0 | 150 | 25 | 0 | 0 | 0.69 | GI222 | SV20 |

| | |
|---|---|
| GI222 | VCGX 1303.. |

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

# SVPB(C)(RL) EXT

P M K N S H

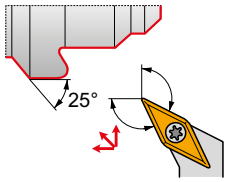
PRAMET

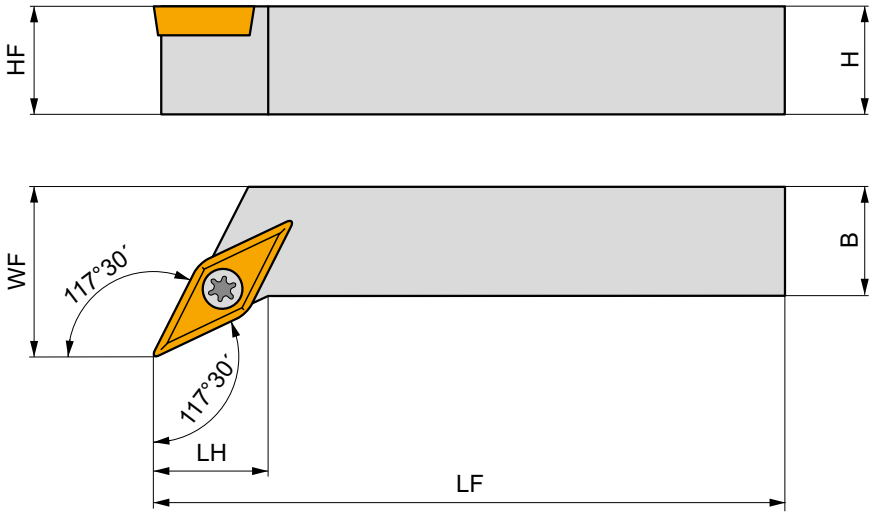
S

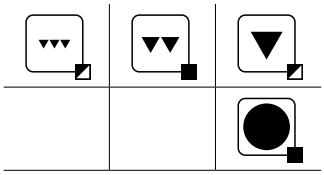


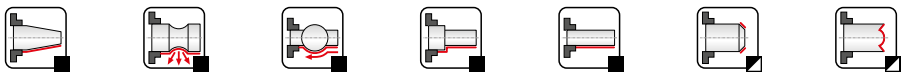
## Ekstern skruelåsværktøjsholder med 117.5 ° skærevinkel til VB/VC.. Skær

Ekstern højre / venstre værktøjsholder til skruetype positive VB .. 11 eller 16 og VC .. 11 eller 16 skær. Velegnet til udvendigt ende og langsgående drejning med skulder, tilspidsning, ansigtskopi, der drejer op til 25 ° og affasning. Fås med skaftstørrelse 16x16 op til 32x25 mm. Krop behandlet for længere levetid på værktøjet.





| | 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 | 0.20 | GI194 | S01 |
| | **SVPBR 2020 K 11** | 20 | 20 | 20 | 25 | 125 | 12 | 0 | 0 | 0.41 | GI194 | S01 |
| | **SVPCR 2020 K 16-M-A** | 20 | 20 | 20 | 25 | 125 | 20 | 0 | 0 | 0.40 | GI017 | SV10 |
| | **SVPCR 2525 M 16-M-A** | 25 | 25 | 25 | 32 | 150 | 25 | 0 | 0 | 0.75 | GI017 | SV10 |
| | **SVPCR 3225 P 16-M-A** | 32 | 25 | 32 | 32 | 170 | 25 | 0 | 0 | 1.10 | GI017 | SV10 |
| L | **SVPBL 1616 H 11** | 16 | 16 | 16 | 20 | 100 | 12 | 0 | 0 | 0.20 | GI194 | S01 |
| | **SVPBL 2020 K 11** | 20 | 20 | 20 | 25 | 125 | 12 | 0 | 0 | 0.39 | GI194 | S01 |
| | **SVPCL 2020 K 16-M-A** | 20 | 20 | 20 | 25 | 125 | 20 | 0 | 0 | 0.70 | GI017 | SV10 |
| | **SVPCL 2525 M 16-M-A** | 25 | 25 | 25 | 32 | 150 | 25 | 0 | 0 | 0.70 | GI017 | SV10 |
| | **SVPCL 3225 P 16-M-A** | 32 | 25 | 32 | 32 | 170 | 25 | 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

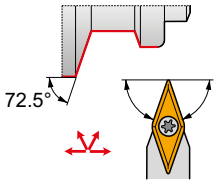
PRAMET

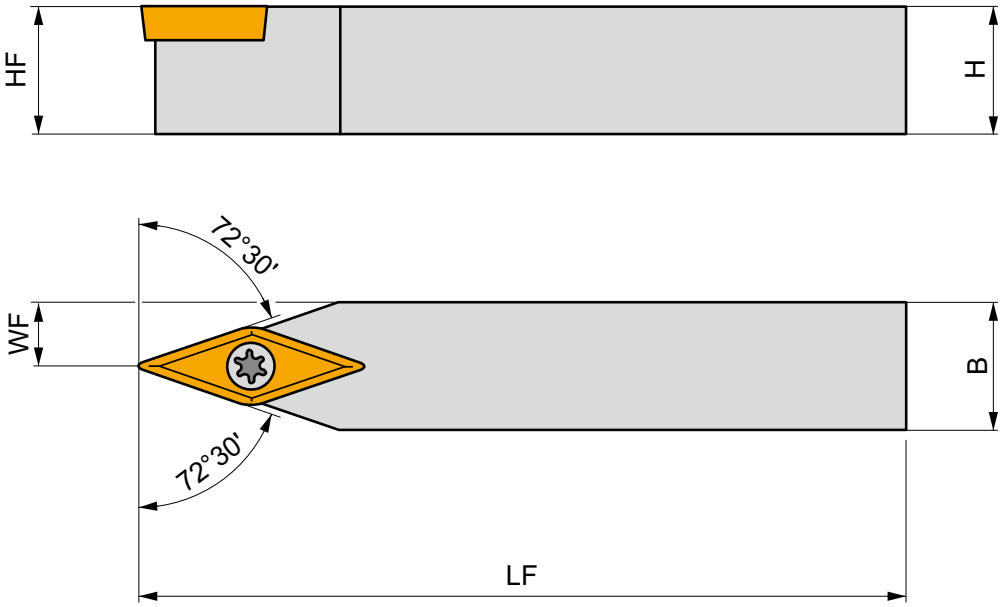
S

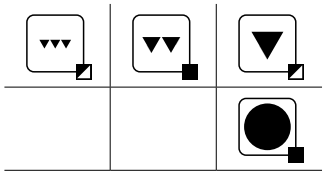


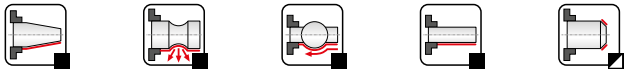
## Ekstern skruelåsværktøjsholder, 72,5 ° skærevinkel til VB / VC .. Skær

Ekstern neutral værktøjsholder til skruetype positiv VB .. 11 eller 16 og VC .. 11 op til 16 skær. Velegnet til udvendig langsgående drejning uden skulder, tilspidsning, kopidrejning op til 72,5 ° og affasning. Fås med skaftstørrelse 12x12 op til 32x25 mm. Krop behandlet for længere levetid





| | 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 | 0.11 | GI194 | S01 |
| | **SVVBN 1616 H 11** | 16 | 16 | 16 | 8 | 100 | – | 0 | 0 | 0.18 | GI194 | S01 |
| | **SVVBN 2020 K 11** | 20 | 20 | 20 | 10 | 125 | – | 0 | 0 | 0.38 | 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 | 0.68 | GI017 | SV10 |
| | **SVVCN 3225 P 16-M-A** | 32 | 25 | 32 | 12.5 | 170 | – | 0 | 0 | 0.98 | 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

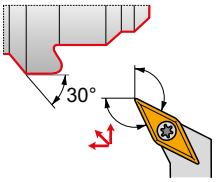
PRAMET

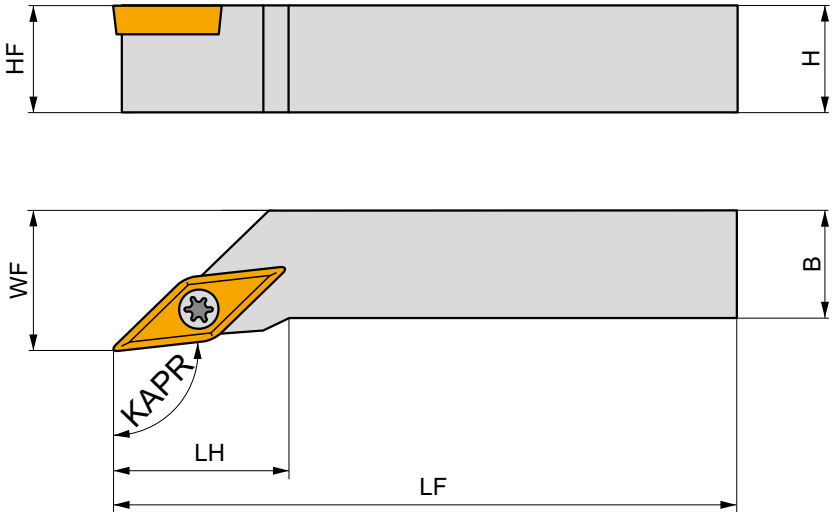
S

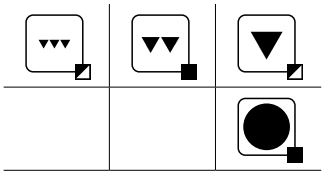


## Ekstern skruelåsværktøjsholder med 98/113 ° skærevinkel til VB/VC.. Skær

Ekstern højre / venstre værktøjsholder til skruetype positiv VB .. 11 eller 16 og VC .. 11 op til 16 skær. Velegnet til udvendig langsgående drejning med skulder, tilspidsning, kopidrejning op til 30 ° og affasning. Fås med skaftstørrelse 12x12 op til 32x25 mm. Krop behandlet for længere levetid på værktøjet.





| | 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 | 98 | 0 | 0 | 0.09 | GI194 | SO1 |
| | **SVXBR 1616 H 11** | 16 | 16 | 16 | 20 | 100 | 14 | 98 | 0 | 0 | 0.19 | GI194 | SO1 |
| | **SVXCR 2020 K 13** | 20 | 20 | 20 | 25 | 125 | 12 | 113 | 0 | 0 | 0.38 | GI211 | SV22 |
| | **SVXCR 2020 K 16-M-A** | 20 | 20 | 20 | 25 | 125 | 28 | 98 | 0 | 0 | 0.41 | GI017 | SV10 |
| | **SVXCR 2525 M 16-M-A** | 25 | 25 | 25 | 32 | 150 | 32 | 98 | 0 | 0 | 0.68 | GI017 | SV10 |
| | **SVXCR 3225 P 16-M-A** | 32 | 25 | 32 | 32 | 170 | 32 | 98 | 0 | 0 | 1.00 | GI017 | SV10 |
| L | **SVXBL 1212 F 11** | 12 | 12 | 12 | 16 | 80 | 20 | 98 | 0 | 0 | 0.09 | GI194 | SO1 |
| | **SVXBL 1616 H 11** | 16 | 16 | 16 | 20 | 100 | 14 | 98 | 0 | 0 | 0.19 | GI194 | SO1 |
| | **SVXCL 2020 K 13** | 20 | 20 | 20 | 25 | 125 | 12 | 113 | 0 | 0 | 0.38 | GI211 | SV22 |
| | **SVXCL 2020 K 16-M-A** | 20 | 20 | 20 | 25 | 125 | 28 | 98 | 0 | 0 | 0.38 | GI017 | SV10 |
| | **SVXCL 2525 M 16-M-A** | 25 | 25 | 25 | 32 | 150 | 32 | 98 | 0 | 0 | 0.69 | GI017 | SV10 |
| | **SVXCL 3225 P 16-M-A** | 32 | 25 | 32 | 32 | 170 | 32 | 98 | 0 | 0 | 0.99 | GI017 | SV10 |

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

| | | Nm | | | | | | |
|---|---|---|---|---|---|---|---|---|
| SO1 | 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 |

NEW

# C.-SVHB(RL) EXT

P M K N S H

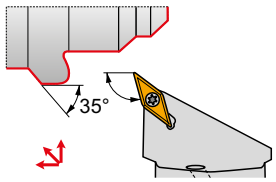
PRAMET

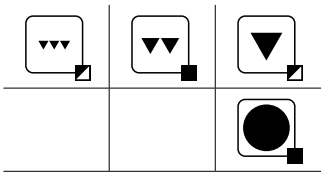
S

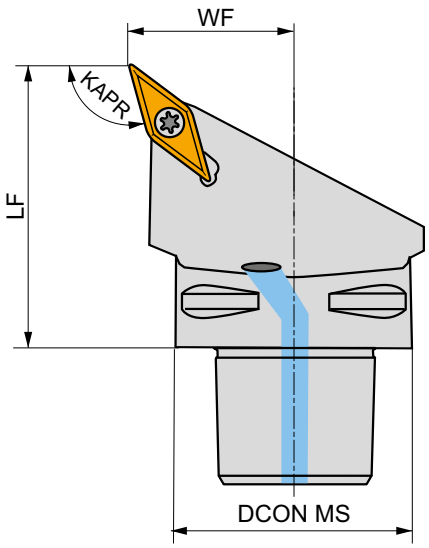


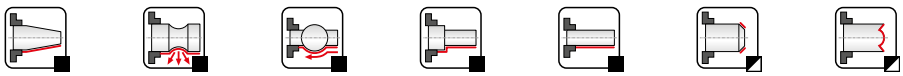
## Ekst. PSC Quick Change, skruelås, 107,5 ° skærevinkel, VB / VC .. skær

Eksternt højre / venstre værktøj, gennemgåendekølevæske, til skruetype positive VB .. 16 og VC .. 16 skær. Velegnet til udvendig langsgående drejning med skulder, tilspidsning, kopidrejning op til 35 ° og affasning. Fås med PSC (Polygon Shank Coupling) størrelse C4 op til C6. Krop behandlet for længere levetid på værktøjet.





| | 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 |

NEW

# C.-SVJB(RL) EXT

P M K N S H

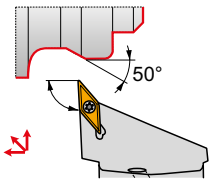
PRAMET

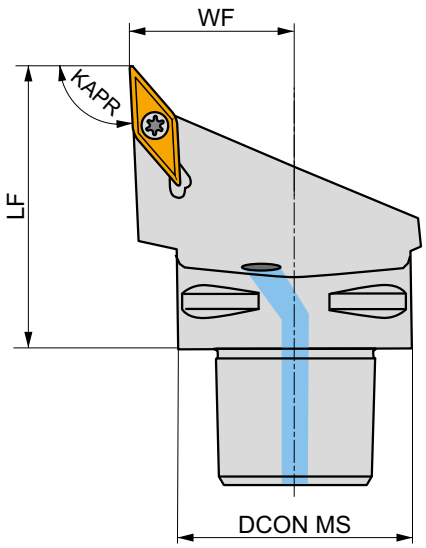
S

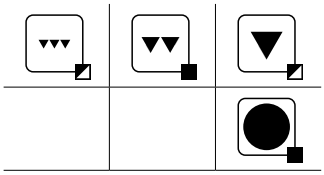


## Ekst. PSC Hurtig skift værktøj, skruelås, 93 ° skærevinkel til VB / VC .. skær

Eksternt højre / venstre værktøj gennemgående kølevæske til skruetype positiv VB .. 11 eller 16 og VC .. 11 op til 16 skær. Velegnet til udvendig langsgående drejning med skulder, tilspidsning, kopidrejning op til 50 ° og affasning. Fås med PSC (Polygon Shank Coupling) størrelse C3 op til C6. Krop behandlet for længere levetid på værktøjet.





| | 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 | ✓ | 0.35 | 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 |

NEW

# C.-SVVBN EXT

P M K N S H

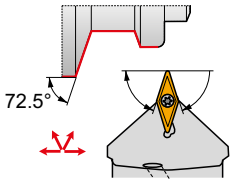
PRAMET

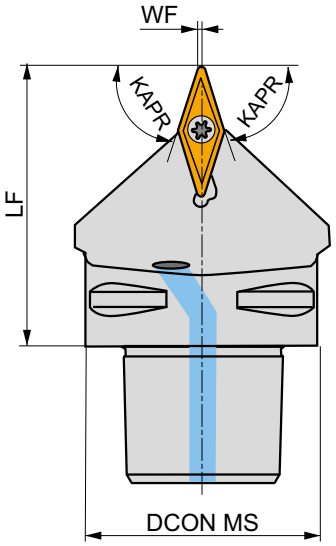
S

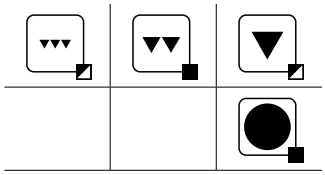


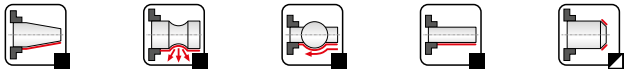
## Ekst. PSC Quick Change Tool, skruelås, 72,5 ° skærevinkel, VB / VC .. Skær

Eksternt neutralt værktøj indvendig kølevæske til skruetype positive VB .. 16 og VC .. 16 skær. Velegnet til udvendig langsgående drejning uden skulder, tilspidsning, kopidrejning op til 72,5 ° og affasning. Fås med PSC (Polygon Shank Coupling) størrelse C4 op til C6. Krop behandlet for længere levetid





| | 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

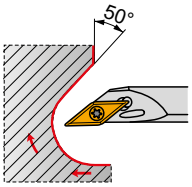
PRAMET

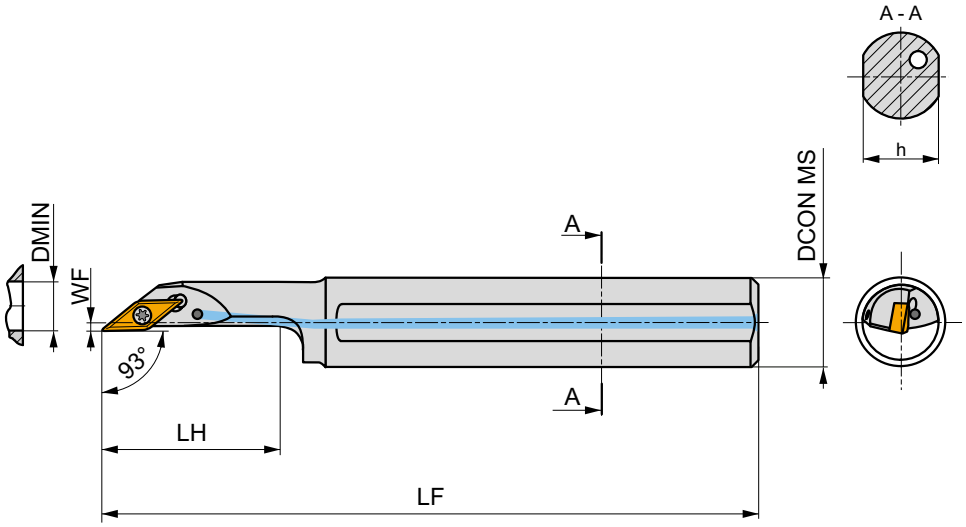
S

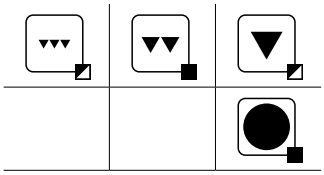


## Intern skruelåsborestang med 93 ° skærevinkel til VB/VC .. Skær

Intern højre / venstre borestang, indvendig kølevæske, med 93° skærevinkel til skrue type VB .. 11 og VC .. 11. Mindste indvendige drejediameter Ø25 mm. Velegnet til endekopi, der bliver under 50°. Fås med skaftstørrelse Ø20 og Ø25 mm. Krop behandlet for længere levetid på værktøjet.





| | 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 | -5 | -5 | ✓ | 0.44 | GI194 | S07 |
| | A25S-SVJBR 11 | 25 | 32 | 3.5 | 23 | 250 | 50 | -5 | -5 | ✓ | 0.82 | GI194 | S07 |
| L | A20R-SVJBL 11 | 20 | 25 | 2 | 18 | 200 | 40 | -5 | -5 | ✓ | 0.42 | GI194 | S07 |
| | A25S-SVJBL 11 | 25 | 32 | 3.5 | 23 | 250 | 50 | -5 | -5 | ✓ | 0.82 | GI194 | S07 |

| | | |
|---|---|---|
| GI194 | VB.. 1103.. | VC.. 1103.. |

| | | | | | |
|---|---|---|---|---|---|
| S07 | US 2506-T07P | 0.9 Nm | M 2.5 | 6.3 | FLAG T07P |

# SVLC(RL) INT

P M K N S H

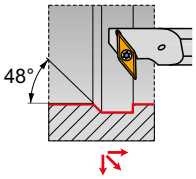
PRAMET

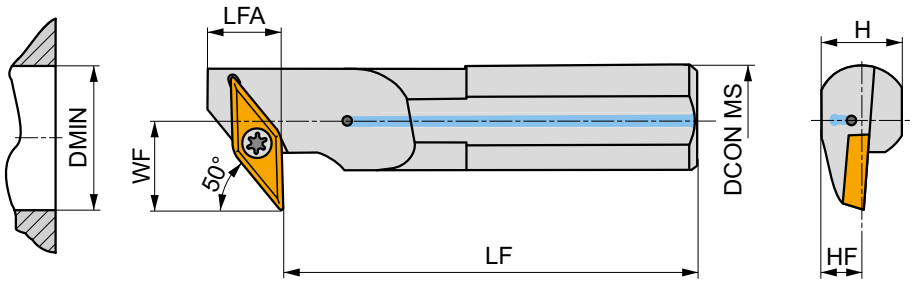
S

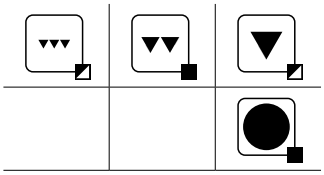


## Intern skruelåsborestang med 50 ° skærevinkel til VC .. Skær

Intern højre / venstre borestang, indvendig kølevæske, med 50° skærevinkel til skruetype VC .. 13 skær. Mindste indvendige drejediameter Ø27 mm. Velegnet til en bred vifte af interne drejningsoperationer og kopiering under 48°. Fås med skaftstørrelse Ø20 op til Ø32 mm. Krop behandlet for længere levetid på værktøjet.





| | 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 |

# SVQB(C)(RL) INT

P M K N S H

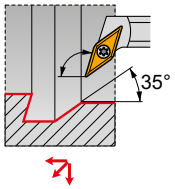
PRAMET

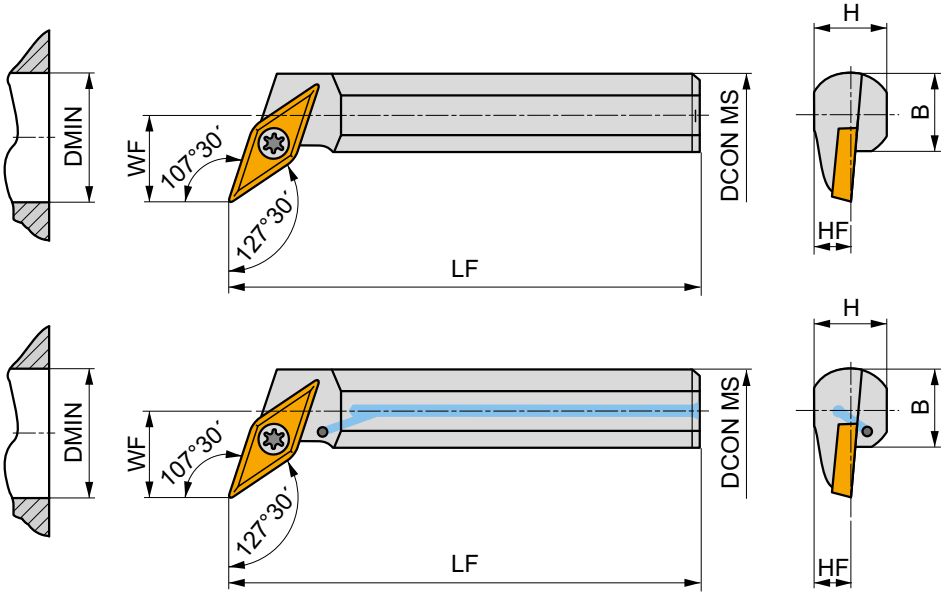
S

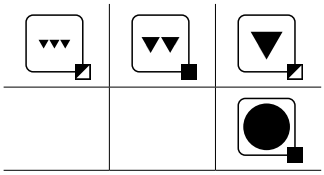


## Intern skruelåsborestang med 107.5 ° skærevinkel til VB/VC .. Skær

Intern højre / venstre borestang, indvendig kølevæske med 107,5 107 skærevinkel til skruetype VB .../ VC .. 11 og 16 skær. Mindste indvendige drejediameter Ø20 mm. Velegnet til en bred vifte af interne drejeoperationer. Fås med skaftstørrelse Ø16 op til Ø40 mm.





| | 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 | ✓ | 0.58 | GI194 | S01 |
| | A16R-SVQCR 13 | 16 | 21 | 11 | 15 | 15 | 200 | -6 | 0 | ✓ | 0.30 | 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 | – | 1.10 | 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 | ✓ | 0.33 | GI194 | S01 |
| | A20S-SVQBL 11 | 20 | 25 | 13 | 18 | 18.5 | 250 | -4 | 0 | ✓ | 0.58 | 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 | – | 1.09 | 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

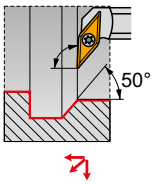
PRAMET

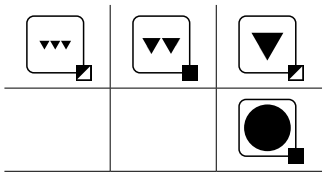
S

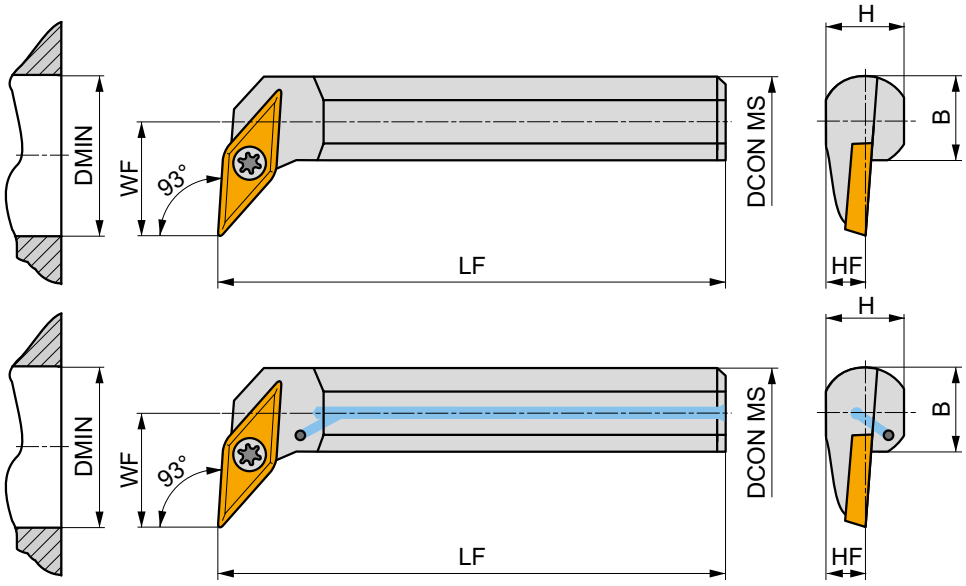


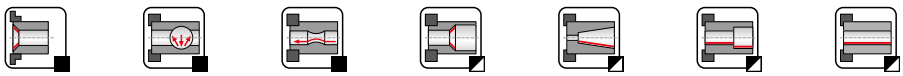
## Intern skruelåsborestang med 93 ° skærevinkel til VB/VC .. Skær

Intern højre / venstre borestang, indvendig kølevæske med 93° skærevinkel til skruetype VB .../ VC .. 11 og 16 skær. Mindste indvendige drejediameter Ø20 mm. Til en bred vifte af interne drejeoperationer og kopiering under 50 under. Ø16 op til Ø40 mm skaft fås. Krop behandlet for længere levetid på værktøjet.





| | 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 | ✓ | 0.34 | GI194 | S01 |
| | **A20S-SVUBR 11** | 20 | 25 | 13 | 18 | 18.8 | 250 | -4 | 0 | ✓ | 0.58 | GI194 | S01 |
| | **A20S-SVUCR 13** | 20 | 25 | 13 | 19 | 18.5 | 250 | -4 | 2 | ✓ | 0.40 | 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 | ✓ | 1.70 | GI211 | SV22 |
| | **S25T-SVUCR 16** | 25 | 32 | 17 | 23 | 23 | 300 | -7 | 0 | – | 1.10 | 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 | ✓ | 0.34 | GI194 | S01 |
| | **A20S-SVUBL 11** | 20 | 25 | 13 | 18 | 18.5 | 250 | -4 | 0 | ✓ | 0.58 | 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 | ✓ | 1.70 | GI211 | SV22 |
| | **S25T-SVUCL 16** | 25 | 32 | 17 | 23 | 23 | 300 | -7 | 0 | – | 1.10 | 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 |

# SVXC(RL) INT

P M K N S H

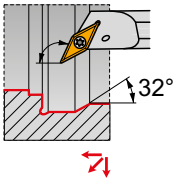
PRAMET

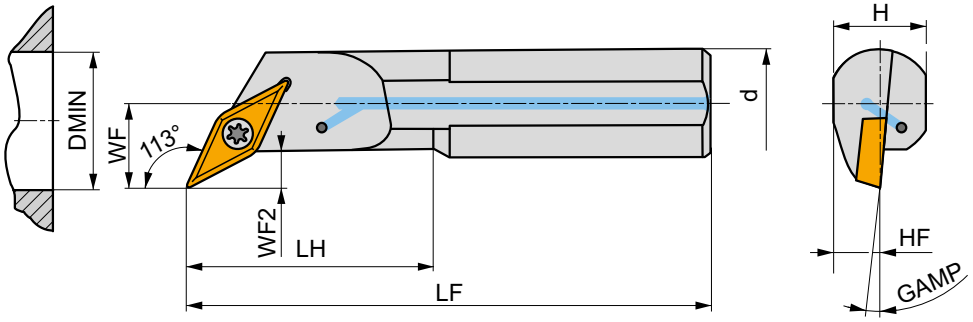
S

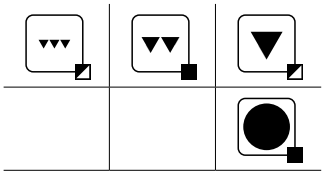


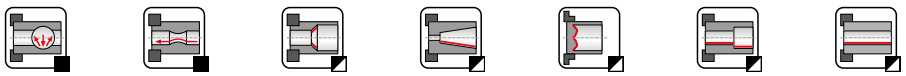
## Intern skruelåsborestang med 113 ° skærevinkel til VC .. Skær

Intern højre / venstre borestang, indvendig kølevæske, med 113° skærevinkel til skruetype VC .. 07 skær. Mindste indvendige drejediameter Ø12,5 mm. Velegnet til en bred vifte af interne drejeoperationer og kopiering under 32°. Fås med skaftstørrelse Ø10 op til Ø16 mm. Krop behandlet for længere levetid på værktøjet.





| | 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 | 3 | -10 | ✓ | 0.06 | GI234 | SV23 |
| | A12K-SVXCR 07 | 12 | 15.5 | 9 | 11 | 125 | 5.5 | 28 | 3 | -8 | ✓ | 0.11 | GI234 | SV23 |
| | A16M-SVXCR 07 | 16 | 17.5 | 11 | 15 | 150 | 7.5 | 36 | 3 | -6 | ✓ | 0.19 | GI234 | SV23 |
| L | A10H-SVXCL 07 | 10 | 12.5 | 7 | 9 | 100 | 4.5 | 22 | 3 | -10 | ✓ | 0.06 | GI234 | SV23 |
| | A12K-SVXCL 07 | 12 | 15.5 | 9 | 11 | 125 | 5.5 | 28 | 3 | -8 | ✓ | 0.11 | GI234 | SV23 |
| | A16M-SVXCL 07 | 16 | 17.5 | 11 | 15 | 150 | 7.5 | 36 | 3 | -6 | ✓ | 0.20 | GI234 | SV23 |

| | |
|---|---|
| GI234 | VC.. 0702.. |

| | | | | | |
|---|---|---|---|---|---|
| SV23 | DVF 3584 | 0.6 | M 2 | 5.5 | DMD 1650 |

# SVXC(RL)-E INT

P M K N S H

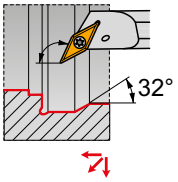
PRAMET

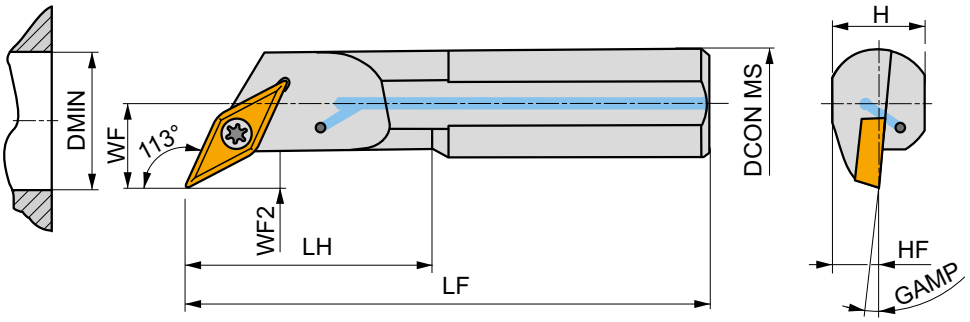
S

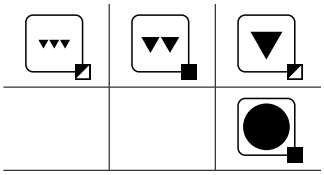


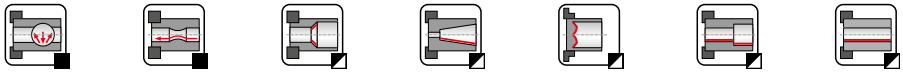
## Indvendig hårdmetal borestang med skruelås, 113 ° skærevinkel til VC .. Skær

Indvendigt højre / venstre hårdmetalborestang, indvendig kølevæske, med 113° skærevinkel til skruetype VC .. 07 skær. Mindste indvendige drejediameter Ø12,5 mm. Velegnet til en bred vifte af interne drejeoperationer og kopiering under 32°. Fås med skaftstørrelse Ø10 op til Ø16 mm. Til værktøjsudhæng> 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 | 3 | -10 | ✓ | 0.10 | GI234 | SV23 |
| | **E12K-SVXCR 07** | 12 | 15.5 | 9 | 11 | 5.5 | 125 | 28 | 3 | -8 | ✓ | 0.19 | GI234 | SV23 |
| | **E16M-SVXCR 07** | 16 | 17.5 | 11 | 15 | 7.5 | 150 | 36 | 3 | -6 | ✓ | 0.33 | GI234 | SV23 |
| L | **E10H-SVXCL 07** | 10 | 12.5 | 7 | 9 | 4.5 | 100 | 22 | 3 | -10 | ✓ | 0.10 | GI234 | SV23 |
| | **E12K-SVXCL 07** | 12 | 15.5 | 9 | 11 | 5.5 | 125 | 28 | 3 | -8 | ✓ | 0.19 | GI234 | SV23 |
| | **E16M-SVXCL 07** | 16 | 17.5 | 11 | 15 | 7.5 | 150 | 36 | 3 | -6 | ✓ | 0.33 | GI234 | SV23 |

| | |
|---|---|
| GI234 | VC.. 0702.. |

| | | | | | |
|---|---|---|---|---|---|
| SV23 | DVF 3584 | 0.6 Nm | M 2 | 5.5 | DMD 1650 |

NEW

# C.-SVQB(RL) INT

P M K N S H

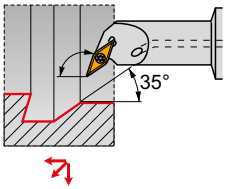
PRAMET

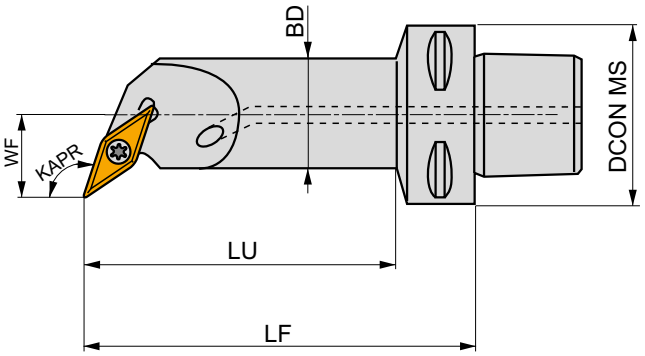
S

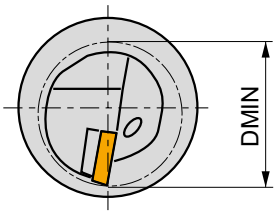


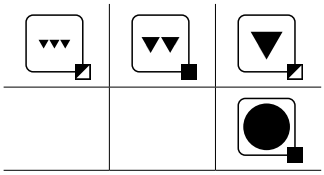
## Int. PSC Hurtig skift værktøj, skruelås, 107,5 ° skærevinkel, VB / VC .. Skær

Internt højre / venstre hånd, indvendig kølevæske, med 107,5° skærevinkel til skruetype VB .. 16 eller VC .. 16 skær. Mindste indvendige drejediameter Ø33 mm. Velegnet til en bred vifte af interne drejeoperationer. PSC-skaft (Polygon Shank Coupling) størrelse C4 og C5 med valg af længder. Krop behandlet for længere levetid på værktøjet.





| | 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.. |

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

# WC

02/ 06/ 08/ 16

## CARBIDE INSERTS

**WCGT**



212

**WCGX**



213

**WCMT**



213

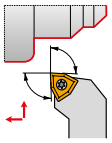
**MATCH THE RIGHT SIZE (example)**

| Insert | Tool Holder |
|---|---|
| WCGT **02**0102E-FF2 | A0508H-SWUCR 0**2** |

## ISO-DREJNING – UDVENDIGT

**SWLC(RL) EXT**

95°



WC..

06
08

16×16
25×25

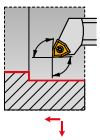
215

212 – 214

## ISO-DREJNING – INDVENDIG

**SWLC(RL) INT**

95°



WC..

06
08

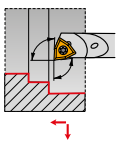
ØDmin 25/40

216

212 – 214

**SWUC(RL) INT**

93°



WC..

02

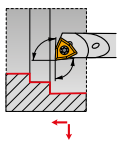
ØDmin 5,8/7,8

217

212 – 214

**SWUC(RL)-E INT**

93°



WC..

02

ØDmin 5,8/7,8

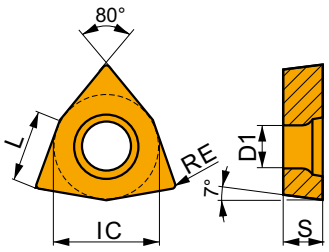
218

212 – 214

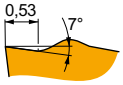
# WCGT

PRAMET

| | IC (mm) | D1 (mm) | L (mm) | S (mm) |
|---|---|---|---|---|
| 0201 | 3.970 | 2.20 | 2.70 | 1.59 |
| 06T3 | 9.525 | 4.40 | 6.50 | 3.97 |
| 0804 | 12.700 | 5.50 | 8.70 | 4.76 |



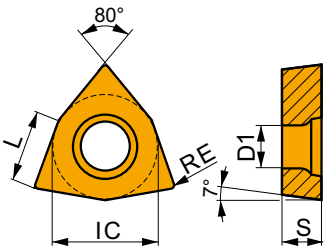

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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 | | | | | | | | | | | | | | | | | |
| AL-geometri med meget positivt design til fin-finish til grov bearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | | | | |
| **WCGT 06T302F-AL** | **HF7** | 0.2 | – | – | – | – | – | – | – | – | – | ■ 450 | 0.12 | 1.0 | – | – | – | – | – | – |
| **WCGT 06T304F-AL** | **HF7** | 0.4 | – | – | – | – | – | – | – | – | – | ■ 360 | 0.24 | 1.0 | – | – | – | – | – | – |
| | **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 | – | – | – | – | – | – |
| | **T0315** | 1.2 | – | – | – | – | – | – | – | – | – | ■ 375 | 0.72 | 2.4 | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | U | | E | | | | | | | | | | | | | | | |
| FF2-geometri med positivt design for finbearbejdning til færdigbearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | | | | |
| **WCGT 020102E-FF2** | **HF7** | 0.2 | – | – | – | – | – | – | ■ 210 | 0.05 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.2 | ■ 205 | 0.05 | 0.8 | – | – | – | ■ 190 | 0.05 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.2 | ■ 280 | 0.05 | 0.8 | – | – | – | ◪ 230 | 0.05 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **TT010** | 0.2 | ■ 345 | 0.05 | 0.5 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **WCGT 020104E-FF2** | **HF7** | 0.4 | – | – | – | – | – | – | ■ 155 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.4 | ■ 170 | 0.12 | 0.8 | – | – | – | ■ 160 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.4 | ■ 205 | 0.12 | 0.8 | – | – | – | ◪ 170 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **TT010** | 0.4 | ■ 350 | 0.06 | 0.5 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |

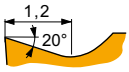
# WCGX

PRAMET

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



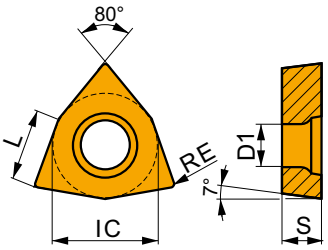

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | |  | | | | | | | | | | | | | | | | | |
| | | | 1,2 20° | | | | | | | | | | | | | | | | | |
| | | | F | | | | | | | | | | | | | | | | | |
| JZ-geometri med venstrehåndet design til finbearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **WCGX 020102FL-JZ** | **TT010** | 0.2 | ■ 330 | 0.06 | 0.5 | ◪ 195 | 0.05 | 0.5 | – | – | – | – | – | – | – | – | – | – | – | – |

# WCMT

PRAMET

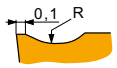
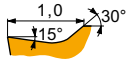
| | IC (mm) | D1 (mm) | L (mm) | S (mm) |
|---|---|---|---|---|
| 06T3 | 9.525 | 4.40 | 6.50 | 3.97 |
| 0804 | 12.700 | 5.50 | 8.70 | 4.76 |




Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | |  | | | | | | | | | | | | | | | | | |
| | | | 15° | | | | | | | | | | | | | | | | | |
| | | | 1 E | | | | | | | | | | | | | | | | | |
| FM-geometri til fin til halv grov bearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | | | | |
| **WCMT 06T304E-FM** | **T7325** | 0.4 | ◪ 195 | 0.15 | 1.2 | ■ 150 | 0.15 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 0.4 | ◪ 190 | 0.15 | 1.2 | ■ 145 | 0.15 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.4 | ◪ 180 | 0.15 | 1.2 | ■ 105 | 0.14 | 1.2 | ◪ 170 | 0.15 | 1.2 | ◪ 540 | 0.18 | 1.2 | – | – | – | – | – | – |
| | **T8330** | 0.4 | ■ 170 | 0.15 | 1.2 | ■ 100 | 0.14 | 1.2 | ◪ 160 | 0.15 | 1.2 | ◪ 510 | 0.18 | 1.2 | – | – | – | – | – | – |
| | **T8430** | 0.4 | ■ 200 | 0.15 | 1.2 | ■ 110 | 0.14 | 1.2 | ◪ 165 | 0.15 | 1.2 | ◪ 555 | 0.18 | 1.2 | – | – | – | – | – | – |
| | **T9315** | 0.4 | ■ 275 | 0.15 | 1.2 | – | – | – | ◪ 260 | 0.15 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | ■ 245 | 0.15 | 1.2 | ■ 145 | 0.15 | 1.2 | ◪ 230 | 0.15 | 1.2 | – | – | – | – | – | – | – | – | – |
| **WCMT 06T308E-FM** | **T7325** | 0.8 | ◪ 215 | 0.20 | 1.2 | ■ 165 | 0.18 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 0.8 | ◪ 205 | 0.20 | 1.2 | ■ 155 | 0.18 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.8 | ◪ 195 | 0.20 | 1.2 | ■ 115 | 0.18 | 1.2 | ◪ 185 | 0.20 | 1.2 | ◪ 585 | 0.24 | 1.2 | – | – | – | – | – | – |
| | **T8330** | 0.8 | ■ 185 | 0.20 | 1.2 | ■ 110 | 0.18 | 1.2 | ◪ 175 | 0.20 | 1.2 | ◪ 555 | 0.24 | 1.2 | – | – | – | – | – | – |
| | **T8430** | 0.8 | ■ 210 | 0.20 | 1.2 | ■ 115 | 0.18 | 1.2 | ◪ 175 | 0.20 | 1.2 | ◪ 585 | 0.24 | 1.2 | – | – | – | – | – | – |
| | **T9315** | 0.8 | ■ 290 | 0.20 | 1.2 | – | – | – | ◪ 275 | 0.20 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | ■ 260 | 0.20 | 1.2 | ■ 155 | 0.18 | 1.2 | ◪ 245 | 0.20 | 1.2 | – | – | – | – | – | – | – | – | – |

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |  | |  | | | | | | | | | | | | | | | | | |
| FM-geometri til fin til halv grov bearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | | | | |
| **WCMT 080404E-FM** | **T7325** | 0.4 | 190 | 0.15 | 1.7 | 145 | 0.15 | 1.7 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.4 | 170 | 0.15 | 1.7 | 100 | 0.14 | 1.7 | 160 | 0.15 | 1.7 | 510 | 0.18 | 1.7 | – | – | – | – | – | – |
| | **T8330** | 0.4 | 165 | 0.15 | 1.7 | 95 | 0.14 | 1.7 | 155 | 0.15 | 1.7 | 495 | 0.18 | 1.7 | – | – | – | – | – | – |
| | **T8430** | 0.4 | 195 | 0.15 | 1.7 | 105 | 0.14 | 1.7 | 160 | 0.15 | 1.7 | 540 | 0.18 | 1.7 | – | – | – | – | – | – |
| | **T9315** | 0.4 | 265 | 0.15 | 1.7 | – | – | – | 250 | 0.15 | 1.7 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 240 | 0.15 | 1.7 | 140 | 0.15 | 1.7 | 225 | 0.15 | 1.7 | – | – | – | – | – | – | – | – | – |
| **WCMT 080408E-FM** | **T7325** | 0.8 | 205 | 0.20 | 1.7 | 155 | 0.18 | 1.7 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 0.8 | 200 | 0.20 | 1.7 | 155 | 0.18 | 1.7 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.8 | 190 | 0.20 | 1.7 | 110 | 0.18 | 1.7 | 180 | 0.20 | 1.7 | 570 | 0.24 | 1.7 | – | – | – | – | – | – |
| | **T8330** | 0.8 | 180 | 0.20 | 1.7 | 105 | 0.18 | 1.7 | 170 | 0.20 | 1.7 | 540 | 0.24 | 1.7 | – | – | – | – | – | – |
| | **T8430** | 0.8 | 205 | 0.20 | 1.7 | 110 | 0.18 | 1.7 | 170 | 0.20 | 1.7 | 570 | 0.24 | 1.7 | – | – | – | – | – | – |
| | **T9315** | 0.8 | 280 | 0.20 | 1.7 | – | – | – | 265 | 0.20 | 1.7 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 250 | 0.20 | 1.7 | 150 | 0.18 | 1.7 | 235 | 0.20 | 1.7 | – | – | – | – | – | – | – | – | – |
| **WCMT 080412E-FM** | **T8330** | 1.2 | 175 | 0.27 | 1.7 | 105 | 0.24 | 1.7 | 165 | 0.27 | 1.7 | 525 | 0.32 | 1.7 | – | – | – | – | – | – |
| | **T8430** | 1.2 | 190 | 0.27 | 1.7 | 105 | 0.24 | 1.7 | 155 | 0.27 | 1.7 | 525 | 0.32 | 1.7 | – | – | – | – | – | – |
| | **T9325** | 1.2 | 235 | 0.27 | 1.7 | 140 | 0.24 | 1.7 | 220 | 0.27 | 1.7 | – | – | – | – | – | – | – | – | – |
|  |  | |  | | | | | | | | | | | | | | | | | |
| I.C. 9,525 12,7 / R 1,5 2,5 | | | | | | | | | | | | | | | | | | | | |
| RF-geometri til semi-grov til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **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 | – | – | – | – | – | – | – | – | – | – | – | – |
|  |  | |  | | | | | | | | | | | | | | | | | |
| UR-geometri til finbearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | | | | |
| **WCMT 06T308E-UR** | **T7325** | 0.8 | 185 | 0.20 | 1.2 | 140 | 0.18 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.8 | 250 | 0.20 | 1.2 | – | – | – | 235 | 0.20 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 225 | 0.20 | 1.2 | 135 | 0.18 | 1.2 | 210 | 0.20 | 1.2 | – | – | – | – | – | – | – | – | – |

# SWLC(RL) EXT

P M K N S H

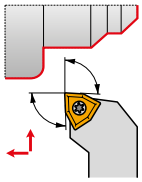
PRAMET

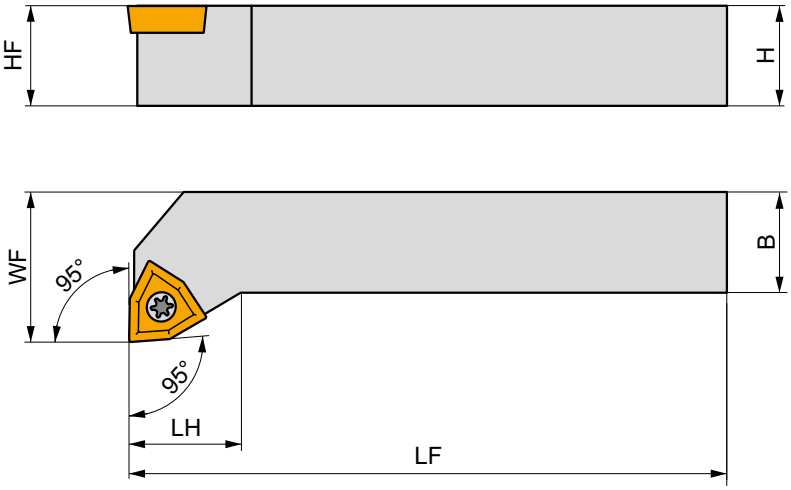
S

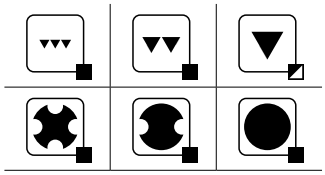


## Ekstern skruelåsværktøjsholder med 95 ° skærevinkel til WC .. Skær

Ekstern højre / venstre værktøjsholder til skruetype positiv skruetype WC .. 06 eller 08 skær. Velegnet til ende og langsgående drejning med skulder-, konisk- og affasedrejning. Fås med skaftstørrelse 16x16 op til 25x25 mm. Krop behandlet for længere levetid på værktøjet.







| | Product | H (mm) | B (mm) | HF (mm) | WF (mm) | LF (mm) | LH (mm) | LAMS (°) | GAMO (°) | kg | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| R | SWLCR 1616 H 06 | 16 | 16 | 16 | 20 | 100 | 15 | 0 | 0 | 0.24 | GI055 | S04 |
| | SWLCR 2020 K 06 | 20 | 20 | 20 | 25 | 125 | 15 | 0 | 0 | 0.40 | GI055 | S04 |
| | SWLCR 2525 M 08 | 25 | 25 | 25 | 32 | 150 | 20 | 0 | 0 | 0.77 | GI049 | S09 |
| L | SWLCL 1616 H 06 | 16 | 16 | 16 | 20 | 100 | 15 | 0 | 0 | 0.23 | GI055 | S04 |
| | SWLCL 2020 K 06 | 20 | 20 | 20 | 25 | 125 | 15 | 0 | 0 | 0.40 | GI055 | S04 |
| | SWLCL 2525 M 08 | 25 | 25 | 25 | 32 | 150 | 20 | 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

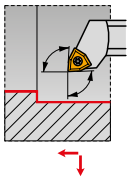
PRAMET

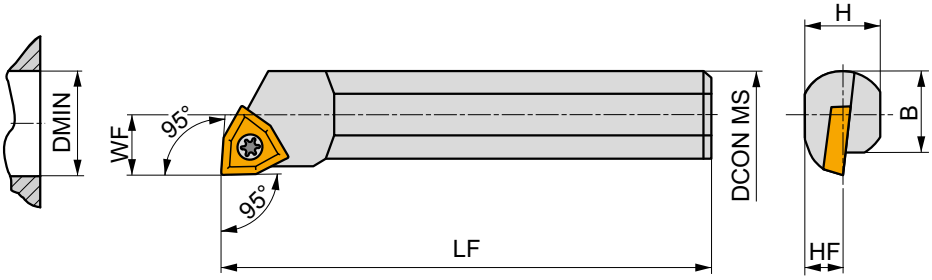
S

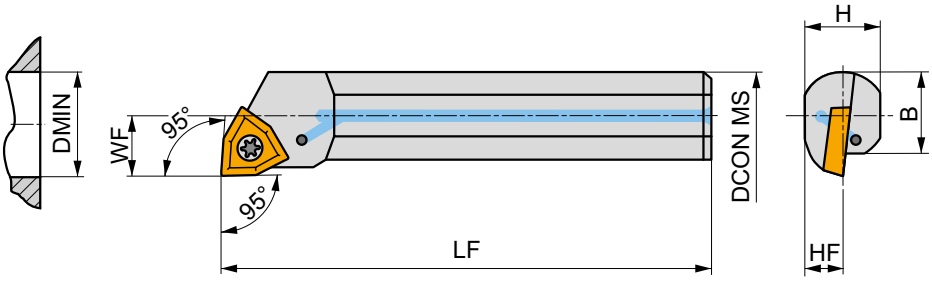


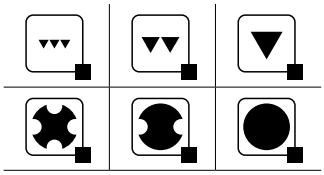
## Intern skruelåsborestang med 95 ° skærevinkel til WC .. Skær

Intern højre / venstre borestang, indvendig kølevæske, 95° skærevinkel til skruetype WC .. 06 og 08 skær. Mindste indvendige drejediameter Ø25 mm. Til indvendig konisk og langsgående drejning med drejning af skulder og affasning. Fås med skaftstørrelse Ø20 til Ø32mm. Krop behandlet for længere levetid på værktøjet.







| | 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 | – | 0.62 | GI055 | S04 |
| | A25R-SWLCR 06 | 25 | 32 | 17 | 23 | 23 | 200 | -7 | 0 | ✓ | 0.70 | GI055 | S04 |
| | S25T-SWLCR 06 | 25 | 32 | 17 | 23 | 23 | 300 | -7 | 0 | – | 1.15 | 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 | ✓ | 0.70 | GI055 | S04 |
| | S25T-SWLCL 06 | 25 | 32 | 17 | 23 | 23 | 300 | -7 | 0 | – | 1.15 | GI055 | S04 |
| | A25R-SWLCL 08 | 25 | 32 | 17 | 23 | 23 | 200 | -7 | 0 | ✓ | 0.70 | GI049 | S04 |
| | A32S-SWLCL 08 | 32 | 40 | 22 | 30 | 30 | 250 | -5 | 0 | ✓ | 1.32 | GI049 | S09 |
| | S32U-SWLCL 08 | 32 | 40 | 22 | 30 | 30 | 350 | -5 | 0 | – | 4.10 | 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 |

# SWUC(RL) INT

P M K N S H

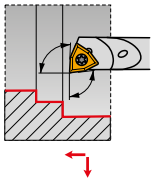
PRAMET

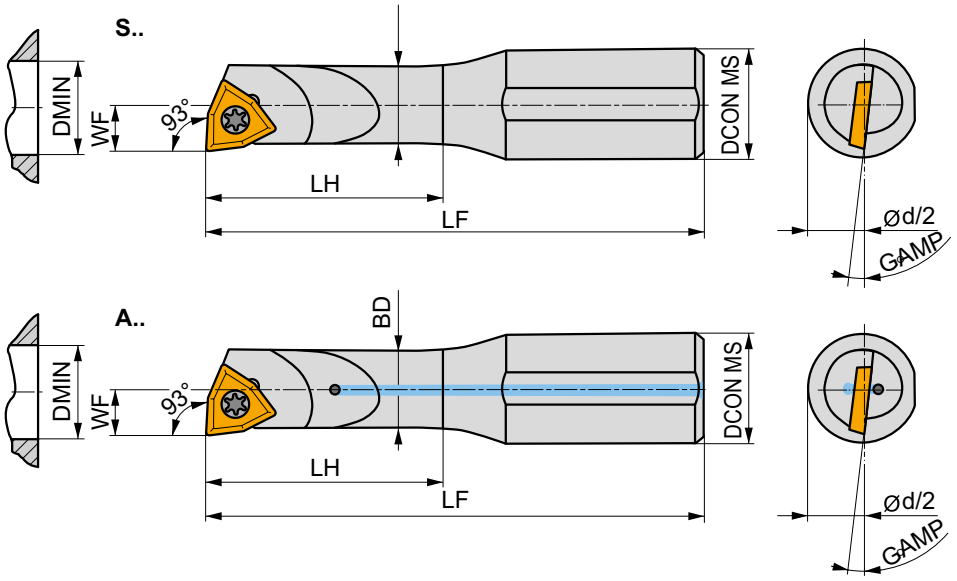
S

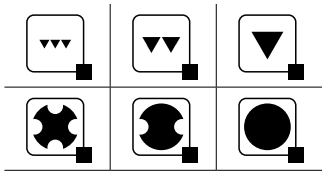


## Intern skruelåsborestang med 93 ° skærevinkel til WC .. Skær

Intern højre / venstre borestang, indvendig kølevæske, 93° skærevinkel til skruetype WC .. 0201 skær. Mindste indvendige drejediameter Ø5,8 mm. Velegnet til indvendig tilspidsning og langsgående drejning med skulder- og affasedrejning. Fås kun med skaftstørrelse Ø8 mm. Krop behandlet for længere levetid på værktøjet.







| | 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 | -17 | ✓ | 0.09 | GI221 | SW21 |
| | S0508H-SWUCR 02 | 8 | 5.8 | 5 | 2.9 | 100 | 18 | -17 | – | 0.04 | GI221 | SW21 |
| | A0608H-SWUCR 02 | 8 | 7.8 | 6 | 3.9 | 100 | 24 | -12 | ✓ | 0.04 | GI221 | SW21 |
| | S0608H-SWUCR 02 | 8 | 7.8 | 6 | 3.9 | 100 | 24 | -12 | – | 0.04 | GI221 | SW21 |
| L | A0508H-SWUCL 02 | 8 | 5.8 | 5 | 2.9 | 100 | 18 | -17 | ✓ | 0.04 | GI221 | SW21 |
| | S0508H-SWUCL 02 | 8 | 5.8 | 5 | 2.9 | 100 | 18 | -17 | – | 0.04 | GI221 | SW21 |
| | A0608H-SWUCL 02 | 8 | 7.8 | 6 | 3.9 | 100 | 24 | -12 | ✓ | 0.04 | GI221 | SW21 |
| | S0608H-SWUCL 02 | 8 | 7.8 | 6 | 3.9 | 100 | 24 | -12 | – | 0.04 | GI221 | SW21 |

| | |
|---|---|
| GI221 | WC.. 0201.. |

| | | | | | |
|---|---|---|---|---|---|
| SW21 | T20.037 | 0.6 | M 2 | 3.7 | DMD 1650 |

# SWUC(RL)-E INT

P M K N S H

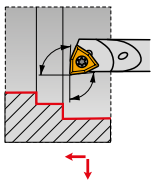
PRAMET

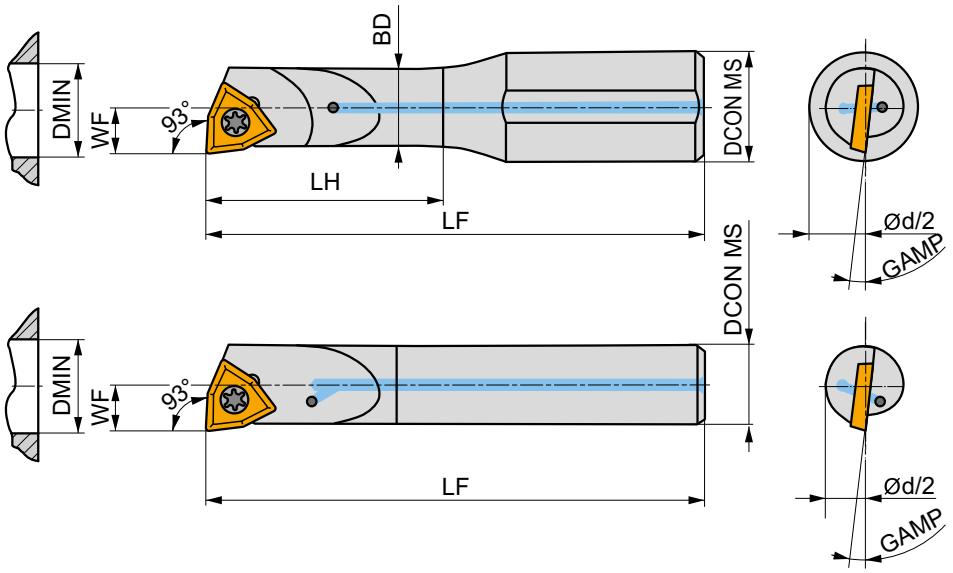
S

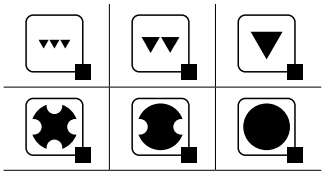


## Indvendig hårdmetal borestang med skruelås, 93 ° skærevinkel til WC .. Skær

Indvendigt højre / venstre hårdmetalborestang, indvendig kølevæske, med 93° skærevinkel til skruetype WC .. 0201 skær. Mindste indvendige drejediameter Ø5,8 mm. Velegnet til indvendig tilspidsning og langsgående drejning med skulder- og affasedrejning. Fås med skaftstørrelse Ø5 op til Ø8 mm. Til værktøjsudhæng> 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 | -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 | -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 | -17 | ✓ | 0.07 | 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 | -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 |



# NEGATIVE INSERTS

# CN

09/ 12/ 16/ 19/ 25

## CARBIDE INSERTS

### CNGG



222

### CNMA



222

### CNMG



223

### CNMM



234

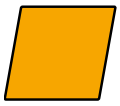
## CER AND CBN INSERTS

### CNGA CER



238

### CNGN CER



238

### CNGA CBN



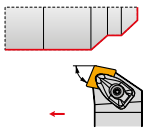
239

| MATCH THE RIGHT SIZE (example) | |
|---|---|
| **Insert** | **Tool Holder** |
| CNMM 120412E-OR | DCBNR 2525 M 12 |

## ISO-DREJNING – UDVENDIGT

### DCBN(RL) EXT

75°



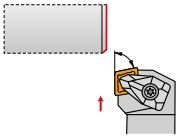
| CN.. |
|---|
| 12 |
| 16 |
| 19 |

20×20
40×40

240 | 222 – 239

### DCKN(RL) EXT

75°



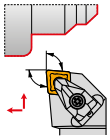
| CN.. |
|---|
| 12 |
| 16 |

20×20
32×32

242 | 222 – 239

### DCLN(RL) EXT

95°



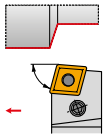
| CN.. |
|---|
| 09 |
| 12 |
| 16 |
| 19 |

16×16
40×40

243 | 222 – 239

### PCBN(RL) EXT

75°



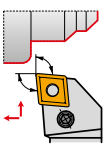
| CN.. |
|---|
| 12 |
| 16 |
| 19 |
| 25 |

20×20
50×50

245 | 222 – 239

### PCLN(RL) EXT

95°



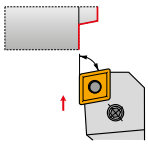
| CN.. |
|---|
| 12 |
| 16 |
| 19 |
| 25 |

20×20
50×50

247 | 222 – 239

### PCKN(RL) EXT

75°



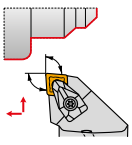
| CN.. |
|---|
| 12 |
| 16 |
| 19 |

20×20
40×40

246 | 222 – 239

### C.-DCLN(RL) EXT NEW

95°



| CN.. |
|---|
| 12 |
| 16 |
| 19 |

C3
C8

249 | 222 – 239

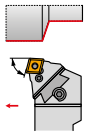
# CN

09/ 12/ 16/ 19/ 25

## ISO-DREJNING – GROVBEARBEJDNING UDVENDIGT

### KHP-CBNR + DKH(RL)

75°






40×50
60×80

251, 253

CN..

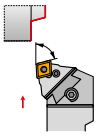


25

222 – 239

### KHP-CBNL + DKH(RL)

75°






40×50
60×80

251, 253

CN..

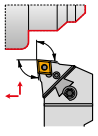


25

222 – 239

### KHP-CLNR/L + DKH(RL)

95°






40×50
60×80

252, 253

CN..



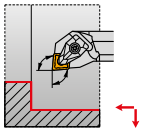
19
25

222 – 239

## ISO-DREJNING – INDVENDIG

### DCLN(RL) INT

95°






32
50

254

CN..

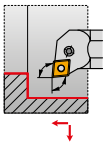


09
12

222 – 239

### PCLN(RL) INT

95°






20
80

255

CN..

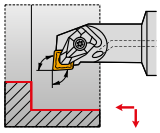


09
12
16
19

222 – 239

### C.-DCLN(RL) INT NEW

95°






25
50

257

CN..



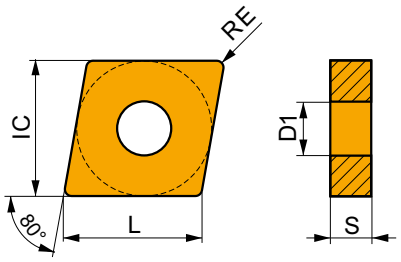
09
12
16

222 – 239

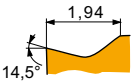
# CNGG

PRAMET

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




Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

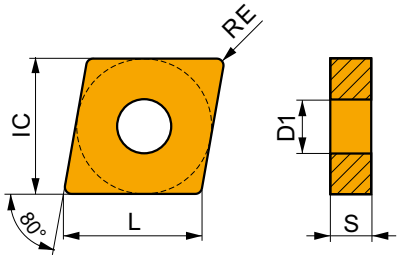
| Product | | RE (mm) | P vc (m/min) | P f (mm/rev) | P ap (mm) | M vc (m/min) | M f (mm/rev) | M ap (mm) | K vc (m/min) | K f (mm/rev) | K ap (mm) | N vc (m/min) | N f (mm/rev) | N ap (mm) | S vc (m/min) | S f (mm/rev) | S ap (mm) | H vc (m/min) | H f (mm/rev) | H ap (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | |  | | | | | | | | | | | | | | | | | |
| **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 | – | – | – |
| | **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 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| | **T8330** | 0.2 | 195 | 0.10 | 1.0 | 115 | 0.09 | 1.0 | 185 | 0.10 | 1.0 | 585 | 0.12 | 1.0 | 45 | 0.08 | 0.8 | 35 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |

SF-geometri med positivt design til finbearbejdning af tynde vægge i kontinuerlige snit.

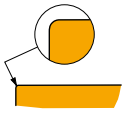
# CNMA

PRAMET

| | 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 |

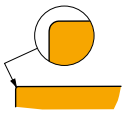
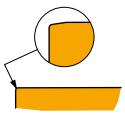



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | |  | | | | | | | | | | | | | | | | | |
| **CNMA 120404** | **T5305** | 0.4 | – | – | – | – | – | – | 235 | 0.10 | 4.0 | – | – | – | – | – | – | 50 | 0.15 | 1.0 |
| | **T5315** | 0.4 | – | – | – | – | – | – | 200 | 0.10 | 4.0 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| **CNMA 120408** | **T5305** | 0.8 | – | – | – | – | – | – | 220 | 0.20 | 4.0 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |
| | **T5315** | 0.8 | – | – | – | – | – | – | 190 | 0.20 | 4.0 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| | **T6310** | 0.8 | – | – | – | – | – | – | 100 | 0.20 | 4.0 | – | – | – | – | – | – | 25 | 0.15 | 1.0 |
| **CNMA 120412** | **T5305** | 1.2 | – | – | – | – | – | – | 195 | 0.30 | 4.0 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| | **T5315** | 1.2 | – | – | – | – | – | – | 180 | 0.30 | 4.0 | – | – | – | – | – | – | 35 | 0.15 | 1.0 |
| | **T6310** | 1.2 | – | – | – | – | – | – | 95 | 0.30 | 4.0 | – | – | – | – | – | – | 20 | 0.15 | 1.0 |
| **CNMA 120416** | **T5305** | 1.6 | – | – | – | – | – | – | 190 | 0.40 | 4.0 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| | **T5315** | 1.6 | – | – | – | – | – | – | 170 | 0.40 | 4.0 | – | – | – | – | – | – | 35 | 0.15 | 1.0 |

Til fin til halv grov bearbejdning og kontinuerlig til let afbrudt snit.

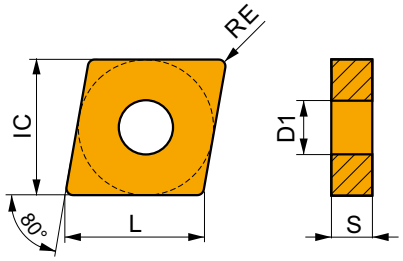
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) | | | | | | | | | | | | | | | | | | |
| | | |  Til fin til halv grov bearbejdning og kontinuerlig til let afbrudt snit. | | | | | | | | | | | | | | | | | |
| **CNMA 160612** | **T5305** | 1.2 | – | – | – | – | – | – | ■ 190 | 0.30 | 5.0 | – | – | – | – | – | – | ◪ 40 | 0.15 | 1.0 |
| | **T5315** | 1.2 | – | – | – | – | – | – | ■ 175 | 0.30 | 5.0 | – | – | – | – | – | – | ◪ 35 | 0.15 | 1.0 |
| | **T6310** | 1.2 | – | – | – | – | – | – | ■ 90 | 0.30 | 5.0 | – | – | – | – | – | – | ◪ 20 | 0.15 | 1.0 |
| **CNMA 160616** | **T5305** | 1.6 | – | – | – | – | – | – | ■ 185 | 0.40 | 5.0 | – | – | – | – | – | – | ◪ 35 | 0.15 | 1.0 |
| | **T5315** | 1.6 | – | – | – | – | – | – | ■ 165 | 0.40 | 5.0 | – | – | – | – | – | – | ◪ 35 | 0.15 | 1.0 |
| **CNMA 190612** | **T5305** | 1.2 | – | – | – | – | – | – | ■ 190 | 0.30 | 6.0 | – | – | – | – | – | – | ◪ 40 | 0.15 | 1.0 |
| | **T5315** | 1.2 | – | – | – | – | – | – | ■ 170 | 0.30 | 6.0 | – | – | – | – | – | – | ◪ 35 | 0.15 | 1.0 |
| | **T6310** | 1.2 | – | – | – | – | – | – | ■ 85 | 0.30 | 6.0 | – | – | – | – | – | – | ◪ 20 | 0.15 | 1.0 |
| **CNMA 190616** | **T5305** | 1.6 | – | – | – | – | – | – | ■ 180 | 0.40 | 6.0 | – | – | – | – | – | – | ◪ 35 | 0.15 | 1.0 |
| | **T5315** | 1.6 | – | – | – | – | – | – | ■ 160 | 0.40 | 6.0 | – | – | – | – | – | – | ◪ 30 | 0.15 | 1.0 |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | |  Til fin til halv grov bearbejdning og kontinuerlig til let afbrudt snit. | | | | | | | | | | | | | | | | | |
| **CNMA 120408S** | **T5305** | 0.8 | – | – | – | – | – | – | ■ 220 | 0.20 | 4.0 | – | – | – | – | – | – | ◪ 45 | 0.15 | 1.0 |
| **CNMA 120412S** | **T5305** | 1.2 | – | – | – | – | – | – | ■ 190 | 0.40 | 4.0 | – | – | – | – | – | – | ◪ 40 | 0.15 | 1.0 |
| **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 | 0.15 | 1.0 |

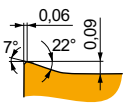
## CNMG

PRAMET

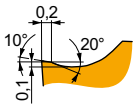
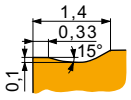
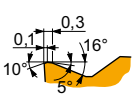
| | IC (mm) | D1 (mm) | L (mm) | S (mm) |
|---|---|---|---|---|
| 0903 | 9.525 | 3.81 | 9.70 | 3.18 |
| 1204 | 12.700 | 5.16 | 12.90 | 4.76 |
| 1606 | 15.880 | 6.35 | 16.10 | 6.35 |
| 1906 | 19.050 | 7.94 | 19.30 | 6.35 |
| 2509 | 25.400 | 9.12 | 25.80 | 9.53 |



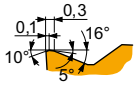
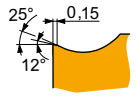

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) | | | | | | | | | | | | | | | | | | |
| | | |  FF-geometri med meget positivt design til finbearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | |
| **CNMG 120404E-FF** | **T7325** | 0.4 | ◪ 235 | 0.12 | 1.0 | ■ 180 | 0.11 | 1.0 | | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.4 | ◪ 220 | 0.12 | 1.0 | ■ 130 | 0.11 | 1.0 | ◪ 205 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| **CNMG 120408E-FF** | **T7325** | 0.8 | ◪ 265 | 0.15 | 1.0 | ■ 205 | 0.14 | 1.0 | | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.8 | ◪ 245 | 0.15 | 1.0 | ■ 145 | 0.14 | 1.0 | ◪ 230 | 0.15 | 1.0 | – | – | – | – | – | – | – | – | – |

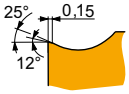
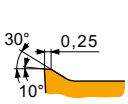
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | FM-geometri med positivt design til fin til halvgrov bearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | |
| **CNMG 090304E-FM** | **T7325** | 0.4 | 195 | 0.20 | 1.4 | 150 | 0.18 | 1.4 | – | – | – | – | – | – | 60 | 0.16 | 1.1 | – | – | – |
| | **T8330** | 0.4 | 175 | 0.20 | 1.4 | 105 | 0.18 | 1.4 | 165 | 0.20 | 1.4 | – | – | – | 40 | 0.14 | 1.1 | – | – | – |
| | **T8430** | 0.4 | 195 | 0.20 | 1.4 | 105 | 0.18 | 1.4 | 160 | 0.20 | 1.4 | – | – | – | 40 | 0.14 | 1.1 | – | – | – |
| | **T9315** | 0.4 | 265 | 0.20 | 1.4 | – | – | – | 250 | 0.20 | 1.4 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 240 | 0.20 | 1.4 | 140 | 0.18 | 1.4 | 225 | 0.20 | 1.4 | – | – | – | 50 | 0.16 | 1.1 | – | – | – |
| **CNMG 090308E-FM** | **T7325** | 0.8 | 235 | 0.20 | 1.4 | 180 | 0.18 | 1.4 | – | – | – | – | – | – | 75 | 0.16 | 1.1 | – | – | – |
| | **T8330** | 0.8 | 205 | 0.20 | 1.4 | 120 | 0.18 | 1.4 | 190 | 0.20 | 1.4 | – | – | – | 50 | 0.14 | 1.1 | – | – | – |
| | **T8430** | 0.8 | 235 | 0.20 | 1.4 | 125 | 0.18 | 1.4 | 190 | 0.20 | 1.4 | – | – | – | 50 | 0.14 | 1.1 | – | – | – |
| | **T9315** | 0.8 | 315 | 0.20 | 1.4 | – | – | – | 295 | 0.20 | 1.4 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 285 | 0.20 | 1.4 | 170 | 0.18 | 1.4 | 270 | 0.20 | 1.4 | – | – | – | 60 | 0.16 | 1.1 | – | – | – |
| **CNMG 120404E-FM** | **T7325** | 0.4 | 185 | 0.20 | 2.1 | 140 | 0.18 | 2.1 | – | – | – | – | – | – | 60 | 0.16 | 1.7 | – | – | – |
| | **T7335** | 0.4 | 180 | 0.20 | 2.1 | 140 | 0.18 | 2.1 | – | – | – | – | – | – | 55 | 0.16 | 1.7 | – | – | – |
| | **T8315** | 0.4 | 175 | 0.20 | 2.1 | 105 | 0.18 | 2.1 | 165 | 0.20 | 2.1 | – | – | – | 40 | 0.14 | 1.7 | – | – | – |
| | **T8330** | 0.4 | 165 | 0.20 | 2.1 | 95 | 0.18 | 2.1 | 155 | 0.20 | 2.1 | – | – | – | 40 | 0.14 | 1.7 | – | – | – |
| | **T8430** | 0.4 | 190 | 0.20 | 2.1 | 105 | 0.18 | 2.1 | 155 | 0.20 | 2.1 | – | – | – | 40 | 0.14 | 1.7 | – | – | – |
| | **T9310** | 0.4 | 285 | 0.20 | 2.1 | – | – | – | 270 | 0.20 | 2.1 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.4 | 255 | 0.20 | 2.1 | – | – | – | 240 | 0.20 | 2.1 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 230 | 0.20 | 2.1 | 135 | 0.18 | 2.1 | 215 | 0.20 | 2.1 | – | – | – | 50 | 0.16 | 1.7 | – | – | – |
| | **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 | – | – | – |
| | **T7335** | 0.8 | 215 | 0.20 | 2.1 | 165 | 0.18 | 2.1 | – | – | – | – | – | – | 65 | 0.16 | 1.7 | – | – | – |
| | **T8315** | 0.8 | 205 | 0.20 | 2.1 | 120 | 0.18 | 2.1 | 190 | 0.20 | 2.1 | – | – | – | 50 | 0.16 | 1.7 | – | – | – |
| | **T8330** | 0.8 | 195 | 0.20 | 2.1 | 115 | 0.18 | 2.1 | 185 | 0.20 | 2.1 | – | – | – | 45 | 0.16 | 1.7 | – | – | – |
| | **T8430** | 0.8 | 225 | 0.20 | 2.1 | 120 | 0.18 | 2.1 | 185 | 0.20 | 2.1 | – | – | – | 45 | 0.16 | 1.7 | – | – | – |
| | **T9310** | 0.8 | 335 | 0.20 | 2.1 | – | – | – | 315 | 0.20 | 2.1 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.8 | 305 | 0.20 | 2.1 | – | – | – | 285 | 0.20 | 2.1 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 275 | 0.20 | 2.1 | 165 | 0.18 | 2.1 | 260 | 0.20 | 2.1 | – | – | – | 60 | 0.16 | 1.7 | – | – | – |
| | **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 | – | – | – |
| | **T9315** | 1.2 | 285 | 0.27 | 2.1 | – | – | – | 270 | 0.27 | 2.1 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | 255 | 0.27 | 2.1 | 150 | 0.24 | 2.1 | 240 | 0.27 | 2.1 | – | – | – | 55 | 0.19 | 1.7 | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | KR-geometri til semi-grov til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **CNMG 120408E-KR** | **T5305** | 0.8 | 255 | 0.35 | 4.0 | – | – | – | 240 | 0.35 | 4.0 | – | – | – | – | – | – | 50 | 0.15 | 1.0 |
| | **T5315** | 0.8 | 225 | 0.35 | 4.0 | – | – | – | 210 | 0.35 | 4.0 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |
| **CNMG 120412E-KR** | **T5305** | 1.2 | 255 | 0.40 | 4.0 | – | – | – | 240 | 0.40 | 4.0 | – | – | – | – | – | – | 50 | 0.15 | 1.0 |
| | **T5315** | 1.2 | 230 | 0.40 | 4.0 | – | – | – | 215 | 0.40 | 4.0 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | M-geometri til fin til halv grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **CNMG 090308E-M** | **T9315** | 0.8 | 230 | 0.32 | 1.8 | – | – | – | 215 | 0.32 | 1.8 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |
| | **T9325** | 0.8 | 205 | 0.32 | 1.8 | – | – | – | 190 | 0.32 | 1.8 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.8 | 180 | 0.32 | 1.8 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **CNMG 120404E-M** | **T5315** | 0.4 | 245 | 0.20 | 2.1 | – | – | – | 230 | 0.20 | 2.1 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |
| | **T9310** | 0.4 | 260 | 0.20 | 2.1 | – | – | – | 245 | 0.20 | 2.1 | – | – | – | – | – | – | 50 | 0.15 | 1.0 |
| | **T9315** | 0.4 | 235 | 0.20 | 2.1 | – | – | – | 220 | 0.20 | 2.1 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |
| | **T9325** | 0.4 | 210 | 0.20 | 2.1 | – | – | – | 195 | 0.20 | 2.1 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.4 | 180 | 0.20 | 2.1 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |

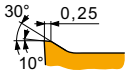
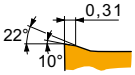
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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-geometri til fin til halv grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **CNMG 120408E-M** | **6640** | 0.8 | ■ 165 | 0.32 | 2.1 | – | – | – | ■ 155 | 0.32 | 2.1 | – | – | – | – | – | – | – | – | – |
| | **T5305** | 0.8 | ◪ 280 | 0.32 | 2.1 | – | – | – | ■ 265 | 0.32 | 2.1 | – | – | – | – | – | – | ◪ 55 | 0.15 | 1.0 |
| | **T5315** | 0.8 | ◪ 250 | 0.32 | 2.1 | – | – | – | ■ 235 | 0.32 | 2.1 | – | – | – | – | – | – | ◪ 50 | 0.15 | 1.0 |
| | **T8330** | 0.8 | ■ 155 | 0.32 | 2.1 | – | – | – | ■ 145 | 0.32 | 2.1 | – | – | – | – | – | – | ◪ 30 | 0.15 | 1.0 |
| | **T8430** | 0.8 | ■ 170 | 0.32 | 2.1 | – | – | – | ◪ 135 | 0.32 | 2.1 | – | – | – | – | – | – | ◪ 25 | 0.15 | 1.0 |
| | **T9310** | 0.8 | ■ 245 | 0.32 | 2.1 | – | – | – | ◪ 230 | 0.32 | 2.1 | – | – | – | – | – | – | ◪ 45 | 0.15 | 1.0 |
| | **T9315** | 0.8 | ■ 225 | 0.32 | 2.1 | – | – | – | ◪ 210 | 0.32 | 2.1 | – | – | – | – | – | – | ◪ 45 | 0.15 | 1.0 |
| | **T9325** | 0.8 | ■ 200 | 0.32 | 2.1 | – | – | – | ◪ 190 | 0.32 | 2.1 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.8 | ■ 180 | 0.32 | 2.1 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **CNMG 120412E-M** | **T5305** | 1.2 | ◪ 275 | 0.40 | 2.1 | – | – | – | ■ 260 | 0.40 | 2.1 | – | – | – | – | – | – | ◪ 55 | 0.15 | 1.0 |
| | **T5315** | 1.2 | ◪ 245 | 0.40 | 2.1 | – | – | – | ■ 230 | 0.40 | 2.1 | – | – | – | – | – | – | ◪ 45 | 0.15 | 1.0 |
| | **T9310** | 1.2 | ■ 235 | 0.40 | 2.1 | – | – | – | ◪ 220 | 0.40 | 2.1 | – | – | – | – | – | – | ◪ 45 | 0.15 | 1.0 |
| | **T9315** | 1.2 | ■ 220 | 0.40 | 2.1 | – | – | – | ◪ 205 | 0.40 | 2.1 | – | – | – | – | – | – | ◪ 40 | 0.15 | 1.0 |
| | **T9325** | 1.2 | ■ 195 | 0.40 | 2.1 | – | – | – | ◪ 185 | 0.40 | 2.1 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.2 | ■ 170 | 0.40 | 2.1 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **CNMG 120416E-M** | **T9325** | 1.6 | ■ 200 | 0.40 | 2.1 | – | – | – | ◪ 190 | 0.40 | 2.1 | – | – | – | – | – | – | – | – | – |
| | **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 | 0.15 | 1.0 |
| | **T9315** | 0.8 | ■ 215 | 0.32 | 3.6 | – | – | – | ◪ 200 | 0.32 | 3.6 | – | – | – | – | – | – | ◪ 40 | 0.15 | 1.0 |
| | **T9325** | 0.8 | ■ 190 | 0.32 | 3.6 | – | – | – | ◪ 180 | 0.32 | 3.6 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.8 | ■ 170 | 0.32 | 3.6 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **CNMG 160612E-M** | **T9315** | 1.2 | ■ 210 | 0.40 | 3.6 | – | – | – | ◪ 195 | 0.40 | 3.6 | – | – | – | – | – | – | ◪ 40 | 0.15 | 1.0 |
| | **T9325** | 1.2 | ■ 185 | 0.40 | 3.6 | – | – | – | ◪ 175 | 0.40 | 3.6 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.2 | ■ 160 | 0.40 | 3.6 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **CNMG 160616E-M** | **T9325** | 1.6 | ■ 190 | 0.40 | 3.6 | – | – | – | ◪ 180 | 0.40 | 3.6 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.6 | ■ 165 | 0.40 | 3.6 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **CNMG 190608E-M** | **T9315** | 0.8 | ■ 210 | 0.32 | 4.2 | – | – | – | ◪ 195 | 0.32 | 4.2 | – | – | – | – | – | – | ◪ 40 | 0.15 | 1.0 |
| | **T9325** | 0.8 | ■ 190 | 0.32 | 4.2 | – | – | – | ◪ 180 | 0.32 | 4.2 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.8 | ■ 165 | 0.32 | 4.2 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **CNMG 190612E-M** | **6640** | 1.2 | ■ 145 | 0.40 | 4.2 | – | – | – | ■ 135 | 0.40 | 4.2 | – | – | – | – | – | – | – | – | – |
| | **T9310** | 1.2 | ■ 220 | 0.40 | 4.2 | – | – | – | ◪ 205 | 0.40 | 4.2 | – | – | – | – | – | – | ◪ 40 | 0.15 | 1.0 |
| | **T9315** | 1.2 | ■ 205 | 0.40 | 4.2 | – | – | – | ◪ 190 | 0.40 | 4.2 | – | – | – | – | – | – | ◪ 40 | 0.15 | 1.0 |
| | **T9325** | 1.2 | ■ 185 | 0.40 | 4.2 | – | – | – | ◪ 175 | 0.40 | 4.2 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.2 | ■ 160 | 0.40 | 4.2 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **CNMG 190616E-M** | **T9310** | 1.6 | ■ 230 | 0.40 | 4.2 | – | – | – | ◪ 215 | 0.40 | 4.2 | – | – | – | – | – | – | ◪ 45 | 0.15 | 1.0 |
| | **T9315** | 1.6 | ■ 215 | 0.40 | 4.2 | – | – | – | ◪ 200 | 0.40 | 4.2 | – | – | – | – | – | – | ◪ 40 | 0.15 | 1.0 |
| | **T9325** | 1.6 | ■ 190 | 0.40 | 4.2 | – | – | – | ◪ 180 | 0.40 | 4.2 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.6 | ■ 165 | 0.40 | 4.2 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
|  |  | |  | | | | | | | | | | | | | | | | | |
| | | | NF-geometri med meget positivt design til finbearbejdning til medium bearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | |
| **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 | – | – | – |
| | **T7335** | 0.4 | ◪ 210 | 0.18 | 0.8 | ■ 160 | 0.16 | 0.8 | – | – | – | – | – | – | ◪ 65 | 0.16 | 0.6 | – | – | – |
| | **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 | – | – | – |
| | **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 | – | – | – |
| | **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** | **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 | – | – | – |
| | **T7335** | 0.8 | ◪ 240 | 0.19 | 1.0 | ■ 185 | 0.17 | 1.0 | – | – | – | – | – | – | ◪ 75 | 0.15 | 0.8 | – | – | – |
| | **T8330** | 0.8 | ■ 215 | 0.19 | 1.0 | ■ 125 | 0.17 | 1.0 | ◪ 200 | 0.19 | 1.0 | ◪ 645 | 0.23 | 1.0 | ◪ 50 | 0.15 | 0.8 | – | – | – |
| | **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 | – | – | – |
| | **T9325** | 0.8 | ■ 300 | 0.19 | 1.0 | ■ 180 | 0.17 | 1.0 | ◪ 285 | 0.19 | 1.0 | – | – | – | ◪ 65 | 0.15 | 0.8 | – | – | – |

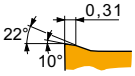
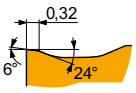
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |  | | | | | | | | | | | | | | | | | | | |
| NF-geometri med meget positivt design til finbearbejdning til medium bearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **CNMG 120404E-NF** | **HF7** | 0.4 | – | – | – | 95 | 0.15 | 1.7 | 155 | 0.17 | 1.7 | 495 | 0.20 | 1.7 | – | – | – | – | – | – |
| | **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 | – | – | – |
| | **T7325** | 0.4 | 200 | 0.18 | 1.7 | 155 | 0.16 | 1.7 | – | – | – | – | – | – | 65 | 0.16 | 1.4 | – | – | – |
| | **T7335** | 0.4 | 195 | 0.18 | 1.7 | 150 | 0.16 | 1.7 | – | – | – | – | – | – | 60 | 0.16 | 1.4 | – | – | – |
| | **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 | – | – | – |
| | **T8330** | 0.4 | 180 | 0.17 | 1.7 | 105 | 0.15 | 1.7 | 170 | 0.17 | 1.7 | 540 | 0.20 | 1.7 | 45 | 0.14 | 1.4 | – | – | – |
| | **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 | – | – | – |
| | **T9315** | 0.4 | 285 | 0.17 | 1.7 | – | – | – | 270 | 0.17 | 1.7 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 250 | 0.18 | 1.7 | 150 | 0.16 | 1.7 | 235 | 0.18 | 1.7 | – | – | – | 55 | 0.16 | 1.4 | – | – | – |
| **CNMG 120408E-NF** | **HF7** | 0.8 | – | – | – | 110 | 0.17 | 1.7 | 180 | 0.19 | 1.7 | 570 | 0.23 | 1.7 | – | – | – | – | – | – |
| | **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 | – | – | – |
| | **T7325** | 0.8 | 235 | 0.19 | 1.7 | 180 | 0.17 | 1.7 | – | – | – | – | – | – | 75 | 0.15 | 1.4 | – | – | – |
| | **T7335** | 0.8 | 225 | 0.19 | 1.7 | 175 | 0.17 | 1.7 | – | – | – | – | – | – | 70 | 0.15 | 1.4 | – | – | – |
| | **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 | – | – | – |
| | **T8330** | 0.8 | 200 | 0.19 | 1.7 | 120 | 0.17 | 1.7 | 190 | 0.19 | 1.7 | 600 | 0.23 | 1.7 | 50 | 0.15 | 1.4 | – | – | – |
| | **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 | – | – | – |
| | **T9315** | 0.8 | 320 | 0.19 | 1.7 | – | – | – | 300 | 0.19 | 1.7 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 285 | 0.19 | 1.7 | 170 | 0.17 | 1.7 | 270 | 0.19 | 1.7 | – | – | – | 60 | 0.15 | 1.4 | – | – | – |
| **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 | – | – | – |
| | **T7325** | 1.2 | 205 | 0.30 | 2.1 | 155 | 0.27 | 2.1 | – | – | – | – | – | – | 65 | 0.21 | 1.7 | – | – | – |
| | **T7335** | 1.2 | 200 | 0.30 | 2.1 | 155 | 0.27 | 2.1 | – | – | – | – | – | – | 65 | 0.21 | 1.7 | – | – | – |
| | **T8330** | 1.2 | 185 | 0.30 | 2.1 | 110 | 0.27 | 2.1 | 175 | 0.30 | 2.1 | 555 | 0.36 | 2.1 | 45 | 0.21 | 1.7 | – | – | – |
| | **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 | – | – | – |
| | **T9315** | 1.2 | 275 | 0.30 | 2.1 | – | – | – | 260 | 0.30 | 2.1 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | 245 | 0.30 | 2.1 | 145 | 0.27 | 2.1 | 230 | 0.30 | 2.1 | – | – | – | 55 | 0.21 | 1.7 | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| NM-geometri med meget positivt design til finbearbejdning, mellem og grov bearbejdning i kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **CNMG 120404E-NM** | **T7325** | 0.4 | 195 | 0.20 | 2.1 | 150 | 0.18 | 2.1 | – | – | – | – | – | – | 60 | 0.16 | 1.7 | – | – | – |
| | **T7335** | 0.4 | 190 | 0.20 | 2.1 | 145 | 0.18 | 2.1 | – | – | – | – | – | – | 60 | 0.16 | 1.7 | – | – | – |
| | **T8315** | 0.4 | 180 | 0.20 | 2.1 | 105 | 0.18 | 2.1 | – | – | – | 540 | 0.24 | 2.1 | 45 | 0.16 | 1.7 | – | – | – |
| | **T8330** | 0.4 | 170 | 0.20 | 2.1 | 100 | 0.18 | 2.1 | – | – | – | 510 | 0.24 | 2.1 | 40 | 0.16 | 1.7 | – | – | – |
| | **T8430** | 0.4 | 195 | 0.20 | 2.1 | 105 | 0.18 | 2.1 | – | – | – | 540 | 0.24 | 2.1 | 40 | 0.16 | 1.7 | – | – | – |
| | **T9315** | 0.4 | 270 | 0.20 | 2.1 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 240 | 0.20 | 2.1 | 140 | 0.18 | 2.1 | – | – | – | – | – | – | 50 | 0.16 | 1.7 | – | – | – |
| **CNMG 120408E-NM** | **T7325** | 0.8 | 215 | 0.25 | 2.1 | 165 | 0.23 | 2.1 | – | – | – | – | – | – | 65 | 0.20 | 1.7 | – | – | – |
| | **T7335** | 0.8 | 210 | 0.25 | 2.1 | 160 | 0.23 | 2.1 | – | – | – | – | – | – | 65 | 0.20 | 1.7 | – | – | – |
| | **T8315** | 0.8 | 205 | 0.25 | 2.1 | 120 | 0.23 | 2.1 | – | – | – | 615 | 0.30 | 2.1 | 50 | 0.20 | 1.7 | – | – | – |
| | **T8330** | 0.8 | 195 | 0.25 | 2.1 | 115 | 0.23 | 2.1 | – | – | – | 585 | 0.30 | 2.1 | 45 | 0.20 | 1.7 | – | – | – |
| | **T8430** | 0.8 | 210 | 0.25 | 2.1 | 115 | 0.23 | 2.1 | – | – | – | 585 | 0.30 | 2.1 | 45 | 0.20 | 1.7 | – | – | – |
| | **T9315** | 0.8 | 290 | 0.25 | 2.1 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 260 | 0.25 | 2.1 | 155 | 0.23 | 2.1 | – | – | – | – | – | – | 55 | 0.20 | 1.7 | – | – | – |
| **CNMG 120412E-NM** | **T7325** | 1.2 | 215 | 0.30 | 2.1 | 165 | 0.27 | 2.1 | – | – | – | – | – | – | 65 | 0.24 | 1.7 | – | – | – |
| | **T7335** | 1.2 | 210 | 0.30 | 2.1 | 160 | 0.27 | 2.1 | – | – | – | – | – | – | 65 | 0.24 | 1.7 | – | – | – |
| | **T8315** | 1.2 | 205 | 0.30 | 2.1 | 120 | 0.27 | 2.1 | – | – | – | 615 | 0.36 | 2.1 | 50 | 0.24 | 1.7 | – | – | – |
| | **T8330** | 1.2 | 195 | 0.30 | 2.1 | 115 | 0.27 | 2.1 | – | – | – | 585 | 0.36 | 2.1 | 45 | 0.24 | 1.7 | – | – | – |
| | **T8430** | 1.2 | 210 | 0.30 | 2.1 | 115 | 0.27 | 2.1 | – | – | – | 585 | 0.36 | 2.1 | 45 | 0.24 | 1.7 | – | – | – |
| | **T9315** | 1.2 | 285 | 0.30 | 2.1 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **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 | – | – | – |
| | **T7335** | 0.8 | 190 | 0.30 | 3.6 | 145 | 0.27 | 3.6 | – | – | – | – | – | – | 60 | 0.27 | 2.9 | – | – | – |
| | **T8315** | 0.8 | 185 | 0.30 | 3.6 | 110 | 0.27 | 3.6 | – | – | – | 555 | 0.36 | 3.6 | 45 | 0.27 | 2.9 | – | – | – |
| | **T8330** | 0.8 | 170 | 0.30 | 3.6 | 100 | 0.27 | 3.6 | – | – | – | 510 | 0.36 | 3.6 | 40 | 0.27 | 2.9 | – | – | – |
| | **T8430** | 0.8 | 185 | 0.30 | 3.6 | 100 | 0.27 | 3.6 | – | – | – | 510 | 0.36 | 3.6 | 40 | 0.27 | 2.9 | – | – | – |
| | **T9325** | 0.8 | 225 | 0.30 | 3.6 | 135 | 0.27 | 3.6 | – | – | – | – | – | – | 50 | 0.27 | 2.9 | – | – | – |

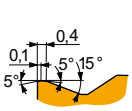
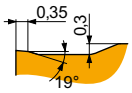
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |   | | | | | | | | | | | | | | | | | | | |
| NM-geometri med meget positivt design til finbearbejdning, mellem og grov bearbejdning i kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **CNMG 160612E-NM** | **T7325** | 1.2 | ◪ 205 | 0.30 | 3.6 | ■ 155 | 0.27 | 3.6 | – | – | – | – | – | – | ■ 65 | 0.27 | 2.9 | – | – | – |
| | **T7335** | 1.2 | ◪ 200 | 0.30 | 3.6 | ■ 155 | 0.27 | 3.6 | – | – | – | – | – | – | ■ 65 | 0.27 | 2.9 | – | – | – |
| | **T8315** | 1.2 | ◪ 195 | 0.30 | 3.6 | ■ 115 | 0.27 | 3.6 | – | – | – | ◪ 585 | 0.36 | 3.6 | ◪ 45 | 0.27 | 2.9 | – | – | – |
| | **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 | – | – | – |
| | **T7335** | 1.2 | ◪ 180 | 0.35 | 4.2 | ■ 140 | 0.32 | 4.2 | – | – | – | – | – | – | ■ 55 | 0.32 | 3.4 | – | – | – |
| | **T8315** | 1.2 | ◪ 180 | 0.35 | 4.2 | ■ 105 | 0.32 | 4.2 | – | – | – | ◪ 540 | 0.42 | 4.2 | ◪ 45 | 0.32 | 3.4 | – | – | – |
| | **T8330** | 1.2 | ■ 170 | 0.35 | 4.2 | ■ 100 | 0.32 | 4.2 | – | – | – | ◪ 510 | 0.42 | 4.2 | ◪ 40 | 0.32 | 3.4 | – | – | – |
| | **T8430** | 1.2 | ■ 180 | 0.35 | 4.2 | ■ 95 | 0.32 | 4.2 | – | – | – | ◪ 495 | 0.42 | 4.2 | ◪ 35 | 0.32 | 3.4 | – | – | – |
| | **T9325** | 1.2 | ■ 220 | 0.35 | 4.2 | ■ 130 | 0.32 | 4.2 | – | – | – | – | – | – | ◪ 45 | 0.32 | 3.4 | – | – | – |
|  |   | | | | | | | | | | | | | | | | | | | |
| NMR-geometri med positivt design til medium til grov bearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **CNMG 090308E-NMR** | **T7325** | 0.8 | ◪ 175 | 0.35 | 1.6 | ■ 135 | 0.32 | 1.6 | – | – | – | – | – | – | ■ 55 | 0.25 | 1.3 | – | – | – |
| | **T7335** | 0.8 | ◪ 170 | 0.35 | 1.6 | ■ 130 | 0.32 | 1.6 | – | – | – | – | – | – | ■ 55 | 0.25 | 1.3 | – | – | – |
| | **T9325** | 0.8 | ■ 200 | 0.35 | 1.6 | ■ 120 | 0.32 | 1.6 | – | – | – | – | – | – | ◪ 45 | 0.25 | 1.3 | – | – | – |
| **CNMG 120404E-NMR** | **T6310** | 0.4 | ■ 140 | 0.25 | 2.7 | ■ 100 | 0.23 | 2.7 | – | – | – | – | – | – | ■ 40 | 0.20 | 2.2 | – | – | – |
| | **T7325** | 0.4 | ◪ 155 | 0.25 | 2.7 | ■ 120 | 0.23 | 2.7 | – | – | – | – | – | – | ■ 50 | 0.20 | 2.2 | – | – | – |
| | **T7335** | 0.4 | ◪ 155 | 0.25 | 2.0 | ■ 120 | 0.23 | 2.0 | – | – | – | – | – | – | ■ 50 | 0.20 | 1.6 | – | – | – |
| | **T8330** | 0.4 | ■ 140 | 0.25 | 2.0 | ■ 80 | 0.23 | 2.0 | – | – | – | – | – | – | ◪ 35 | 0.20 | 1.6 | – | – | – |
| | **T8430** | 0.4 | ■ 150 | 0.25 | 2.7 | ■ 80 | 0.23 | 2.7 | – | – | – | – | – | – | ◪ 30 | 0.20 | 2.2 | – | – | – |
| | **T9315** | 0.4 | ■ 215 | 0.25 | 2.0 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | ■ 190 | 0.25 | 2.0 | ■ 110 | 0.23 | 2.0 | – | – | – | – | – | – | ◪ 40 | 0.20 | 1.6 | – | – | – |
| **CNMG 120408E-NMR** | **T6310** | 0.8 | ■ 150 | 0.35 | 2.7 | ■ 105 | 0.32 | 2.7 | – | – | – | – | – | – | ■ 45 | 0.25 | 2.2 | – | – | – |
| | **T7325** | 0.8 | ◪ 170 | 0.35 | 2.7 | ■ 130 | 0.32 | 2.7 | – | – | – | – | – | – | ■ 55 | 0.25 | 2.2 | – | – | – |
| | **T7335** | 0.8 | ◪ 160 | 0.35 | 2.7 | ■ 120 | 0.32 | 2.7 | – | – | – | – | – | – | ■ 50 | 0.25 | 2.2 | – | – | – |
| | **T8330** | 0.8 | ■ 150 | 0.35 | 2.7 | ■ 90 | 0.32 | 2.7 | – | – | – | – | – | – | ◪ 35 | 0.25 | 2.2 | – | – | – |
| | **T8430** | 0.8 | ■ 155 | 0.35 | 2.7 | ■ 85 | 0.32 | 2.7 | – | – | – | – | – | – | ◪ 30 | 0.25 | 2.2 | – | – | – |
| | **T9315** | 0.8 | ■ 210 | 0.35 | 2.7 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | ■ 190 | 0.35 | 2.7 | ■ 110 | 0.32 | 2.7 | – | – | – | – | – | – | ◪ 40 | 0.25 | 2.2 | – | – | – |
| **CNMG 120412E-NMR** | **T6310** | 1.2 | ■ 150 | 0.40 | 2.7 | ■ 105 | 0.36 | 2.7 | – | – | – | – | – | – | ■ 45 | 0.28 | 2.2 | – | – | – |
| | **T7325** | 1.2 | ◪ 170 | 0.40 | 2.7 | ■ 130 | 0.36 | 2.7 | – | – | – | – | – | – | ■ 55 | 0.28 | 2.2 | – | – | – |
| | **T7335** | 1.2 | ◪ 160 | 0.40 | 2.7 | ■ 120 | 0.36 | 2.7 | – | – | – | – | – | – | ■ 50 | 0.28 | 2.2 | – | – | – |
| | **T8330** | 1.2 | ■ 150 | 0.40 | 2.7 | ■ 90 | 0.36 | 2.7 | – | – | – | – | – | – | ◪ 35 | 0.28 | 2.2 | – | – | – |
| | **T8430** | 1.2 | ■ 155 | 0.40 | 2.7 | ■ 85 | 0.36 | 2.7 | – | – | – | – | – | – | ◪ 30 | 0.28 | 2.2 | – | – | – |
| | **T9315** | 1.2 | ■ 215 | 0.40 | 2.7 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | ■ 190 | 0.40 | 2.7 | ■ 110 | 0.36 | 2.7 | – | – | – | – | – | – | ◪ 40 | 0.28 | 2.2 | – | – | – |
| **CNMG 120416E-NMR** | **T7325** | 1.6 | ◪ 170 | 0.45 | 2.7 | ■ 130 | 0.41 | 2.7 | – | – | – | – | – | – | ■ 55 | 0.32 | 2.2 | – | – | – |
| | **T7335** | 1.6 | ◪ 160 | 0.45 | 2.7 | ■ 120 | 0.41 | 2.7 | – | – | – | – | – | – | ■ 50 | 0.32 | 2.2 | – | – | – |
| | **T9325** | 1.6 | ■ 190 | 0.45 | 2.7 | ■ 110 | 0.41 | 2.7 | – | – | – | – | – | – | ◪ 40 | 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 | – | – | – |
| | **T7335** | 0.8 | ◪ 150 | 0.35 | 4.0 | ■ 115 | 0.32 | 4.0 | – | – | – | – | – | – | ■ 45 | 0.25 | 3.2 | – | – | – |
| | **T9315** | 0.8 | ■ 205 | 0.35 | 4.0 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | ■ 185 | 0.35 | 4.0 | ■ 110 | 0.32 | 4.0 | – | – | – | – | – | – | ◪ 40 | 0.25 | 3.2 | – | – | – |
| **CNMG 160612E-NMR** | **T7325** | 1.2 | ◪ 165 | 0.40 | 4.0 | ■ 125 | 0.36 | 4.0 | – | – | – | – | – | – | ■ 50 | 0.28 | 3.2 | – | – | – |
| | **T7335** | 1.2 | ◪ 155 | 0.40 | 4.0 | ■ 120 | 0.36 | 4.0 | – | – | – | – | – | – | ■ 50 | 0.28 | 3.2 | – | – | – |
| | **T8330** | 1.2 | ■ 145 | 0.40 | 4.0 | ■ 85 | 0.36 | 4.0 | – | – | – | – | – | – | ◪ 35 | 0.28 | 3.2 | – | – | – |
| | **T8430** | 1.2 | ■ 150 | 0.40 | 4.0 | ■ 80 | 0.36 | 4.0 | – | – | – | – | – | – | ◪ 30 | 0.28 | 3.2 | – | – | – |
| | **T9315** | 1.2 | ■ 205 | 0.40 | 4.0 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | ■ 185 | 0.40 | 4.0 | ■ 110 | 0.36 | 4.0 | – | – | – | – | – | – | ◪ 40 | 0.28 | 3.2 | – | – | – |

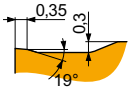
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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-geometri med positivt design til medium til grov bearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **CNMG 160616E-NMR** | **T7325** | 1.6 | 165 | 0.45 | 4.0 | 125 | 0.41 | 4.0 | – | – | – | – | – | – | 50 | 0.32 | 3.2 | – | – | – |
| | **T7335** | 1.6 | 155 | 0.45 | 4.0 | 120 | 0.41 | 4.0 | – | – | – | – | – | – | 50 | 0.32 | 3.2 | – | – | – |
| | **T8330** | 1.6 | 145 | 0.45 | 4.0 | 85 | 0.41 | 4.0 | – | – | – | – | – | – | 35 | 0.32 | 3.2 | – | – | – |
| | **T8430** | 1.6 | 150 | 0.45 | 4.0 | 80 | 0.41 | 4.0 | – | – | – | – | – | – | 30 | 0.32 | 3.2 | – | – | – |
| | **T9315** | 1.6 | 200 | 0.45 | 4.0 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.6 | 180 | 0.45 | 4.0 | 105 | 0.41 | 4.0 | – | – | – | – | – | – | 40 | 0.32 | 3.2 | – | – | – |
| **CNMG 190608E-NMR** | **T6310** | 0.8 | 140 | 0.35 | 5.2 | 100 | 0.32 | 5.2 | – | – | – | – | – | – | 40 | 0.25 | 4.2 | – | – | – |
| | **T7325** | 0.8 | 155 | 0.35 | 5.2 | 120 | 0.32 | 5.2 | – | – | – | – | – | – | 50 | 0.25 | 4.2 | – | – | – |
| | **T7335** | 0.8 | 150 | 0.35 | 5.2 | 115 | 0.32 | 5.2 | – | – | – | – | – | – | 45 | 0.25 | 4.2 | – | – | – |
| | **T9315** | 0.8 | 195 | 0.35 | 5.2 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 180 | 0.35 | 5.2 | 105 | 0.32 | 5.2 | – | – | – | – | – | – | 40 | 0.25 | 4.2 | – | – | – |
| **CNMG 190612E-NMR** | **T6310** | 1.2 | 140 | 0.40 | 5.2 | 100 | 0.36 | 5.2 | – | – | – | – | – | – | 40 | 0.28 | 4.2 | – | – | – |
| | **T7325** | 1.2 | 160 | 0.40 | 5.2 | 120 | 0.36 | 5.2 | – | – | – | – | – | – | 50 | 0.28 | 4.2 | – | – | – |
| | **T7335** | 1.2 | 150 | 0.40 | 5.2 | 115 | 0.36 | 5.2 | – | – | – | – | – | – | 45 | 0.28 | 4.2 | – | – | – |
| | **T8330** | 1.2 | 140 | 0.40 | 5.2 | 80 | 0.36 | 5.2 | – | – | – | – | – | – | 35 | 0.28 | 4.2 | – | – | – |
| | **T8430** | 1.2 | 145 | 0.40 | 5.2 | 80 | 0.36 | 5.2 | – | – | – | – | – | – | 30 | 0.28 | 4.2 | – | – | – |
| | **T9315** | 1.2 | 200 | 0.40 | 5.2 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **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 | – | – | – |
| | **T7335** | 1.6 | 150 | 0.45 | 5.2 | 115 | 0.41 | 5.2 | – | – | – | – | – | – | 45 | 0.32 | 4.2 | – | – | – |
| | **T9315** | 1.6 | 195 | 0.45 | 5.2 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.6 | 175 | 0.45 | 5.2 | 105 | 0.41 | 5.2 | – | – | – | – | – | – | 35 | 0.32 | 4.2 | – | – | – |
|  |   | | | | | | | | | | | | | | | | | | | |
| NRM-geometri med positivt design til halv grov til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **CNMG 120408-NRM** | **T7325** | 0.8 | 160 | 0.35 | 4.0 | 120 | 0.32 | 4.0 | – | – | – | – | – | – | 50 | 0.28 | 3.2 | – | – | – |
| | **T7335** | 0.8 | 150 | 0.35 | 4.0 | 115 | 0.32 | 4.0 | – | – | – | – | – | – | 45 | 0.28 | 3.2 | – | – | – |
| | **T9315** | 0.8 | 205 | 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 | – | – | – |
| | **T7335** | 1.2 | 155 | 0.40 | 4.0 | 120 | 0.36 | 4.0 | – | – | – | – | – | – | 50 | 0.28 | 3.2 | – | – | – |
| | **T9315** | 1.2 | 205 | 0.40 | 4.0 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **CNMG 120416-NRM** | **T7325** | 1.6 | 165 | 0.45 | 4.0 | 125 | 0.41 | 4.0 | – | – | – | – | – | – | 50 | 0.36 | 3.2 | – | – | – |
| | **T7335** | 1.6 | 155 | 0.45 | 4.0 | 120 | 0.41 | 4.0 | – | – | – | – | – | – | 50 | 0.36 | 3.2 | – | – | – |
| | **T9315** | 1.6 | 200 | 0.45 | 4.0 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **CNMG 160608-NRM** | **T7325** | 0.8 | 155 | 0.35 | 6.0 | 120 | 0.32 | 6.0 | – | – | – | – | – | – | 50 | 0.28 | 4.8 | – | – | – |
| | **T7335** | 0.8 | 145 | 0.35 | 6.0 | 110 | 0.32 | 6.0 | – | – | – | – | – | – | 45 | 0.28 | 4.8 | – | – | – |
| | **T9315** | 0.8 | 195 | 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 | – | – | – |
| | **T7335** | 1.2 | 150 | 0.40 | 6.0 | 115 | 0.36 | 6.0 | – | – | – | – | – | – | 45 | 0.32 | 4.8 | – | – | – |
| | **T9315** | 1.2 | 200 | 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 | – | – | – |
| | **T7335** | 1.6 | 150 | 0.45 | 6.0 | 115 | 0.41 | 6.0 | – | – | – | – | – | – | 45 | 0.36 | 4.8 | – | – | – |
| | **T9315** | 1.6 | 195 | 0.45 | 6.0 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **CNMG 190608-NRM** | **T7325** | 0.8 | 150 | 0.35 | 8.0 | 115 | 0.32 | 8.0 | – | – | – | – | – | – | 45 | 0.28 | 6.4 | – | – | – |
| | **T7335** | 0.8 | 140 | 0.35 | 8.0 | 105 | 0.32 | 8.0 | – | – | – | – | – | – | 45 | 0.28 | 6.4 | – | – | – |
| | **T9315** | 0.8 | 190 | 0.35 | 8.0 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **CNMG 190612-NRM** | **T7325** | 1.2 | 155 | 0.40 | 8.0 | 120 | 0.36 | 8.0 | – | – | – | – | – | – | 50 | 0.32 | 6.4 | – | – | – |
| | **T7335** | 1.2 | 145 | 0.40 | 8.0 | 110 | 0.36 | 8.0 | – | – | – | – | – | – | 45 | 0.32 | 6.4 | – | – | – |
| | **T9315** | 1.2 | 190 | 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 | – | – | – |
| | **T7335** | 1.6 | 145 | 0.45 | 8.0 | 110 | 0.41 | 8.0 | – | – | – | – | – | – | 45 | 0.36 | 6.4 | – | – | – |
| | **T9315** | 1.6 | 190 | 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 | – | – | – |
| | **T7335** | 2.4 | 90 | 0.70 | 10.0 | 70 | 0.63 | 10.0 | – | – | – | – | – | – | 25 | 0.49 | 8.0 | – | – | – |
| | **T9315** | 2.4 | 115 | 0.70 | 10.0 | – | – | – | 105 | 0.70 | 10.0 | – | – | – | – | – | – | – | – | – |

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) | | | | | | | | | | | | | | | | | | |
|  |  | |  | | | | | | | | | | | | | | | | | |
| | | | R-geometri til semi-grov til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **CNMG 120408E-R** | **6640** | 0.8 | ■ | 140 | 0.40 | 4.0 | | – | – | – | ■ | 130 | 0.40 | 4.0 | | – | – | – | | – | – | – | | – | – | – |
| | **T5305** | 0.8 | ◪ | 240 | 0.40 | 4.0 | | – | – | – | ■ | 225 | 0.40 | 4.0 | | – | – | – | | – | – | – | ◪ | 45 | 0.15 | 1.0 |
| | **T5315** | 0.8 | ◪ | 215 | 0.40 | 4.0 | | – | – | – | ■ | 200 | 0.40 | 4.0 | | – | – | – | | – | – | – | ◪ | 40 | 0.15 | 1.0 |
| | **T9310** | 0.8 | ■ | 205 | 0.40 | 4.0 | | – | – | – | ◪ | 190 | 0.40 | 4.0 | | – | – | – | | – | – | – | ◪ | 40 | 0.15 | 1.0 |
| | **T9315** | 0.8 | ■ | 190 | 0.40 | 4.0 | | – | – | – | ◪ | 180 | 0.40 | 4.0 | | – | – | – | | – | – | – | ◪ | 35 | 0.15 | 1.0 |
| | **T9325** | 0.8 | ■ | 175 | 0.40 | 4.0 | | – | – | – | ◪ | 165 | 0.40 | 4.0 | | – | – | – | | – | – | – | | – | – | – |
| | **T9335** | 0.8 | ■ | 150 | 0.40 | 4.0 | | – | – | – | | – | – | – | | – | – | – | | – | – | – | | – | – | – |
| **CNMG 120412E-R** | **T5305** | 1.2 | ◪ | 245 | 0.45 | 4.0 | | – | – | – | ■ | 230 | 0.45 | 4.0 | | – | – | – | | – | – | – | ◪ | 45 | 0.15 | 1.0 |
| | **T5315** | 1.2 | ◪ | 220 | 0.45 | 4.0 | | – | – | – | ■ | 205 | 0.45 | 4.0 | | – | – | – | | – | – | – | ◪ | 40 | 0.15 | 1.0 |
| | **T9315** | 1.2 | ■ | 195 | 0.45 | 4.0 | | – | – | – | ◪ | 185 | 0.45 | 4.0 | | – | – | – | | – | – | – | ◪ | 35 | 0.15 | 1.0 |
| | **T9325** | 1.2 | ■ | 175 | 0.45 | 4.0 | | – | – | – | ◪ | 165 | 0.45 | 4.0 | | – | – | – | | – | – | – | | – | – | – |
| | **T9335** | 1.2 | ■ | 155 | 0.45 | 4.0 | | – | – | – | | – | – | – | | – | – | – | | – | – | – | | – | – | – |
| **CNMG 120416E-R** | **T5315** | 1.6 | ◪ | 225 | 0.50 | 4.0 | | – | – | – | ■ | 210 | 0.50 | 4.0 | | – | – | – | | – | – | – | ◪ | 45 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| **CNMG 160612E-R** | **T5305** | 1.2 | ◪ | 235 | 0.45 | 5.5 | | – | – | – | ■ | 220 | 0.45 | 5.5 | | – | – | – | | – | – | – | ◪ | 45 | 0.15 | 1.0 |
| | **T5315** | 1.2 | ◪ | 215 | 0.45 | 5.5 | | – | – | – | ■ | 200 | 0.45 | 5.5 | | – | – | – | | – | – | – | ◪ | 40 | 0.15 | 1.0 |
| | **T7335** | 1.2 | ◪ | 145 | 0.45 | 5.5 | | – | – | – | | – | – | – | | – | – | – | | – | – | – | | – | – | – |
| | **T9310** | 1.2 | ■ | 205 | 0.45 | 5.5 | | – | – | – | ◪ | 190 | 0.45 | 5.5 | | – | – | – | | – | – | – | ◪ | 40 | 0.15 | 1.0 |
| | **T9315** | 1.2 | ■ | 190 | 0.45 | 5.5 | | – | – | – | ◪ | 180 | 0.45 | 5.5 | | – | – | – | | – | – | – | ◪ | 35 | 0.15 | 1.0 |
| | **T9325** | 1.2 | ■ | 170 | 0.45 | 5.5 | | – | – | – | ◪ | 160 | 0.45 | 5.5 | | – | – | – | | – | – | – | | – | – | – |
| **CNMG 160616E-R** | **T5305** | 1.6 | ◪ | 240 | 0.50 | 5.5 | | – | – | – | ■ | 225 | 0.50 | 5.5 | | – | – | – | | – | – | – | ◪ | 45 | 0.15 | 1.0 |
| **CNMG 190608E-R** | **T5315** | 0.8 | ◪ | 205 | 0.40 | 7.0 | | – | – | – | ■ | 190 | 0.40 | 7.0 | | – | – | – | | – | – | – | ◪ | 40 | 0.15 | 1.0 |
| **CNMG 190612E-R** | **6640** | 1.2 | ■ | 135 | 0.45 | 7.0 | | – | – | – | ■ | 125 | 0.45 | 7.0 | | – | – | – | | – | – | – | | – | – | – |
| | **T5305** | 1.2 | ◪ | 230 | 0.45 | 7.0 | | – | – | – | ■ | 215 | 0.45 | 7.0 | | – | – | – | | – | – | – | ◪ | 45 | 0.15 | 1.0 |
| | **T5315** | 1.2 | ◪ | 210 | 0.45 | 7.0 | | – | – | – | ■ | 195 | 0.45 | 7.0 | | – | – | – | | – | – | – | ◪ | 40 | 0.15 | 1.0 |
| | **T9315** | 1.2 | ■ | 185 | 0.45 | 7.0 | | – | – | – | ◪ | 175 | 0.45 | 7.0 | | – | – | – | | – | – | – | ◪ | 35 | 0.15 | 1.0 |
| | **T9325** | 1.2 | ■ | 165 | 0.45 | 7.0 | | – | – | – | ◪ | 155 | 0.45 | 7.0 | | – | – | – | | – | – | – | | – | – | – |
| | **T9335** | 1.2 | ■ | 145 | 0.45 | 7.0 | | – | – | – | | – | – | – | | – | – | – | | – | – | – | | – | – | – |
| **CNMG 190616E-R** | **6640** | 1.6 | ■ | 130 | 0.50 | 7.0 | | – | – | – | ■ | 120 | 0.50 | 7.0 | | – | – | – | | – | – | – | | – | – | – |
| | **T5305** | 1.6 | ◪ | 235 | 0.50 | 7.0 | | – | – | – | ■ | 220 | 0.50 | 7.0 | | – | – | – | | – | – | – | ◪ | 45 | 0.15 | 1.0 |
| | **T5315** | 1.6 | ◪ | 210 | 0.50 | 7.0 | | – | – | – | ■ | 195 | 0.50 | 7.0 | | – | – | – | | – | – | – | ◪ | 40 | 0.15 | 1.0 |
| | **T9310** | 1.6 | ■ | 195 | 0.50 | 7.0 | | – | – | – | ◪ | 185 | 0.50 | 7.0 | | – | – | – | | – | – | – | ◪ | 35 | 0.15 | 1.0 |
| | **T9315** | 1.6 | ■ | 180 | 0.50 | 7.0 | | – | – | – | ◪ | 170 | 0.50 | 7.0 | | – | – | – | | – | – | – | ◪ | 35 | 0.15 | 1.0 |
| | **T9325** | 1.6 | ■ | 165 | 0.50 | 7.0 | | – | – | – | ◪ | 155 | 0.50 | 7.0 | | – | – | – | | – | – | – | | – | – | – |
| | **T9335** | 1.6 | ■ | 145 | 0.50 | 7.0 | | – | – | – | | – | – | – | | – | – | – | | – | – | – | | – | – | – |
|  |  | |  | | | | | | | | | | | | | | | | | |
| | | | RM-geometri til semi-grov til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **CNMG 120408E-RM** | **T5305** | 0.8 | ◪ | 275 | 0.40 | 4.0 | | – | – | – | ◪ | 260 | 0.40 | 4.0 | | – | – | – | | – | – | – | | – | – | – |
| | **T5315** | 0.8 | ◪ | 250 | 0.40 | 4.0 | | – | – | – | ◪ | 235 | 0.40 | 4.0 | | – | – | – | | – | – | – | | – | – | – |
| | **T6310** | 0.8 | ■ | 155 | 0.40 | 4.0 | ◪ | 110 | 0.36 | 4.0 | ◪ | 125 | 0.40 | 4.0 | | – | – | – | | – | – | – | | – | – | – |
| | **T7325** | 0.8 | ◪ | 180 | 0.40 | 4.0 | ◪ | 140 | 0.36 | 4.0 | | – | – | – | | – | – | – | | – | – | – | | – | – | – |
| | **T7335** | 0.8 | ◪ | 165 | 0.40 | 4.0 | ◪ | 125 | 0.36 | 4.0 | | – | – | – | | – | – | – | | – | – | – | | – | – | – |
| | **T8315** | 0.8 | ◪ | 165 | 0.40 | 4.0 | ◪ | 95 | 0.36 | 4.0 | ◪ | 155 | 0.40 | 4.0 | | – | – | – | | – | – | – | | – | – | – |
| | **T8330** | 0.8 | ■ | 155 | 0.40 | 4.0 | ◪ | 90 | 0.36 | 4.0 | ◪ | 145 | 0.40 | 4.0 | | – | – | – | | – | – | – | | – | – | – |
| | **T8430** | 0.8 | ■ | 165 | 0.40 | 4.0 | ◪ | 90 | 0.36 | 4.0 | ◪ | 135 | 0.40 | 4.0 | | – | – | – | | – | – | – | | – | – | – |
| | **T9310** | 0.8 | ■ | 240 | 0.40 | 4.0 | | – | – | – | ◪ | 225 | 0.40 | 4.0 | | – | – | – | | – | – | – | | – | – | – |
| | **T9315** | 0.8 | ■ | 220 | 0.40 | 4.0 | | – | – | – | ◪ | 205 | 0.40 | 4.0 | | – | – | – | | – | – | – | | – | – | – |
| | **T9325** | 0.8 | ■ | 200 | 0.40 | 4.0 | ◪ | 120 | 0.36 | 4.0 | ◪ | 190 | 0.40 | 4.0 | | – | – | – | | – | – | – | | – | – | – |
| | **T9335** | 0.8 | ■ | 170 | 0.40 | 4.0 | ◪ | 100 | 0.36 | 4.0 | | – | – | – | | – | – | – | | – | – | – | | – | – | – |

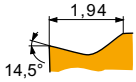
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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-geometri til semi-grov til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **CNMG 120412E-RM** | **T5305** | 1.2 | ◪ 280 | 0.45 | 4.0 | – | – | – | ◪ 265 | 0.45 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T5315** | 1.2 | ◪ 250 | 0.45 | 4.0 | – | – | – | ◪ 235 | 0.45 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T6310** | 1.2 | ■ 160 | 0.45 | 4.0 | ◪ 115 | 0.41 | 4.0 | ◪ 125 | 0.45 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 1.2 | ◪ 180 | 0.45 | 4.0 | ◪ 140 | 0.41 | 4.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 1.2 | ◪ 170 | 0.45 | 4.0 | ◪ 130 | 0.41 | 4.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 1.2 | ◪ 170 | 0.45 | 4.0 | ◪ 100 | 0.41 | 4.0 | ◪ 160 | 0.45 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T8330** | 1.2 | ■ 160 | 0.45 | 4.0 | ◪ 95 | 0.41 | 4.0 | ◪ 150 | 0.45 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 1.2 | ■ 170 | 0.45 | 4.0 | ◪ 90 | 0.41 | 4.0 | ◪ 135 | 0.45 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T9310** | 1.2 | ■ 240 | 0.45 | 4.0 | – | – | – | ◪ 225 | 0.45 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 1.2 | ■ 220 | 0.45 | 4.0 | – | – | – | ◪ 205 | 0.45 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | ■ 200 | 0.45 | 4.0 | ◪ 120 | 0.41 | 4.0 | ◪ 190 | 0.45 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.2 | ■ 175 | 0.45 | 4.0 | ◪ 105 | 0.41 | 4.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| **CNMG 120416E-RM** | **T5305** | 1.6 | ◪ 280 | 0.50 | 4.0 | – | – | – | ◪ 265 | 0.50 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T5315** | 1.6 | ◪ 255 | 0.50 | 4.0 | – | – | – | ◪ 240 | 0.50 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 1.6 | ◪ 185 | 0.50 | 4.0 | ◪ 140 | 0.45 | 4.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 1.6 | ◪ 175 | 0.50 | 4.0 | ◪ 135 | 0.45 | 4.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 1.6 | ■ 160 | 0.50 | 4.0 | ◪ 95 | 0.45 | 4.0 | ◪ 150 | 0.50 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 1.6 | ■ 170 | 0.50 | 4.0 | ◪ 90 | 0.45 | 4.0 | ◪ 135 | 0.50 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T9310** | 1.6 | ■ 240 | 0.50 | 4.0 | – | – | – | ◪ 225 | 0.50 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 1.6 | ■ 220 | 0.50 | 4.0 | – | – | – | ◪ 205 | 0.50 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.6 | ■ 205 | 0.50 | 4.0 | ◪ 120 | 0.45 | 4.0 | ◪ 190 | 0.50 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.6 | ■ 175 | 0.50 | 4.0 | ◪ 105 | 0.45 | 4.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| **CNMG 160608E-RM** | **T5305** | 0.8 | ◪ 265 | 0.40 | 6.0 | – | – | – | ◪ 250 | 0.40 | 6.0 | – | – | – | – | – | – | – | – | – |
| | **T5315** | 0.8 | ◪ 240 | 0.40 | 6.0 | – | – | – | ◪ 225 | 0.40 | 6.0 | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.8 | ■ 150 | 0.40 | 6.0 | ◪ 90 | 0.36 | 6.0 | ◪ 140 | 0.40 | 6.0 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.8 | ■ 155 | 0.40 | 6.0 | ◪ 85 | 0.36 | 6.0 | ◪ 130 | 0.40 | 6.0 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.8 | ■ 215 | 0.40 | 6.0 | – | – | – | ◪ 200 | 0.40 | 6.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | ■ 190 | 0.40 | 6.0 | ◪ 110 | 0.36 | 6.0 | ◪ 180 | 0.40 | 6.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.8 | ■ 165 | 0.40 | 6.0 | ◪ 95 | 0.36 | 6.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| **CNMG 160612E-RM** | **T5305** | 1.2 | ◪ 270 | 0.45 | 6.0 | – | – | – | ◪ 255 | 0.45 | 6.0 | – | – | – | – | – | – | – | – | – |
| | **T5315** | 1.2 | ◪ 245 | 0.45 | 6.0 | – | – | – | ◪ 230 | 0.45 | 6.0 | – | – | – | – | – | – | – | – | – |
| | **T6310** | 1.2 | ■ 155 | 0.45 | 6.0 | ◪ 110 | 0.41 | 6.0 | ◪ 125 | 0.45 | 6.0 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 1.2 | ◪ 170 | 0.45 | 6.0 | ◪ 130 | 0.41 | 6.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 1.2 | ◪ 165 | 0.45 | 6.0 | ◪ 125 | 0.41 | 6.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 1.2 | ■ 155 | 0.45 | 6.0 | ◪ 90 | 0.41 | 6.0 | ◪ 145 | 0.45 | 6.0 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 1.2 | ■ 155 | 0.45 | 6.0 | ◪ 85 | 0.41 | 6.0 | ◪ 130 | 0.45 | 6.0 | – | – | – | – | – | – | – | – | – |
| | **T9310** | 1.2 | ■ 230 | 0.45 | 6.0 | – | – | – | ◪ 215 | 0.45 | 6.0 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 1.2 | ■ 215 | 0.45 | 6.0 | – | – | – | ◪ 200 | 0.45 | 6.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | ■ 195 | 0.45 | 6.0 | ◪ 115 | 0.41 | 6.0 | ◪ 185 | 0.45 | 6.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.2 | ■ 165 | 0.45 | 6.0 | ◪ 95 | 0.41 | 6.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| **CNMG 160616E-RM** | **T5305** | 1.6 | ◪ 270 | 0.50 | 6.0 | – | – | – | ◪ 255 | 0.50 | 6.0 | – | – | – | – | – | – | – | – | – |
| | **T5315** | 1.6 | ◪ 245 | 0.50 | 6.0 | – | – | – | ◪ 230 | 0.50 | 6.0 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 1.6 | ◪ 175 | 0.50 | 6.0 | ◪ 135 | 0.45 | 6.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 1.6 | ◪ 165 | 0.50 | 6.0 | ◪ 125 | 0.45 | 6.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9310** | 1.6 | ■ 225 | 0.50 | 6.0 | – | – | – | ◪ 210 | 0.50 | 6.0 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 1.6 | ■ 215 | 0.50 | 6.0 | – | – | – | ◪ 200 | 0.50 | 6.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.6 | ■ 190 | 0.50 | 6.0 | ◪ 110 | 0.45 | 6.0 | ◪ 180 | 0.50 | 6.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.6 | ■ 165 | 0.50 | 6.0 | ◪ 95 | 0.45 | 6.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| **CNMG 190608E-RM** | **T5305** | 0.8 | ◪ 260 | 0.40 | 7.5 | – | – | – | ◪ 245 | 0.40 | 7.5 | – | – | – | – | – | – | – | – | – |
| | **T5315** | 0.8 | ◪ 230 | 0.40 | 7.5 | – | – | – | ◪ 215 | 0.40 | 7.5 | – | – | – | – | – | – | – | – | – |
| | **T7335** | 0.8 | ◪ 155 | 0.40 | 7.5 | ◪ 120 | 0.36 | 7.5 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.8 | ■ 210 | 0.40 | 7.5 | – | – | – | ◪ 195 | 0.40 | 7.5 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | ■ 190 | 0.40 | 7.5 | ◪ 110 | 0.36 | 7.5 | ◪ 180 | 0.40 | 7.5 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.8 | ■ 160 | 0.40 | 7.5 | ◪ 95 | 0.36 | 7.5 | – | – | – | – | – | – | – | – | – | – | – | – |

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
| **CNMG 190612E-RM** | **T5305** | 1.2 | 260 | 0.45 | 7.5 | – | – | – | 245 | 0.45 | 7.5 | – | – | – | – | – | – | – | – | – |
| | **T5315** | 1.2 | 240 | 0.45 | 7.5 | – | – | – | 225 | 0.45 | 7.5 | – | – | – | – | – | – | – | – | – |
| | **T6310** | 1.2 | 155 | 0.45 | 7.5 | 110 | 0.41 | 7.5 | 125 | 0.45 | 7.5 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 1.2 | 170 | 0.45 | 7.5 | 130 | 0.41 | 7.5 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 1.2 | 160 | 0.45 | 7.5 | 120 | 0.41 | 7.5 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 1.2 | 155 | 0.45 | 7.5 | 90 | 0.41 | 7.5 | 145 | 0.45 | 7.5 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 1.2 | 150 | 0.45 | 7.5 | 80 | 0.41 | 7.5 | 125 | 0.45 | 7.5 | – | – | – | – | – | – | – | – | – |
| | **T9310** | 1.2 | 220 | 0.45 | 7.5 | – | – | – | 205 | 0.45 | 7.5 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 1.2 | 210 | 0.45 | 7.5 | – | – | – | 195 | 0.45 | 7.5 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | 185 | 0.45 | 7.5 | 110 | 0.41 | 7.5 | 175 | 0.45 | 7.5 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.2 | 165 | 0.45 | 7.5 | 95 | 0.41 | 7.5 | – | – | – | – | – | – | – | – | – | – | – | – |
| **CNMG 190616E-RM** | **T5305** | 1.6 | 265 | 0.50 | 7.5 | – | – | – | 250 | 0.50 | 7.5 | – | – | – | – | – | – | – | – | – |
| | **T5315** | 1.6 | 240 | 0.50 | 7.5 | – | – | – | 225 | 0.50 | 7.5 | – | – | – | – | – | – | – | – | – |
| | **T6310** | 1.6 | 155 | 0.50 | 7.5 | 110 | 0.45 | 7.5 | 125 | 0.50 | 7.5 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 1.6 | 175 | 0.50 | 7.5 | 135 | 0.45 | 7.5 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 1.6 | 160 | 0.50 | 7.5 | 120 | 0.45 | 7.5 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9310** | 1.6 | 225 | 0.50 | 7.5 | – | – | – | 210 | 0.50 | 7.5 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 1.6 | 210 | 0.50 | 7.5 | – | – | – | 195 | 0.50 | 7.5 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.6 | 190 | 0.50 | 7.5 | 110 | 0.45 | 7.5 | 180 | 0.50 | 7.5 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.6 | 160 | 0.50 | 7.5 | 95 | 0.45 | 7.5 | – | – | – | – | – | – | – | – | – | – | – | – |
| **CNMG 250924E-RM** | **T7325** | 2.4 | 105 | 0.80 | 12.0 | 80 | 0.72 | 12.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 2.4 | 100 | 0.80 | 12.0 | 75 | 0.72 | 12.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9226** | 2.4 | 90 | 0.80 | 12.0 | 50 | 0.72 | 12.0 | 85 | 0.80 | 12.0 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 2.4 | 120 | 0.80 | 12.0 | – | – | – | 110 | 0.80 | 12.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 2.4 | 105 | 0.80 | 12.0 | 60 | 0.72 | 12.0 | 95 | 0.80 | 12.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 2.4 | 85 | 0.80 | 12.0 | 50 | 0.72 | 12.0 | – | – | – | – | – | – | – | – | – | – | – | – |

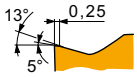
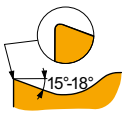




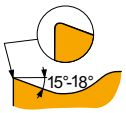
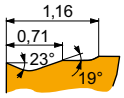
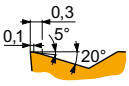
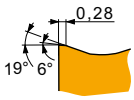
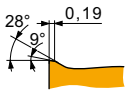

SF-geometri med positivt design til finbearbejdning af tynde vægge og kontinuerlige snit.

| | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **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 | – | – | – |
| | **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 | 0.15 | 1.0 |
| | **T7325** | 0.4 | 205 | 0.17 | 1.0 | 155 | 0.15 | 1.0 | – | – | – | – | – | – | 65 | 0.15 | 0.8 | – | – | – |
| | **T7335** | 0.4 | 200 | 0.17 | 1.0 | 155 | 0.15 | 1.0 | – | – | – | – | – | – | 65 | 0.15 | 0.8 | – | – | – |
| | **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 | 0.15 | 1.0 |
| | **T8330** | 0.4 | 180 | 0.15 | 1.0 | 105 | 0.14 | 1.0 | 170 | 0.15 | 1.0 | 540 | 0.18 | 1.0 | 45 | 0.12 | 0.8 | 35 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| | **T9315** | 0.4 | 300 | 0.15 | 1.0 | – | – | – | 285 | 0.15 | 1.0 | – | – | – | – | – | – | 60 | 0.15 | 1.0 |
| | **T9325** | 0.4 | 255 | 0.17 | 1.0 | 150 | 0.15 | 1.0 | 240 | 0.17 | 1.0 | – | – | – | 55 | 0.15 | 0.8 | – | – | – |
| **CNMG 120408E-SF** | **H07** | 0.8 | – | – | – | 95 | 0.18 | 1.0 | 155 | 0.20 | 1.0 | 495 | 0.24 | 1.0 | 50 | 0.14 | 0.8 | – | – | – |
| | **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 | 0.15 | 1.0 |
| | **T7325** | 0.8 | 230 | 0.20 | 1.0 | 175 | 0.18 | 1.0 | – | – | – | – | – | – | 70 | 0.16 | 0.8 | – | – | – |
| | **T7335** | 0.8 | 220 | 0.20 | 1.0 | 170 | 0.18 | 1.0 | – | – | – | – | – | – | 70 | 0.16 | 0.8 | – | – | – |
| | **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 | 0.15 | 1.0 |
| | **T8330** | 0.8 | 200 | 0.20 | 1.0 | 120 | 0.18 | 1.0 | 190 | 0.20 | 1.0 | 600 | 0.24 | 1.0 | 50 | 0.14 | 0.8 | 40 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| | **T9315** | 0.8 | 315 | 0.20 | 1.0 | – | – | – | 295 | 0.20 | 1.0 | – | – | – | – | – | – | 60 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| | **T7325** | 1.2 | 220 | 0.25 | 1.5 | 170 | 0.23 | 1.5 | – | – | – | – | – | – | 70 | 0.18 | 1.2 | – | – | – |
| | **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 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |

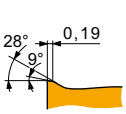
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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-geometri med positivt design til medium bearbejdning og kontinuerlige til afbrudte snit. | | | | | | | | | | | | | | | | | | | | |
| **CNMG 120404E-SM** | **T6310** | 0.4 | ■ 155 | 0.22 | 2.0 | ■ 110 | 0.20 | 2.0 | ■ 125 | 0.22 | 2.0 | ◪ 465 | 0.26 | 2.0 | ■ 45 | 0.20 | 1.6 | ◪ 30 | 0.15 | 1.0 |
| | **T7325** | 0.4 | ◪ 175 | 0.22 | 2.0 | ■ 135 | 0.20 | 2.0 | – | – | – | – | – | – | ■ 55 | 0.20 | 1.6 | – | – | – |
| | **T7335** | 0.4 | ◪ 170 | 0.22 | 2.0 | ■ 130 | 0.20 | 2.0 | – | – | – | – | – | – | ■ 55 | 0.20 | 1.6 | – | – | – |
| | **T8330** | 0.4 | ■ 155 | 0.22 | 2.0 | ■ 90 | 0.20 | 2.0 | ■ 145 | 0.22 | 2.0 | ◪ 465 | 0.26 | 2.0 | ◪ 35 | 0.20 | 1.6 | ◪ 30 | 0.15 | 1.0 |
| | **T8430** | 0.4 | ■ 170 | 0.22 | 2.0 | ■ 90 | 0.20 | 2.0 | ◪ 135 | 0.22 | 2.0 | ◪ 465 | 0.26 | 2.0 | ◪ 35 | 0.20 | 1.6 | ◪ 25 | 0.15 | 1.0 |
| | **T9315** | 0.4 | ■ 245 | 0.20 | 2.0 | – | – | – | ◪ 230 | 0.20 | 2.0 | – | – | – | – | – | – | ◪ 45 | 0.15 | 1.0 |
| | **T9325** | 0.4 | ■ 210 | 0.22 | 2.0 | ■ 125 | 0.20 | 2.0 | ◪ 195 | 0.22 | 2.0 | – | – | – | ◪ 45 | 0.20 | 1.6 | – | – | – |
| **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 | 0.15 | 1.0 |
| | **T7325** | 0.8 | ◪ 200 | 0.25 | 2.0 | ■ 155 | 0.23 | 2.0 | – | – | – | – | – | – | ■ 65 | 0.20 | 1.6 | – | – | – |
| | **T7335** | 0.8 | ◪ 190 | 0.25 | 2.0 | ■ 145 | 0.23 | 2.0 | – | – | – | – | – | – | ■ 60 | 0.20 | 1.6 | – | – | – |
| | **T8330** | 0.8 | ■ 175 | 0.25 | 2.0 | ■ 105 | 0.23 | 2.0 | ■ 165 | 0.25 | 2.0 | ◪ 525 | 0.30 | 2.0 | ◪ 40 | 0.20 | 1.6 | ◪ 35 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| | **T9315** | 0.8 | ■ 265 | 0.25 | 2.0 | – | – | – | ◪ 250 | 0.25 | 2.0 | – | – | – | – | – | – | ◪ 50 | 0.15 | 1.0 |
| | **T9325** | 0.8 | ■ 235 | 0.25 | 2.0 | ■ 140 | 0.23 | 2.0 | ◪ 220 | 0.25 | 2.0 | – | – | – | ◪ 50 | 0.20 | 1.6 | – | – | – |
| **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 |
| | **T7325** | 1.2 | ◪ 195 | 0.30 | 2.0 | ■ 150 | 0.27 | 2.0 | – | – | – | – | – | – | ■ 60 | 0.24 | 1.6 | – | – | – |
| | **T7335** | 1.2 | ◪ 190 | 0.30 | 2.0 | ■ 145 | 0.27 | 2.0 | – | – | – | – | – | – | ■ 60 | 0.24 | 1.6 | – | – | – |
| | **T8330** | 1.2 | ■ 175 | 0.30 | 2.0 | ■ 105 | 0.27 | 2.0 | ■ 165 | 0.30 | 2.0 | ◪ 525 | 0.36 | 2.0 | ◪ 40 | 0.24 | 1.6 | ◪ 35 | 0.15 | 1.0 |
| | **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 |
| | **T9315** | 1.2 | ■ 260 | 0.30 | 2.0 | – | – | – | ◪ 245 | 0.30 | 2.0 | – | – | – | – | – | – | ◪ 50 | 0.15 | 1.0 |
| | **T9325** | 1.2 | ■ 235 | 0.30 | 2.0 | ■ 140 | 0.27 | 2.0 | ◪ 220 | 0.30 | 2.0 | – | – | – | ◪ 50 | 0.24 | 1.6 | – | – | – |
| **CNMG 160608E-SM** | **T7325** | 0.8 | ◪ 185 | 0.26 | 3.0 | ■ 140 | 0.23 | 3.0 | – | – | – | – | – | – | ■ 60 | 0.23 | 2.4 | – | – | – |
| | **T7335** | 0.8 | ◪ 180 | 0.26 | 3.0 | ■ 140 | 0.23 | 3.0 | – | – | – | – | – | – | ■ 55 | 0.23 | 2.4 | – | – | – |
| | **T8330** | 0.8 | ■ 165 | 0.26 | 3.0 | ■ 95 | 0.23 | 3.0 | ■ 155 | 0.26 | 3.0 | ◪ 495 | 0.31 | 3.0 | ◪ 40 | 0.23 | 2.4 | ◪ 30 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| | **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 |
| | **T7325** | 1.2 | ◪ 190 | 0.30 | 3.0 | ■ 145 | 0.27 | 3.0 | – | – | – | – | – | – | ■ 60 | 0.27 | 2.4 | – | – | – |
| | **T7335** | 1.2 | ◪ 180 | 0.30 | 3.0 | ■ 140 | 0.27 | 3.0 | – | – | – | – | – | – | ■ 55 | 0.27 | 2.4 | – | – | – |
| | **T9315** | 1.2 | ■ 250 | 0.30 | 3.0 | – | – | – | ◪ 235 | 0.30 | 3.0 | – | – | – | – | – | – | ◪ 50 | 0.15 | 1.0 |
| | **T9325** | 1.2 | ■ 225 | 0.30 | 3.0 | ■ 135 | 0.27 | 3.0 | ◪ 210 | 0.30 | 3.0 | – | – | – | ◪ 50 | 0.27 | 2.4 | – | – | – |
| **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 |
| | **T7325** | 1.2 | ◪ 185 | 0.30 | 4.0 | ■ 140 | 0.27 | 4.0 | – | – | – | – | – | – | ■ 60 | 0.27 | 3.2 | – | – | – |
| | **T7335** | 1.2 | ◪ 175 | 0.30 | 4.0 | ■ 135 | 0.27 | 4.0 | – | – | – | – | – | – | ■ 55 | 0.27 | 3.2 | – | – | – |
| | **T9315** | 1.2 | ■ 245 | 0.30 | 4.0 | – | – | – | ◪ 230 | 0.30 | 4.0 | – | – | – | – | – | – | ◪ 45 | 0.15 | 1.0 |
| | **T9325** | 1.2 | ■ 220 | 0.30 | 4.0 | ■ 130 | 0.27 | 4.0 | ◪ 205 | 0.30 | 4.0 | – | – | – | ◪ 45 | 0.27 | 3.2 | – | – | – |
|  |  | |  | | | | | | | | | | | | | | | | | |
| ER-SI geometri med positivt venstrehåndet design til finbearbejdning til halv grov bearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **CNMG 120404ER-SI** | **T7325** | 0.4 | ◪ 220 | 0.20 | 1.7 | ■ 170 | 0.18 | 1.7 | – | – | – | – | – | – | ◪ 70 | 0.18 | 1.4 | – | – | – |
| | **T7335** | 0.4 | ◪ 215 | 0.20 | 1.7 | ■ 165 | 0.18 | 1.7 | – | – | – | – | – | – | ◪ 65 | 0.18 | 1.4 | – | – | – |
| | **T8330** | 0.4 | ■ 195 | 0.20 | 1.7 | ■ 115 | 0.18 | 1.7 | – | – | – | ◪ 585 | 0.24 | 1.7 | ◪ 45 | 0.18 | 1.4 | – | – | – |
| | **T8430** | 0.4 | ■ 225 | 0.20 | 1.7 | ■ 120 | 0.18 | 1.7 | – | – | – | ◪ 615 | 0.24 | 1.7 | ◪ 45 | 0.18 | 1.4 | – | – | – |
| | **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 | – | – | – |
| | **T7335** | 0.8 | ◪ 205 | 0.35 | 1.7 | ■ 155 | 0.32 | 1.7 | – | – | – | – | – | – | ◪ 65 | 0.25 | 1.4 | – | – | – |
| | **T8315** | 0.8 | ◪ 205 | 0.35 | 1.7 | ■ 120 | 0.32 | 1.7 | – | – | – | ◪ 615 | 0.42 | 1.7 | ◪ 50 | 0.25 | 1.4 | – | – | – |
| | **T8330** | 0.8 | ■ 195 | 0.35 | 1.7 | ■ 115 | 0.32 | 1.7 | – | – | – | ◪ 585 | 0.42 | 1.7 | ◪ 45 | 0.25 | 1.4 | – | – | – |
| | **T8430** | 0.8 | ■ 210 | 0.35 | 1.7 | ■ 115 | 0.32 | 1.7 | – | – | – | ◪ 585 | 0.42 | 1.7 | ◪ 45 | 0.25 | 1.4 | – | – | – |
| | **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 | – | – | – |

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |   | | E | | | | | | | | | | | | | | | | | |
| | | | EL-SI geometri med positivt venstrehåndet design til finbearbejdning til halv grov bearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | |
| **CNMG 120404EL-SI** | **T7325** | 0.4 | 220 | 0.20 | 1.7 | 170 | 0.18 | 1.7 | – | – | – | – | – | – | 70 | 0.18 | 1.4 | – | – | – |
| | **T7335** | 0.4 | 215 | 0.20 | 1.7 | 165 | 0.18 | 1.7 | – | – | – | – | – | – | 65 | 0.18 | 1.4 | – | – | – |
| | **T8330** | 0.4 | 195 | 0.20 | 1.7 | 115 | 0.18 | 1.7 | – | – | – | 585 | 0.24 | 1.7 | 45 | 0.18 | 1.4 | – | – | – |
| | **T8430** | 0.4 | 225 | 0.20 | 1.7 | 120 | 0.18 | 1.7 | – | – | – | 615 | 0.24 | 1.7 | 45 | 0.18 | 1.4 | – | – | – |
| | **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 | – | – | – |
| | **T7335** | 0.8 | 205 | 0.35 | 1.7 | 155 | 0.32 | 1.7 | – | – | – | – | – | – | 65 | 0.25 | 1.4 | – | – | – |
| | **T8315** | 0.8 | 205 | 0.35 | 1.7 | 120 | 0.32 | 1.7 | – | – | – | 615 | 0.42 | 1.7 | 50 | 0.25 | 1.4 | – | – | – |
| | **T8330** | 0.8 | 195 | 0.35 | 1.7 | 115 | 0.32 | 1.7 | – | – | – | 585 | 0.42 | 1.7 | 45 | 0.25 | 1.4 | – | – | – |
| | **T8430** | 0.8 | 210 | 0.35 | 1.7 | 115 | 0.32 | 1.7 | – | – | – | 585 | 0.42 | 1.7 | 45 | 0.25 | 1.4 | – | – | – |
| | **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 | – | – | – |
|  |   | | W E | | | | | | | | | | | | | | | | | |
| | | | W-F wiper geometri til finbearbejdning med øget tilspænding og forbedret overfladefinish. | | | | | | | | | | | | | | | | | |
| **CNMG 120408W-F** | **T9315** | 0.8 | 215 | 0.45 | 0.8 | – | – | – | 200 | 0.45 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 190 | 0.45 | 0.8 | – | – | – | 180 | 0.45 | 0.8 | – | – | – | – | – | – | – | – | – |
|  |   | | W S | | | | | | | | | | | | | | | | | |
| | | | W-M wiper geometri til halv grov til hård bearbejdning med øget tilspænding og forbedret overfladefinish. | | | | | | | | | | | | | | | | | |
| **CNMG 120408W-M** | **T5315** | 0.8 | 230 | 0.45 | 1.5 | – | – | – | 215 | 0.45 | 1.5 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.8 | 200 | 0.45 | 1.5 | – | – | – | 190 | 0.45 | 1.5 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 185 | 0.45 | 1.5 | – | – | – | 175 | 0.45 | 1.5 | – | – | – | – | – | – | – | – | – |
| **CNMG 120412W-M** | **T5315** | 1.2 | 230 | 0.55 | 1.5 | – | – | – | 215 | 0.55 | 1.5 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 1.2 | 200 | 0.55 | 1.5 | – | – | – | 190 | 0.55 | 1.5 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | 180 | 0.55 | 1.5 | – | – | – | 170 | 0.55 | 1.5 | – | – | – | – | – | – | – | – | – |
|  |   | | W S | | | | | | | | | | | | | | | | | |
| | | | W-MR wiper geometri til halv grov til hård bearbejdning med øget tilspænding og forbedret overfladefinish. | | | | | | | | | | | | | | | | | |
| **CNMG 120404W-MR** | **T9315** | 0.4 | 200 | 0.30 | 1.5 | – | – | – | 190 | 0.30 | 1.5 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 180 | 0.30 | 1.5 | 105 | 0.27 | 1.5 | 170 | 0.30 | 1.5 | – | – | – | – | – | – | – | – | – |
| **CNMG 120408W-MR** | **T5315** | 0.8 | 230 | 0.45 | 1.5 | – | – | – | 215 | 0.45 | 1.5 | – | – | – | – | – | – | – | – | – |
| | **T9310** | 0.8 | 215 | 0.45 | 1.5 | – | – | – | 200 | 0.45 | 1.5 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.8 | 200 | 0.45 | 1.5 | – | – | – | 190 | 0.45 | 1.5 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 185 | 0.45 | 1.5 | 110 | 0.41 | 1.5 | 175 | 0.45 | 1.5 | – | – | – | – | – | – | – | – | – |
| **CNMG 120412W-MR** | **T5315** | 1.2 | 230 | 0.55 | 1.5 | – | – | – | 215 | 0.55 | 1.5 | – | – | – | – | – | – | – | – | – |
| | **T9310** | 1.2 | 210 | 0.55 | 1.5 | – | – | – | 195 | 0.55 | 1.5 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 1.2 | 200 | 0.55 | 1.5 | – | – | – | 190 | 0.55 | 1.5 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | 180 | 0.55 | 1.5 | 105 | 0.50 | 1.5 | 170 | 0.55 | 1.5 | – | – | – | – | – | – | – | – | – |
|  |   | | W 1 U S | | | | | | | | | | | | | | | | | |
| | | | W-NM wiper geometri til halv grov til hård bearbejdning med øget tilspænding og forbedret overfladefinish. | | | | | | | | | | | | | | | | | |
| **CNMG 120404W-NM** | **T7325** | 0.4 | 195 | 0.20 | 2.1 | 150 | 0.18 | 2.1 | – | – | – | – | – | – | 60 | 0.16 | 1.7 | – | – | – |
| | **T7335** | 0.4 | 190 | 0.20 | 2.1 | 145 | 0.18 | 2.1 | – | – | – | – | – | – | 60 | 0.16 | 1.7 | – | – | – |
| | **T9315** | 0.4 | 270 | 0.20 | 2.1 | – | – | – | 255 | 0.20 | 2.1 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 240 | 0.20 | 2.1 | 140 | 0.18 | 2.1 | 225 | 0.20 | 2.1 | – | – | – | 50 | 0.16 | 1.7 | – | – | – |

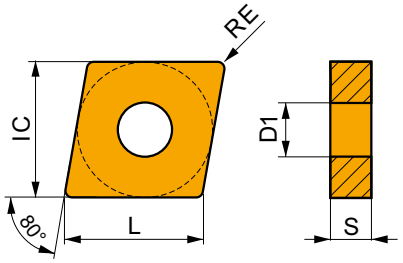
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) | | | | | | | | | | | | | | | | | | |
|  |  | | W 1 U S | | | | | | | | | | | | | | | | | |
| | | | W-NM wiper geometri til halv grov til hård bearbejdning med øget tilspænding og forbedret overfladefinish. | | | | | | | | | | | | | | | | | |
| **CNMG 120408W-NM** | **T7325** | 0.8 | 215 | 0.25 | 2.1 | 165 | 0.23 | 2.1 | – | – | – | – | – | – | 65 | 0.20 | 1.7 | – | – | – |
| | **T7335** | 0.8 | 210 | 0.25 | 2.1 | 160 | 0.23 | 2.1 | – | – | – | – | – | – | 65 | 0.20 | 1.7 | – | – | – |
| | **T9315** | 0.8 | 290 | 0.25 | 2.1 | – | – | – | 275 | 0.25 | 2.1 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 260 | 0.25 | 2.1 | 155 | 0.23 | 2.1 | 245 | 0.25 | 2.1 | – | – | – | 55 | 0.20 | 1.7 | – | – | – |
| **CNMG 120412W-NM** | **T7325** | 1.2 | 215 | 0.30 | 2.1 | 165 | 0.27 | 2.1 | – | – | – | – | – | – | 65 | 0.24 | 1.7 | – | – | – |
| | **T7335** | 1.2 | 210 | 0.30 | 2.1 | 160 | 0.27 | 2.1 | – | – | – | – | – | – | 65 | 0.24 | 1.7 | – | – | – |
| | **T9315** | 1.2 | 285 | 0.30 | 2.1 | – | – | – | 270 | 0.30 | 2.1 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | 255 | 0.30 | 2.1 | 150 | 0.27 | 2.1 | 240 | 0.30 | 2.1 | – | – | – | 55 | 0.24 | 1.7 | – | – | – |

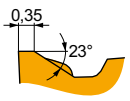
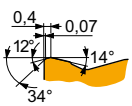
# CNMM

PRAMET

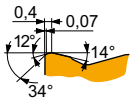
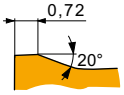
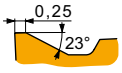
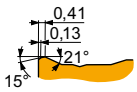
| | IC (mm) | D1 (mm) | L (mm) | S (mm) |
|---|---|---|---|---|
| 1204 | 12.700 | 5.16 | 12.90 | 4.76 |
| 1606 | 15.875 | 6.35 | 16.10 | 6.35 |
| 1906 | 19.050 | 7.94 | 19.30 | 6.35 |
| 2509 | 25.400 | 9.12 | 25.80 | 9.53 |



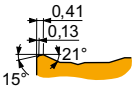
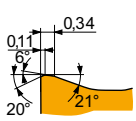
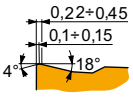

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) | | | | | | | | | | | | | | | | | | |
|  |  | | S | | | | | | | | | | | | | | | | | |
| | | | DR-geometri til hård til ekstra hård bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **CNMM 160612E-DR** | **T9315** | 1.2 | 225 | 0.45 | 6.0 | – | – | – | 210 | 0.45 | 6.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | 200 | 0.45 | 6.0 | 120 | 0.41 | 6.0 | 190 | 0.45 | 6.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.2 | 170 | 0.45 | 6.0 | 100 | 0.41 | 6.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| **CNMM 190608E-DR** | **T9315** | 0.8 | 215 | 0.40 | 8.0 | – | – | – | 200 | 0.40 | 8.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 190 | 0.40 | 8.0 | 110 | 0.36 | 8.0 | 180 | 0.40 | 8.0 | – | – | – | – | – | – | – | – | – |
| **CNMM 190612E-DR** | **T9315** | 1.2 | 220 | 0.45 | 8.0 | – | – | – | 205 | 0.45 | 8.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | 195 | 0.45 | 8.0 | 115 | 0.41 | 8.0 | 185 | 0.45 | 8.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.2 | 170 | 0.45 | 8.0 | 100 | 0.41 | 8.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| **CNMM 190616E-DR** | **T9325** | 1.6 | 195 | 0.50 | 9.0 | 115 | 0.45 | 9.0 | 185 | 0.50 | 9.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.6 | 170 | 0.50 | 9.0 | 100 | 0.45 | 9.0 | – | – | – | – | – | – | – | – | – | – | – | – |
|  |  | | P | | | | | | | | | | | | | | | | | |
| | | | HR-geometri til hård til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **CNMM 190616E-HR** | **6640** | 1.6 | 75 | 0.60 | 10.0 | 45 | 0.54 | 10.0 | 70 | 0.60 | 10.0 | – | – | – | – | – | – | – | – | – |
| | **T8345** | 1.6 | 55 | 0.60 | 10.0 | 30 | 0.54 | 10.0 | 50 | 0.60 | 10.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.6 | 105 | 0.60 | 10.0 | 60 | 0.54 | 10.0 | 95 | 0.60 | 10.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.6 | 80 | 0.60 | 10.0 | 45 | 0.54 | 10.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| **CNMM 190624E-HR** | **T8345** | 2.4 | 60 | 0.65 | 10.0 | 35 | 0.59 | 10.0 | 55 | 0.65 | 10.0 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 2.4 | 115 | 0.65 | 10.0 | – | – | – | 105 | 0.65 | 10.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 2.4 | 100 | 0.65 | 10.0 | 60 | 0.59 | 10.0 | 95 | 0.65 | 10.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 2.4 | 85 | 0.65 | 10.0 | 50 | 0.59 | 10.0 | – | – | – | – | – | – | – | – | – | – | – | – |

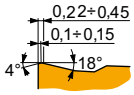
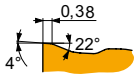
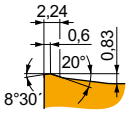
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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-geometri til hård til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **CNMM 250924E-HR** | **6640** | 2.4 | 75 | 0.65 | 14.0 | 45 | 0.59 | 14.0 | 70 | 0.65 | 14.0 | – | – | – | – | – | – | – | – | – |
| | **T8345** | 2.4 | 55 | 0.65 | 14.0 | 30 | 0.59 | 14.0 | 50 | 0.65 | 14.0 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 2.4 | 110 | 0.65 | 14.0 | – | – | – | 100 | 0.65 | 14.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 2.4 | 100 | 0.65 | 14.0 | 60 | 0.59 | 14.0 | 95 | 0.65 | 14.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 2.4 | 80 | 0.65 | 14.0 | 45 | 0.59 | 14.0 | – | – | – | – | – | – | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | HR2-geometri til hård til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **CNMM 190616-HR2** | **T9226** | 1.6 | 85 | 0.65 | 10.0 | 50 | 0.59 | 10.0 | 80 | 0.65 | 10.0 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 1.6 | 110 | 0.65 | 10.0 | – | – | – | 100 | 0.65 | 10.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.6 | 80 | 0.65 | 10.0 | 45 | 0.59 | 10.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| **CNMM 190624-HR2** | **T9226** | 2.4 | 80 | 0.85 | 10.0 | 45 | 0.77 | 10.0 | 75 | 0.85 | 10.0 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 2.4 | 100 | 0.85 | 10.0 | – | – | – | 95 | 0.85 | 10.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 2.4 | 75 | 0.85 | 10.0 | 45 | 0.77 | 10.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| **CNMM 250924-HR2** | **T9315** | 2.4 | 100 | 0.85 | 12.0 | – | – | – | 95 | 0.85 | 12.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 2.4 | 75 | 0.85 | 12.0 | 45 | 0.77 | 12.0 | – | – | – | – | – | – | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | NR-geometri til semi-ru til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **CNMM 120408E-NR** | **6640** | 0.8 | 155 | 0.40 | 3.0 | 90 | 0.36 | 3.0 | 145 | 0.40 | 3.0 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 0.8 | 175 | 0.40 | 3.0 | 135 | 0.36 | 3.0 | – | – | – | – | – | – | 55 | 0.28 | 2.4 | – | – | – |
| | **T7335** | 0.8 | 165 | 0.40 | 3.0 | 125 | 0.36 | 3.0 | – | – | – | – | – | – | 50 | 0.28 | 2.4 | – | – | – |
| | **T8330** | 0.8 | 155 | 0.40 | 3.0 | 90 | 0.36 | 3.0 | 145 | 0.40 | 3.0 | – | – | – | 35 | 0.28 | 2.4 | – | – | – |
| | **T8430** | 0.8 | 165 | 0.40 | 3.0 | 90 | 0.36 | 3.0 | 135 | 0.40 | 3.0 | – | – | – | 35 | 0.28 | 2.4 | – | – | – |
| | **T9315** | 0.8 | 215 | 0.40 | 3.0 | – | – | – | 200 | 0.40 | 3.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 195 | 0.40 | 3.0 | 115 | 0.36 | 3.0 | 185 | 0.40 | 3.0 | – | – | – | 40 | 0.28 | 2.4 | – | – | – |
| **CNMM 120412E-NR** | **T7325** | 1.2 | 185 | 0.40 | 3.0 | 140 | 0.36 | 3.0 | – | – | – | – | – | – | 60 | 0.28 | 2.4 | – | – | – |
| | **T7335** | 1.2 | 175 | 0.40 | 3.0 | 135 | 0.36 | 3.0 | – | – | – | – | – | – | 55 | 0.28 | 2.4 | – | – | – |
| | **T8330** | 1.2 | 165 | 0.40 | 3.0 | 95 | 0.36 | 3.0 | 155 | 0.40 | 3.0 | – | – | – | 40 | 0.28 | 2.4 | – | – | – |
| | **T8430** | 1.2 | 170 | 0.40 | 3.0 | 90 | 0.36 | 3.0 | 135 | 0.40 | 3.0 | – | – | – | 35 | 0.28 | 2.4 | – | – | – |
| | **T9325** | 1.2 | 205 | 0.40 | 3.0 | 120 | 0.36 | 3.0 | 190 | 0.40 | 3.0 | – | – | – | 45 | 0.28 | 2.4 | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | NR2-geometri til semi-ru til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **CNMM 120408E-NR2** | **T7325** | 0.8 | 165 | 0.40 | 5.0 | 125 | 0.36 | 5.0 | – | – | – | – | – | – | 50 | 0.28 | 4.0 | – | – | – |
| | **T7335** | 0.8 | 155 | 0.40 | 5.0 | 120 | 0.36 | 5.0 | – | – | – | – | – | – | 50 | 0.28 | 4.0 | – | – | – |
| | **T8330** | 0.8 | 150 | 0.40 | 5.0 | 90 | 0.36 | 5.0 | 140 | 0.40 | 5.0 | – | – | – | 35 | 0.28 | 4.0 | – | – | – |
| | **T8430** | 0.8 | 150 | 0.40 | 5.0 | 80 | 0.36 | 5.0 | 125 | 0.40 | 5.0 | – | – | – | 30 | 0.28 | 4.0 | – | – | – |
| | **T9315** | 0.8 | 205 | 0.40 | 5.0 | – | – | – | 190 | 0.40 | 5.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 185 | 0.40 | 5.0 | 110 | 0.36 | 5.0 | 175 | 0.40 | 5.0 | – | – | – | 40 | 0.28 | 4.0 | – | – | – |
| **CNMM 120412E-NR2** | **T7335** | 1.2 | 155 | 0.45 | 5.0 | 120 | 0.41 | 5.0 | – | – | – | – | – | – | 50 | 0.32 | 4.0 | – | – | – |
| | **T8330** | 1.2 | 150 | 0.45 | 5.0 | 90 | 0.41 | 5.0 | 140 | 0.45 | 5.0 | – | – | – | 35 | 0.32 | 4.0 | – | – | – |
| | **T8430** | 1.2 | 150 | 0.45 | 5.0 | 80 | 0.41 | 5.0 | 125 | 0.45 | 5.0 | – | – | – | 30 | 0.32 | 4.0 | – | – | – |
| | **T9315** | 1.2 | 205 | 0.45 | 5.0 | – | – | – | 190 | 0.45 | 5.0 | – | – | – | – | – | – | – | – | – |
| | **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** | **T8330** | 0.8 | 145 | 0.40 | 6.0 | 85 | 0.36 | 6.0 | 135 | 0.40 | 6.0 | – | – | – | 35 | 0.32 | 4.8 | – | – | – |
| | **T8430** | 0.8 | 150 | 0.40 | 6.0 | 80 | 0.36 | 6.0 | 125 | 0.40 | 6.0 | – | – | – | 30 | 0.32 | 4.8 | – | – | – |
| | **T9325** | 0.8 | 180 | 0.40 | 6.0 | 105 | 0.36 | 6.0 | 170 | 0.40 | 6.0 | – | – | – | 40 | 0.32 | 4.8 | – | – | – |

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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-geometri til semi-ru til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **CNMM 160612E-NR2** | **T7325** | 1.2 | 165 | 0.45 | 6.0 | 125 | 0.41 | 6.0 | – | – | – | – | – | – | 50 | 0.36 | 4.8 | – | – | – |
| | **T7335** | 1.2 | 155 | 0.45 | 6.0 | 120 | 0.41 | 6.0 | – | – | – | – | – | – | 50 | 0.36 | 4.8 | – | – | – |
| | **T8330** | 1.2 | 145 | 0.45 | 6.0 | 85 | 0.41 | 6.0 | 135 | 0.45 | 6.0 | – | – | – | 35 | 0.36 | 4.8 | – | – | – |
| | **T8430** | 1.2 | 150 | 0.45 | 6.0 | 80 | 0.41 | 6.0 | 125 | 0.45 | 6.0 | – | – | – | 30 | 0.36 | 4.8 | – | – | – |
| | **T9315** | 1.2 | 205 | 0.45 | 6.0 | – | – | – | 190 | 0.45 | 6.0 | – | – | – | – | – | – | – | – | – |
| | **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 | – | – | – |
| | **T7335** | 1.6 | 160 | 0.50 | 6.0 | 120 | 0.45 | 6.0 | – | – | – | – | – | – | 50 | 0.40 | 4.8 | – | – | – |
| | **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 | – | – | – |
| | **T7335** | 1.2 | 145 | 0.45 | 9.0 | 110 | 0.41 | 9.0 | – | – | – | – | – | – | 45 | 0.36 | 7.2 | – | – | – |
| | **T8330** | 1.2 | 140 | 0.45 | 9.0 | 80 | 0.41 | 9.0 | 130 | 0.45 | 9.0 | – | – | – | 35 | 0.36 | 7.2 | – | – | – |
| | **T8430** | 1.2 | 140 | 0.45 | 9.0 | 75 | 0.41 | 9.0 | 115 | 0.45 | 9.0 | – | – | – | 30 | 0.36 | 7.2 | – | – | – |
| | **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 | – | – | – |
| | **T7335** | 1.6 | 150 | 0.50 | 9.0 | 115 | 0.45 | 9.0 | – | – | – | – | – | – | 45 | 0.40 | 7.2 | – | – | – |
| | **T8330** | 1.6 | 140 | 0.50 | 9.0 | 80 | 0.45 | 9.0 | 130 | 0.50 | 9.0 | – | – | – | 35 | 0.40 | 7.2 | – | – | – |
| | **T8430** | 1.6 | 140 | 0.50 | 9.0 | 75 | 0.45 | 9.0 | 115 | 0.50 | 9.0 | – | – | – | 30 | 0.40 | 7.2 | – | – | – |
| | **T9315** | 1.6 | 195 | 0.50 | 9.0 | – | – | – | 185 | 0.50 | 9.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.6 | 175 | 0.50 | 9.0 | 105 | 0.45 | 9.0 | 165 | 0.50 | 9.0 | – | – | – | 35 | 0.40 | 7.2 | – | – | – |
| **CNMM 190624E-NR2** | **T7335** | 2.4 | 130 | 0.80 | 9.0 | 100 | 0.72 | 9.0 | – | – | – | – | – | – | 40 | 0.56 | 7.2 | – | – | – |
| | **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** | **T7325** | 2.4 | 100 | 0.80 | 12.0 | 75 | 0.72 | 12.0 | – | – | – | – | – | – | 30 | 0.56 | 9.6 | – | – | – |
| | **T7335** | 2.4 | 95 | 0.80 | 12.0 | 70 | 0.72 | 12.0 | – | – | – | – | – | – | 30 | 0.56 | 9.6 | – | – | – |
| | **T8430** | 2.4 | 80 | 0.80 | 12.0 | 45 | 0.72 | 12.0 | 65 | 0.80 | 12.0 | – | – | – | 15 | 0.56 | 9.6 | – | – | – |
| | **T9315** | 2.4 | 110 | 0.80 | 12.0 | – | – | – | 100 | 0.80 | 12.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 2.4 | 100 | 0.80 | 12.0 | 60 | 0.72 | 12.0 | 95 | 0.80 | 12.0 | – | – | – | 20 | 0.56 | 9.6 | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| NRM-geometri med positivt design til halv grov til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **CNMM 250924-NRM** | **T7325** | 2.4 | 95 | 0.70 | 10.0 | 70 | 0.63 | 10.0 | – | – | – | – | – | – | 30 | 0.49 | 8.0 | – | – | – |
| | **T7335** | 2.4 | 90 | 0.70 | 10.0 | 70 | 0.63 | 10.0 | – | – | – | – | – | – | 25 | 0.49 | 8.0 | – | – | – |
| | **T9315** | 2.4 | 115 | 0.70 | 10.0 | – | – | – | 105 | 0.70 | 10.0 | – | – | – | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| OR geometri til semi-grov til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **CNMM 120408E-OR** | **T8330** | 0.8 | 150 | 0.40 | 5.0 | 90 | 0.36 | 5.0 | 140 | 0.40 | 5.0 | – | – | – | 35 | 0.28 | 4.0 | – | – | – |
| | **T8430** | 0.8 | 150 | 0.40 | 5.0 | 80 | 0.36 | 5.0 | 125 | 0.40 | 5.0 | – | – | – | 30 | 0.28 | 4.0 | – | – | – |
| | **T9315** | 0.8 | 205 | 0.40 | 5.0 | – | – | – | 190 | 0.40 | 5.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 185 | 0.40 | 5.0 | 110 | 0.36 | 5.0 | 175 | 0.40 | 5.0 | – | – | – | 40 | 0.28 | 4.0 | – | – | – |
| | **T9335** | 0.8 | 160 | 0.40 | 5.0 | 95 | 0.36 | 5.0 | – | – | – | – | – | – | 35 | 0.28 | 4.0 | – | – | – |
| **CNMM 120412E-OR** | **T9315** | 1.2 | 205 | 0.45 | 5.0 | – | – | – | 190 | 0.45 | 5.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | 185 | 0.45 | 5.0 | 110 | 0.41 | 5.0 | 175 | 0.45 | 5.0 | – | – | – | 40 | 0.36 | 4.0 | – | – | – |
| | **T9335** | 1.2 | 165 | 0.45 | 5.0 | 95 | 0.41 | 5.0 | – | – | – | – | – | – | 35 | 0.36 | 4.0 | – | – | – |
| **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 | – | – | – |
| | **T9335** | 1.6 | 165 | 0.50 | 5.0 | 95 | 0.45 | 5.0 | – | – | – | – | – | – | 35 | 0.40 | 4.0 | – | – | – |
| **CNMM 160608E-OR** | **T9315** | 0.8 | 205 | 0.40 | 6.0 | – | – | – | 190 | 0.40 | 6.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 180 | 0.40 | 6.0 | 105 | 0.36 | 6.0 | 170 | 0.40 | 6.0 | – | – | – | 40 | 0.32 | 4.8 | – | – | – |
| | **T9335** | 0.8 | 160 | 0.40 | 6.0 | 95 | 0.36 | 6.0 | – | – | – | – | – | – | 35 | 0.32 | 4.8 | – | – | – |
| **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 | – | – | – |
| | **T9315** | 1.2 | 205 | 0.45 | 6.0 | – | – | – | 190 | 0.45 | 6.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | 185 | 0.45 | 6.0 | 110 | 0.41 | 6.0 | 175 | 0.45 | 6.0 | – | – | – | 40 | 0.36 | 4.8 | – | – | – |

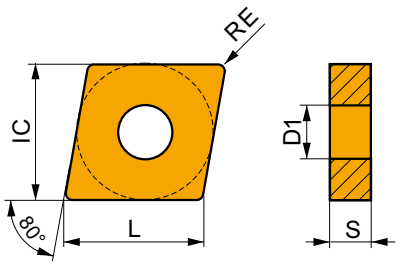
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |   | | | | | | | | | | | | | | | | | | | |
| OR geometri til semi-grov til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **CNMM 160616E-OR** | **T9315** | 1.6 | ■ | 205 | 0.50 | 6.0 | | – | – | – | ◪ | 190 | 0.50 | 6.0 | | – | – | – | | – | – | – | | – | – | – |
| | **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-OR** | **T8330** | 1.2 | ■ | 140 | 0.45 | 9.0 | ◪ | 80 | 0.41 | 9.0 | ■ | 130 | 0.45 | 9.0 | | – | – | – | ◪ | 35 | 0.36 | 7.2 | | – | – | – |
| | **T8430** | 1.2 | ■ | 140 | 0.45 | 9.0 | ◪ | 75 | 0.41 | 9.0 | ◪ | 115 | 0.45 | 9.0 | | – | – | – | ◪ | 30 | 0.36 | 7.2 | | – | – | – |
| | **T9315** | 1.2 | ■ | 195 | 0.45 | 9.0 | | – | – | – | ◪ | 185 | 0.45 | 9.0 | | – | – | – | | – | – | – | | – | – | – |
| | **T9325** | 1.2 | ■ | 175 | 0.45 | 9.0 | ◪ | 105 | 0.41 | 9.0 | ◪ | 165 | 0.45 | 9.0 | | – | – | – | ◪ | 35 | 0.36 | 7.2 | | – | – | – |
| | **T9335** | 1.2 | ■ | 150 | 0.45 | 9.0 | ◪ | 90 | 0.41 | 9.0 | | – | – | – | | – | – | – | ◪ | 30 | 0.36 | 7.2 | | – | – | – |
| **CNMM 190616E-OR** | **T8330** | 1.6 | ■ | 140 | 0.50 | 9.0 | ◪ | 80 | 0.45 | 9.0 | ■ | 130 | 0.50 | 9.0 | | – | – | – | ◪ | 35 | 0.40 | 7.2 | | – | – | – |
| | **T8345** | 1.6 | ■ | 120 | 0.50 | 9.0 | ◪ | 70 | 0.45 | 9.0 | ◪ | 110 | 0.50 | 9.0 | | – | – | – | ◪ | 30 | 0.40 | 7.2 | | – | – | – |
| | **T8430** | 1.6 | ■ | 140 | 0.50 | 9.0 | ◪ | 75 | 0.45 | 9.0 | ◪ | 115 | 0.50 | 9.0 | | – | – | – | ◪ | 30 | 0.40 | 7.2 | | – | – | – |
| | **T9315** | 1.6 | ■ | 195 | 0.50 | 9.0 | | – | – | – | ◪ | 185 | 0.50 | 9.0 | | – | – | – | | – | – | – | | – | – | – |
| | **T9325** | 1.6 | ■ | 175 | 0.50 | 9.0 | ◪ | 105 | 0.45 | 9.0 | ◪ | 165 | 0.50 | 9.0 | | – | – | – | ◪ | 35 | 0.40 | 7.2 | | – | – | – |
| | **T9335** | 1.6 | ■ | 155 | 0.50 | 9.0 | ◪ | 90 | 0.45 | 9.0 | | – | – | – | | – | – | – | ◪ | 30 | 0.40 | 7.2 | | – | – | – |
| **CNMM 190624E-OR** | **T9315** | 2.4 | ■ | 165 | 0.80 | 9.0 | | – | – | – | ◪ | 155 | 0.80 | 9.0 | | – | – | – | | – | – | – | | – | – | – |
| | **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-OR** | **T8330** | 2.4 | ■ | 75 | 1.00 | 12.0 | ◪ | 45 | 0.90 | 12.0 | ■ | 70 | 1.00 | 12.0 | | – | – | – | ◪ | 15 | 0.70 | 9.6 | | – | – | – |
| | **T8430** | 2.4 | ■ | 75 | 1.00 | 12.0 | ◪ | 40 | 0.90 | 12.0 | ◪ | 60 | 1.00 | 12.0 | | – | – | – | ◪ | 15 | 0.70 | 9.6 | | – | – | – |
| | **T9315** | 2.4 | ■ | 100 | 1.00 | 12.0 | | – | – | – | ◪ | 95 | 1.00 | 12.0 | | – | – | – | | – | – | – | | – | – | – |
| | **T9325** | 2.4 | ■ | 95 | 1.00 | 12.0 | ◪ | 55 | 0.90 | 12.0 | ◪ | 90 | 1.00 | 12.0 | | – | – | – | ◪ | 20 | 0.70 | 9.6 | | – | – | – |
| | **T9335** | 2.4 | ■ | 75 | 1.00 | 12.0 | ◪ | 45 | 0.90 | 12.0 | | – | – | – | | – | – | – | ◪ | 15 | 0.70 | 9.6 | | – | – | – |
|  |   | | | | | | | | | | | | | | | | | | | |
| OR1-geometri til semi-grov til tung-grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **CNMM 190616E-OR1** | **T9325** | 1.6 | ■ | 175 | 0.50 | 9.0 | ◪ | 105 | 0.45 | 9.0 | ◪ | 165 | 0.50 | 9.0 | | – | – | – | ◪ | 35 | 0.35 | 7.2 | | – | – | – |
| | **T9335** | 1.6 | ■ | 155 | 0.50 | 9.0 | ◪ | 90 | 0.45 | 9.0 | | – | – | – | | – | – | – | ◪ | 30 | 0.35 | 7.2 | | – | – | – |
|  |   | | | | | | | | | | | | | | | | | | | |
| Geometri 923 til semi-grov til tung-hård bearbejdning og kontinuerlig til kraftig afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **CNMM 250924S-923** | **T8330** | 2.4 | ■ | 75 | 0.85 | 12.0 | ■ | 45 | 0.77 | 12.0 | ◪ | 70 | 0.85 | 12.0 | | – | – | – | ◪ | 15 | 0.60 | 9.6 | | – | – | – |
| | **T8430** | 2.4 | ■ | 75 | 0.85 | 12.0 | ■ | 40 | 0.77 | 12.0 | ◪ | 60 | 0.85 | 12.0 | | – | – | – | ◪ | 15 | 0.60 | 9.6 | | – | – | – |
| | **T9335** | 2.4 | ■ | 75 | 0.85 | 12.0 | ■ | 45 | 0.77 | 12.0 | | – | – | – | | – | – | – | ◪ | 15 | 0.60 | 9.6 | | – | – | – |

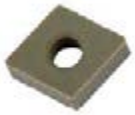
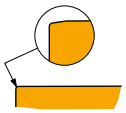
# CNGA CER

PRAMET

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



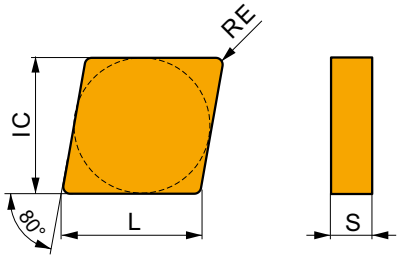

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | HSC T | | | | | | | | | | | | | | | | | |
| | | | Til bearbejdning med høje hastigheder og kontinuerlige snit. | | | | | | | | | | | | | | | | | |
| **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 | – | – | – | – | – | – | – | – | – |

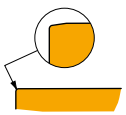
# CNGN CER

PRAMET

| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 1204 | 12.700 | 12.90 | 4.76 |
| 1207 | 12.700 | 12.90 | 7.94 |



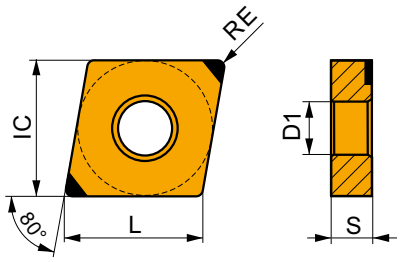

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | HSC T | | | | | | | | | | | | | | | | | |
| | | | Til bearbejdning med høje hastigheder og kontinuerlige snit. | | | | | | | | | | | | | | | | | |
| **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 | – | – | – | – | – | – | – | – | – |

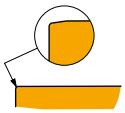
# CNGA CBN

PRAMET

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




Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | HSC | | S | | | | | | | | | | | | | | | |
| | | | Til færdigbearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | |
| **CNGA 120404S01020B** | **TB310** | 0.4 | – | – | – | – | – | – | ◪ 510 | 0.10 | 0.4 | – | – | – | ◪ 135 | 0.07 | 0.3 | ■ 105 | 0.15 | 1.0 |
| **CNGA 120408S01020B** | **TB310** | 0.8 | – | – | – | – | – | – | ◪ 530 | 0.15 | 0.6 | – | – | – | ◪ 140 | 0.11 | 0.5 | ■ 110 | 0.15 | 1.0 |

# DCBN(RL) EXT

P M K N S H

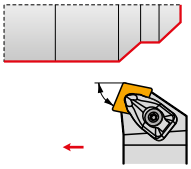
PRAMET

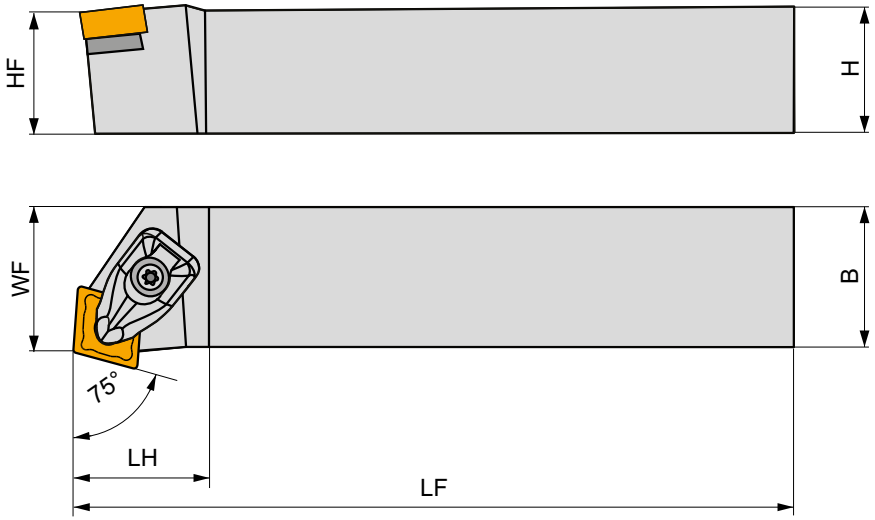
D

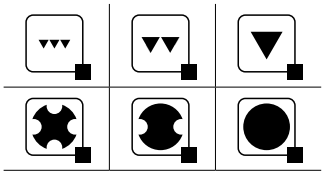


## Ekstern dobbeltholder, 75 ° skærevinkel til CN .. skær

Ekstern højre / venstre dobbeltklemme 75 ° værktøjsholder. Velegnet til længde- og endedrejning uden skulder og affasning med negativ CN .. 12 op til 19 størrelse skær. Fås med skaft 20x20 op til 40x40 mm. Krop behandlet for længere levetid







| | Product | H (mm) | B (mm) | HF (mm) | WF (mm) | LF (mm) | LH (mm) | LAMS (°) | GAMO (°) | kg | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 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 | -6 | -6 | 1.11 | GI050 | DC16 | AT005 |
| | DCBNR 3232 P 19 | 32 | 32 | 32 | 27 | 170 | 46.1 | -6 | -6 | 1.39 | GI042 | DC19 | – |
| | DCBNR 4040 S 19 | 40 | 40 | 40 | 35 | 250 | 46.7 | -6 | -6 | 3.16 | GI042 | DC19 | – |
| L | DCBNL 2020 K 12 | 20 | 20 | 20 | 17 | 125 | 34.2 | -6 | -6 | 0.43 | GI043 | DC12 | AT001 |
| | 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 | -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

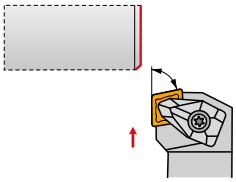
PRAMET

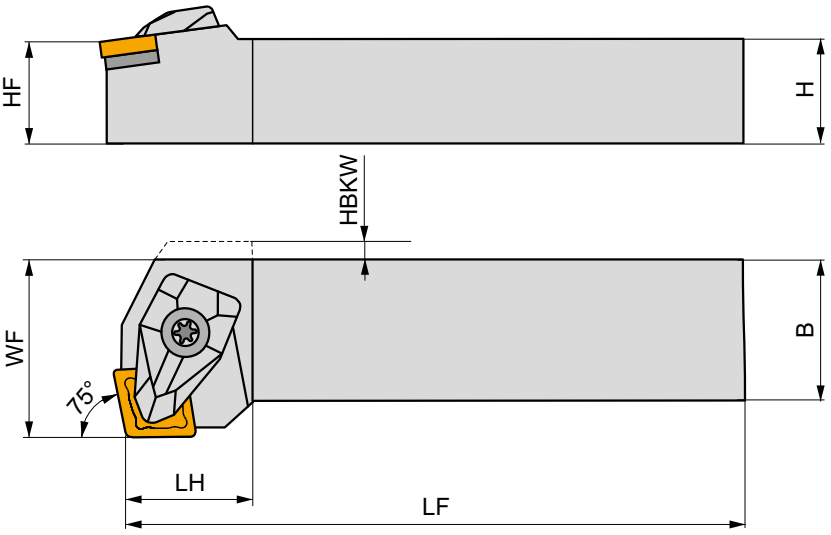
D

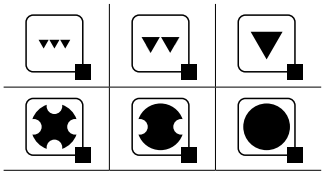


## Ekstern dobbeltholder, 75 ° skærevinkel til CN .. skær

Ekstern højre / venstre dobbeltklemme 75 ° værktøjsholder. Velegnet til endedrejning og lejlighedsvis affasning med negative CN .. 12 eller 16 størrelse skær. Fås med skaft 20x20 op til 32x32 mm. Krop behandlet for længere levetid







| | Product | H (mm) | B (mm) | HF (mm) | WF (mm) | LF (mm) | LH (mm) | HBKW (mm) | LAMS (°) | GAMO (°) | kg | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 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 | – | -6 | -6 | 1.46 | GI050 | DC16 | AT005 |
| L | DCKNL 2020 K 12 | 20 | 20 | 20 | 25 | 125 | 21.2 | 4.5 | -6 | -6 | 0.46 | GI043 | DC12 | AT001 |
| | 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 | – | -6 | -6 | 1.46 | GI050 | DC16 | AT005 |

| | |
|---|---|
| GI043 | CN.. 1204.. |
| GI050 | CN.. 1606.. |

| | | | | | | |
|---|---|---|---|---|---|---|
| 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

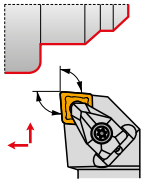
PRAMET

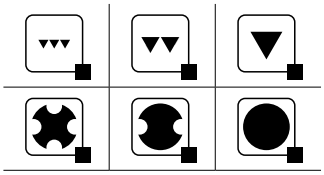
D

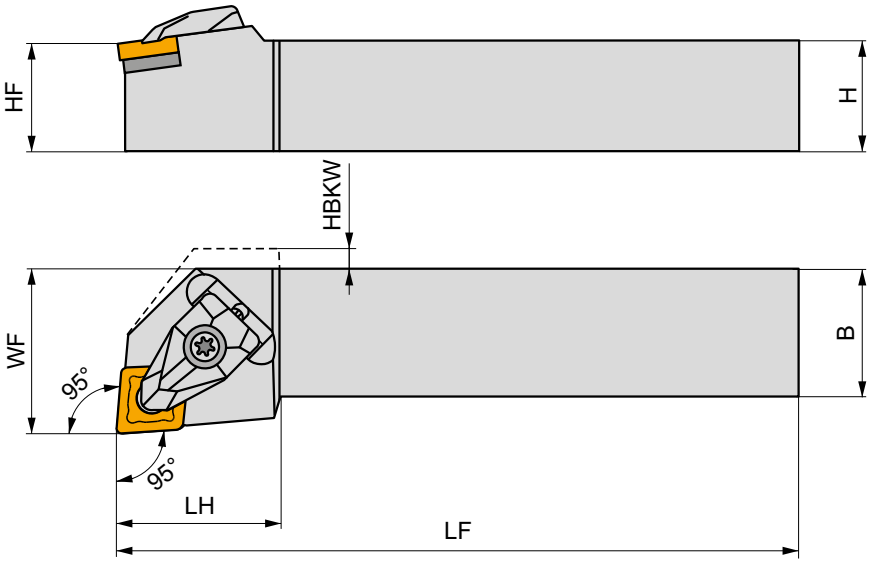


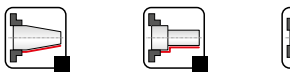
## Ekstern dobbeltholder, 95 ° skærevinkel til CN .. skær

Ekstern højre / venstre dobbeltklemme 75 ° værktøjsholder. Velegnet til længde- og endedrejning uden skulder og affasning med negativ CN .. 12 op til 19 størrelse skær. Fås med skaft 20x20 op til 40x40 mm. Krop behandlet for længere levetid







| | Product | H (mm) | B (mm) | HF (mm) | WF (mm) | LF (mm) | LH (mm) | HBKW (mm) | LAMS (°) | GAMO (°) | kg | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| R | DCLNR 1616 H 09 | 16 | 16 | 16 | 20 | 100 | 25 | – | -6 | -6 | 0.27 | GI133 | DC09 | – |
| | DCLNR 2020 K 09 | 20 | 20 | 20 | 25 | 125 | 25 | – | -6 | -6 | 0.44 | GI133 | DC09 | – |
| | DCLNR 2525 M 09 | 25 | 25 | 25 | 32 | 150 | 25 | – | -6 | -6 | 0.78 | 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 | – | -6 | -6 | 0.44 | GI043 | DC12 | AT001 |
| | DCLNR 2525 M 12 | 25 | 25 | 25 | 32 | 150 | 30 | – | -6 | -6 | 0.78 | GI043 | DC12 | AT001 |
| | DCLNR 3225 P 12 | 32 | 25 | 32 | 32 | 170 | 30 | – | -6 | -6 | 1.10 | GI043 | DC12 | AT001 |
| | DCLNR 2525 M 16 | 25 | 25 | 25 | 32 | 150 | 39 | – | -6 | -6 | 0.81 | GI050 | DC16 | AT005 |
| | DCLNR 3225 P 16 | 32 | 25 | 32 | 32 | 170 | 35 | – | -6 | -6 | 1.20 | GI050 | DC16 | AT005 |
| | DCLNR 3232 P 19 | 32 | 32 | 32 | 40 | 170 | 40 | – | -6 | -6 | 1.55 | GI042 | DC19 | – |
| | DCLNR 4040 S 19 | 40 | 40 | 40 | 50 | 250 | 43.4 | – | -6 | -6 | 3.26 | 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 | – | -6 | -6 | 0.44 | GI043 | DC12 | AT001 |
| | DCLNL 2525 M 12 | 25 | 25 | 25 | 32 | 150 | 32 | – | -6 | -6 | 0.78 | GI043 | DC12 | AT001 |
| | DCLNL 3225 P 12 | 32 | 25 | 32 | 32 | 170 | 32 | – | -6 | -6 | 1.10 | GI043 | DC12 | AT001 |
| | DCLNL 2525 M 16 | 25 | 25 | 25 | 32 | 150 | 39 | – | -6 | -6 | 0.81 | GI050 | DC16 | AT005 |
| | DCLNL 3225 P 16 | 32 | 25 | 32 | 32 | 170 | 39 | – | -6 | -6 | 1.20 | GI050 | DC16 | AT005 |
| | DCLNL 3232 P 19 | 32 | 32 | 32 | 40 | 170 | 43.2 | – | -6 | -6 | 1.51 | 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

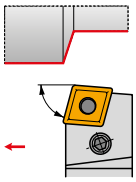
PRAMET

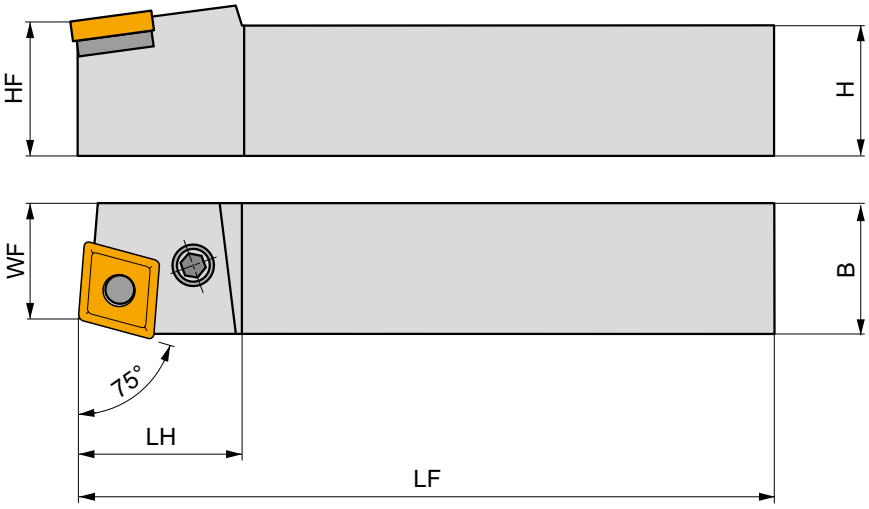
P

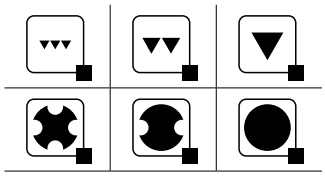


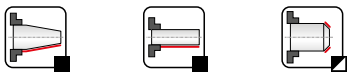
## Ekstern Lever Lock Drejeholder med 75 ° skærevinkel til CN .. Skær

Ekstern højre / venstre hånd 75 ° værktøjsholder. Velegnet til udvendig affasning, tilspidsning og langsgående drejning uden skulder ved hjælp af negative CN .. 12, 16, 19 eller 25 størrelse skær. Fås i 20x20 op til 50x50 mm skaft. Krop behandlet for længere levetid







| | Product | H (mm) | B (mm) | HF (mm) | WF (mm) | LF (mm) | LH (mm) | LAMS (°) | GAMO (°) | kg | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| R | PCBNR 2020 K 12 | 20 | 20 | 20 | 17 | 125 | 36 | -6 | -6 | 0.43 | GI043 | PC22 |
| | PCBNR 2525 M 12 | 25 | 25 | 25 | 22 | 150 | 36 | -6 | -6 | 0.63 | GI043 | PC20 |
| | PCBNR 3225 P 12 | 32 | 25 | 32 | 22 | 170 | 36 | -6 | -6 | 0.70 | GI043 | PC20 |
| | PCBNR 3232 P 16 | 32 | 32 | 32 | 27 | 170 | 40 | -6 | -6 | 1.36 | GI050 | PC40 |
| | PCBNR 3232 P 19 | 32 | 32 | 32 | 27 | 170 | 45 | -6 | -6 | 1.10 | GI042 | PC50 |
| | PCBNR 4040 S 19 | 40 | 40 | 40 | 35 | 250 | 45 | -6 | -6 | 3.15 | GI042 | PC50 |
| | PCBNR 4040 S 25 | 40 | 40 | 40 | 35 | 250 | 45 | -6 | -6 | 3.10 | GI062 | PC60 |
| | PCBNR 5050 T 25 | 50 | 50 | 50 | 43 | 300 | 50 | -6 | -6 | 5.80 | GI062 | PC60 |
| L | PCBNL 2020 K 12 | 20 | 20 | 20 | 17 | 125 | 36 | -6 | -6 | 0.38 | GI043 | PC22 |
| | PCBNL 2525 M 12 | 25 | 25 | 25 | 22 | 150 | 36 | -6 | -6 | 0.73 | GI043 | PC20 |
| | PCBNL 3225 P 12 | 32 | 25 | 32 | 22 | 170 | 36 | -6 | -6 | 0.70 | GI043 | PC20 |
| | PCBNL 3232 P 16 | 32 | 32 | 32 | 27 | 170 | 40 | -6 | -6 | 1.25 | GI050 | PC40 |
| | PCBNL 3232 P 19 | 32 | 32 | 32 | 27 | 170 | 45 | -6 | -6 | 1.10 | GI042 | PC50 |
| | PCBNL 4040 S 19 | 40 | 40 | 40 | 35 | 250 | 45 | -6 | -6 | 3.15 | GI042 | PC50 |
| | PCBNL 4040 S 25 | 40 | 40 | 40 | 35 | 250 | 45 | -6 | -6 | 3.15 | GI062 | PC60 |
| | PCBNL 5050 T 25 | 50 | 50 | 50 | 43 | 300 | 50 | -6 | -6 | 5.80 | GI062 | PC60 |

| | |
|---|---|
| GI042 | CN.. 1906.. |
| GI043 | CN.. 1204.. |
| GI050 | CN.. 1606.. |
| GI062 | CN.. 2509.. |

| | | | | Nm | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| PC20 | CNU 120312 | PU 02 | US 35 | 6.0 | M 8x1 | 22.5 | NT 05 | MT 05 | HXK 4 |
| PC22 | CNU 120312 | PU 02 | US 42 | 6.0 | M 8x1 | 21 | NT 05 | MT 05 | HXK 4 |
| PC40 | CNU 150312 | PU 04 | US 36 | 6.0 | M 8x1 | 26 | NT 07 | MT 07 | HXK 4 |
| 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 |

# PCKN(RL) EXT

P M K N S H

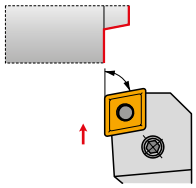
PRAMET

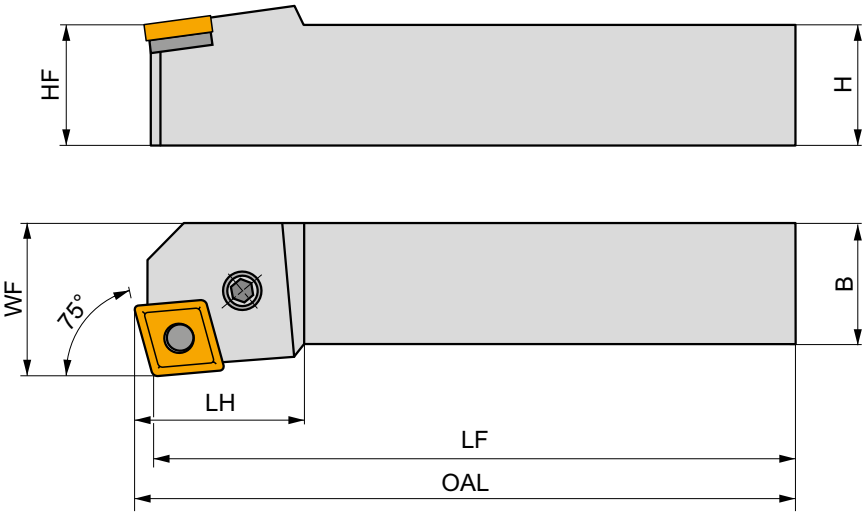
P

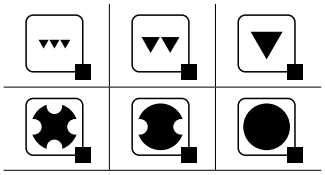


## Ekstern Lever Lock Drejeholder med 75 ° skærevinkel til CN .. Skær

Ekstern højre / venstre hånd 75 ° værktøjsholder. Velegnet til ekstern affasning og endedrejning med skulder ved hjælp af negative CN .. 12, 16 eller 19 størrelse skær. Fås i 20x20 op til 40x40 mm skaft. Krop behandlet for længere levetid







| | Product | H (mm) | B (mm) | HF (mm) | WF (mm) | LF (mm) | LH (mm) | LAMS (°) | GAMO (°) | kg | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| R | **PCKNR 2020 K 12** | 20 | 20 | 20 | 25 | 125 | 36 | -6 | -6 | 0.42 | GI043 | PC22 |
| | **PCKNR 2525 M 12** | 25 | 25 | 25 | 32 | 150 | 36 | -6 | -6 | 0.79 | GI043 | PC20 |
| | **PCKNR 3225 P 12** | 32 | 25 | 32 | 32 | 170 | 36 | -6 | -6 | 0.85 | GI043 | PC20 |
| | **PCKNR 3232 P 16** | 32 | 32 | 32 | 40 | 170 | 40 | -6 | -6 | 1.43 | GI050 | PC40 |
| | **PCKNR 3232 P 19** | 32 | 32 | 32 | 40 | 170 | 45 | -6 | -6 | 1.40 | GI042 | PC50 |
| | **PCKNR 4040 S 19** | 40 | 40 | 40 | 50 | 250 | 45 | -6 | -6 | 3.25 | GI042 | PC50 |
| L | **PCKNL 2020 K 12** | 20 | 20 | 20 | 25 | 125 | 36 | -6 | -6 | 0.42 | GI043 | PC22 |
| | **PCKNL 2525 M 12** | 25 | 25 | 25 | 32 | 150 | 36 | -6 | -6 | 0.78 | GI043 | PC20 |
| | **PCKNL 3225 P 12** | 32 | 25 | 32 | 32 | 170 | 36 | -6 | -6 | 1.15 | GI043 | PC20 |
| | **PCKNL 3232 P 16** | 32 | 32 | 32 | 40 | 170 | 40 | -6 | -6 | 1.40 | GI050 | PC40 |
| | **PCKNL 3232 P 19** | 32 | 32 | 32 | 40 | 170 | 45 | -6 | -6 | 1.40 | GI042 | PC50 |
| | **PCKNL 4040 S 19** | 40 | 40 | 40 | 50 | 250 | 45 | -6 | -6 | 3.27 | GI042 | PC50 |

| | |
|---|---|
| GI042 | CN.. 1906.. |
| GI043 | CN.. 1204.. |
| GI050 | CN.. 1606.. |

| | | | | Nm | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| PC20 | CNU 120312 | PU 02 | US 35 | 6.0 | M 8x1 | 22.5 | NT 05 | MT 05 | HXK 4 |
| PC22 | CNU 120312 | PU 02 | US 42 | 6.0 | M 8x1 | 21 | NT 05 | MT 05 | HXK 4 |
| PC40 | CNU 150312 | PU 04 | US 36 | 6.0 | M 8x1 | 26 | NT 07 | MT 07 | HXK 4 |
| PC50 | CNU 190416 | PU 05 | US 38 | 8.0 | M 10x1 | 29 | NT 06 | MT 06 | HXK 5 |

# PCLN(RL) EXT

P M K N S H

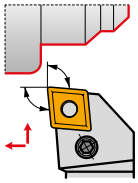
PRAMET

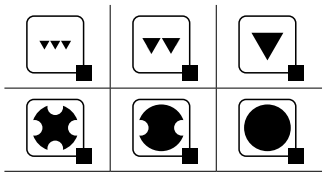
P

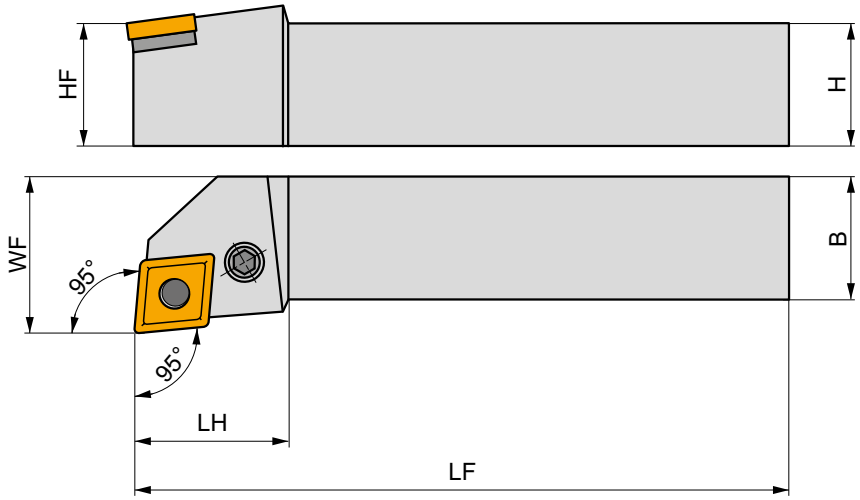


## Ekstern Lever Lock Drejeholder med 95 ° skærevinkel til CN .. Skær

Ekstern højre / venstre hånd 95 ° værktøjsholder. Velegnet til udvendig tilspidsning, ende, langsgående med skulder drejning og affasning med negative CN .. 12, 16, 19 eller 25 størrelse skær. Fås i 20x20 op til 50x50 mm skaft. Krop behandlet for længere levetid










| | 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 | 36 | -6 | -6 | 0.44 | GI043 | PC22 |
| | PCLNR 2525 M 12 | 25 | 25 | 25 | 32 | 150 | 36 | -6 | -6 | 0.68 | GI043 | PC20 |
| | PCLNR 3225 P 12 | 32 | 25 | 32 | 32 | 170 | 36 | -6 | -6 | 0.98 | GI043 | PC20 |
| | PCLNR 3225 P 16 | 32 | 25 | 32 | 32 | 170 | 40 | -6 | -6 | 1.10 | GI050 | PC40 |
| | PCLNR 3232 P 19 | 32 | 32 | 32 | 40 | 170 | 45 | -6 | -6 | 1.40 | GI042 | PC50 |
| | PCLNR 4040 R 19 | 40 | 40 | 40 | 50 | 200 | 45 | -6 | -6 | 2.50 | GI042 | PC50 |
| | PCLNR 4040 S 19 | 40 | 40 | 40 | 50 | 250 | 45 | -6 | -6 | 3.19 | GI042 | PC50 |
| | PCLNR 4040 S 25 | 40 | 40 | 40 | 50 | 250 | 45 | -6 | -6 | 3.15 | GI062 | PC60 |
| | PCLNR 5050 T 25 | 50 | 50 | 50 | 60 | 300 | 50 | -6 | -6 | 5.90 | GI062 | PC60 |
| L | PCLNL 2020 K 12 | 20 | 20 | 20 | 25 | 125 | 36 | -6 | -6 | 0.42 | GI043 | PC22 |
| | PCLNL 2525 M 12 | 25 | 25 | 25 | 32 | 150 | 36 | -6 | -6 | 0.75 | GI043 | PC20 |
| | PCLNL 3225 P 12 | 32 | 25 | 32 | 32 | 170 | 36 | -6 | -6 | 1.10 | GI043 | PC20 |
| | PCLNL 3225 P 16 | 32 | 25 | 32 | 32 | 170 | 40 | -6 | -6 | 1.10 | GI050 | PC40 |
| | PCLNL 3232 P 19 | 32 | 32 | 32 | 40 | 170 | 45 | -6 | -6 | 1.42 | GI042 | PC50 |
| | PCLNL 4040 R 19 | 40 | 40 | 40 | 50 | 200 | 45 | -6 | -6 | 2.60 | GI042 | PC50 |
| | PCLNL 4040 S 19 | 40 | 40 | 40 | 50 | 250 | 45 | -6 | -6 | 3.19 | GI042 | PC50 |
| | PCLNL 4040 S 25 | 40 | 40 | 40 | 50 | 250 | 45 | -6 | -6 | 2.45 | GI062 | PC60 |
| | PCLNL 5050 T 25 | 50 | 50 | 50 | 60 | 300 | 50 | -6 | -6 | 5.90 | GI062 | PC60 |

| | |
|---|---|
| GI042 | CN.. 1906.. |
| GI043 | CN.. 1204.. |
| GI050 | CN.. 1606.. |
| GI062 | CN.. 2509.. |

| | | | | Nm | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| PC20 | CNU 120312 | PU 02 | US 35 | 6.0 | M 8x1 | 22.5 | NT 05 | MT 05 | HXK 4 |
| PC22 | CNU 120312 | PU 02 | US 42 | 6.0 | M 8x1 | 21 | NT 05 | MT 05 | HXK 4 |
| PC40 | CNU 150312 | PU 04 | US 36 | 6.0 | M 8x1 | 26 | NT 07 | MT 07 | HXK 4 |
| 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 |

NEW

# C.-DCLN(RL) EXT

P M K N S H

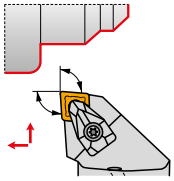
PRAMET

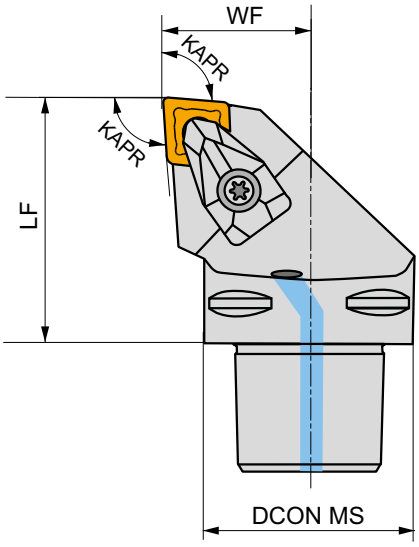
D

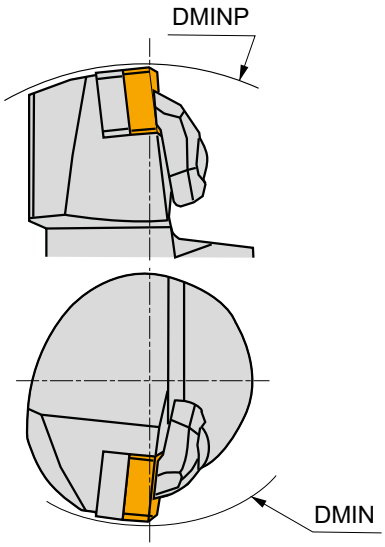


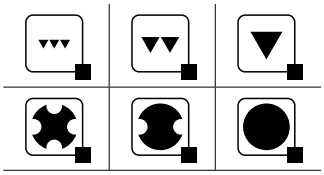
## Eksternt PSC hurtig skift værktøj, dobbelt klemme, 95 ° skærevinkel, CN .. Skær

Eksternt højre / venstre dobbeltklemmeværktøj, indvendig kølemiddel, med 95° skærevinkel til langsgående drejning, affasning og endedrejning med skulder ved hjælp af negative CN .. 12 op til 19 størrelse skær. Fås med PSC (Polygon Shank Coupling) C3 op til C8. Krop behandlet for længere levetid







| | 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 | ✓ | 0.48 | 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)

P M K

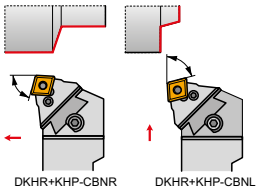
PRAMET

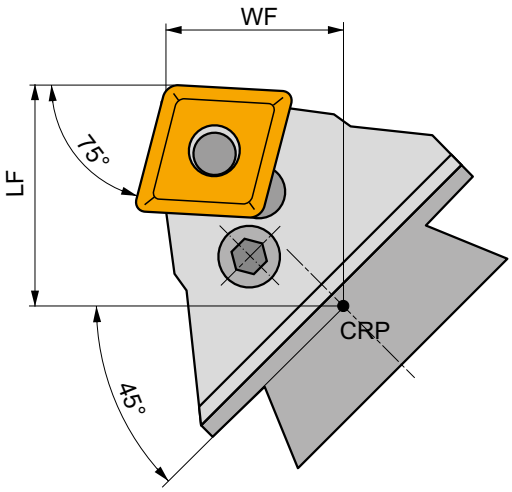
P

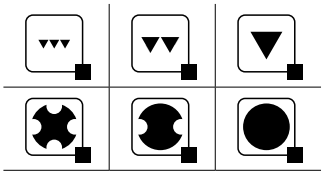


## Modulær KHP drejeholder, 75 ° skærevinkel til CN .. Skær

Drejeholder højre / venstre håndlås drejepatron, 75 ° skærevinkel, til montering på DKH værktøjsholderskaft. Velegnet til kraftig langsgående drejning uden hjørne, plandrejning, konisk drejning med fasning med negativ CN .. 25 skær. Værktøjsholder behandlet for længere værktøjslevetid.





| | 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 Nm | M 10x1 | 33 | NT 08 | MT 08 | HXK 5 |

# KHP-CLN(RL)

P M K

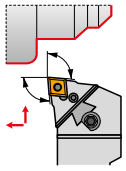
PRAMET

P

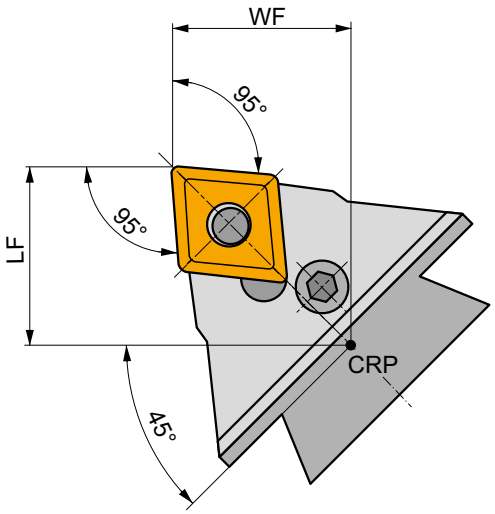


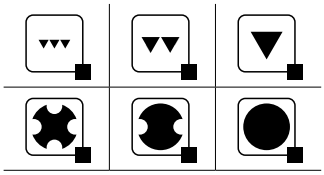
## Modulær KHP drejeholder, )5 ° skærevinkel til CN .. Skær

Drejeholder højre / venstre håndlås, drejepatron, 95 ° skærevinkel, til montering på DKH værktøjsholderskaft. Velegnet til kraftig langsgående drejning med hjørne, plandrejning med hjørne, tilspidsning og affasning med negativ CN .. 19 eller 25 skær. Værktøjsholder behandlet for længere værktøjslevetid.



DKHR+KHP-CLNR





| | Product | WF (mm) | LF (mm) | LAMS (°) | GAMO (°) | kg | | |
|---|---|---|---|---|---|---|---|---|
| R | **KHP-CLNR 19** | 35 | 45 | -6 | -6 | 1.30 | 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 |

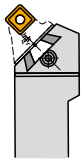
# DKH(RL)

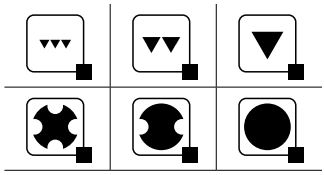
PRAMET

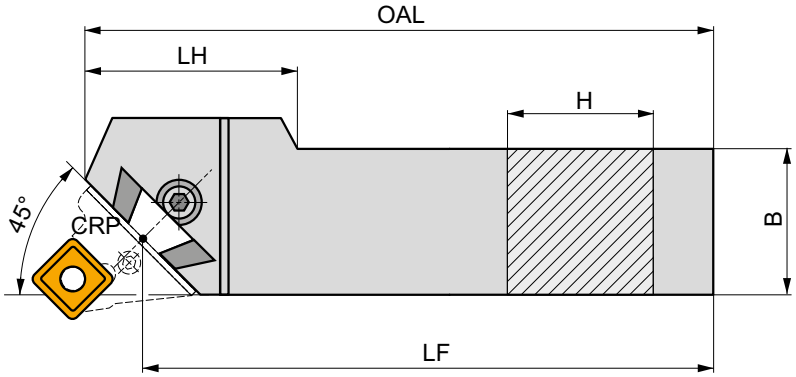


## Eksternt værktøjsholderskaft til KHP / KHS tung drejening

Drejeholder højre / venstre modulære værktøjsskaft til KHP / KHS patroner. Velegnet til tunge drejeprogrammer. Fås med skaftstørrelse 40x50 op til 60x80 mm. Krop behandlet for længere levetid








| | Product | H (mm) | B (mm) | LF (mm) | OAL (mm) | LH (mm) | kg | | |
|---|---|---|---|---|---|---|---|---|---|
| R | **DKHR 4050 V** | 40 | 50 | 400 | 425 | 100 | 7.10 | GI098 | DKH10 |
| | **DKHR 5060 W** | 50 | 60 | 450 | 475 | 110 | 11.30 | GI098 | DKH10 |
| | **DKHR 6080 W-A** | 60 | 80 | 450 | 485 | 90 | 19.65 | GI098 | DKH10 |
| L | **DKHL 4050 V** | 40 | 50 | 400 | 425 | 100 | 7.10 | GI098 | DKH10 |
| | **DKHL 5060 W** | 50 | 60 | 450 | 475 | 110 | 11.30 | GI098 | DKH10 |
| | **DKHL 6080 W-A** | 60 | 80 | 450 | 485 | 90 | 19.28 | GI098 | DKH10 |

| | | |
|---|---|---|
| GI098 | KHP | KHS |

| | | |
|---|---|---|
| DKH10 | SR 14 | HXK 10 |

# DCLN(RL) INT

P M K N S H

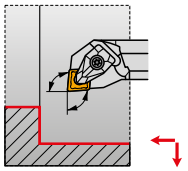
PRAMET

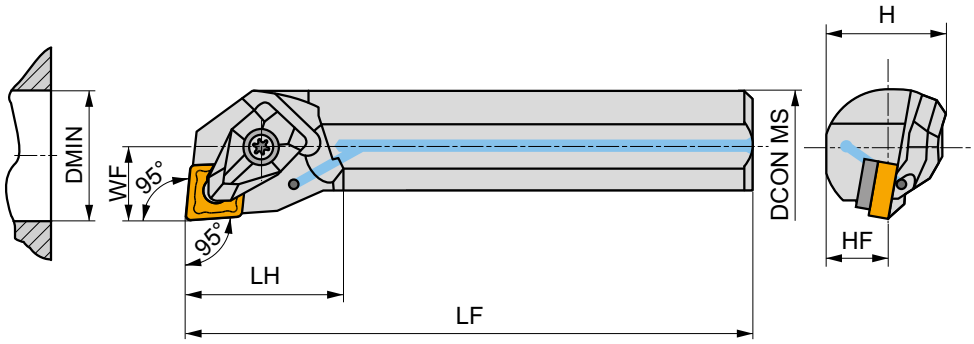
D

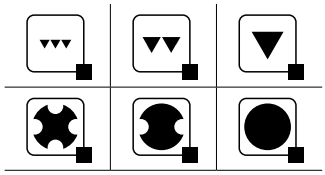


## Intern dobbeltklemmeholder med 95 ° skærevinkel til CN .. Skær

Intern højre- / venstrehånds dobbeltspændeboring, indvendig kølevæske, 95° skærevinkel til CN .. 09 og 12 skær. Mindste indvendige drejediameter Ø32 mm. Til indvendig konisk og langsgående drejning med drejning af skulder og affasning. Fås med skaftstørrelse Ø25 op til Ø40 mm. Krop behandlet for længere levetid på værktøjet.







| | 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 | -11 | -6 | ✓ | 1.13 | GI133 | DC09 |
| | **A25T-DCLNR 12** | 25 | 32 | 17 | 23 | 11.5 | 300 | 31 | -12 | -6 | ✓ | 1.12 | GI043 | DCI12 |
| | **A32T-DCLNR 12** | 32 | 40 | 22 | 30 | 15 | 300 | 30 | -10 | -6 | ✓ | 1.68 | GI043 | DCI12 |
| | **A40T-DCLNR 12** | 40 | 50 | 27 | 37 | 18.5 | 300 | 32 | -15 | -6 | ✓ | 2.56 | GI043 | DC12 |
| L | **A25T-DCLNL 09** | 25 | 32 | 17 | 23 | 11.5 | 300 | 31 | -11 | -6 | ✓ | 1.12 | GI133 | DC09 |
| | **A25T-DCLNL 12** | 25 | 32 | 17 | 23 | 11.5 | 300 | 31 | -12 | -6 | ✓ | 1.11 | GI043 | DCI12 |
| | **A32T-DCLNL 12** | 32 | 40 | 22 | 30 | 15 | 300 | 30 | -10 | -6 | ✓ | 1.68 | GI043 | DCI12 |
| | **A40T-DCLNL 12** | 40 | 50 | 27 | 37 | 18.5 | 300 | 32 | -15 | -6 | ✓ | 2.56 | 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

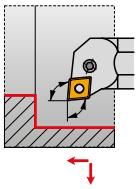
PRAMET

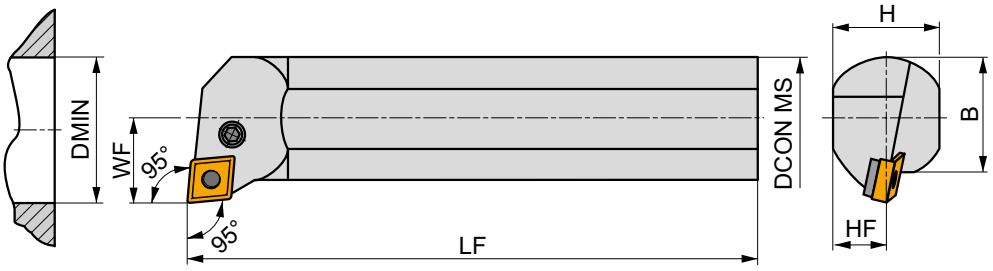
P

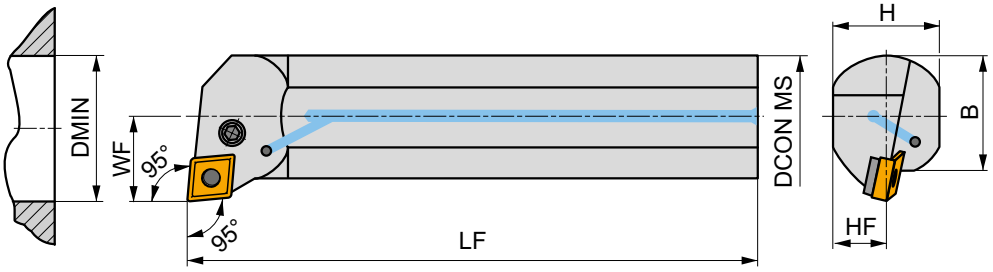


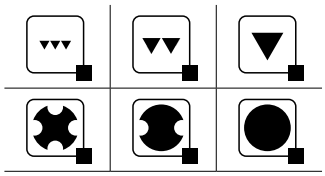
## Intern låseholder med 95 ° skærevinkel til CN .. Skær

Intern højre / venstre hånd borestang, indvendig kølemiddel, 95° skærevinkel til CN .. 09, 12, 16 og 19 skær. Mindste indvendige drejediameter Ø20 mm. Til indvendig konisk og langsgående drejning med drejning af skulder og affasning. Ø16 til Ø60 mm skaft til rådighed. Krop behandlet for længere levetid på værktøjet.







| | 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 | 15 | 150 | -13.5 | -5 | ✓ | 0.22 | GI133 | PC09 |
| | A20Q-PCLNR 09 | 20 | 25 | 13 | 18 | 18 | 180 | -13.5 | -5 | ✓ | 0.36 | GI133 | PC09 |
| | A25R-PCLNR 12 | 25 | 32 | 17 | 23 | 23 | 200 | -13 | -7 | ✓ | 0.65 | GI043 | PC25 |
| | S25T-PCLNR 12 | 25 | 32 | 17 | 23 | 23 | 300 | -13 | -7 | – | 1.10 | GI043 | PC25 |
| | A32S-PCLNR 12 | 32 | 40 | 22 | 30 | 30 | 250 | -12 | -6 | ✓ | 1.48 | GI043 | PC21 |
| | A40T-PCLNR 12 | 40 | 50 | 27 | 38 | 38 | 300 | -12 | -6 | ✓ | 2.40 | GI043 | PC20 |
| | A40T-PCLNR 16 | 40 | 50 | 27 | 38 | 38 | 300 | -12 | -6 | ✓ | 2.90 | GI050 | PC41 |
| | A50U-PCLNR 16 | 50 | 63 | 35 | 47 | 48.5 | 350 | -12 | -6 | ✓ | 5.20 | GI050 | PC40 |
| | A60V-PCLNR 16 | 60 | 80 | 43 | 57 | 58.5 | 400 | -12 | -6 | ✓ | 8.70 | GI050 | PC40 |
| | A50U-PCLNR 19 | 50 | 63 | 35 | 47 | 48.5 | 350 | -12 | -6 | ✓ | 5.20 | GI042 | PC50 |
| | A60V-PCLNR 19 | 60 | 80 | 43 | 57 | 58.5 | 400 | -12 | -6 | ✓ | 8.22 | GI042 | PC50 |
| L | A16M-PCLNL 09 | 16 | 20 | 11 | 15 | 15 | 150 | -13.5 | -5 | ✓ | 0.20 | GI133 | PC09 |
| | A20Q-PCLNL 09 | 20 | 25 | 13 | 18 | 18 | 180 | -13.5 | -5 | ✓ | 0.34 | GI133 | PC09 |
| | A25R-PCLNL 12 | 25 | 32 | 17 | 23 | 23 | 200 | -13 | -7 | ✓ | 0.65 | GI043 | PC25 |
| | S25T-PCLNL 12 | 25 | 32 | 17 | 23 | 23 | 300 | -13 | -7 | – | 1.15 | GI043 | PC25 |
| | A32S-PCLNL 12 | 32 | 40 | 22 | 30 | 30 | 250 | -12 | -6 | ✓ | 1.48 | GI043 | PC21 |
| | A40T-PCLNL 12 | 40 | 50 | 27 | 38 | 38 | 300 | -12 | -6 | ✓ | 2.58 | GI043 | PC20 |
| | A40T-PCLNL 16 | 40 | 50 | 27 | 38 | 38 | 300 | -12 | -6 | ✓ | 2.58 | GI050 | PC41 |
| | A50U-PCLNL 16 | 50 | 63 | 35 | 47 | 48.5 | 350 | -12 | -6 | ✓ | 4.95 | GI050 | PC40 |
| | A60V-PCLNL 16 | 60 | 80 | 43 | 57 | 58.5 | 400 | -12 | -6 | ✓ | 8.70 | GI050 | PC40 |
| | A50U-PCLNL 19 | 50 | 63 | 35 | 47 | 48.5 | 350 | -12 | -6 | ✓ | 5.20 | GI042 | PC50 |
| | A60V-PCLNL 19 | 60 | 80 | 43 | 57 | 58.5 | 400 | -12 | -6 | ✓ | 8.40 | GI042 | PC50 |

| | |
|---|---|
| GI042 | CN.. 1906.. |
| GI043 | CN.. 1204.. |

| | |
|---|---|
| GI050 | CN.. 1606.. |
| GI133 | CN.. 0903.. |

| | | | | Nm | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| PC09 | – | PU 8451 | PS 8290 | 2.0 | M 5 | 12 | – | – | HXK 2 |
| PC20 | CNU 120312 | PU 02 | US 35 | 6.0 | M 8x1 | 22.5 | NT 05 | MT 05 | HXK 4 |
| PC21 | CNU 120312 | PU 02 | US 41 | 6.0 | M 8x1 | 17 | NT 05 | MT 05 | HXK 4 |
| PC25 | – | PU 32 | US 46 | 5.0 | M 6x0.75 | 13.2 | – | – | HXK 3 |
| PC40 | CNU 150312 | PU 04 | US 36 | 6.0 | M 8x1 | 26 | NT 07 | MT 07 | HXK 4 |
| PC41 | CNU 150312 | PU 04 | US 40 | 6.0 | M 8x1 | 20.5 | NT 07 | MT 07 | HXK 4 |
| PC50 | CNU 190416 | PU 05 | US 38 | 8.0 | M 10x1 | 29 | NT 06 | MT 06 | HXK 5 |

NEW

# C.-DCLN(RL) INT

P M K N S H

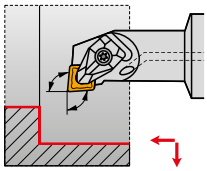
PRAMET

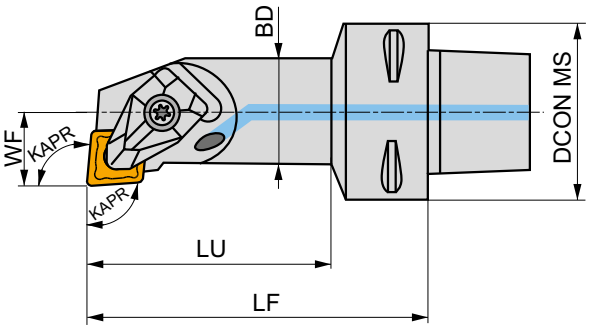
D

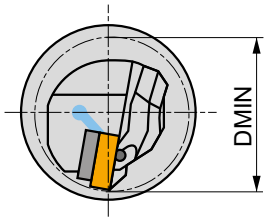


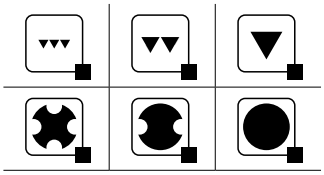
## Internt PSC Hurtig skift Værktøj, dobbelt klemme, 95 ° skærevinkel, CN .. Skær

Internt højre / venstre dobbeltklemmeværktøj, indvendig kølevæske, med 95° skærevinkel til negativ CN .. 09 op til 16 skær, velegnet til en bred vifte af indvendige drejeanvendelser, mindste diameter Ø25mm. PSC-skaft (Polygon Shank Coupling) størrelse C4 op til C6 med valg af længder. Krop behandlet for længere levetid på værktøjet.







| | 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 |
| | **C4-DCLNR-17090-12** | 40 | 32 | 17 | 90 | 68 | 25 | 95 | -12 | -6 | ✓ | 0.53 | GI043 | DCI12 |
| | **C5-DCLNR-17090-12** | 50 | 32 | 17 | 90 | 66 | 25 | 95 | -12 | -6 | ✓ | 0.72 | GI043 | DCI12 |
| | **C6-DCLNR-17100-12** | 63 | 32 | 17 | 100 | 72 | 25 | 95 | -12 | -6 | ✓ | 1.15 | GI043 | DCI12 |
| | **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 |
| | **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 | – |

# DN

11/ 15

## CARBIDE INSERTS

### DNMA



260

### DNMG



260

### DNMM



270

## CER AND CBN INSERTS

### DNGA CER



271

### DNGN CER



271

### DNGA CBN



272

| MATCH THE RIGHT SIZE (example) | |
|---|---|
| **Insert** | **Tool Holder** |
| DNMG 150404E-SF | DDJNL 2020 K 15 |

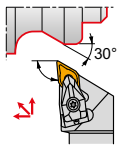
## ISO-DREJNING – UDVENDIGT

### DDJN(RL) EXT

93°

DN..

11
15




20×20
32×32

273

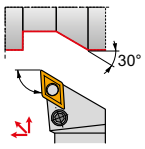
260 – 272

### PDJN(RL) EXT

93°

DN..

11
15




20×20
32×32

274

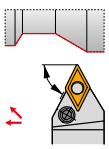
260 – 272

### PDNN(RL) EXT

62°30´

DN..

11
15



20×20
32×25

275

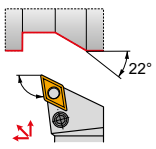
260 – 272

### PDXN(RL) EXT

98°

DN..

15




20×20
32×25

276

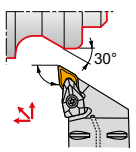
260 – 272

### C.-DDJN(RL) EXT NEW

93°

DN..

11
15




C4
C6

277

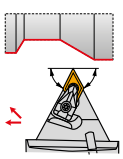
260 – 272

### C.-DDNNN EXT NEW

62,5°

DN..

15



C5
C6

278

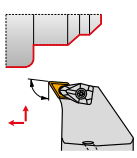
260 – 272

### C.-DDUN(RL) EXT NEW

93°

DN..

15



C5
C6

279

260 – 272

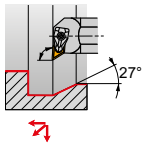
# DN



## ISO-DREJNING – INDVENDIG

### DDUN(RL) INT

93°







25 / 50

280

DN..

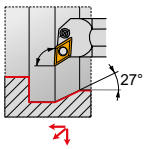


11
15

260 – 272

### PDUN(RL) INT

93°







25 / 60

281

DN..

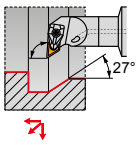


11
15

260 – 272

### C.-DDUN(RL) INT NEW

93°







12

282

DN..



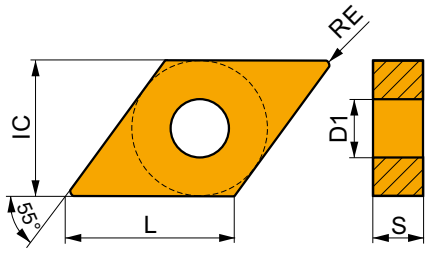
11

260 – 272

# DNMA

PRAMET

| | 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 |



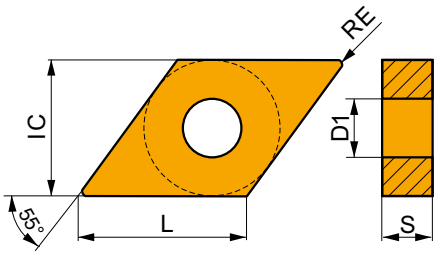

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | E | | | | | | | | | | | | | | | | | |
| | | | Til fin til halv grov bearbejdning og kontinuerlig til let afbrudt snit. | | | | | | | | | | | | | | | | | |
| **DNMA 150404** | **T5305** | 0.4 | – | – | – | – | – | – | 205 | 0.10 | 1.7 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| **DNMA 150408** | **T5305** | 0.8 | – | – | – | – | – | – | 190 | 0.20 | 1.7 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| | **T5315** | 0.8 | – | – | – | – | – | – | 165 | 0.20 | 1.7 | – | – | – | – | – | – | 35 | 0.15 | 1.0 |
| **DNMA 150604** | **T5305** | 0.4 | – | – | – | – | – | – | 205 | 0.10 | 1.7 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| | **T5315** | 0.4 | – | – | – | – | – | – | 180 | 0.10 | 1.7 | – | – | – | – | – | – | 35 | 0.15 | 1.0 |
| | **T6310** | 0.4 | – | – | – | – | – | – | 85 | 0.10 | 1.7 | – | – | – | – | – | – | 20 | 0.15 | 1.0 |
| **DNMA 150608** | **T5305** | 0.8 | – | – | – | – | – | – | 190 | 0.20 | 1.7 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| | **T5315** | 0.8 | – | – | – | – | – | – | 165 | 0.20 | 1.7 | – | – | – | – | – | – | 35 | 0.15 | 1.0 |
| | **T6310** | 0.8 | – | – | – | – | – | – | 85 | 0.20 | 1.7 | – | – | – | – | – | – | 20 | 0.15 | 1.0 |
| **DNMA 150612** | **T5305** | 1.2 | – | – | – | – | – | – | 200 | 0.20 | 1.7 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| | **T5315** | 1.2 | – | – | – | – | – | – | 175 | 0.20 | 1.7 | – | – | – | – | – | – | 35 | 0.15 | 1.0 |

# DNMG

PRAMET

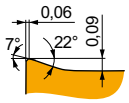
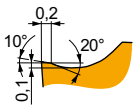
| | IC (mm) | D1 (mm) | L (mm) | S (mm) |
|---|---|---|---|---|
| 1104 | 9.525 | 3.81 | 11.60 | 4.76 |
| 1504 | 12.700 | 5.16 | 15.50 | 4.76 |
| 1506 | 12.700 | 5.16 | 15.50 | 6.35 |



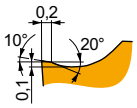

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | U S | | | | | | | | | | | | | | | | | |
| | | | FF-geometri med meget positivt design til finbearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | |
| **DNMG 110402E-FF** | **T8315** | 0.2 | 175 | 0.10 | 0.8 | 105 | 0.09 | 0.8 | 165 | 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 | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.4 | 165 | 0.12 | 0.8 | 95 | 0.11 | 0.8 | 155 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **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 | – | – | – | – | – | – | – | – | – |

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |   | | U S | | | | | | | | | | | | | | | | | |
| FF-geometri med meget positivt design til finbearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | | | | |
| **DNMG 150404E-FF** | **T8315** | 0.4 | ◪ 175 | 0.12 | 1.0 | ■ 105 | 0.11 | 1.0 | ◪ 165 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| **DNMG 150604E-FF** | **T7325** | 0.4 | ◪ 190 | 0.12 | 1.0 | ■ 145 | 0.11 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.4 | ◪ 175 | 0.12 | 1.0 | ■ 105 | 0.11 | 1.0 | ◪ 165 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| **DNMG 150608E-FF** | **T7325** | 0.8 | ◪ 210 | 0.15 | 1.0 | ■ 160 | 0.14 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.8 | ◪ 195 | 0.15 | 1.0 | ■ 115 | 0.14 | 1.0 | ◪ 185 | 0.15 | 1.0 | – | – | – | – | – | – | – | – | – |
|  |   | | 1 S | | | | | | | | | | | | | | | | | |
| FM-geometri med positivt design til fin til halvgrov bearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | | | | |
| **DNMG 110404E-FM** | **T7325** | 0.4 | ◪ 165 | 0.20 | 0.8 | ◪ 125 | 0.18 | 0.8 | – | – | – | – | – | – | ◪ 50 | 0.20 | 0.6 | – | – | – |
| | **T8315** | 0.4 | ◪ 150 | 0.20 | 0.8 | ◪ 90 | 0.18 | 0.8 | ■ 140 | 0.20 | 0.8 | – | – | – | ◪ 35 | 0.14 | 0.6 | – | – | – |
| | **T8330** | 0.4 | ■ 145 | 0.20 | 0.8 | ◪ 85 | 0.18 | 0.8 | ■ 135 | 0.20 | 0.8 | – | – | – | ◪ 35 | 0.14 | 0.6 | – | – | – |
| | **T8430** | 0.4 | ■ 165 | 0.20 | 0.8 | ◪ 90 | 0.18 | 0.8 | ◪ 135 | 0.20 | 0.8 | – | – | – | ◪ 35 | 0.14 | 0.6 | – | – | – |
| | **T9310** | 0.4 | ■ 245 | 0.20 | 0.8 | – | – | – | ◪ 230 | 0.20 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.4 | ■ 225 | 0.20 | 0.8 | – | – | – | ◪ 210 | 0.20 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | ■ 200 | 0.20 | 0.8 | ◪ 120 | 0.18 | 0.8 | ◪ 190 | 0.20 | 0.8 | – | – | – | ◪ 45 | 0.20 | 0.6 | – | – | – |
| **DNMG 110408E-FM** | **T7325** | 0.8 | ◪ 200 | 0.20 | 0.8 | ◪ 155 | 0.18 | 0.8 | – | – | – | – | – | – | ◪ 65 | 0.16 | 0.6 | – | – | – |
| | **T8315** | 0.8 | ◪ 180 | 0.20 | 0.8 | ◪ 105 | 0.18 | 0.8 | ■ 170 | 0.20 | 0.8 | – | – | – | ◪ 45 | 0.14 | 0.6 | – | – | – |
| | **T8330** | 0.8 | ■ 175 | 0.20 | 0.8 | ◪ 105 | 0.18 | 0.8 | ■ 165 | 0.20 | 0.8 | – | – | – | ◪ 40 | 0.14 | 0.6 | – | – | – |
| | **T8430** | 0.8 | ■ 195 | 0.20 | 0.8 | ◪ 105 | 0.18 | 0.8 | ◪ 160 | 0.20 | 0.8 | – | – | – | ◪ 40 | 0.14 | 0.6 | – | – | – |
| | **T9310** | 0.8 | ■ 295 | 0.20 | 0.8 | – | – | – | ◪ 280 | 0.20 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.8 | ■ 270 | 0.20 | 0.8 | – | – | – | ◪ 255 | 0.20 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | ■ 240 | 0.20 | 0.8 | ◪ 140 | 0.18 | 0.8 | ◪ 225 | 0.20 | 0.8 | – | – | – | ◪ 50 | 0.16 | 0.6 | – | – | – |
| **DNMG 150404E-FM** | **T7325** | 0.4 | ◪ 150 | 0.20 | 1.7 | ◪ 115 | 0.18 | 1.7 | – | – | – | – | – | – | ◪ 45 | 0.20 | 1.4 | – | – | – |
| | **T8330** | 0.4 | ■ 135 | 0.20 | 1.7 | ◪ 80 | 0.18 | 1.7 | ■ 125 | 0.20 | 1.7 | – | – | – | ◪ 30 | 0.14 | 1.4 | – | – | – |
| | **T8430** | 0.4 | ■ 150 | 0.20 | 1.7 | ◪ 80 | 0.18 | 1.7 | ◪ 125 | 0.20 | 1.7 | – | – | – | ◪ 30 | 0.14 | 1.4 | – | – | – |
| | **T9315** | 0.4 | ■ 210 | 0.20 | 1.7 | – | – | – | ◪ 195 | 0.20 | 1.7 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | ■ 190 | 0.20 | 1.7 | ◪ 110 | 0.18 | 1.7 | ◪ 180 | 0.20 | 1.7 | – | – | – | ◪ 40 | 0.20 | 1.4 | – | – | – |
| **DNMG 150408E-FM** | **T7325** | 0.8 | ◪ 180 | 0.20 | 1.7 | ◪ 140 | 0.18 | 1.7 | – | – | – | – | – | – | ◪ 55 | 0.16 | 1.4 | – | – | – |
| | **T8330** | 0.8 | ■ 160 | 0.20 | 1.7 | ◪ 95 | 0.18 | 1.7 | ■ 150 | 0.20 | 1.7 | – | – | – | ◪ 40 | 0.16 | 1.4 | – | – | – |
| | **T8430** | 0.8 | ■ 185 | 0.20 | 1.7 | ◪ 100 | 0.18 | 1.7 | ◪ 150 | 0.20 | 1.7 | – | – | – | ◪ 40 | 0.16 | 1.4 | – | – | – |
| | **T9315** | 0.8 | ■ 250 | 0.20 | 1.7 | – | – | – | ◪ 235 | 0.20 | 1.7 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | ■ 225 | 0.20 | 1.7 | ◪ 135 | 0.18 | 1.7 | ◪ 210 | 0.20 | 1.7 | – | – | – | ◪ 50 | 0.16 | 1.4 | – | – | – |
| **DNMG 150604E-FM** | **T7325** | 0.4 | ◪ 150 | 0.20 | 1.7 | ◪ 115 | 0.18 | 1.7 | – | – | – | – | – | – | ◪ 45 | 0.20 | 1.4 | – | – | – |
| | **T7335** | 0.4 | ◪ 150 | 0.20 | 1.7 | ◪ 115 | 0.18 | 1.7 | – | – | – | – | – | – | ◪ 45 | 0.20 | 1.4 | – | – | – |
| | **T8315** | 0.4 | ◪ 140 | 0.20 | 1.7 | ◪ 80 | 0.18 | 1.7 | ■ 130 | 0.20 | 1.7 | – | – | – | ◪ 35 | 0.14 | 1.4 | – | – | – |
| | **T8330** | 0.4 | ■ 135 | 0.20 | 1.7 | ◪ 80 | 0.18 | 1.7 | ■ 125 | 0.20 | 1.7 | – | – | – | ◪ 30 | 0.14 | 1.4 | – | – | – |
| | **T8430** | 0.4 | ■ 150 | 0.20 | 1.7 | ◪ 80 | 0.18 | 1.7 | ◪ 125 | 0.20 | 1.7 | – | – | – | ◪ 30 | 0.14 | 1.4 | – | – | – |
| | **T9310** | 0.4 | ■ 230 | 0.20 | 1.7 | – | – | – | ◪ 215 | 0.20 | 1.7 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.4 | ■ 210 | 0.20 | 1.7 | – | – | – | ◪ 195 | 0.20 | 1.7 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | ■ 190 | 0.20 | 1.7 | ◪ 110 | 0.18 | 1.7 | ◪ 180 | 0.20 | 1.7 | – | – | – | ◪ 40 | 0.20 | 1.4 | – | – | – |
| | **TT310** | 0.4 | ■ 210 | 0.20 | 1.7 | ◪ 125 | 0.18 | 1.7 | – | – | – | – | – | – | – | – | – | – | – | – |
| **DNMG 150608E-FM** | **T7325** | 0.8 | ◪ 180 | 0.20 | 1.7 | ◪ 140 | 0.18 | 1.7 | – | – | – | – | – | – | ◪ 55 | 0.16 | 1.4 | – | – | – |
| | **T7335** | 0.8 | ◪ 175 | 0.20 | 1.7 | ◪ 135 | 0.18 | 1.7 | – | – | – | – | – | – | ◪ 55 | 0.16 | 1.4 | – | – | – |
| | **T8315** | 0.8 | ◪ 170 | 0.20 | 1.7 | ◪ 100 | 0.18 | 1.7 | ■ 160 | 0.20 | 1.7 | – | – | – | ◪ 40 | 0.16 | 1.4 | – | – | – |
| | **T8330** | 0.8 | ■ 160 | 0.20 | 1.7 | ◪ 95 | 0.18 | 1.7 | ■ 150 | 0.20 | 1.7 | – | – | – | ◪ 40 | 0.16 | 1.4 | – | – | – |
| | **T8430** | 0.8 | ■ 185 | 0.20 | 1.7 | ◪ 100 | 0.18 | 1.7 | ◪ 150 | 0.20 | 1.7 | – | – | – | ◪ 40 | 0.16 | 1.4 | – | – | – |
| | **T9310** | 0.8 | ■ 275 | 0.20 | 1.7 | – | – | – | ◪ 260 | 0.20 | 1.7 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.8 | ■ 250 | 0.20 | 1.7 | – | – | – | ◪ 235 | 0.20 | 1.7 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | ■ 225 | 0.20 | 1.7 | ◪ 135 | 0.18 | 1.7 | ◪ 210 | 0.20 | 1.7 | – | – | – | ◪ 50 | 0.16 | 1.4 | – | – | – |
| | **TT310** | 0.8 | ■ 250 | 0.20 | 1.7 | ◪ 150 | 0.18 | 1.7 | – | – | – | – | – | – | – | – | – | – | – | – |
| **DNMG 150612E-FM** | **T7325** | 1.2 | ◪ 180 | 0.25 | 1.7 | ◪ 140 | 0.23 | 1.7 | – | – | – | – | – | – | ◪ 55 | 0.18 | 1.4 | – | – | – |
| | **T8430** | 1.2 | ■ 175 | 0.25 | 1.7 | ◪ 95 | 0.23 | 1.7 | ◪ 140 | 0.25 | 1.7 | – | – | – | ◪ 35 | 0.18 | 1.4 | – | – | – |
| | **T9310** | 1.2 | ■ 260 | 0.25 | 1.7 | – | – | – | ◪ 245 | 0.25 | 1.7 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 1.2 | ■ 240 | 0.25 | 1.7 | – | – | – | ◪ 225 | 0.25 | 1.7 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | ■ 215 | 0.25 | 1.7 | ◪ 125 | 0.23 | 1.7 | ◪ 200 | 0.25 | 1.7 | – | – | – | ◪ 45 | 0.18 | 1.4 | – | – | – |

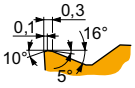
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |  | | | | | | | | | | | | | | | | | | | |

FM-geometri med positivt design til fin til halvgrov bearbejdning og kontinuerlige til let afbrudte snit.

| | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **DNMG 150616E-FM** | **T9315** | 1.6 | ■ 235 | 0.30 | 1.7 | – | – | – | ◪ 220 | 0.30 | 1.7 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.6 | ■ 210 | 0.30 | 1.7 | ◪ 125 | 0.27 | 1.7 | ◪ 195 | 0.30 | 1.7 | – | – | – | ◪ 45 | 0.21 | 1.4 | – | – | – |

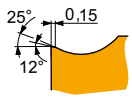




M-geometri til fin til halv grov bearbejdning og kontinuerlig til afbrudt snit.

| | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **DNMG 110404E-M** | **T5315** | 0.4 | ◪ 210 | 0.20 | 1.2 | – | – | – | ■ 195 | 0.20 | 1.2 | – | – | – | – | – | – | ◪ 40 | 0.15 | 1.0 |
| | **T9315** | 0.4 | ■ 195 | 0.20 | 1.2 | – | – | – | ◪ 185 | 0.20 | 1.2 | – | – | – | – | – | – | ◪ 35 | 0.15 | 1.0 |
| | **T9325** | 0.4 | ■ 175 | 0.20 | 1.2 | – | – | – | ◪ 165 | 0.20 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.4 | ■ 150 | 0.20 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **DNMG 110408E-M** | **T5315** | 0.8 | ◪ 215 | 0.30 | 1.2 | – | – | – | ■ 200 | 0.30 | 1.2 | – | – | – | – | – | – | ◪ 40 | 0.15 | 1.0 |
| | **T9315** | 0.8 | ■ 200 | 0.30 | 1.2 | – | – | – | ◪ 190 | 0.30 | 1.2 | – | – | – | – | – | – | ◪ 40 | 0.15 | 1.0 |
| | **T9325** | 0.8 | ■ 175 | 0.30 | 1.2 | – | – | – | ◪ 165 | 0.30 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.8 | ■ 155 | 0.30 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **DNMG 110412E-M** | **T9315** | 1.2 | ■ 185 | 0.40 | 1.2 | – | – | – | ◪ 175 | 0.40 | 1.2 | – | – | – | – | – | – | ◪ 35 | 0.15 | 1.0 |
| | **T9325** | 1.2 | ■ 165 | 0.40 | 1.2 | – | – | – | ◪ 155 | 0.40 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.2 | ■ 140 | 0.40 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **DNMG 150404E-M** | **T5315** | 0.4 | ◪ 200 | 0.20 | 1.9 | – | – | – | ■ 190 | 0.20 | 1.9 | – | – | – | – | – | – | ◪ 40 | 0.15 | 1.0 |
| | **T9315** | 0.4 | ■ 190 | 0.20 | 1.9 | – | – | – | ◪ 180 | 0.20 | 1.9 | – | – | – | – | – | – | ◪ 35 | 0.15 | 1.0 |
| | **T9325** | 0.4 | ■ 170 | 0.20 | 1.9 | – | – | – | ◪ 160 | 0.20 | 1.9 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.4 | ■ 145 | 0.20 | 1.9 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **DNMG 150408E-M** | **T5315** | 0.8 | ◪ 205 | 0.30 | 1.9 | – | – | – | ■ 190 | 0.30 | 1.9 | – | – | – | – | – | – | ◪ 40 | 0.15 | 1.0 |
| | **T9315** | 0.8 | ■ 190 | 0.30 | 1.9 | – | – | – | ◪ 180 | 0.30 | 1.9 | – | – | – | – | – | – | ◪ 35 | 0.15 | 1.0 |
| | **T9325** | 0.8 | ■ 170 | 0.30 | 1.9 | – | – | – | ◪ 160 | 0.30 | 1.9 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.8 | ■ 145 | 0.30 | 1.9 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **DNMG 150412E-M** | **T5315** | 1.2 | ◪ 200 | 0.40 | 1.9 | – | – | – | ■ 190 | 0.40 | 1.9 | – | – | – | – | – | – | ◪ 40 | 0.15 | 1.0 |
| | **T9315** | 1.2 | ■ 175 | 0.40 | 1.9 | – | – | – | ◪ 165 | 0.40 | 1.9 | – | – | – | – | – | – | ◪ 35 | 0.15 | 1.0 |
| | **T9325** | 1.2 | ■ 160 | 0.40 | 1.9 | – | – | – | ◪ 150 | 0.40 | 1.9 | – | – | – | – | – | – | – | – | – |
| **DNMG 150604E-M** | **T5315** | 0.4 | ◪ 200 | 0.20 | 1.9 | – | – | – | ■ 190 | 0.20 | 1.9 | – | – | – | – | – | – | ◪ 40 | 0.15 | 1.0 |
| | **T9315** | 0.4 | ■ 190 | 0.20 | 1.9 | – | – | – | ◪ 180 | 0.20 | 1.9 | – | – | – | – | – | – | ◪ 35 | 0.15 | 1.0 |
| | **T9325** | 0.4 | ■ 170 | 0.20 | 1.9 | – | – | – | ◪ 160 | 0.20 | 1.9 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.4 | ■ 145 | 0.20 | 1.9 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **DNMG 150608E-M** | **T5315** | 0.8 | ◪ 205 | 0.30 | 1.9 | – | – | – | ■ 190 | 0.30 | 1.9 | – | – | – | – | – | – | ◪ 40 | 0.15 | 1.0 |
| | **T9310** | 0.8 | ■ 205 | 0.30 | 1.9 | – | – | – | ◪ 190 | 0.30 | 1.9 | – | – | – | – | – | – | ◪ 40 | 0.15 | 1.0 |
| | **T9315** | 0.8 | ■ 190 | 0.30 | 1.9 | – | – | – | ◪ 180 | 0.30 | 1.9 | – | – | – | – | – | – | ◪ 35 | 0.15 | 1.0 |
| | **T9325** | 0.8 | ■ 170 | 0.30 | 1.9 | – | – | – | ◪ 160 | 0.30 | 1.9 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.8 | ■ 145 | 0.30 | 1.9 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **DNMG 150612E-M** | **T5315** | 1.2 | ◪ 200 | 0.40 | 1.9 | – | – | – | ■ 190 | 0.40 | 1.9 | – | – | – | – | – | – | ◪ 40 | 0.15 | 1.0 |
| | **T9310** | 1.2 | ■ 190 | 0.40 | 1.9 | – | – | – | ◪ 180 | 0.40 | 1.9 | – | – | – | – | – | – | ◪ 35 | 0.15 | 1.0 |
| | **T9315** | 1.2 | ■ 175 | 0.40 | 1.9 | – | – | – | ◪ 165 | 0.40 | 1.9 | – | – | – | – | – | – | ◪ 35 | 0.15 | 1.0 |
| | **T9325** | 1.2 | ■ 160 | 0.40 | 1.9 | – | – | – | ◪ 150 | 0.40 | 1.9 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.2 | ■ 140 | 0.40 | 1.9 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |

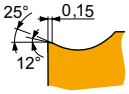
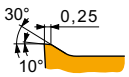




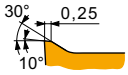
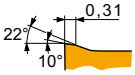
NF-geometri med meget positivt design til finbearbejdning til medium bearbejdning og kontinuerlige snit.

| | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **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 | – | – | – |
| | **T7325** | 0.4 | ◪ 170 | 0.18 | 0.8 | ■ 130 | 0.16 | 0.8 | – | – | – | – | – | – | ◪ 55 | 0.16 | 0.6 | – | – | – |
| | **T7335** | 0.4 | ◪ 165 | 0.18 | 0.8 | ■ 125 | 0.16 | 0.8 | – | – | – | – | – | – | ◪ 50 | 0.16 | 0.6 | – | – | – |
| | **T8330** | 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 | – | – | – |
| | **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 | – | – | – |
| | **T9315** | 0.4 | ■ 255 | 0.15 | 0.8 | – | – | – | ◪ 240 | 0.15 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | ■ 210 | 0.18 | 0.8 | ■ 125 | 0.16 | 0.8 | ◪ 195 | 0.18 | 0.8 | – | – | – | ◪ 45 | 0.16 | 0.6 | – | – | – |

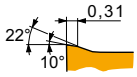
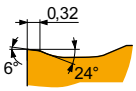
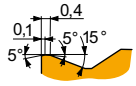
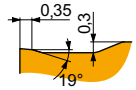
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | NF-geometri med meget positivt design til finbearbejdning til medium bearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | |
| **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 | – | – | – |
| | **T7325** | 0.8 | ◪ 200 | 0.18 | 1.0 | ■ 155 | 0.16 | 1.0 | – | – | – | – | – | – | ◪ 65 | 0.16 | 0.8 | – | – | – |
| | **T7335** | 0.8 | ◪ 195 | 0.18 | 1.0 | ■ 150 | 0.16 | 1.0 | – | – | – | – | – | – | ◪ 60 | 0.16 | 0.8 | – | – | – |
| | **T8330** | 0.8 | ■ 175 | 0.17 | 1.0 | ■ 105 | 0.15 | 1.0 | ◪ 165 | 0.17 | 1.0 | ◪ 525 | 0.20 | 1.0 | ◪ 40 | 0.14 | 0.8 | – | – | – |
| | **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 | – | – | – |
| | **T9315** | 0.8 | ■ 280 | 0.17 | 1.0 | – | – | – | ◪ 265 | 0.17 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | ■ 250 | 0.18 | 1.0 | ■ 150 | 0.16 | 1.0 | ◪ 235 | 0.18 | 1.0 | – | – | – | ◪ 55 | 0.16 | 0.8 | – | – | – |
| **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 | – | – | – |
| | **T7325** | 0.4 | ◪ 160 | 0.18 | 1.7 | ■ 120 | 0.16 | 1.7 | – | – | – | – | – | – | ◪ 50 | 0.16 | 1.4 | – | – | – |
| | **T7335** | 0.4 | ◪ 155 | 0.18 | 1.7 | ■ 120 | 0.16 | 1.7 | – | – | – | – | – | – | ◪ 50 | 0.16 | 1.4 | – | – | – |
| | **T8330** | 0.4 | ■ 140 | 0.17 | 1.7 | ■ 80 | 0.15 | 1.7 | ◪ 130 | 0.17 | 1.7 | ◪ 420 | 0.20 | 1.7 | ◪ 35 | 0.15 | 1.4 | – | – | – |
| | **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 | – | – | – |
| | **T9315** | 0.4 | ■ 235 | 0.15 | 1.7 | – | – | – | ◪ 220 | 0.15 | 1.7 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | ■ 200 | 0.18 | 1.7 | ■ 120 | 0.16 | 1.7 | ◪ 190 | 0.18 | 1.7 | – | – | – | ◪ 45 | 0.16 | 1.4 | – | – | – |
| **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 | – | – | – |
| | **T7325** | 0.8 | ◪ 190 | 0.18 | 1.7 | ■ 145 | 0.16 | 1.7 | – | – | – | – | – | – | ◪ 60 | 0.16 | 1.4 | – | – | – |
| | **T7335** | 0.8 | ◪ 185 | 0.18 | 1.7 | ■ 140 | 0.16 | 1.7 | – | – | – | – | – | – | ◪ 60 | 0.16 | 1.4 | – | – | – |
| | **T8330** | 0.8 | ■ 165 | 0.18 | 1.7 | ■ 95 | 0.16 | 1.7 | ◪ 155 | 0.18 | 1.7 | ◪ 495 | 0.22 | 1.7 | ◪ 40 | 0.16 | 1.4 | – | – | – |
| | **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 | – | – | – |
| | **T9315** | 0.8 | ■ 270 | 0.17 | 1.7 | – | – | – | ◪ 255 | 0.17 | 1.7 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | ■ 235 | 0.18 | 1.7 | ■ 140 | 0.16 | 1.7 | ◪ 220 | 0.18 | 1.7 | – | – | – | ◪ 50 | 0.16 | 1.4 | – | – | – |
| **DNMG 150604E-NF** | **HF7** | 0.4 | – | – | – | ◪ 80 | 0.14 | 1.9 | ◪ 130 | 0.15 | 1.9 | ◪ 420 | 0.18 | 1.9 | – | – | – | – | – | – |
| | **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 | – | – | – |
| | **T7325** | 0.4 | ◪ 155 | 0.18 | 1.9 | ■ 120 | 0.16 | 1.9 | – | – | – | – | – | – | ◪ 50 | 0.16 | 1.5 | – | – | – |
| | **T7335** | 0.4 | ◪ 150 | 0.18 | 1.9 | ■ 115 | 0.16 | 1.9 | – | – | – | – | – | – | ◪ 45 | 0.16 | 1.5 | – | – | – |
| | **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 | – | – | – |
| | **T8330** | 0.4 | ■ 140 | 0.17 | 1.9 | ■ 80 | 0.15 | 1.9 | ◪ 130 | 0.17 | 1.9 | ◪ 420 | 0.20 | 1.9 | ◪ 35 | 0.15 | 1.5 | – | – | – |
| | **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 | – | – | – |
| | **T9315** | 0.4 | ■ 235 | 0.15 | 1.9 | – | – | – | ◪ 220 | 0.15 | 1.9 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | ■ 195 | 0.18 | 1.9 | ■ 115 | 0.16 | 1.9 | ◪ 185 | 0.18 | 1.9 | – | – | – | ◪ 40 | 0.16 | 1.5 | – | – | – |
| **DNMG 150608E-NF** | **HF7** | 0.8 | – | – | – | ◪ 90 | 0.15 | 1.9 | ◪ 145 | 0.17 | 1.9 | ◪ 465 | 0.20 | 1.9 | – | – | – | – | – | – |
| | **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 | – | – | – |
| | **T7325** | 0.8 | ◪ 185 | 0.18 | 1.9 | ■ 140 | 0.16 | 1.9 | – | – | – | – | – | – | ◪ 60 | 0.16 | 1.5 | – | – | – |
| | **T7335** | 0.8 | ◪ 180 | 0.18 | 1.9 | ■ 140 | 0.16 | 1.9 | – | – | – | – | – | – | ◪ 55 | 0.16 | 1.5 | – | – | – |
| | **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 | – | – | – |
| | **T8330** | 0.8 | ■ 165 | 0.18 | 1.9 | ■ 95 | 0.16 | 1.9 | ◪ 155 | 0.18 | 1.9 | ◪ 495 | 0.22 | 1.9 | ◪ 40 | 0.16 | 1.5 | – | – | – |
| | **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 | – | – | – |
| | **T9315** | 0.8 | ■ 265 | 0.17 | 1.9 | – | – | – | ◪ 250 | 0.17 | 1.9 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | ■ 230 | 0.18 | 1.9 | ■ 135 | 0.16 | 1.9 | ◪ 215 | 0.18 | 1.9 | – | – | – | ◪ 50 | 0.16 | 1.5 | – | – | – |
| **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 | – | – | – |
| | **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 | – | – | – |
| | **T9325** | 1.2 | ■ 200 | 0.30 | 1.5 | ■ 120 | 0.27 | 1.5 | ◪ 190 | 0.30 | 1.5 | – | – | – | ◪ 45 | 0.21 | 1.2 | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | NM-geometri med meget positivt design til finbearbejdning, mellem og grov bearbejdning i kontinuerlige snit. | | | | | | | | | | | | | | | | | |
| **DNMG 110404E-NM** | **T7325** | 0.4 | ◪ 175 | 0.20 | 0.8 | ■ 135 | 0.18 | 0.8 | – | – | – | – | – | – | ■ 55 | 0.20 | 0.6 | – | – | – |
| | **T7335** | 0.4 | ◪ 165 | 0.20 | 0.8 | ■ 125 | 0.18 | 0.8 | – | – | – | – | – | – | ■ 50 | 0.20 | 0.6 | – | – | – |
| | **T8315** | 0.4 | ◪ 160 | 0.20 | 0.8 | ■ 95 | 0.18 | 0.8 | – | – | – | ◪ 480 | 0.24 | 0.8 | ◪ 40 | 0.20 | 0.6 | – | – | – |
| | **T8330** | 0.4 | ■ 150 | 0.20 | 0.8 | ■ 90 | 0.18 | 0.8 | – | – | – | ◪ 450 | 0.24 | 0.8 | ◪ 35 | 0.20 | 0.6 | – | – | – |
| | **T8430** | 0.4 | ■ 175 | 0.20 | 0.8 | ■ 95 | 0.18 | 0.8 | – | – | – | ◪ 480 | 0.24 | 0.8 | ◪ 35 | 0.20 | 0.6 | – | – | – |
| | **T9325** | 0.4 | ■ 210 | 0.20 | 0.8 | ■ 125 | 0.18 | 0.8 | – | – | – | – | – | – | ◪ 45 | 0.20 | 0.6 | – | – | – |

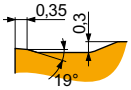
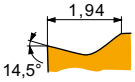
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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-geometri med meget positivt design til finbearbejdning, mellem og grov bearbejdning i kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **DNMG 110408E-NM** | **T7325** | 0.8 | 190 | 0.25 | 0.8 | 145 | 0.23 | 0.8 | – | – | – | – | – | – | 60 | 0.20 | 0.6 | – | – | – |
| | **T7335** | 0.8 | 185 | 0.25 | 0.8 | 140 | 0.23 | 0.8 | – | – | – | – | – | – | 60 | 0.20 | 0.6 | – | – | – |
| | **T8315** | 0.8 | 180 | 0.25 | 0.8 | 105 | 0.23 | 0.8 | – | – | – | 540 | 0.30 | 0.8 | 45 | 0.20 | 0.6 | – | – | – |
| | **T8330** | 0.8 | 170 | 0.25 | 0.8 | 100 | 0.23 | 0.8 | – | – | – | 510 | 0.30 | 0.8 | 40 | 0.20 | 0.6 | – | – | – |
| | **T8430** | 0.8 | 190 | 0.25 | 0.8 | 105 | 0.23 | 0.8 | – | – | – | 525 | 0.30 | 0.8 | 40 | 0.20 | 0.6 | – | – | – |
| | **T9325** | 0.8 | 230 | 0.25 | 0.8 | 135 | 0.23 | 0.8 | – | – | – | – | – | – | 50 | 0.20 | 0.6 | – | – | – |
| **DNMG 150408E-NM** | **T7335** | 0.8 | 170 | 0.25 | 1.9 | 130 | 0.23 | 1.9 | – | – | – | – | – | – | 55 | 0.20 | 1.5 | – | – | – |
| | **T8330** | 0.8 | 155 | 0.25 | 1.9 | 90 | 0.23 | 1.9 | – | – | – | 465 | 0.30 | 1.9 | 35 | 0.20 | 1.5 | – | – | – |
| | **T8430** | 0.8 | 175 | 0.25 | 1.9 | 95 | 0.23 | 1.9 | – | – | – | 480 | 0.30 | 1.9 | 35 | 0.20 | 1.5 | – | – | – |
| | **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 | – | – | – |
| | **T7335** | 0.4 | 150 | 0.20 | 1.9 | 115 | 0.18 | 1.9 | – | – | – | – | – | – | 45 | 0.20 | 1.5 | – | – | – |
| | **T8315** | 0.4 | 150 | 0.20 | 1.9 | 90 | 0.18 | 1.9 | – | – | – | 450 | 0.24 | 1.9 | 35 | 0.20 | 1.5 | – | – | – |
| | **T8330** | 0.4 | 135 | 0.20 | 1.9 | 80 | 0.18 | 1.9 | – | – | – | 405 | 0.24 | 1.9 | 30 | 0.20 | 1.5 | – | – | – |
| | **T8430** | 0.4 | 155 | 0.20 | 1.9 | 85 | 0.18 | 1.9 | – | – | – | 435 | 0.24 | 1.9 | 30 | 0.20 | 1.5 | – | – | – |
| | **T9315** | 0.4 | 220 | 0.20 | 1.9 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **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 | – | – | – |
| | **T7335** | 0.8 | 170 | 0.25 | 1.9 | 130 | 0.23 | 1.9 | – | – | – | – | – | – | 55 | 0.20 | 1.5 | – | – | – |
| | **T8315** | 0.8 | 165 | 0.25 | 1.9 | 95 | 0.23 | 1.9 | – | – | – | 495 | 0.30 | 1.9 | 40 | 0.20 | 1.5 | – | – | – |
| | **T8330** | 0.8 | 155 | 0.25 | 1.9 | 90 | 0.23 | 1.9 | – | – | – | 465 | 0.30 | 1.9 | 35 | 0.20 | 1.5 | – | – | – |
| | **T8430** | 0.8 | 175 | 0.25 | 1.9 | 95 | 0.23 | 1.9 | – | – | – | 480 | 0.30 | 1.9 | 35 | 0.20 | 1.5 | – | – | – |
| | **T9315** | 0.8 | 235 | 0.25 | 1.9 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 210 | 0.25 | 1.9 | 125 | 0.23 | 1.9 | – | – | – | – | – | – | 45 | 0.20 | 1.5 | – | – | – |
| **DNMG 150612E-NM** | **T7325** | 1.2 | 175 | 0.30 | 1.9 | 135 | 0.27 | 1.9 | – | – | – | – | – | – | 55 | 0.24 | 1.5 | – | – | – |
| | **T7335** | 1.2 | 170 | 0.30 | 1.9 | 130 | 0.27 | 1.9 | – | – | – | – | – | – | 55 | 0.24 | 1.5 | – | – | – |
| | **T8315** | 1.2 | 165 | 0.30 | 1.9 | 95 | 0.27 | 1.9 | – | – | – | 495 | 0.36 | 1.9 | 40 | 0.24 | 1.5 | – | – | – |
| | **T9325** | 1.2 | 205 | 0.30 | 1.9 | 120 | 0.27 | 1.9 | – | – | – | – | – | – | 45 | 0.24 | 1.5 | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| NMR-geometri med positivt design til medium til grov bearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **DNMG 110404E-NMR** | **T7325** | 0.4 | 150 | 0.20 | 0.8 | 115 | 0.18 | 0.8 | – | – | – | – | – | – | 45 | 0.18 | 0.6 | – | – | – |
| | **T9315** | 0.4 | 205 | 0.20 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **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 | – | – | – |
| | **T9315** | 0.8 | 205 | 0.30 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 185 | 0.30 | 0.8 | 110 | 0.27 | 0.8 | – | – | – | – | – | – | 40 | 0.24 | 0.6 | – | – | – |
| **DNMG 110412E-NMR** | **T7325** | 1.2 | 155 | 0.30 | 1.6 | 120 | 0.27 | 1.6 | – | – | – | – | – | – | 50 | 0.24 | 1.3 | – | – | – |
| | **T9315** | 1.2 | 200 | 0.30 | 1.6 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | 180 | 0.30 | 1.6 | 105 | 0.27 | 1.6 | – | – | – | – | – | – | 40 | 0.24 | 1.3 | – | – | – |
| **DNMG 150404E-NMR** | **T7325** | 0.4 | 140 | 0.20 | 1.9 | 105 | 0.18 | 1.9 | – | – | – | – | – | – | 45 | 0.18 | 1.5 | – | – | – |
| | **T7335** | 0.4 | 130 | 0.20 | 1.9 | 100 | 0.18 | 1.9 | – | – | – | – | – | – | 40 | 0.18 | 1.5 | – | – | – |
| | **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 | – | – | – |
| | **T7335** | 0.8 | 140 | 0.30 | 1.9 | 105 | 0.27 | 1.9 | – | – | – | – | – | – | 45 | 0.24 | 1.5 | – | – | – |
| | **T8330** | 0.8 | 125 | 0.30 | 1.9 | 75 | 0.27 | 1.9 | – | – | – | – | – | – | 30 | 0.24 | 1.5 | – | – | – |
| | **T8430** | 0.8 | 135 | 0.30 | 1.9 | 75 | 0.27 | 1.9 | – | – | – | – | – | – | 25 | 0.24 | 1.5 | – | – | – |
| | **T9315** | 0.8 | 190 | 0.30 | 1.9 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 170 | 0.30 | 1.9 | 100 | 0.27 | 1.9 | – | – | – | – | – | – | 35 | 0.24 | 1.5 | – | – | – |
| **DNMG 150604E-NMR** | **T7325** | 0.4 | 140 | 0.20 | 1.9 | 105 | 0.18 | 1.9 | – | – | – | – | – | – | 45 | 0.18 | 1.5 | – | – | – |
| | **T7335** | 0.4 | 130 | 0.20 | 1.9 | 100 | 0.18 | 1.9 | – | – | – | – | – | – | 40 | 0.18 | 1.5 | – | – | – |
| | **T8330** | 0.4 | 120 | 0.20 | 1.9 | 70 | 0.18 | 1.9 | – | – | – | – | – | – | 30 | 0.18 | 1.5 | – | – | – |
| | **T8430** | 0.4 | 135 | 0.20 | 1.9 | 75 | 0.18 | 1.9 | – | – | – | – | – | – | 25 | 0.18 | 1.5 | – | – | – |
| | **T9315** | 0.4 | 190 | 0.20 | 1.9 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 170 | 0.20 | 1.9 | 100 | 0.18 | 1.9 | – | – | – | – | – | – | 35 | 0.18 | 1.5 | – | – | – |

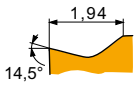
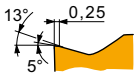
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |   | | | | | | | | | | | | | | | | | | | |
| NMR-geometri med positivt design til medium til grov bearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **DNMG 150608E-NMR** | **T6310** | 0.8 | ■ 125 | 0.30 | 1.9 | ■ 90 | 0.27 | 1.9 | – | – | – | – | – | – | ■ 35 | 0.24 | 1.5 | – | – | – |
| | **T7325** | 0.8 | ◪ 145 | 0.30 | 1.9 | ■ 110 | 0.27 | 1.9 | – | – | – | – | – | – | ■ 45 | 0.24 | 1.5 | – | – | – |
| | **T7335** | 0.8 | ◪ 140 | 0.30 | 1.9 | ■ 105 | 0.27 | 1.9 | – | – | – | – | – | – | ■ 45 | 0.24 | 1.5 | – | – | – |
| | **T8330** | 0.8 | ■ 125 | 0.30 | 1.9 | ■ 75 | 0.27 | 1.9 | – | – | – | – | – | – | ◪ 30 | 0.24 | 1.5 | – | – | – |
| | **T8430** | 0.8 | ■ 135 | 0.30 | 1.9 | ■ 75 | 0.27 | 1.9 | – | – | – | – | – | – | ◪ 25 | 0.24 | 1.5 | – | – | – |
| | **T9315** | 0.8 | ■ 190 | 0.30 | 1.9 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | ■ 170 | 0.30 | 1.9 | ■ 100 | 0.27 | 1.9 | – | – | – | – | – | – | ◪ 35 | 0.24 | 1.5 | – | – | – |
| **DNMG 150612E-NMR** | **T7325** | 1.2 | ◪ 155 | 0.30 | 1.9 | ■ 120 | 0.27 | 1.9 | – | – | – | – | – | – | ■ 50 | 0.24 | 1.5 | – | – | – |
| | **T7335** | 1.2 | ◪ 145 | 0.30 | 1.9 | ■ 110 | 0.27 | 1.9 | – | – | – | – | – | – | ■ 45 | 0.24 | 1.5 | – | – | – |
| | **T8330** | 1.2 | ■ 135 | 0.30 | 1.9 | ■ 80 | 0.27 | 1.9 | – | – | – | – | – | – | ◪ 30 | 0.24 | 1.5 | – | – | – |
| | **T8430** | 1.2 | ■ 145 | 0.30 | 1.9 | ■ 80 | 0.27 | 1.9 | – | – | – | – | – | – | ◪ 30 | 0.24 | 1.5 | – | – | – |
| | **T9315** | 1.2 | ■ 200 | 0.30 | 1.9 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | ■ 180 | 0.30 | 1.9 | ■ 105 | 0.27 | 1.9 | – | – | – | – | – | – | ◪ 40 | 0.24 | 1.5 | – | – | – |
|  |   | | | | | | | | | | | | | | | | | | | |
| NRM-geometri med positivt design til halv grov til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **DNMG 150408-NRM** | **T7325** | 0.8 | ◪ 140 | 0.30 | 3.0 | ■ 105 | 0.27 | 3.0 | – | – | – | – | – | – | ■ 45 | 0.24 | 2.4 | – | – | – |
| | **T7335** | 0.8 | ◪ 130 | 0.30 | 3.0 | ■ 100 | 0.27 | 3.0 | – | – | – | – | – | – | ■ 40 | 0.24 | 2.4 | – | – | – |
| | **T9315** | 0.8 | ■ 180 | 0.30 | 3.0 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **DNMG 150604-NRM** | **T7325** | 0.4 | ◪ 130 | 0.20 | 3.0 | ■ 100 | 0.18 | 3.0 | – | – | – | – | – | – | ■ 40 | 0.20 | 2.4 | – | – | – |
| | **T7335** | 0.4 | ◪ 130 | 0.20 | 3.0 | ■ 100 | 0.18 | 3.0 | – | – | – | – | – | – | ■ 40 | 0.20 | 2.4 | – | – | – |
| | **T9315** | 0.4 | ■ 180 | 0.20 | 3.0 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **DNMG 150608-NRM** | **T7325** | 0.8 | ◪ 140 | 0.30 | 3.0 | ■ 105 | 0.27 | 3.0 | – | – | – | – | – | – | ■ 45 | 0.24 | 2.4 | – | – | – |
| | **T7335** | 0.8 | ◪ 130 | 0.30 | 3.0 | ■ 100 | 0.27 | 3.0 | – | – | – | – | – | – | ■ 40 | 0.24 | 2.4 | – | – | – |
| | **T9315** | 0.8 | ■ 180 | 0.30 | 3.0 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **DNMG 150612-NRM** | **T7325** | 1.2 | ◪ 145 | 0.30 | 3.0 | ■ 110 | 0.27 | 3.0 | – | – | – | – | – | – | ■ 45 | 0.27 | 2.4 | – | – | – |
| | **T7335** | 1.2 | ◪ 140 | 0.30 | 3.0 | ■ 105 | 0.27 | 3.0 | – | – | – | – | – | – | ■ 45 | 0.27 | 2.4 | – | – | – |
| | **T9315** | 1.2 | ■ 190 | 0.30 | 3.0 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
|  |   | | | | | | | | | | | | | | | | | | | |
| R-geometri til semi-grov til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **DNMG 150408E-R** | **T5315** | 0.8 | ◪ 175 | 0.40 | 3.0 | – | – | – | ■ 165 | 0.40 | 3.0 | – | – | – | – | – | – | ◪ 35 | 0.15 | 1.0 |
| **DNMG 150608E-R** | **T5305** | 0.8 | ◪ 200 | 0.40 | 3.0 | – | – | – | ■ 190 | 0.40 | 3.0 | – | – | – | – | – | – | ◪ 40 | 0.15 | 1.0 |
| | **T5315** | 0.8 | ◪ 175 | 0.40 | 3.0 | – | – | – | ■ 165 | 0.40 | 3.0 | – | – | – | – | – | – | ◪ 35 | 0.15 | 1.0 |
| | **T9310** | 0.8 | ■ 170 | 0.40 | 3.0 | – | – | – | ◪ 160 | 0.40 | 3.0 | – | – | – | – | – | – | ◪ 30 | 0.15 | 1.0 |
| | **T9315** | 0.8 | ■ 155 | 0.40 | 3.0 | – | – | – | ◪ 145 | 0.40 | 3.0 | – | – | – | – | – | – | ◪ 30 | 0.15 | 1.0 |
| | **T9325** | 0.8 | ■ 140 | 0.40 | 3.0 | – | – | – | ◪ 130 | 0.40 | 3.0 | – | – | – | – | – | – | – | – | – |
| **DNMG 150612E-R** | **T5305** | 1.2 | ◪ 210 | 0.40 | 3.0 | – | – | – | ■ 195 | 0.40 | 3.0 | – | – | – | – | – | – | ◪ 40 | 0.15 | 1.0 |
| | **T5315** | 1.2 | ◪ 185 | 0.40 | 3.0 | – | – | – | ■ 175 | 0.40 | 3.0 | – | – | – | – | – | – | ◪ 35 | 0.15 | 1.0 |
| | **T9310** | 1.2 | ■ 180 | 0.40 | 3.0 | – | – | – | ◪ 170 | 0.40 | 3.0 | – | – | – | – | – | – | ◪ 35 | 0.15 | 1.0 |
| | **T9315** | 1.2 | ■ 165 | 0.40 | 3.0 | – | – | – | ◪ 155 | 0.40 | 3.0 | – | – | – | – | – | – | ◪ 30 | 0.15 | 1.0 |
| | **T9325** | 1.2 | ■ 150 | 0.40 | 3.0 | – | – | – | ◪ 140 | 0.40 | 3.0 | – | – | – | – | – | – | – | – | – |
| **DNMG 150616E-R** | **T9325** | 1.6 | ■ 155 | 0.40 | 3.0 | – | – | – | ◪ 145 | 0.40 | 3.0 | – | – | – | – | – | – | – | – | – |
|  |   | | | | | | | | | | | | | | | | | | | |
| RM-geometri til semi-grov til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **DNMG 110408E-RM** | **T9315** | 0.8 | ■ 190 | 0.40 | 2.0 | – | – | – | ◪ 180 | 0.40 | 2.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | ■ 170 | 0.40 | 2.0 | ◪ 100 | 0.36 | 2.0 | ◪ 160 | 0.40 | 2.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.8 | ■ 145 | 0.40 | 2.0 | ◪ 85 | 0.36 | 2.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| **DNMG 110412E-RM** | **T9315** | 1.2 | ■ 230 | 0.30 | 2.0 | – | – | – | ◪ 215 | 0.30 | 2.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | ■ 205 | 0.30 | 2.0 | ◪ 120 | 0.27 | 2.0 | ◪ 190 | 0.30 | 2.0 | – | – | – | – | – | – | – | – | – |

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |  | |  | | | | | | | | | | | | | | | | | |
| RM-geometri til semi-grov til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **DNMG 150408E-RM** | **T9315** | 0.8 | 180 | 0.40 | 3.0 | – | – | – | 170 | 0.40 | 3.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 165 | 0.40 | 3.0 | 95 | 0.36 | 3.0 | 155 | 0.40 | 3.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.8 | 140 | 0.40 | 3.0 | 80 | 0.36 | 3.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| **DNMG 150412E-RM** | **T7325** | 1.2 | 155 | 0.40 | 3.0 | 120 | 0.36 | 3.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9315** | 1.2 | 190 | 0.40 | 3.0 | – | – | – | 180 | 0.40 | 3.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | 170 | 0.40 | 3.0 | 100 | 0.36 | 3.0 | 160 | 0.40 | 3.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.2 | 150 | 0.40 | 3.0 | 90 | 0.36 | 3.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| **DNMG 150608E-RM** | **T5305** | 0.8 | 230 | 0.40 | 3.0 | – | – | – | 215 | 0.40 | 3.0 | – | – | – | – | – | – | – | – | – |
| | **T5315** | 0.8 | 205 | 0.40 | 3.0 | – | – | – | 190 | 0.40 | 3.0 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 0.8 | 145 | 0.40 | 3.0 | 110 | 0.36 | 3.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 0.8 | 135 | 0.40 | 3.0 | 105 | 0.36 | 3.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.8 | 135 | 0.40 | 3.0 | 80 | 0.36 | 3.0 | 125 | 0.40 | 3.0 | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.8 | 130 | 0.40 | 3.0 | 75 | 0.36 | 3.0 | 120 | 0.40 | 3.0 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.8 | 135 | 0.40 | 3.0 | 75 | 0.36 | 3.0 | 110 | 0.40 | 3.0 | – | – | – | – | – | – | – | – | – |
| | **T9310** | 0.8 | 200 | 0.40 | 3.0 | – | – | – | 190 | 0.40 | 3.0 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.8 | 180 | 0.40 | 3.0 | – | – | – | 170 | 0.40 | 3.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 165 | 0.40 | 3.0 | 95 | 0.36 | 3.0 | 155 | 0.40 | 3.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.8 | 140 | 0.40 | 3.0 | 80 | 0.36 | 3.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| **DNMG 150612E-RM** | **T5305** | 1.2 | 240 | 0.40 | 3.0 | – | – | – | 225 | 0.40 | 3.0 | – | – | – | – | – | – | – | – | – |
| | **T5315** | 1.2 | 215 | 0.40 | 3.0 | – | – | – | 200 | 0.40 | 3.0 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 1.2 | 155 | 0.40 | 3.0 | 120 | 0.36 | 3.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 1.2 | 145 | 0.40 | 3.0 | 110 | 0.36 | 3.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 1.2 | 135 | 0.40 | 3.0 | 80 | 0.36 | 3.0 | 125 | 0.40 | 3.0 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 1.2 | 140 | 0.40 | 3.0 | 75 | 0.36 | 3.0 | 115 | 0.40 | 3.0 | – | – | – | – | – | – | – | – | – |
| | **T9310** | 1.2 | 210 | 0.40 | 3.0 | – | – | – | 195 | 0.40 | 3.0 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 1.2 | 190 | 0.40 | 3.0 | – | – | – | 180 | 0.40 | 3.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | 170 | 0.40 | 3.0 | 100 | 0.36 | 3.0 | 160 | 0.40 | 3.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.2 | 150 | 0.40 | 3.0 | 90 | 0.36 | 3.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| **DNMG 150616E-RM** | **T5315** | 1.6 | 225 | 0.40 | 3.0 | – | – | – | 210 | 0.40 | 3.0 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 1.6 | 200 | 0.40 | 3.0 | – | – | – | 190 | 0.40 | 3.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.6 | 180 | 0.40 | 3.0 | 105 | 0.36 | 3.0 | 170 | 0.40 | 3.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.6 | 155 | 0.40 | 3.0 | 90 | 0.36 | 3.0 | – | – | – | – | – | – | – | – | – | – | – | – |
|  |  | |  | | | | | | | | | | | | | | | | | |
| SF-geometri med positivt design til finbearbejdning af tynde vægge og kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **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 | 0.15 | 1.0 |
| | **T7325** | 0.4 | 165 | 0.17 | 0.8 | 125 | 0.15 | 0.8 | – | – | – | – | – | – | 50 | 0.15 | 0.6 | – | – | – |
| | **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 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| | **T9315** | 0.4 | 245 | 0.15 | 0.8 | – | – | – | 230 | 0.15 | 0.8 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |
| | **T9325** | 0.4 | 210 | 0.17 | 0.8 | 125 | 0.15 | 0.8 | 195 | 0.17 | 0.8 | – | – | – | 45 | 0.15 | 0.6 | – | – | – |
| **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 | 0.15 | 1.0 |
| | **T7325** | 0.8 | 195 | 0.17 | 0.8 | 150 | 0.15 | 0.8 | – | – | – | – | – | – | 60 | 0.15 | 0.6 | – | – | – |
| | **T7335** | 0.8 | 195 | 0.17 | 0.8 | 150 | 0.15 | 0.8 | – | – | – | – | – | – | 60 | 0.15 | 0.6 | – | – | – |
| | **T8315** | 0.8 | 180 | 0.17 | 0.8 | 105 | 0.15 | 0.8 | 170 | 0.17 | 0.8 | 540 | 0.20 | 0.8 | 45 | 0.14 | 0.6 | 35 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| | **T9325** | 0.8 | 250 | 0.17 | 0.8 | 150 | 0.15 | 0.8 | 235 | 0.17 | 0.8 | – | – | – | 55 | 0.15 | 0.6 | – | – | – |
| **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 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| | **T9325** | 0.4 | 195 | 0.17 | 1.5 | 115 | 0.15 | 1.5 | 185 | 0.17 | 1.5 | – | – | – | 40 | 0.15 | 1.2 | – | – | – |

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | | | | | | | | | | | | | | | | | | |
| **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 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| | **T8330** | 0.8 | ■ | 160 | 0.17 | 1.5 | ■ | 95 | 0.15 | 1.5 | ■ | 150 | 0.17 | 1.5 | ◪ | 480 | 0.20 | 1.5 | ◪ | 40 | 0.14 | 1.2 | ◪ | 30 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| | **T9325** | 0.8 | ■ | 235 | 0.17 | 1.5 | ■ | 140 | 0.15 | 1.5 | ◪ | 220 | 0.17 | 1.5 | | – | – | – | ◪ | 50 | 0.15 | 1.2 | | – | – | – |
| **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 | | – | – | – |
| | **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 | 0.15 | 1.0 |
| | **T7325** | 0.4 | ◪ | 155 | 0.17 | 1.5 | ■ | 120 | 0.15 | 1.5 | | – | – | – | | – | – | – | ■ | 50 | 0.15 | 1.2 | | – | – | – |
| | **T7335** | 0.4 | ◪ | 150 | 0.17 | 1.5 | ■ | 115 | 0.15 | 1.5 | | – | – | – | | – | – | – | ■ | 45 | 0.15 | 1.2 | | – | – | – |
| | **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 | 0.15 | 1.0 |
| | **T8330** | 0.4 | ■ | 140 | 0.15 | 1.5 | ■ | 80 | 0.14 | 1.5 | ■ | 130 | 0.15 | 1.5 | ◪ | 420 | 0.18 | 1.5 | ◪ | 35 | 0.12 | 1.2 | ◪ | 25 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| | **T9315** | 0.4 | ■ | 230 | 0.15 | 1.5 | | – | – | – | ◪ | 215 | 0.15 | 1.5 | | – | – | – | | – | – | – | ◪ | 45 | 0.15 | 1.0 |
| | **T9325** | 0.4 | ■ | 195 | 0.17 | 1.5 | ■ | 115 | 0.15 | 1.5 | ◪ | 185 | 0.17 | 1.5 | | – | – | – | ◪ | 40 | 0.15 | 1.2 | | – | – | – |
| **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 | | – | – | – |
| | **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 | 0.15 | 1.0 |
| | **T7325** | 0.8 | ◪ | 185 | 0.17 | 1.5 | ■ | 140 | 0.15 | 1.5 | | – | – | – | | – | – | – | ■ | 60 | 0.15 | 1.2 | | – | – | – |
| | **T7335** | 0.8 | ◪ | 180 | 0.17 | 1.5 | ■ | 140 | 0.15 | 1.5 | | – | – | – | | – | – | – | ■ | 55 | 0.15 | 1.2 | | – | – | – |
| | **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 | 0.15 | 1.0 |
| | **T8330** | 0.8 | ■ | 160 | 0.17 | 1.5 | ■ | 95 | 0.15 | 1.5 | ■ | 150 | 0.17 | 1.5 | ◪ | 480 | 0.20 | 1.5 | ◪ | 40 | 0.14 | 1.2 | ◪ | 30 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| | **T9315** | 0.8 | ■ | 255 | 0.17 | 1.5 | | – | – | – | ◪ | 240 | 0.17 | 1.5 | | – | – | – | | – | – | – | ◪ | 50 | 0.15 | 1.0 |
| | **T9325** | 0.8 | ■ | 235 | 0.17 | 1.5 | ■ | 140 | 0.15 | 1.5 | ◪ | 220 | 0.17 | 1.5 | | – | – | – | ◪ | 50 | 0.15 | 1.2 | | – | – | – |
| **DNMG 150612E-SF** | **T6310** | 1.2 | ■ | 145 | 0.30 | 1.5 | ■ | 100 | 0.27 | 1.5 | ■ | 115 | 0.30 | 1.5 | ◪ | 435 | 0.36 | 1.5 | ■ | 40 | 0.21 | 1.2 | ■ | 25 | 0.15 | 1.0 |
| | **T7325** | 1.2 | ◪ | 165 | 0.30 | 1.5 | ■ | 125 | 0.27 | 1.5 | | – | – | – | | – | – | – | ■ | 50 | 0.21 | 1.2 | | – | – | – |
| | **T9315** | 1.2 | ■ | 210 | 0.30 | 1.5 | | – | – | – | ◪ | 195 | 0.30 | 1.5 | | – | – | – | | – | – | – | ◪ | 40 | 0.15 | 1.0 |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | | | | | | | | | | | | | | | | | | |
| **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 | 0.20 | 0.6 | ◪ | 25 | 0.15 | 1.0 |
| | **T7325** | 0.4 | ◪ | 160 | 0.20 | 0.8 | ■ | 120 | 0.18 | 0.8 | | – | – | – | | – | – | – | ■ | 50 | 0.20 | 0.6 | | – | – | – |
| | **T7335** | 0.4 | ◪ | 150 | 0.20 | 0.8 | ■ | 115 | 0.18 | 0.8 | | – | – | – | | – | – | – | ■ | 45 | 0.20 | 0.6 | | – | – | – |
| | **T8430** | 0.4 | ■ | 155 | 0.20 | 0.8 | ■ | 85 | 0.18 | 0.8 | ◪ | 130 | 0.20 | 0.8 | ◪ | 435 | 0.24 | 0.8 | ◪ | 30 | 0.20 | 0.6 | ◪ | 25 | 0.15 | 1.0 |
| | **T9325** | 0.4 | ■ | 190 | 0.20 | 0.8 | ■ | 110 | 0.18 | 0.8 | ◪ | 180 | 0.20 | 0.8 | | – | – | – | ◪ | 40 | 0.20 | 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 | 0.15 | 1.0 |
| | **T7325** | 0.8 | ◪ | 170 | 0.25 | 1.2 | ■ | 130 | 0.23 | 1.2 | | – | – | – | | – | – | – | ■ | 55 | 0.20 | 1.0 | | – | – | – |
| | **T7335** | 0.8 | ◪ | 160 | 0.25 | 1.2 | ■ | 120 | 0.23 | 1.2 | | – | – | – | | – | – | – | ■ | 50 | 0.20 | 1.0 | | – | – | – |
| | **T8330** | 0.8 | ■ | 150 | 0.25 | 1.2 | ■ | 90 | 0.23 | 1.2 | ■ | 140 | 0.25 | 1.2 | ◪ | 450 | 0.30 | 1.2 | ◪ | 35 | 0.20 | 1.0 | ◪ | 30 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| | **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 | ■ | 125 | 0.22 | 1.7 | ■ | 90 | 0.20 | 1.7 | ■ | 100 | 0.22 | 1.7 | ◪ | 375 | 0.26 | 1.7 | ■ | 35 | 0.20 | 1.4 | ◪ | 25 | 0.15 | 1.0 |
| **DNMG 150408E-SM** | **T6310** | 0.8 | ■ | 140 | 0.25 | 2.1 | ■ | 100 | 0.23 | 2.1 | ■ | 110 | 0.25 | 2.1 | ◪ | 420 | 0.30 | 2.1 | ■ | 40 | 0.20 | 1.7 | ◪ | 25 | 0.15 | 1.0 |
| **DNMG 150604E-SM** | **T6310** | 0.4 | ■ | 125 | 0.22 | 1.7 | ■ | 90 | 0.20 | 1.7 | ■ | 100 | 0.22 | 1.7 | ◪ | 375 | 0.26 | 1.7 | ■ | 35 | 0.20 | 1.4 | ◪ | 25 | 0.15 | 1.0 |
| | **T7325** | 0.4 | ◪ | 140 | 0.22 | 1.7 | ■ | 105 | 0.20 | 1.7 | | – | – | – | | – | – | – | ■ | 45 | 0.20 | 1.4 | | – | – | – |
| | **T7335** | 0.4 | ◪ | 140 | 0.22 | 1.7 | ■ | 105 | 0.20 | 1.7 | | – | – | – | | – | – | – | ■ | 45 | 0.20 | 1.4 | | – | – | – |
| | **T8330** | 0.4 | ■ | 125 | 0.22 | 1.7 | ■ | 75 | 0.20 | 1.7 | ■ | 115 | 0.22 | 1.7 | ◪ | 375 | 0.26 | 1.7 | ◪ | 30 | 0.20 | 1.4 | ◪ | 25 | 0.15 | 1.0 |
| | **T8430** | 0.4 | ■ | 140 | 0.22 | 1.7 | ■ | 75 | 0.20 | 1.7 | ◪ | 115 | 0.22 | 1.7 | ◪ | 390 | 0.26 | 1.7 | ◪ | 30 | 0.20 | 1.4 | ◪ | 20 | 0.15 | 1.0 |
| | **T9315** | 0.4 | ■ | 200 | 0.20 | 1.7 | | – | – | – | ◪ | 190 | 0.20 | 1.7 | | – | – | – | | – | – | – | ◪ | 40 | 0.15 | 1.0 |
| | **T9325** | 0.4 | ■ | 170 | 0.22 | 1.7 | ■ | 100 | 0.20 | 1.7 | ◪ | 160 | 0.22 | 1.7 | | – | – | – | ◪ | 35 | 0.20 | 1.4 | | – | – | – |

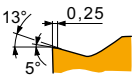
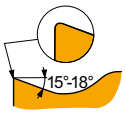
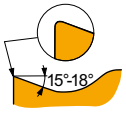



SF-geometri med positivt design til finbearbejdning af tynde vægge og kontinuerlige snit.

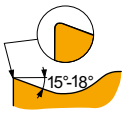
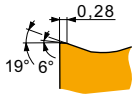
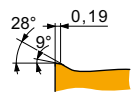



SM-geometri med positivt design til medium bearbejdning og kontinuerlige til afbrudte snit.

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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-geometri med positivt design til medium bearbejdning og kontinuerlige til afbrudte snit. | | | | | | | | | | | | | | | | | | | | |
| **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 | 0.15 | 1.0 |
| | **T7325** | 0.8 | 160 | 0.25 | 1.7 | 120 | 0.23 | 1.7 | – | – | – | – | – | – | 50 | 0.20 | 1.4 | – | – | – |
| | **T7335** | 0.8 | 155 | 0.25 | 1.7 | 120 | 0.23 | 1.7 | – | – | – | – | – | – | 50 | 0.20 | 1.4 | – | – | – |
| | **T8330** | 0.8 | 140 | 0.25 | 1.7 | 80 | 0.23 | 1.7 | 130 | 0.25 | 1.7 | 420 | 0.30 | 1.7 | 35 | 0.20 | 1.4 | 25 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| | **T9315** | 0.8 | 215 | 0.25 | 1.7 | – | – | – | 200 | 0.25 | 1.7 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| | **T9325** | 0.8 | 195 | 0.25 | 1.7 | 115 | 0.23 | 1.7 | 185 | 0.25 | 1.7 | – | – | – | 40 | 0.20 | 1.4 | – | – | – |
| **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 | 1.0 |
| | **T7325** | 1.2 | 160 | 0.30 | 1.7 | 120 | 0.27 | 1.7 | – | – | – | – | – | – | 50 | 0.24 | 1.4 | – | – | – |
| | **T7335** | 1.2 | 155 | 0.30 | 1.7 | 120 | 0.27 | 1.7 | – | – | – | – | – | – | 50 | 0.24 | 1.4 | – | – | – |
| | **T8330** | 1.2 | 145 | 0.30 | 1.7 | 85 | 0.27 | 1.7 | 135 | 0.30 | 1.7 | 435 | 0.36 | 1.7 | 35 | 0.24 | 1.4 | 25 | 0.15 | 1.0 |
| | **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 | 1.0 |
| | **T9315** | 1.2 | 210 | 0.30 | 1.7 | – | – | – | 195 | 0.30 | 1.7 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| | **T9325** | 1.2 | 190 | 0.30 | 1.7 | 110 | 0.27 | 1.7 | 180 | 0.30 | 1.7 | – | – | – | 40 | 0.24 | 1.4 | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| ER-SI geometri med positivt venstrehåndet design til finbearbejdning til halv grov bearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **DNMG 110404ER-SI** | **T7325** | 0.4 | 185 | 0.20 | 1.0 | 140 | 0.18 | 1.0 | – | – | – | – | – | – | 60 | 0.18 | 0.8 | – | – | – |
| | **T7335** | 0.4 | 180 | 0.20 | 1.0 | 140 | 0.18 | 1.0 | – | – | – | – | – | – | 55 | 0.18 | 0.8 | – | – | – |
| | **T8330** | 0.4 | 160 | 0.20 | 1.0 | 95 | 0.18 | 1.0 | – | – | – | 480 | 0.24 | 1.0 | 40 | 0.18 | 0.8 | – | – | – |
| | **T8430** | 0.4 | 185 | 0.20 | 1.0 | 100 | 0.18 | 1.0 | – | – | – | 510 | 0.24 | 1.0 | 40 | 0.18 | 0.8 | – | – | – |
| | **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 | – | – | – |
| | **T8330** | 0.8 | 165 | 0.35 | 1.0 | 95 | 0.32 | 1.0 | – | – | – | 495 | 0.42 | 1.0 | 40 | 0.25 | 0.8 | – | – | – |
| | **T8430** | 0.8 | 180 | 0.35 | 1.0 | 95 | 0.32 | 1.0 | – | – | – | 495 | 0.42 | 1.0 | 35 | 0.25 | 0.8 | – | – | – |
| | **T9325** | 0.8 | 210 | 0.35 | 1.0 | 125 | 0.32 | 1.0 | – | – | – | – | – | – | 45 | 0.25 | 0.8 | – | – | – |
| **DNMG 150404ER-SI** | **T8330** | 0.4 | 155 | 0.20 | 1.5 | 90 | 0.18 | 1.5 | – | – | – | 465 | 0.24 | 1.5 | 35 | 0.18 | 1.2 | – | – | – |
| | **T8430** | 0.4 | 175 | 0.20 | 1.5 | 95 | 0.18 | 1.5 | – | – | – | 480 | 0.24 | 1.5 | 35 | 0.18 | 1.2 | – | – | – |
| | **T9325** | 0.4 | 220 | 0.20 | 1.5 | 130 | 0.18 | 1.5 | – | – | – | – | – | – | 45 | 0.18 | 1.2 | – | – | – |
| **DNMG 150408ER-SI** | **T8330** | 0.8 | 160 | 0.35 | 1.5 | 95 | 0.32 | 1.5 | – | – | – | 480 | 0.42 | 1.5 | 40 | 0.25 | 1.2 | – | – | – |
| | **T8430** | 0.8 | 170 | 0.35 | 1.5 | 90 | 0.32 | 1.5 | – | – | – | 465 | 0.42 | 1.5 | 35 | 0.25 | 1.2 | – | – | – |
| | **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 | – | – | – |
| | **T7335** | 0.4 | 170 | 0.20 | 1.5 | 130 | 0.18 | 1.5 | – | – | – | – | – | – | 55 | 0.18 | 1.2 | – | – | – |
| | **T8315** | 0.4 | 165 | 0.20 | 1.5 | 95 | 0.18 | 1.5 | – | – | – | 495 | 0.24 | 1.5 | 40 | 0.18 | 1.2 | – | – | – |
| | **T8330** | 0.4 | 155 | 0.20 | 1.5 | 90 | 0.18 | 1.5 | – | – | – | 465 | 0.24 | 1.5 | 35 | 0.18 | 1.2 | – | – | – |
| | **T8430** | 0.4 | 175 | 0.20 | 1.5 | 95 | 0.18 | 1.5 | – | – | – | 480 | 0.24 | 1.5 | 35 | 0.18 | 1.2 | – | – | – |
| | **T9325** | 0.4 | 220 | 0.20 | 1.5 | 130 | 0.18 | 1.5 | – | – | – | – | – | – | 45 | 0.18 | 1.2 | – | – | – |
| | **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 | – | – | – |
| | **T7335** | 0.8 | 170 | 0.35 | 1.5 | 130 | 0.32 | 1.5 | – | – | – | – | – | – | 55 | 0.25 | 1.2 | – | – | – |
| | **T8315** | 0.8 | 165 | 0.35 | 1.5 | 95 | 0.32 | 1.5 | – | – | – | 495 | 0.42 | 1.5 | 40 | 0.25 | 1.2 | – | – | – |
| | **T8330** | 0.8 | 160 | 0.35 | 1.5 | 95 | 0.32 | 1.5 | – | – | – | 480 | 0.42 | 1.5 | 40 | 0.25 | 1.2 | – | – | – |
| | **T8430** | 0.8 | 170 | 0.35 | 1.5 | 90 | 0.32 | 1.5 | – | – | – | 465 | 0.42 | 1.5 | 35 | 0.25 | 1.2 | – | – | – |
| | **T9325** | 0.8 | 200 | 0.35 | 1.5 | 120 | 0.32 | 1.5 | – | – | – | – | – | – | 45 | 0.25 | 1.2 | – | – | – |
| | **T9335** | 0.8 | 180 | 0.35 | 1.5 | 105 | 0.32 | 1.5 | – | – | – | – | – | – | 40 | 0.25 | 1.2 | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| EL-SI geometri med positivt venstrehåndet design til finbearbejdning til halv grov bearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **DNMG 110404EL-SI** | **T7335** | 0.4 | 180 | 0.20 | 1.0 | 140 | 0.18 | 1.0 | – | – | – | – | – | – | 55 | 0.18 | 0.8 | – | – | – |
| | **T8330** | 0.4 | 160 | 0.20 | 1.0 | 95 | 0.18 | 1.0 | – | – | – | 480 | 0.24 | 1.0 | 40 | 0.18 | 0.8 | – | – | – |
| | **T8430** | 0.4 | 185 | 0.20 | 1.0 | 100 | 0.18 | 1.0 | – | – | – | 510 | 0.24 | 1.0 | 40 | 0.18 | 0.8 | – | – | – |
| | **T9325** | 0.4 | 225 | 0.20 | 1.0 | 135 | 0.18 | 1.0 | – | – | – | – | – | – | 50 | 0.18 | 0.8 | – | – | – |

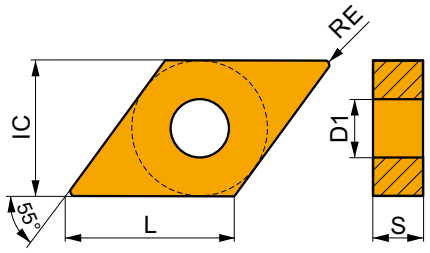
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | E | | | | | | | | | | | | | | | | | |
| EL-SI geometri med positivt venstrehåndet design til finbearbejdning til halv grov bearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **DNMG 110408EL-SI** | **T7325** | 0.8 | ◪ 185 | 0.35 | 1.0 | ■ 140 | 0.32 | 1.0 | – | – | – | – | – | – | ◪ 60 | 0.25 | 0.8 | – | – | – |
| | **T8330** | 0.8 | ■ 165 | 0.35 | 1.0 | ■ 95 | 0.32 | 1.0 | – | – | – | ◪ 495 | 0.42 | 1.0 | ◪ 40 | 0.25 | 0.8 | – | – | – |
| | **T8430** | 0.8 | ■ 180 | 0.35 | 1.0 | ■ 95 | 0.32 | 1.0 | – | – | – | ◪ 495 | 0.42 | 1.0 | ◪ 35 | 0.25 | 0.8 | – | – | – |
| | **T9325** | 0.8 | ■ 210 | 0.35 | 1.0 | ■ 125 | 0.32 | 1.0 | – | – | – | – | – | – | ◪ 45 | 0.25 | 0.8 | – | – | – |
| **DNMG 150404EL-SI** | **T8330** | 0.4 | ■ 155 | 0.20 | 1.5 | ■ 90 | 0.18 | 1.5 | – | – | – | ◪ 465 | 0.24 | 1.5 | ◪ 35 | 0.18 | 1.2 | – | – | – |
| | **T8430** | 0.4 | ■ 175 | 0.20 | 1.5 | ■ 95 | 0.18 | 1.5 | – | – | – | ◪ 480 | 0.24 | 1.5 | ◪ 35 | 0.18 | 1.2 | – | – | – |
| | **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 | – | – | – |
| | **T8330** | 0.8 | ■ 160 | 0.35 | 1.5 | ■ 95 | 0.32 | 1.5 | – | – | – | ◪ 480 | 0.42 | 1.5 | ◪ 40 | 0.25 | 1.2 | – | – | – |
| | **T8430** | 0.8 | ■ 170 | 0.35 | 1.5 | ■ 90 | 0.32 | 1.5 | – | – | – | ◪ 465 | 0.42 | 1.5 | ◪ 35 | 0.25 | 1.2 | – | – | – |
| | **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 | – | – | – |
| | **T7335** | 0.4 | ◪ 170 | 0.20 | 1.5 | ■ 130 | 0.18 | 1.5 | – | – | – | – | – | – | ◪ 55 | 0.18 | 1.2 | – | – | – |
| | **T8315** | 0.4 | ◪ 165 | 0.20 | 1.5 | ■ 95 | 0.18 | 1.5 | – | – | – | ◪ 495 | 0.24 | 1.5 | ◪ 40 | 0.18 | 1.2 | – | – | – |
| | **T8330** | 0.4 | ■ 155 | 0.20 | 1.5 | ■ 90 | 0.18 | 1.5 | – | – | – | ◪ 465 | 0.24 | 1.5 | ◪ 35 | 0.18 | 1.2 | – | – | – |
| | **T8430** | 0.4 | ■ 175 | 0.20 | 1.5 | ■ 95 | 0.18 | 1.5 | – | – | – | ◪ 480 | 0.24 | 1.5 | ◪ 35 | 0.18 | 1.2 | – | – | – |
| | **T9325** | 0.4 | ■ 220 | 0.20 | 1.5 | ■ 130 | 0.18 | 1.5 | – | – | – | – | – | – | ◪ 45 | 0.18 | 1.2 | – | – | – |
| | **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 | – | – | – |
| | **T7335** | 0.8 | ◪ 170 | 0.35 | 1.5 | ■ 130 | 0.32 | 1.5 | – | – | – | – | – | – | ◪ 55 | 0.25 | 1.2 | – | – | – |
| | **T8315** | 0.8 | ◪ 165 | 0.35 | 1.5 | ■ 95 | 0.32 | 1.5 | – | – | – | ◪ 495 | 0.42 | 1.5 | ◪ 40 | 0.25 | 1.2 | – | – | – |
| | **T8330** | 0.8 | ■ 160 | 0.35 | 1.5 | ■ 95 | 0.32 | 1.5 | – | – | – | ◪ 480 | 0.42 | 1.5 | ◪ 40 | 0.25 | 1.2 | – | – | – |
| | **T8430** | 0.8 | ■ 170 | 0.35 | 1.5 | ■ 90 | 0.32 | 1.5 | – | – | – | ◪ 465 | 0.42 | 1.5 | ◪ 35 | 0.25 | 1.2 | – | – | – |
| | **T9325** | 0.8 | ■ 200 | 0.35 | 1.5 | ■ 120 | 0.32 | 1.5 | – | – | – | – | – | – | ◪ 45 | 0.25 | 1.2 | – | – | – |
| | **T9335** | 0.8 | ■ 180 | 0.35 | 1.5 | ■ 105 | 0.32 | 1.5 | – | – | – | – | – | – | ◪ 40 | 0.25 | 1.2 | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | W | S | | | | | | | | | | | | | | | | |
| W-MR wiper geometri til halv grov til hård bearbejdning med øget tilspænding og forbedret overfladefinish. | | | | | | | | | | | | | | | | | | | | |
| **DNMG 150608W-MR** | **T5315** | 0.8 | ◪ 190 | 0.40 | 1.5 | – | – | – | ◪ 180 | 0.40 | 1.5 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.8 | ■ 170 | 0.40 | 1.5 | – | – | – | ◪ 160 | 0.40 | 1.5 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | ■ 155 | 0.40 | 1.5 | ◪ 90 | 0.36 | 1.5 | ◪ 145 | 0.40 | 1.5 | – | – | – | – | – | – | – | – | – |
| **DNMG 150612W-MR** | **T9310** | 1.2 | ■ 175 | 0.50 | 1.5 | – | – | – | ◪ 165 | 0.50 | 1.5 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 1.2 | ■ 160 | 0.50 | 1.5 | – | – | – | ◪ 150 | 0.50 | 1.5 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | ■ 145 | 0.50 | 1.5 | ◪ 85 | 0.45 | 1.5 | ◪ 135 | 0.50 | 1.5 | – | – | – | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | W | S | | | | | | | | | | | | | | | | |
| W-NM wiper geometri til halv grov til hård bearbejdning med øget tilspænding og forbedret overfladefinish. | | | | | | | | | | | | | | | | | | | | |
| **DNMX 150604W-NM** | **T7325** | 0.4 | ◪ 145 | 0.30 | 1.5 | ◪ 110 | 0.27 | 1.5 | – | – | – | – | – | – | ◪ 45 | 0.21 | 1.2 | – | – | – |
| | **T7335** | 0.4 | ◪ 135 | 0.30 | 1.5 | ◪ 105 | 0.27 | 1.5 | – | – | – | – | – | – | ◪ 40 | 0.21 | 1.2 | – | – | – |
| | **T9315** | 0.4 | ■ 185 | 0.30 | 1.5 | – | – | – | ◪ 175 | 0.30 | 1.5 | – | – | – | – | – | – | – | – | – |
| **DNMX 150608W-NM** | **T7325** | 0.8 | ◪ 155 | 0.40 | 1.5 | ◪ 120 | 0.36 | 1.5 | – | – | – | – | – | – | ◪ 50 | 0.28 | 1.2 | – | – | – |
| | **T7335** | 0.8 | ◪ 145 | 0.40 | 1.5 | ◪ 110 | 0.36 | 1.5 | – | – | – | – | – | – | ◪ 45 | 0.28 | 1.2 | – | – | – |
| | **T9315** | 0.8 | ■ 195 | 0.40 | 1.5 | – | – | – | ◪ 185 | 0.40 | 1.5 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | ■ 175 | 0.40 | 1.5 | ◪ 105 | 0.36 | 1.5 | ◪ 165 | 0.40 | 1.5 | – | – | – | ◪ 35 | 0.28 | 1.2 | – | – | – |

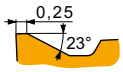
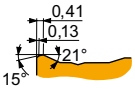
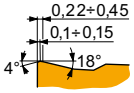
# DNMM

PRAMET

| | 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 |



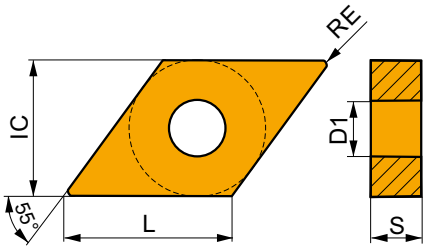

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | NR-geometri til semi-ru til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **DNMM 150408E-NR** | **T9325** | 0.8 | ■ 155 | 0.40 | 3.0 | ■ 90 | 0.36 | 3.0 | ◪ 145 | 0.40 | 3.0 | – | – | – | ◪ 30 | 0.28 | 2.4 | – | – | – |
| **DNMM 150608E-NR** | **T7325** | 0.8 | ◪ 140 | 0.40 | 3.0 | ■ 105 | 0.36 | 3.0 | – | – | – | – | – | – | ◪ 45 | 0.28 | 2.4 | – | – | – |
| | **T8330** | 0.8 | ■ 125 | 0.40 | 3.0 | ■ 75 | 0.36 | 3.0 | ◪ 115 | 0.40 | 3.0 | – | – | – | ◪ 30 | 0.28 | 2.4 | – | – | – |
| | **T8430** | 0.8 | ■ 130 | 0.40 | 3.0 | ■ 70 | 0.36 | 3.0 | ◪ 105 | 0.40 | 3.0 | – | – | – | ◪ 25 | 0.28 | 2.4 | – | – | – |
| | **T9325** | 0.8 | ■ 155 | 0.40 | 3.0 | ■ 90 | 0.36 | 3.0 | ◪ 145 | 0.40 | 3.0 | – | – | – | ◪ 30 | 0.28 | 2.4 | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | NR2-geometri til semi-ru til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **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 | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | OR geometri til semi-grov til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **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** | **T9315** | 1.2 | ■ 180 | 0.40 | 3.0 | – | – | – | ◪ 170 | 0.40 | 3.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | ■ 165 | 0.40 | 3.0 | ◪ 95 | 0.36 | 3.0 | ◪ 155 | 0.40 | 3.0 | – | – | – | ◪ 35 | 0.32 | 2.4 | – | – | – |
| | **T9335** | 1.2 | ■ 145 | 0.40 | 3.0 | ◪ 85 | 0.36 | 3.0 | – | – | – | – | – | – | ◪ 30 | 0.32 | 2.4 | – | – | – |
| **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 | – | – | – |

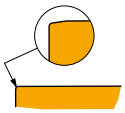
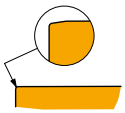
## DNGA CER

PRAMET

| | IC (mm) | D1 (mm) | L (mm) | S (mm) |
|---|---|---|---|---|
| 1504 | 12.700 | 5.16 | 15.50 | 4.76 |



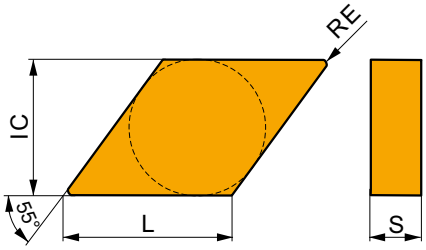

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | HSC S | | | | | | | | | | | | | | | | | |
| | | | Til bearbejdning med høje hastigheder og kontinuerlige snit. | | | | | | | | | | | | | | | | | |
| **DNGA 150408 S02020** | **TC100** | 0.8 | – | – | – | – | – | – | 450 | 0.20 | 1.5 | – | – | – | – | – | – | – | – | – |
|  |  | | HSC T | | | | | | | | | | | | | | | | | |
| | | | Til bearbejdning med høje hastigheder og kontinuerlige snit. | | | | | | | | | | | | | | | | | |
| **DNGA 150404 T01020** | **TC100** | 0.4 | – | – | – | – | – | – | 475 | 0.10 | 1.5 | – | – | – | – | – | – | – | – | – |
| **DNGA 150408 T00520** | **TC100** | 0.8 | – | – | – | – | – | – | 450 | 0.20 | 1.5 | – | – | – | – | – | – | – | – | – |

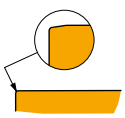
## DNGN CER

PRAMET

| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 1504 | 12.700 | 15.50 | 4.76 |



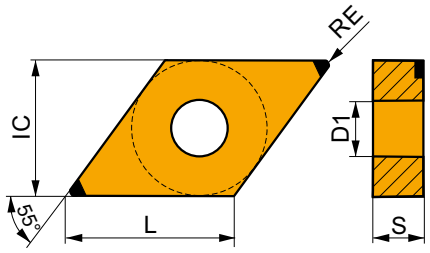

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | HSC T | | | | | | | | | | | | | | | | | |
| | | | Til bearbejdning med høje hastigheder og kontinuerlige snit. | | | | | | | | | | | | | | | | | |
| **DNGN 150408 T01020** | **TC100** | 0.8 | – | – | – | – | – | – | 450 | 0.20 | 1.5 | – | – | – | – | – | – | – | – | – |

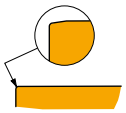
# DNGA CBN

PRAMET

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




Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | HSC | | S | | | | | | | | | | | | | | | |
| | | | Til færdigbearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | |
| **DNGA 150608S01020B** | **TB310** | 0.8 | – | – | – | – | – | – | 420 | 0.15 | 0.6 | – | – | – | 110 | 0.11 | 0.5 | 85 | 0.15 | 1.0 |

# DDJN(RL) EXT

P M K N S H

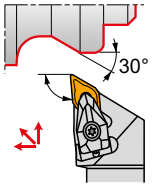
PRAMET

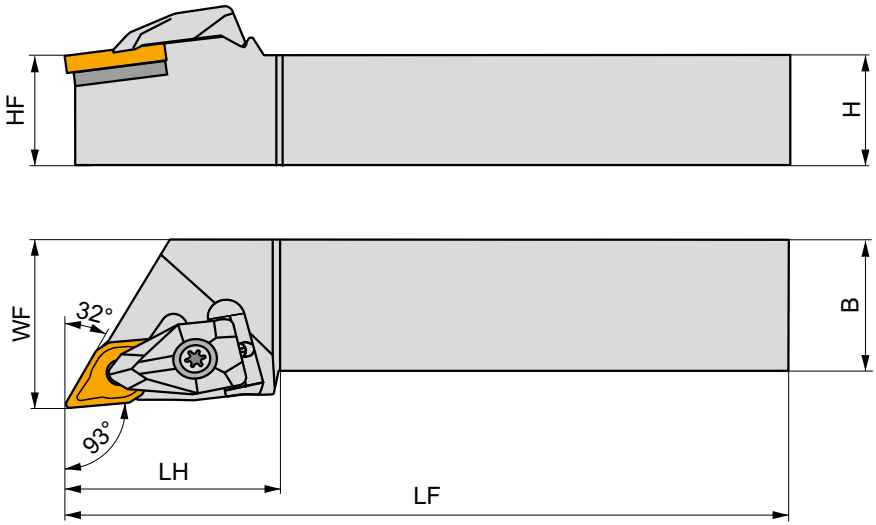
D

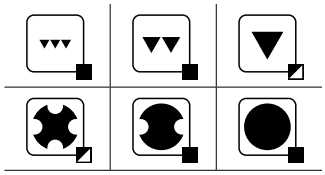


## Ekstern dobbelt drejeholder med 93 ° skærevinkel til DN .. Skær

Ekstern højre / venstre værktøjsholder med dobbelt klemme med skærevinkel på 93 °. Velegnet til langsgående drejning med skulder, konisk drejning og affasning med negative DN .. 11 eller 15 størrelse skær. Fås i 20x20 op til 32x32 mm skaft. Krop behandlet for længere levetid





| | Product | H (mm) | B (mm) | HF (mm) | WF (mm) | LF (mm) | LH (mm) | LAMS (°) | GAMO (°) | kg | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| R | DDJNR 2020 K 11 | 20 | 20 | 20 | 25 | 125 | 30.2 | -7 | -6 | 0.45 | GI046 | DD11 | – |
| | DDJNR 2525 M 11 | 25 | 25 | 25 | 32 | 150 | 30.2 | -7 | -6 | 0.77 | 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 | 1.12 | 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 | 0.45 | GI046 | DD11 | – |
| | DDJNL 2525 M 11 | 25 | 25 | 25 | 32 | 150 | 30.2 | -7 | -6 | 0.77 | 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.. |

| | | 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 | – |

# PDJN(RL) EXT

P M K N S H

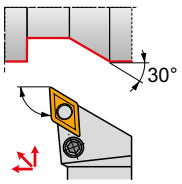
PRAMET

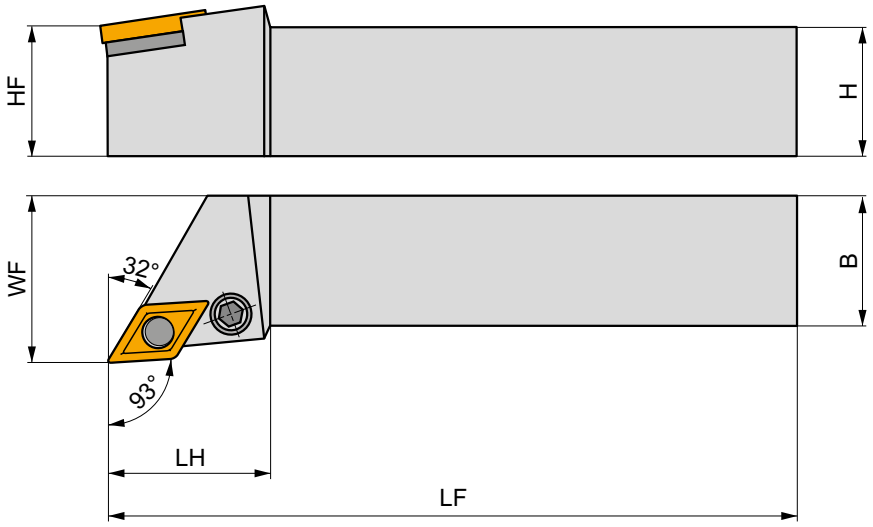
P

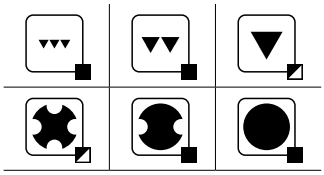


## Ekstern Lever Lock Drejeholder med 93 ° skærevinkel til DN .. Skær

Ekstern højre / venstre hånd værktøjsholder med 93 ° skærevinkel. Velegnet til langsgående drejning med skulder, kopidrejning op til 30 ° og affasning med negative DN .. 11 og 15 størrelse skær. Fås med skaftstørrelse 20x20 op til 32x32 mm. Krop behandlet for længere levetid





| | 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 | 30 | -6 | -6 | 0.43 | GI046 | PD60 |
| | PDJNR 2525 M 11 | 25 | 25 | 25 | 32 | 150 | 30 | -6 | -6 | 0.73 | GI046 | PD60 |
| | PDJNR 3225 P 11 | 32 | 25 | 32 | 32 | 170 | 30 | -6 | -6 | 1.10 | GI046 | PD60 |
| | PDJNR 2020 K 15 | 20 | 20 | 20 | 25 | 125 | 40 | -6 | -6 | 0.44 | GI044 | PD31 |
| | PDJNR 2525 M 15 | 25 | 25 | 25 | 32 | 150 | 40 | -6 | -6 | 0.73 | GI044 | PD30 |
| | PDJNR 3225 P 15 | 32 | 25 | 32 | 32 | 170 | 40 | -6 | -6 | 1.05 | GI044 | PD30 |
| | PDJNR 3232 P 15 | 32 | 32 | 32 | 40 | 170 | 40 | -6 | -6 | 1.30 | GI044 | PD30 |
| L | PDJNL 2020 K 11 | 20 | 20 | 20 | 25 | 125 | 30 | -6 | -6 | 0.41 | GI046 | PD60 |
| | PDJNL 2525 M 11 | 25 | 25 | 25 | 32 | 150 | 30 | -6 | -6 | 0.73 | GI046 | PD60 |
| | PDJNL 3225 P 11 | 32 | 25 | 32 | 32 | 170 | 30 | -6 | -6 | 1.10 | GI046 | PD60 |
| | PDJNL 2020 K 15 | 20 | 20 | 20 | 25 | 125 | 40 | -6 | -6 | 0.42 | GI044 | PD31 |
| | PDJNL 2525 M 15 | 25 | 25 | 25 | 32 | 150 | 40 | -6 | -6 | 0.73 | GI044 | PD30 |
| | PDJNL 3225 P 15 | 32 | 25 | 32 | 32 | 170 | 40 | -6 | -6 | 0.98 | GI044 | PD30 |
| | PDJNL 3232 P 15 | 32 | 32 | 32 | 40 | 170 | 40 | -6 | -6 | 1.30 | GI044 | PD30 |

| | |
|---|---|
| GI044 | DN.. 1506.. |
| GI046 | DN.. 1104.. |

| | | | | Nm | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| PD30 | DNU 150308 | PU 03 | US 36 | 6.0 | M 8x1 | 26 | NT 05 | MT 05 | HXK 4 |
| PD31 | DNU 150308 | PU 03 | US 40 | 6.0 | M 8x1 | 20.5 | NT 05 | MT 05 | HXK 4 |
| PD60 | PDN 110308 | PU 3512 | PS 0616 | 3.0 | M 6 | 16 | NT 5153 | MT 0912 | HXK 2.5 |

# PDNN(RL) EXT

P M K N S H

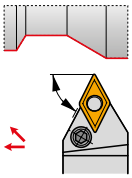
PRAMET

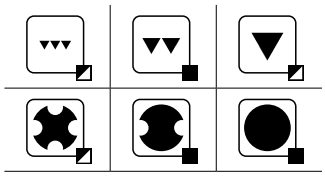
P

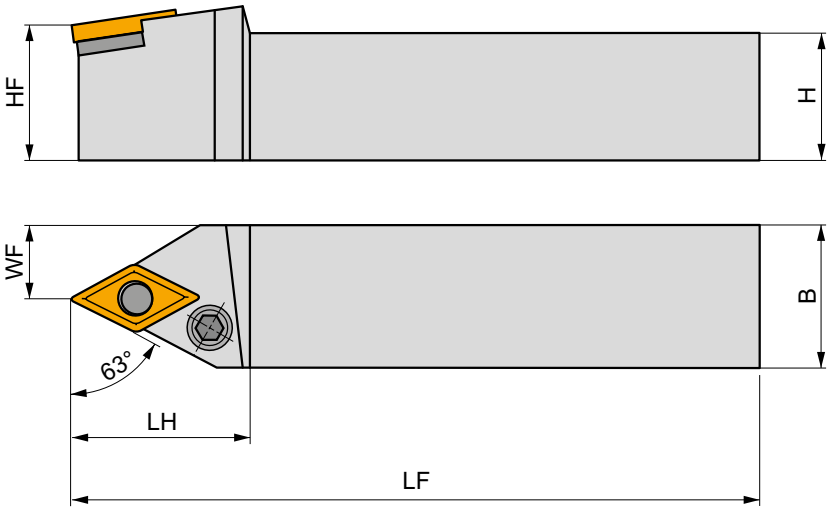


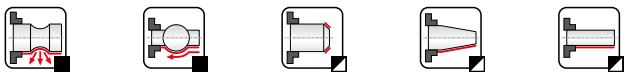
## Ekstern Lever Lock Drejeholder med 63 ° skærevinkel til DN .. Skær

Ekstern højre / venstre hånd 63 ° (neutral) værktøjsholder. Velegnet til langsgående drejning uden skulder, tilspidsning, kopi og affasning med negativ DN .. 15 størrelse skær. Fås med skaftstørrelse 20x20 op til 32x25 mm. Krop behandlet for længere levetid







| | 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 | 24 | -6 | -6 | 0.39 | GI046 | PD60 |
| | PDNNR 2525 M 11 | 25 | 25 | 25 | 12.5 | 150 | 30 | -6 | -6 | 0.60 | GI046 | PD60 |
| | PDNNR 2525 M 15 | 25 | 25 | 25 | 12.5 | 150 | 40 | -6 | -6 | 0.64 | GI044 | PD30 |
| | PDNNR 3225 P 15 | 32 | 25 | 32 | 12.5 | 170 | 40 | -6 | -6 | 1.05 | GI044 | PD30 |
| L | PDNNL 2020 K 11 | 20 | 20 | 20 | 10 | 125 | 24 | -6 | -6 | 0.40 | GI046 | PD60 |
| | PDNNL 2525 M 11 | 25 | 25 | 25 | 12.5 | 150 | 30 | -6 | -6 | 0.60 | GI046 | PD60 |
| | PDNNL 2525 M 15 | 25 | 25 | 25 | 12.5 | 150 | 40 | -6 | -6 | 0.07 | GI044 | PD30 |
| | PDNNL 3225 P 15 | 32 | 25 | 32 | 12.5 | 170 | 40 | -6 | -6 | 1.05 | GI044 | PD30 |

| | |
|---|---|
| GI044 | DN.. 1506.. |
| GI046 | DN.. 1104.. |

| | | | | Nm | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| PD30 | DNU 150308 | PU 03 | US 36 | 6.0 | M 8x1 | 26 | NT 05 | MT 05 | HXK 4 |
| PD60 | PDN 110308 | PU 3512 | PS 0616 | 3.0 | M 6 | 16 | NT 5153 | MT 0912 | HXK 2.5 |

# PDXN(RL) EXT

P M K N S H

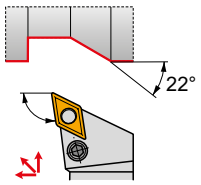
PRAMET

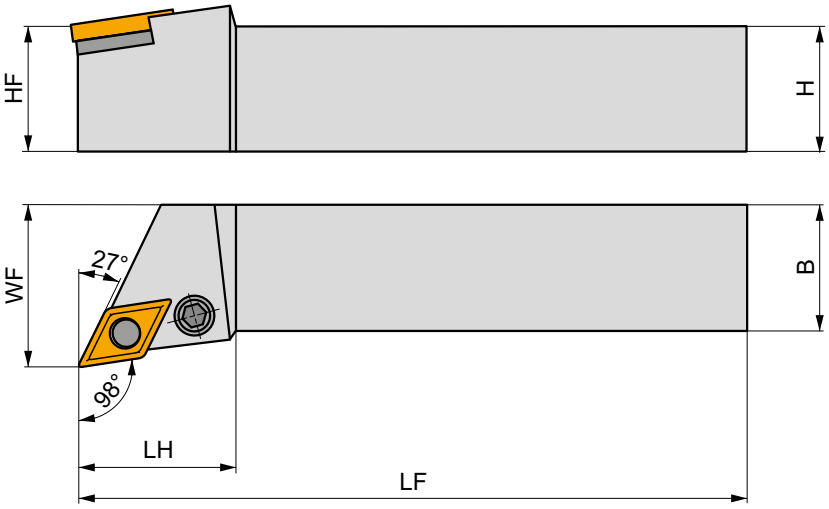
P

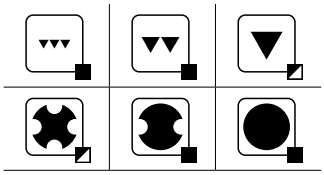


## Ekstern Lever Lock Drejeholder med 98 ° skærevinkel til DN .. Skær

Ekstern højre / venstre hånd værktøjsholder med 98 ° skærevinkel. Velegnet til konisk, langsgående drejning med skulder, kopidrejning op til 22 ° og affasning med negativ DN .. 15 størrelse skær. Fås i 20x20 op til 32x25 mm skaft. Krop behandlet for længere levetid





| | 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 | -6 | -6 | 0.43 | GI044 | PD31 |
| | **PDXNR 2525 M 15** | 25 | 25 | 25 | 32 | 150 | 40 | -6 | -6 | 0.73 | GI044 | PD30 |
| | **PDXNR 3225 P 15** | 32 | 25 | 32 | 32 | 170 | 40 | -6 | -6 | 0.80 | GI044 | PD30 |
| L | **PDXNL 2020 K 15** | 20 | 20 | 20 | 25 | 125 | 40 | -6 | -6 | 0.42 | GI044 | PD31 |
| | **PDXNL 2525 M 15** | 25 | 25 | 25 | 32 | 150 | 40 | -6 | -6 | 0.71 | GI044 | PD30 |
| | **PDXNL 3225 P 15** | 32 | 25 | 32 | 32 | 170 | 40 | -6 | -6 | 0.95 | GI044 | PD30 |

| | |
|---|---|
| GI044 | DN.. 1506.. |

| | | | | Nm | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| PD30 | DNU 150308 | PU 03 | US 36 | 6.0 | M 8x1 | 26 | NT 05 | MT 05 | HXK 4 |
| PD31 | DNU 150308 | PU 03 | US 40 | 6.0 | M 8x1 | 20.5 | NT 05 | MT 05 | HXK 4 |

NEW

# C.-DDJN(RL) EXT

P M K N S H

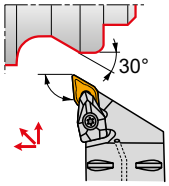
PRAMET

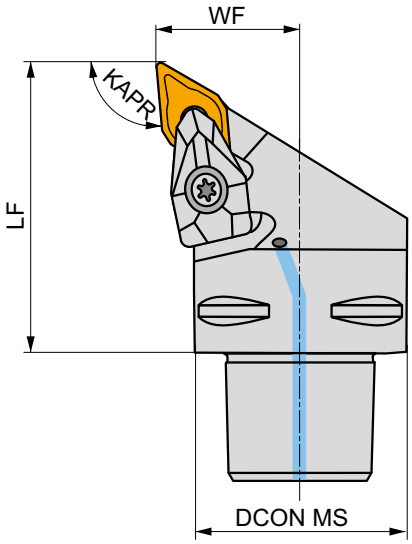
D

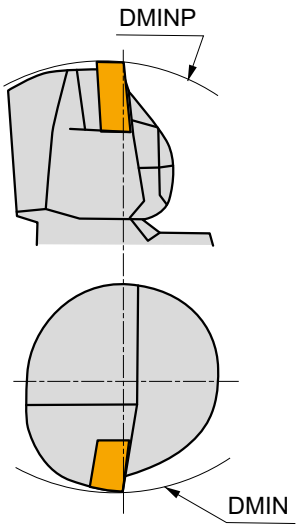


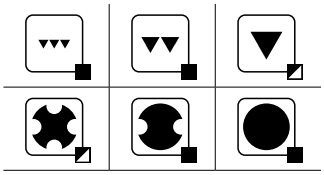
## Eksternt PSC hurtig skift værktøj, dobbelt klemme, 93 ° skærevinkel, DN .. Skær

Eksternt højre / venstre dobbeltklemmeværktøj, indvendig kølemiddel, med skærevinkel på 93 ° til konisk og langsgående drejning med skulder, kopiering og affasning med negative DN .. 11 eller 15 størrelse skær. Fås med PSC (Polygon Shank Coupling) C4 op til C6 kobling. Krop behandlet for længere levetid





| | 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 |

NEW

# C.-DDNNN EXT

P M K N S H

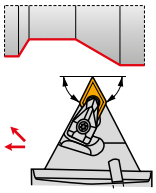
PRAMET

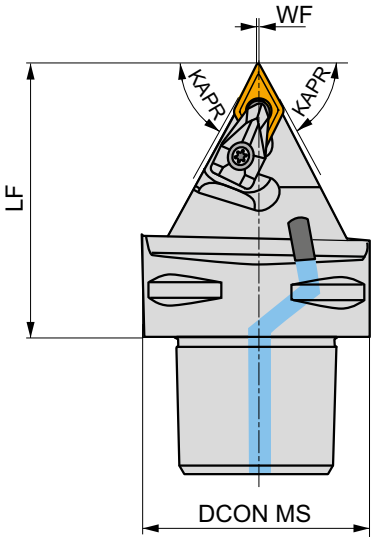
D

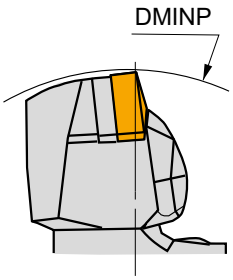


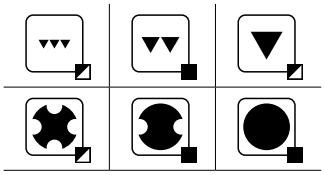
## Eksternt PSC hurtig skift værktøj, dobbelt klemme, 62.5 ° skærevinkel, DN .. Skær

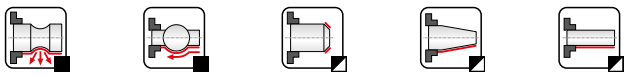
Eksternt højre / venstre dobbeltklemmeværktøj, indvendig kølevæske, med 62,5 ° skærevinkel til konisk og langsgående drejning uden skulder, kopiering og affasning med negative DN .. 15 skær. Fås med PSC (Polygon Shank Coupling) C5 og C6 kobling. Krop behandlet for længere levetid







| | 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 |

NEW

# C.-DDUN(RL) EXT

P M K N S H

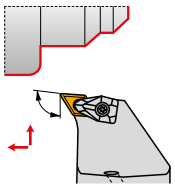
PRAMET

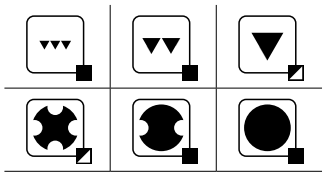
D

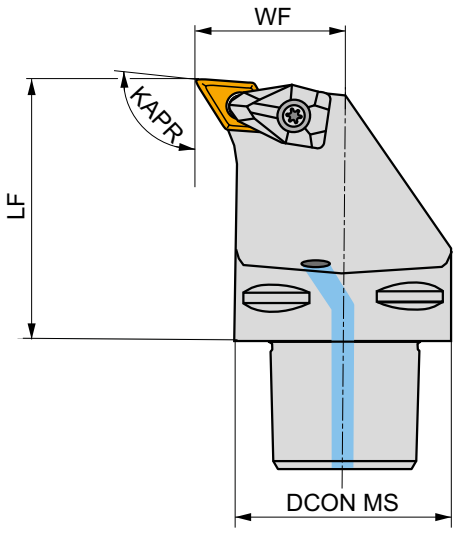


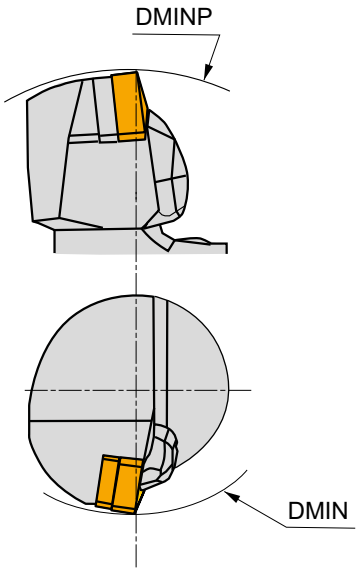
## Eksternt PSC hurtig skift værktøj, dobbelt klemme, 93 ° skærevinkel, DN .. Skær

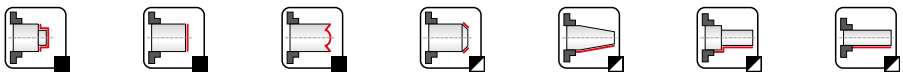
Eksternt højre / venstre hånd dobbeltklemmeværktøj, indvendig kølemiddel, med 93 ° skærevinkel til endedrejning med skulder, endekopiedrejning, konisk drejning, langsgående drejning og affasning med negative DN .. 15 størrelse skær. Fås med PSC (Polygon Shank Coupling) C5 og C6 kobling. Krop behandlet for længere levetid







| | 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

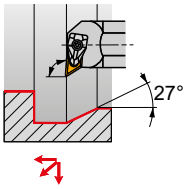
PRAMET

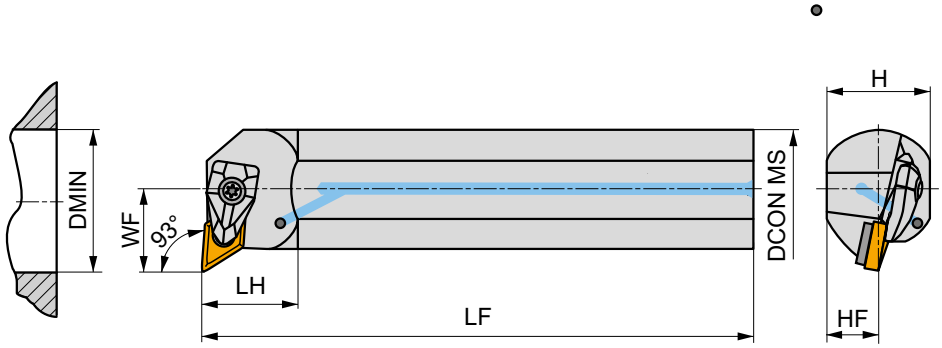
D

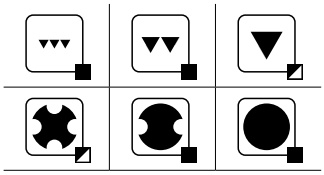


## Intern dobbeltklemmeholder med 93 ° skærevinkel til DN .. Skær

Intern højre / venstre hånd dobbelt klemme, indvendig kølemiddel, 93° skærevinkel til DN .. 11 og 15 skær. Mindste indvendige drejediameter Ø32 mm. Velegnet til en bred vifte af interne drejeprogrammer, kopidrejning op til 27 °. Fås med skaftstørrelse Ø25 op til Ø50 mm. Krop behandlet for længere levetid på værktøjet.





| | 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 | -12 | -6 | ✓ | 0.96 | GI046 | DD11 | – |
| | **A32T-DDUNR 11** | 32 | 40 | 22 | 30 | 15 | 300 | 30 | -10 | -6 | ✓ | 1.68 | GI046 | DD11 | – |
| | **A40T-DDUNR 15** | 40 | 50 | 27 | 37 | 18.5 | 300 | 36 | -11 | -6 | ✓ | 2.59 | GI044 | DD154 | AT002 |
| | **A50U-DDUNR 15** | 50 | 63 | 35 | 47 | 23.5 | 350 | 39 | -8 | -6 | ✓ | 5.23 | GI044 | DD154 | AT002 |
| L | **A25T-DDUNL 11** | 25 | 32 | 17 | 23 | 11.5 | 300 | 28 | -12 | -6 | ✓ | 0.96 | GI046 | DD11 | – |
| | **A32T-DDUNL 11** | 32 | 40 | 22 | 30 | 15 | 300 | 30 | -10 | -6 | ✓ | 1.69 | GI046 | DD11 | – |
| | **A40T-DDUNL 15** | 40 | 50 | 27 | 37 | 18.5 | 300 | 36 | -11 | -6 | ✓ | 2.59 | GI044 | DD154 | AT002 |
| | **A50U-DDUNL 15** | 50 | 63 | 35 | 47 | 23.5 | 350 | 39 | -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

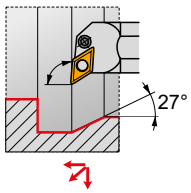
PRAMET

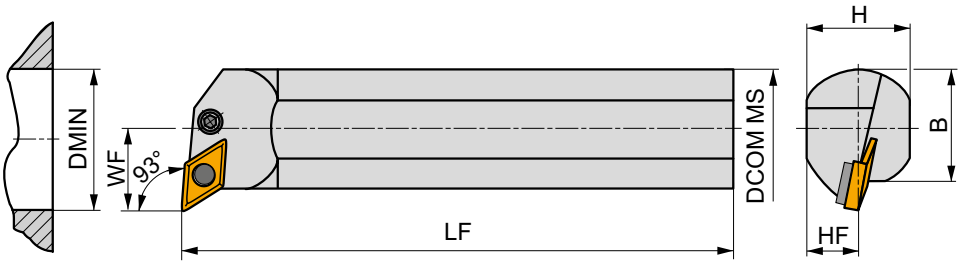
P

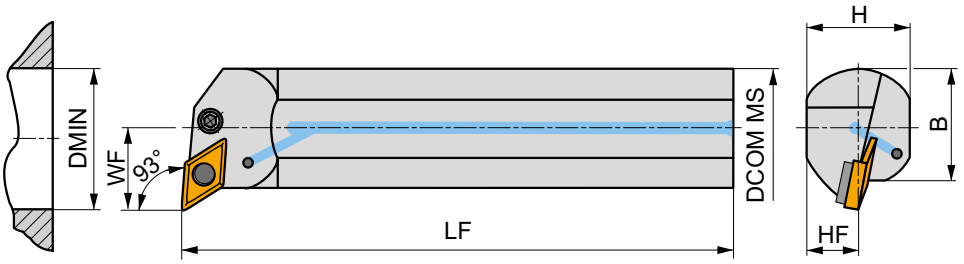


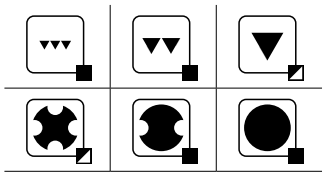
## Intern låseholder med 93 ° skærevinkel til DN .. Skær

Intern højre / venstre hånd, indvendig kølevæske til rådighed, 93° skærevinkel til DN .. 11 og 15 skær. Mindste indvendige drejediameter Ø32 mm. For en bred vifte af interne drejeprogrammer kopieres drejning op til 27 °. Fås med skaftstørrelse Ø25 op til Ø60 mm. Krop behandlet for længere levetid på værktøjet.





| | Product | DCON MS (mm) | DMIN (mm) | WF (mm) | H (mm) | B (mm) | LF (mm) | LAMS (°) | GAMO (°) | | kg | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| R | **S25T-PDUNR 11-A** | 25 | 32 | 17 | 23 | 23 | 300 | -12 | -6 | – | 1.10 | GI046 | PD61 |
| | **S32U-PDUNR 11** | 32 | 40 | 22 | 30 | 30 | 350 | -12 | -6 | – | 2.10 | GI046 | PD60 |
| | **A32S-PDUNR 15** | 32 | 40 | 32 | 30 | 30 | 250 | -12 | -6 | ✓ | 1.47 | GI097 | PD33 |
| | **A40T-PDUNR 15** | 40 | 50 | 27 | 38 | 38 | 300 | -12 | -6 | ✓ | 2.40 | GI097 | PD30 |
| | **A50U-PDUNR 15** | 50 | 63 | 35 | 47 | 48.5 | 350 | -12 | -6 | ✓ | 4.95 | GI097 | PD30 |
| | **A60V-PDUNR 15** | 60 | 80 | 43 | 57 | 58.5 | 400 | -12 | -6 | ✓ | 8.22 | GI097 | PD30 |
| L | **S25T-PDUNL 11-A** | 25 | 32 | 17 | 23 | 23 | 300 | -12 | -6 | – | 1.11 | GI046 | PD61 |
| | **S32U-PDUNL 11** | 32 | 40 | 22 | 30 | 30 | 350 | -12 | -6 | – | 2.09 | GI046 | PD60 |
| | **A32S-PDUNL 15** | 32 | 40 | 32 | 30 | 30 | 250 | -12 | -6 | ✓ | 1.47 | GI097 | PD33 |
| | **A40T-PDUNL 15** | 40 | 50 | 27 | 38 | 38 | 300 | -12 | -6 | ✓ | 2.56 | GI097 | PD30 |
| | **A50U-PDUNL 15** | 50 | 63 | 35 | 47 | 48.5 | 350 | -12 | -6 | ✓ | 5.20 | GI097 | PD30 |
| | **A60V-PDUNL 15** | 60 | 80 | 43 | 57 | 58.5 | 400 | -12 | -6 | ✓ | 8.16 | GI097 | PD30 |

| | |
|---|---|
| GI046 | DN.. 1104.. |
| GI097 | DN.. 1504.. |

| | | | | Nm | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| PD30 | DNU 150308 | PU 03 | US 36 | 6.0 | M 8x1 | 26 | NT 05 | MT 05 | HXK 4 |
| PD33 | – | PU 03-A | US 41 | 6.0 | M 8x1 | 17 | NT 15 | MT 05 | HXK 4 |
| PD60 | PDN 110308 | PU 3512 | PS 0616 | 3.0 | M 6 | 16 | NT 5153 | MT 0912 | HXK 2.5 |
| PD61 | – | PU 3611-A | PS 0512-A | 2.0 | M 5 | 12 | – | – | HXK 2 |

NEW

# C.-DDUN(RL) INT

P M K N S H

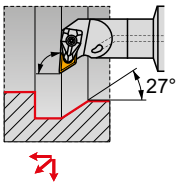
PRAMET

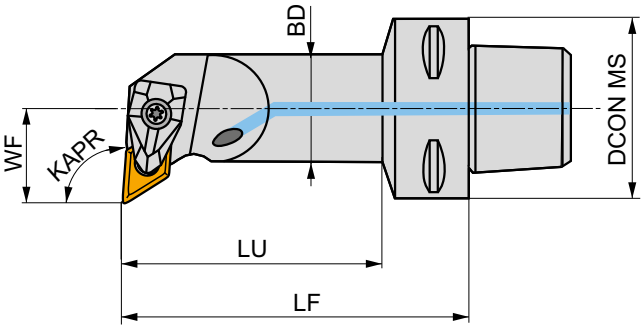
D

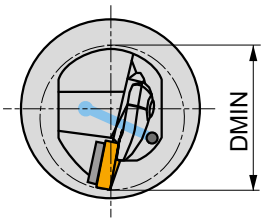


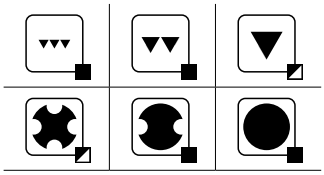
## Internt PSC Hurtig skift Værktøj, dobbelt klemme, 93 ° skærevinkel, DN .. Skær

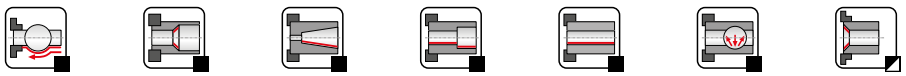
Internt højre / venstre hånd dobbelt klemme værktøj, indvendig kølemiddel, med 93° skærevinkel til indvendige drejeanvendelser inklusive kopidrejning op til 27 ° med DN .. 11 skær, minimum indvendig diameter Ø32mm. PSC-skaft (Polygon Shank Coupling) størrelse C4 med drejelængde på 68 mm. Krop behandlet for længere levetid på værktøjet.





| | 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.. |

| | | | | | |
|---|---|---|---|---|---|
| DD11 | DCS 09 | 1.7 | DDS 267-01 | US 2004-T09P | FLAG T09P |

# KN 16

## CARBIDE INSERTS

**KNUX**

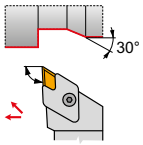


284

| MATCH THE RIGHT SIZE (example) | |
|---|---|
| **Insert** | **Tool Holder** |
| KNUX 160405L-22 | CKJNR 2020 K 16 |

## ISO-DREJNING – UDVENDIGT

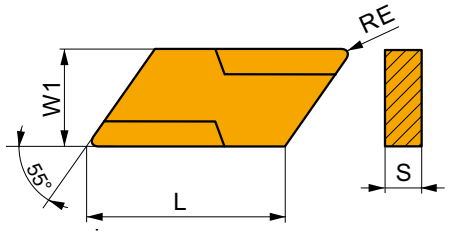
**CKJN(RL) EXT**

| 93° | KN.. |
|---|---|
|  |  16 |
|  20×20 32×25 | |
| 287 | 284 – 286 |

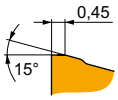
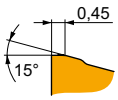
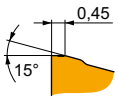
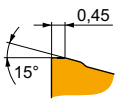
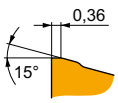
# KNUX

PRAMET

| | W1 (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 1604 | 9.525 | 19.50 | 4.76 |




Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | | | | | | | | | | | | | | | | | | |
| **KNUX 160405L-22** | **T5315** | 0.5 | 190 | 0.25 | 2.7 | – | – | – | 180 | 0.25 | 2.7 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 0.5 | 130 | 0.25 | 2.7 | 100 | 0.25 | 2.7 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 0.5 | 125 | 0.25 | 2.7 | 95 | 0.25 | 2.7 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.5 | 155 | 0.25 | 2.7 | 90 | 0.25 | 2.7 | 145 | 0.25 | 2.7 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.5 | 135 | 0.25 | 2.7 | 80 | 0.25 | 2.7 | – | – | – | – | – | – | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | | | | | | | | | | | | | | | | | | |
| **KNUX 160405R-22** | **T5315** | 0.5 | 190 | 0.25 | 2.7 | – | – | – | 180 | 0.25 | 2.7 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 0.5 | 130 | 0.25 | 2.7 | 100 | 0.25 | 2.7 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 0.5 | 125 | 0.25 | 2.7 | 95 | 0.25 | 2.7 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.5 | 155 | 0.25 | 2.7 | 90 | 0.25 | 2.7 | 145 | 0.25 | 2.7 | – | – | – | – | – | – | – | – | – |
| | **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 | – | – | – | – | – | – | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | | | | | | | | | | | | | | | | | | |
| **KNUX 160410R-22** | **T9335** | 1.0 | 155 | 0.32 | 2.7 | 90 | 0.29 | 2.7 | – | – | – | – | – | – | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | | | | | | | | | | | | | | | | | | |
| **KNUX 160405L-32** | **T5315** | 0.5 | 190 | 0.25 | 2.7 | – | – | – | 180 | 0.25 | 2.7 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 0.5 | 130 | 0.25 | 2.7 | 100 | 0.25 | 2.7 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 0.5 | 125 | 0.25 | 2.7 | 95 | 0.25 | 2.7 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.5 | 155 | 0.25 | 2.7 | 90 | 0.25 | 2.7 | 145 | 0.25 | 2.7 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.5 | 135 | 0.25 | 2.7 | 80 | 0.25 | 2.7 | – | – | – | – | – | – | – | – | – | – | – | – |


L-22 geometri med venstrehåndet design til fin til halv grov bearbejdning og kontinuerlige snit.

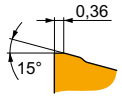
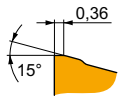
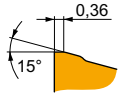
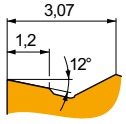
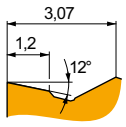
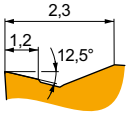
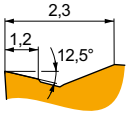
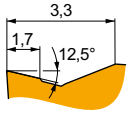

R-22 geometri med højrehåndet design til finish til halv grov bearbejdning og kontinuerlige snit.


L-22 geometri med venstrehåndet design til fin til halv grov bearbejdning og kontinuerlige snit.

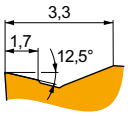

R-22 geometri med højrehåndet design til finish til halv grov bearbejdning og kontinuerlige snit.


L-32 geometri med venstrehåndet design til fin til halv grov bearbejdning og kontinuerlige snit.

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |   | | | | | | | | | | | | | | | | | | | |
| | | | U E | | | | | | | | | | | | | | | | | |
| | | | R-32 geometri med højrehåndet design til finish til halv grov bearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | |
| **KNUX 160405R-32** | **T5315** | 0.5 | ◪ 190 | 0.25 | 2.7 | – | – | – | ◪ 180 | 0.25 | 2.7 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 0.5 | ◪ 130 | 0.25 | 2.7 | ◪ 100 | 0.25 | 2.7 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 0.5 | ◪ 125 | 0.25 | 2.7 | ◪ 95 | 0.25 | 2.7 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.5 | ■ 155 | 0.25 | 2.7 | ◪ 90 | 0.25 | 2.7 | ◪ 145 | 0.25 | 2.7 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.5 | ■ 135 | 0.25 | 2.7 | ◪ 80 | 0.25 | 2.7 | – | – | – | – | – | – | – | – | – | – | – | – |
|  |   | | | | | | | | | | | | | | | | | | | |
| | | | U E | | | | | | | | | | | | | | | | | |
| | | | L-32 geometri med venstrehåndet design til fin til halv grov bearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | |
| **KNUX 160410L-32** | **T9325** | 1.0 | ■ 175 | 0.32 | 2.7 | ◪ 105 | 0.29 | 2.7 | ◪ 165 | 0.32 | 2.7 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.0 | ■ 155 | 0.32 | 2.7 | ◪ 90 | 0.29 | 2.7 | – | – | – | – | – | – | – | – | – | – | – | – |
|  |   | | | | | | | | | | | | | | | | | | | |
| | | | U E | | | | | | | | | | | | | | | | | |
| | | | R-32 geometri med højrehåndet design til finish til halv grov bearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | |
| **KNUX 160410R-32** | **T9325** | 1.0 | ■ 175 | 0.32 | 2.7 | ◪ 105 | 0.29 | 2.7 | ◪ 165 | 0.32 | 2.7 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.0 | ■ 155 | 0.32 | 2.7 | ◪ 90 | 0.29 | 2.7 | – | – | – | – | – | – | – | – | – | – | – | – |
|  |   | | | | | | | | | | | | | | | | | | | |
| | | | E | | | | | | | | | | | | | | | | | |
| | | | ER-72 geometri med højrehåndet design til finbearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | |
| **KNUX 160405ER-72** | **T5315** | 0.5 | ◪ 250 | 0.20 | 2.0 | – | – | – | ■ 235 | 0.20 | 2.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.5 | ■ 215 | 0.20 | 2.0 | ◪ 125 | 0.18 | 2.0 | ◪ 200 | 0.20 | 2.0 | – | – | – | ◪ 45 | 0.16 | 1.6 | – | – | – |
| | **T9335** | 0.5 | ■ 185 | 0.20 | 2.0 | ◪ 110 | 0.18 | 2.0 | – | – | – | – | – | – | ◪ 40 | 0.16 | 1.6 | – | – | – |
|  |   | | | | | | | | | | | | | | | | | | | |
| | | | E | | | | | | | | | | | | | | | | | |
| | | | EL-72 geometri med venstrehåndet design til finbearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | |
| **KNUX 160405EL-72** | **T5315** | 0.5 | ◪ 250 | 0.20 | 2.0 | – | – | – | ■ 235 | 0.20 | 2.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.5 | ■ 215 | 0.20 | 2.0 | ◪ 125 | 0.18 | 2.0 | ◪ 200 | 0.20 | 2.0 | – | – | – | ◪ 45 | 0.16 | 1.6 | – | – | – |
| | **T9335** | 0.5 | ■ 185 | 0.20 | 2.0 | ◪ 110 | 0.18 | 2.0 | – | – | – | – | – | – | ◪ 40 | 0.16 | 1.6 | – | – | – |
|  |   | | | | | | | | | | | | | | | | | | | |
| | | | E | | | | | | | | | | | | | | | | | |
| | | | ER-73 geometri med højrehåndet design til fin til halv grov bearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | |
| **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 | – | – | – | – | – | – | – | – | – |
| | **T5315** | 1.0 | ◪ 235 | 0.40 | 3.0 | – | – | – | ■ 220 | 0.40 | 3.0 | – | – | – | – | – | – | – | – | – |
|  |   | | | | | | | | | | | | | | | | | | | |
| | | | E | | | | | | | | | | | | | | | | | |
| | | | EL-73 geometri med venstrehåndet design til fin til halv grov bearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | |
| **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 | – | – | – | – | – | – | – | – | – |
|  |   | | | | | | | | | | | | | | | | | | | |
| | | | E | | | | | | | | | | | | | | | | | |
| | | | ER-74 geometri med positivt venstrehåndet design til finbearbejdning til halv grov bearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | |
| **KNUX 160415SR-74** | **6640** | 1.5 | ■ 155 | 0.45 | 3.0 | ◪ 90 | 0.41 | 3.0 | ■ 145 | 0.45 | 3.0 | – | – | – | – | – | – | – | – | – |

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |  | |  EL-74 geometri med venstrehåndet design til fin til hård bearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | |
| **KNUX 160415SL-74** | **6640** | 1.5 | ■ | 155 | 0.45 | 3.0 | ◪ | 90 | 0.41 | 3.0 | ■ | 145 | 0.45 | 3.0 | – | – | – | – | – | – | – | – | – |

# CKJN(RL) EXT

P M K N S H

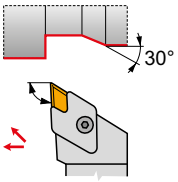
PRAMET

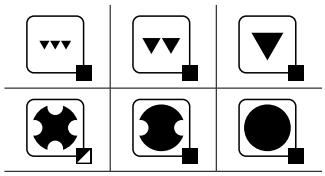
C

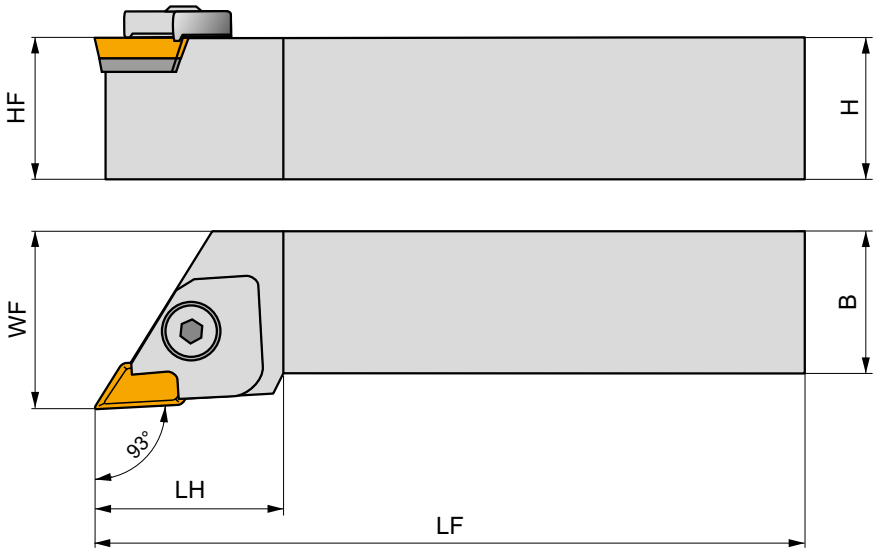


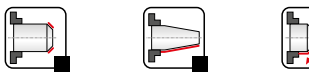
## Ekstern topklemme drejeholder med 93 ° skærevinkel til KN .. 16 skær

Ekstern højre / venstre håndholderholder med 93 ° skærevinkel. Velegnet til konisk, langsgående drejning med skulder, kopidrejning op til 30 ° og affasning med negative KN .. 16 størrelse skær. Fås i 20x20 op til 32x25 mm skaft. Krop behandlet for længere levetid på værktøjet.





| | Product | H (mm) | B (mm) | HF (mm) | WF (mm) | LF (mm) | LH (mm) | LAMS (°) | GAMO (°) | kg | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| R | **CKJNR 2020 K 16** | 20 | 20 | 20 | 30 | 125 | 34 | 1 | -5 | 0.43 | GI066 | R1 |
| | **CKJNR 2525 M 16** | 25 | 25 | 25 | 32 | 150 | 34 | 1 | -5 | 0.70 | GI066 | R |
| | **CKJNR 3225 P 16** | 32 | 25 | 32 | 32 | 170 | 34 | 1 | -5 | 1.05 | GI066 | R |
| L | **CKJNL 2020 K 16** | 20 | 20 | 20 | 30 | 125 | 34 | 1 | -5 | 0.43 | GI067 | L1 |
| | **CKJNL 2525 M 16** | 25 | 25 | 25 | 32 | 150 | 34 | 1 | -5 | 0.74 | GI067 | L |
| | **CKJNL 3225 P 16** | 32 | 25 | 32 | 32 | 170 | 34 | 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 |
| R | KNN 190412R | NT 03 | UP 25 | – | US 83 | 6.0 | PR 07 | K 23 | HXK 4 |
| R1 | KNN 190412R | NT 03 | UP 25 | – | US 83 | 6.0 | PR 07 | K 22 | HXK 4 |

# LN 40/ 50

## CARBIDE INSERTS

**LNUX 40, LN.X 50**

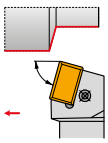


289

| MATCH THE RIGHT SIZE (example) | |
|---|---|
| **Insert** | **Tool Holder** |
| LNUX **40**-1129003 | KHP-LBNR **40**-A |

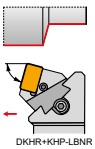
## ISO-DREJNING – UDVENDIGT

**PLBN(RL) EXT**

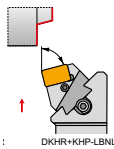
| 75° | LN.. |
|---|---|
|  |  40<br>50 |
| 60×60 | |
| 290 | 289 |

## ISO-DREJNING – GROVBEARBEJDNING UDVENDIGT

**KHP-LBNR + DKH(RL)**

| 75° | LN.. |
|---|---|
|  DKHR+KHP-LBNR |  40 |
| 40×50<br>60×80 | |
| 291, 292 | 289 |

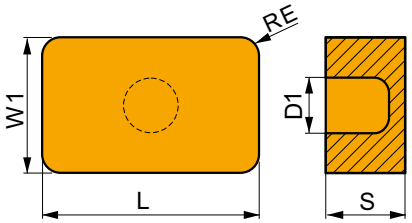
**KHP-LBNL + DKH(RL)**

| 75° | LN.. |
|---|---|
|  DKHR+KHP-LBNL |  40 |
| 40×50<br>60×80 | |
| 291, 292 | 289 |

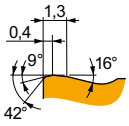
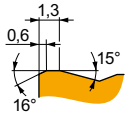
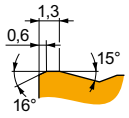
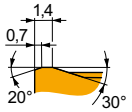
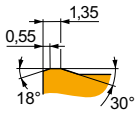
# LNUX 40, LN.X 50

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 |
| 50-2 | 25.400 | 6.45 | 50.80 | 14.00 |
| 5014 | 25.400 | 6.35 | 50.80 | 14.00 |




Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | Til kraftig hård bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **LNUX 40-1129002** | **T9226** | 3.2 | 45 | 1.35 | 25.0 | – | – | – | 40 | 1.35 | 25.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 3.2 | 55 | 1.35 | 25.0 | – | – | – | 50 | 1.35 | 25.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 3.2 | 40 | 1.35 | 25.0 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
|  |  | | Til kraftig hård bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **LNUX 40-1129003** | **T9226** | 3.2 | 45 | 1.35 | 25.0 | – | – | – | 40 | 1.35 | 25.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 3.2 | 55 | 1.35 | 25.0 | – | – | – | 50 | 1.35 | 25.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 3.2 | 40 | 1.35 | 25.0 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
|  |  | | Til kraftig hård bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **LNUX 50-1275000** | **T9226** | 3.2 | 45 | 1.35 | 25.0 | – | – | – | 40 | 1.35 | 25.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 3.2 | 55 | 1.35 | 25.0 | – | – | – | 50 | 1.35 | 25.0 | – | – | – | – | – | – | – | – | – |
|  |  | | Design til kraftig hård bearbejdning og kontinuerlig til kraftig afbrudt snit. | | | | | | | | | | | | | | | | | |
| **LNMX 501432E** | **T9335** | 3.2 | 45 | 1.50 | 25.0 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
|  |  | | Til kraftig hård bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **LNMX 50-2284000** | **T9315** | 3.2 | 60 | 1.50 | 25.0 | – | – | – | 55 | 1.50 | 25.0 | – | – | – | – | – | – | – | – | – |

# PLBN(RL) EXT

P M K

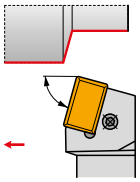
PRAMET

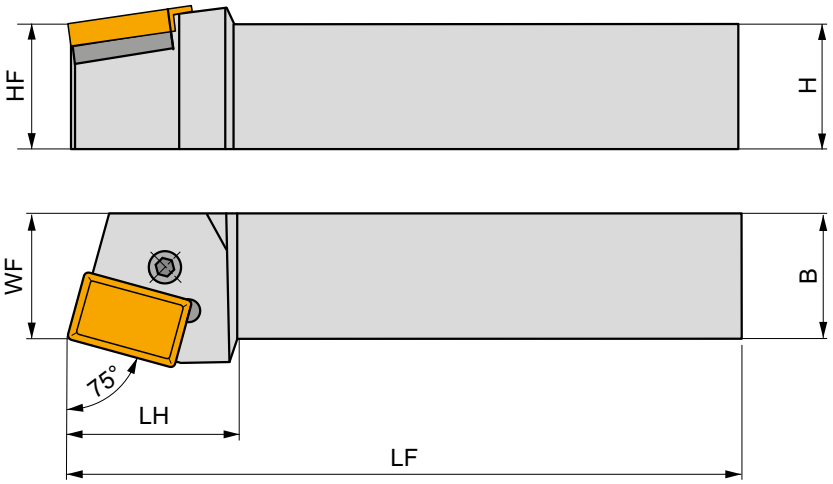
P

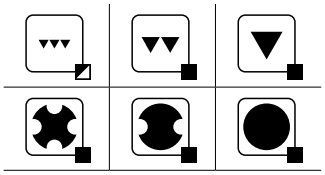


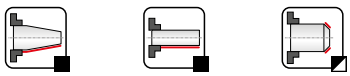
## Ekstern Lever Lock Kraftig drejeholder, 75 ° skærevinkel til LNUX-skær

Ekstern højre / venstre hånd Værktøjsholder med 75 ° skærevinkel til kraftig drejning. Velegnet til langsgående drejning uden skulder, tilspidsning og affasning med negativ LN .. 40 og 50 størrelse skær. Fås i 60x60 mm skaft. Krop behandlet for længere levetid







| | 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 | -6 | -6 | 13.00 | GI102 | PL71 |
| | **PLBNR 6060 V 50** | 60 | 60 | 60 | 60 | 400 | 70 | -6 | -6 | 12.75 | GI145 | PL72 |
| | **PLBNR 6060 V 50-2** | 60 | 60 | 60 | 60 | 400 | 70 | -6 | -6 | 11.60 | GI291 | PL73 |
| L | **PLBNL 6060 V 40-A** | 60 | 60 | 60 | 60 | 400 | 64 | -6 | -6 | 11.14 | GI102 | PL71 |
| | **PLBNL 6060 V 50** | 60 | 60 | 60 | 60 | 400 | 70 | -6 | -6 | 13.09 | GI145 | PL72 |

| | |
|---|---|
| GI102 | LNUX 40.... |
| GI145 | LNUX 50.... |
| GI291 | LNMX 50.... |

| | | | | Nm | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|
| 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 | SDR T15P |

# KHP-LBN(RL)

P M K

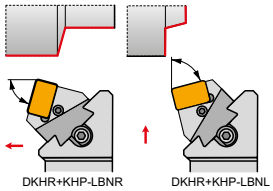
PRAMET

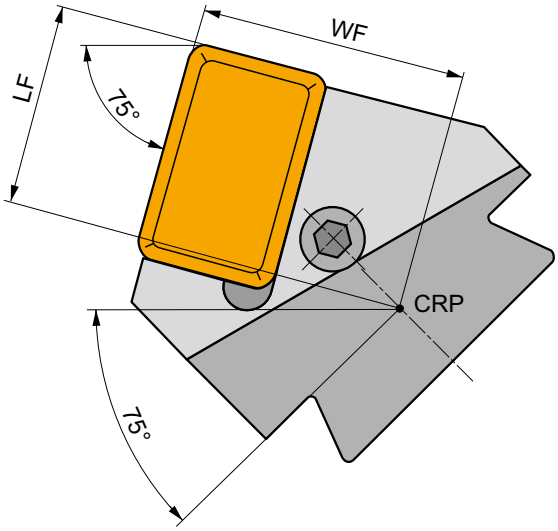
P

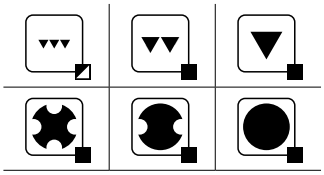


## Modulær KHP drejeholder, 75 ° skærevinkel til LNUX .. Skær

Drejeholder højre / venstre håndlås drejepatron, 75 ° skærevinkel, til montering på DKH værktøjsholderskaft. Velegnet til kraftig langsgående drejning uden hjørne, plandrejning, konisk drejning med fasning med negativ LNUX 40 skær. Værktøjsholder behandlet for længere værktøjslevetid.





| | 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 |

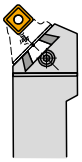
# DKH(RL)

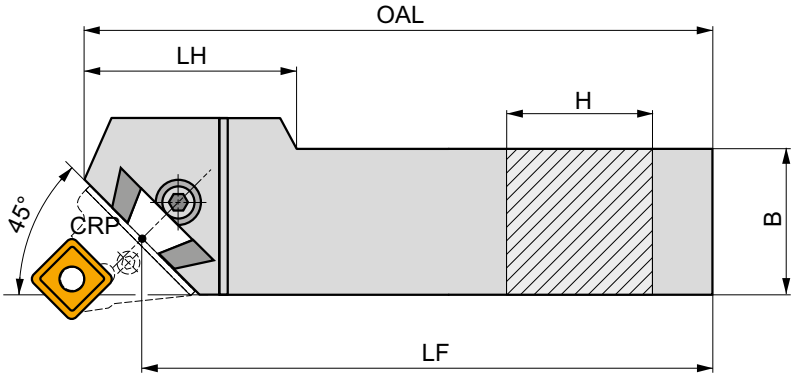
PRAMET

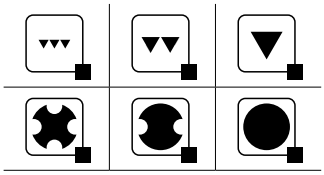


## Eksternt værktøjsholderskaft til KHP / KHS tung drejening

Drejeholder højre / venstre modulære værktøjsskaft til KHP / KHS patroner. Velegnet til tunge drejeprogrammer. Fås med skaftstørrelse 40x50 op til 60x80 mm. Krop behandlet for længere levetid





| | Product | H (mm) | B (mm) | LF (mm) | OAL (mm) | LH (mm) | kg | | |
|---|---|---|---|---|---|---|---|---|---|
| R | **DKHR 4050 V** | 40 | 50 | 400 | 425 | 100 | 7.10 | GI098 | DKH10 |
| | **DKHR 5060 W** | 50 | 60 | 450 | 475 | 110 | 11.30 | GI098 | DKH10 |
| | **DKHR 6080 W-A** | 60 | 80 | 450 | 485 | 90 | 19.65 | GI098 | DKH10 |
| L | **DKHL 4050 V** | 40 | 50 | 400 | 425 | 100 | 7.10 | GI098 | DKH10 |
| | **DKHL 5060 W** | 50 | 60 | 450 | 475 | 110 | 11.30 | GI098 | DKH10 |
| | **DKHL 6080 W-A** | 60 | 80 | 450 | 485 | 90 | 19.28 | GI098 | DKH10 |

| | | |
|---|---|---|
| GI098 | KHP | KHS |

| | | |
|---|---|---|
| DKH10 | SR 14 | HXK 10 |

# RN

09/ 12/ 15/ 19/ 25

## CARBIDE INSERTS

**RNMG**



294

## CER INSERTS

**RNGN CER**

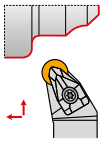


294

| MATCH THE RIGHT SIZE (example) | |
|---|---|
| **Insert** | **Tool Holder** |
| RNMG 120400E-08 | DRSNR 2525 M 12 |

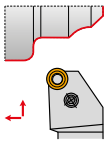
## ISO-DREJNING – UDVENDIGT

**DRSN(RL) EXT**



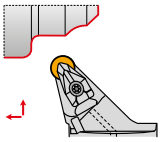
| RN.. |
|---|
| 12 |
| 25×25 |
| 295 |
| 294 |

**PRSN(RL) EXT**



| RN.. |
|---|
| 12<br>15<br>19 |
| 25×25<br>40×40 |
| 296 |
| 294 |

**C.-DRSN(RL) EXT** NEW

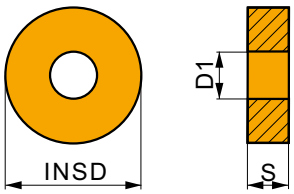


| RN.. |
|---|
| 12 |
| C6 |
| 297 |
| 294 |

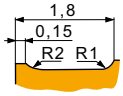
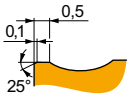
# RNMG

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 |



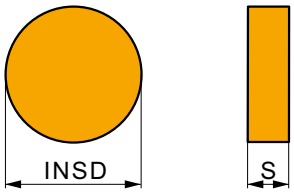

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| Product | | RE (mm) | P vc (m/min) | P f (mm/rev) | P ap (mm) | M vc | M f | M ap | K vc | K f | K ap | N vc | N f | N ap | S vc | S f | S ap | H vc | H f | H ap |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |   | | HFC S | | | | | | | | | | | | | | | | | |
| Geometri 08 til semi-grovtil tung-grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **RNMG 120400E-08** | **T5305** | – | 195 | 0.70 | 3.0 | – | – | – | 185 | 0.70 | 3.0 | – | – | – | – | – | – | 35 | 0.15 | 1.0 |
| | **T9315** | – | 150 | 0.70 | 3.0 | – | – | – | 140 | 0.70 | 3.0 | – | – | – | – | – | – | 30 | 0.15 | 1.0 |
| | **T9325** | – | 135 | 0.70 | 3.0 | – | – | – | 125 | 0.70 | 3.0 | – | – | – | – | – | – | – | – | – |
| **RNMG 150600E-08** | **T5305** | – | 295 | 0.70 | 3.0 | – | – | – | 280 | 0.70 | 3.0 | – | – | – | – | – | – | 55 | 0.15 | 1.0 |
| | **T9315** | – | 225 | 0.70 | 3.0 | – | – | – | 210 | 0.70 | 3.0 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |
| | **T9325** | – | 205 | 0.70 | 3.0 | – | – | – | 190 | 0.70 | 3.0 | – | – | – | – | – | – | – | – | – |
| **RNMG 190600E-08** | **T9315** | – | 150 | 0.70 | 3.0 | – | – | – | 140 | 0.70 | 3.0 | – | – | – | – | – | – | 30 | 0.15 | 1.0 |
| | **T9325** | – | 135 | 0.70 | 3.0 | – | – | – | 125 | 0.70 | 3.0 | – | – | – | – | – | – | – | – | – |
|  |   | | HFC P | | | | | | | | | | | | | | | | | |
| Geometri 081 til hård til meget hård bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **RNMG 250900E-081** | **T9315** | – | 145 | 0.90 | 5.0 | – | – | – | 135 | 0.90 | 5.0 | – | – | – | – | – | – | 25 | 0.15 | 1.0 |
| | **T9325** | – | 130 | 0.90 | 5.0 | – | – | – | 120 | 0.90 | 5.0 | – | – | – | – | – | – | – | – | – |

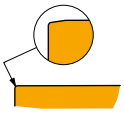
# RNGN CER

PRAMET

| | INSD (mm) | S (mm) |
|---|---|---|
| 0903 | 9.525 | 3.18 |
| 1204 | 12.700 | 4.76 |
| 1207 | 12.700 | 7.94 |




Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| Product | | RE (mm) | P vc (m/min) | P f (mm/rev) | P ap (mm) | M vc | M f | M ap | K vc | K f | K ap | N vc | N f | N ap | S vc | S f | S ap | H vc | H f | H ap |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | HSC T | | | | | | | | | | | | | | | | | |
| Til bearbejdning med høje hastigheder og kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **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 | – | – | – | – | – | – | – | – | – |

# DRSN(RL) EXT

P M K H

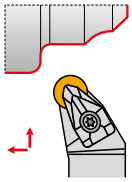
PRAMET

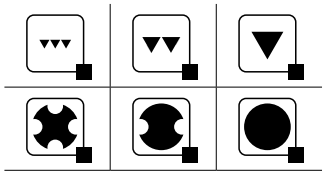
D

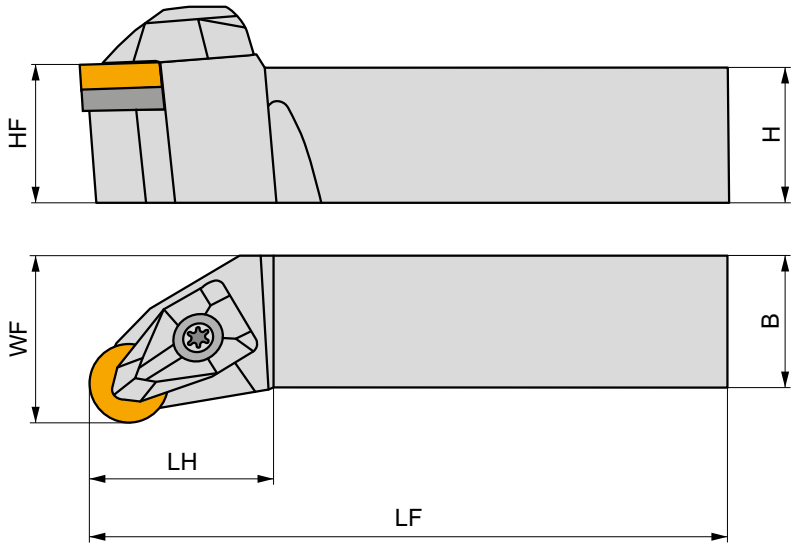


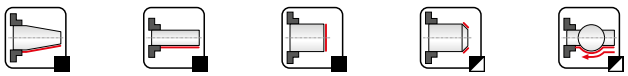
## Ekstern dobbeltholder til RN .. Skær

Ekstern højre / venstre håndholder til dobbelt klemme. Velegnet til langsgående drejning uden skulder, kopidrejning, tilspidsning og affasning med negativ rund RN .. 12 størrelse skær. Fås i 25x25 mm skaft. Krop behandlet for længere levetid







| | 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 |

| | | | | | |
|---|---|---|---|---|---|
| DR12 | DCS 12 | 3.9 | DRS 155-02 | US 2002-T15P | FLAG T15P/3,5 |

# PRSN(RL) EXT

P M K H

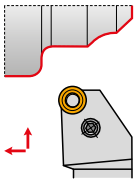
PRAMET

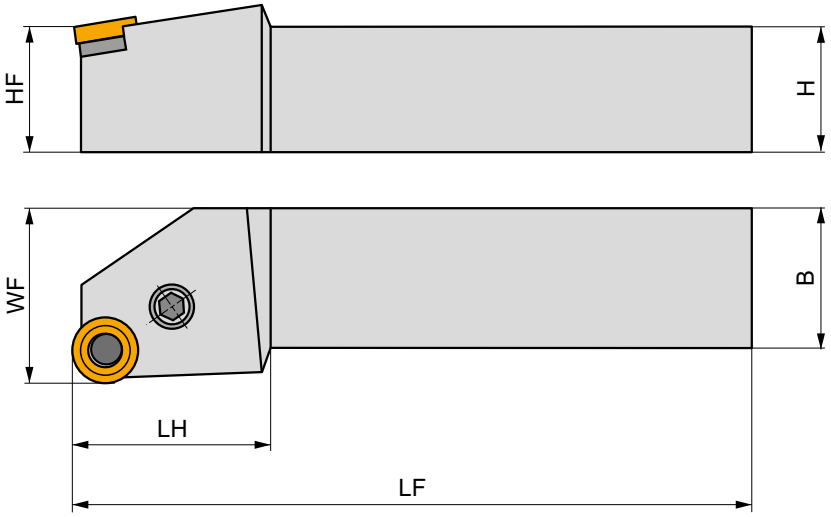
P

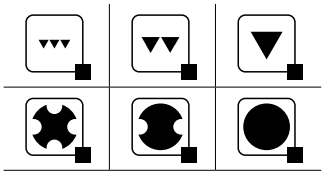


## Ekstern Lever Lock holder til RN .. Skær

Ekstern højre / venstre hånd værktøjsholder. Velegnet til langsgående drejning, kopidrejning op til 90 °, konisk drejning og affasning med negativ runde RN .. 12, 15 og 19 størrelse skær. Fås i 25x25 op til 40x40 mm skaft. Krop behandlet for længere levetid







| | 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 | 32 | -6 | -6 | 0.68 | GI083 | PR20 |
| | **PRSNR 3232 P 15** | 32 | 32 | 32 | 40 | 170 | 38 | -6 | -6 | 1.40 | GI105 | PR40 |
| | **PRSNR 4040 R 19** | 40 | 40 | 40 | 50 | 200 | 40 | -6 | -6 | 2.49 | GI106 | PR50 |
| L | **PRSNL 2525 M 12** | 25 | 25 | 25 | 32 | 150 | 32 | -6 | -6 | 0.74 | GI083 | PR20 |
| | **PRSNL 3232 P 15** | 32 | 32 | 32 | 40 | 170 | 38 | -6 | -6 | 1.40 | GI105 | PR40 |
| | **PRSNL 4040 R 19** | 40 | 40 | 40 | 50 | 200 | 40 | -6 | -6 | 2.48 | GI106 | PR50 |

| | |
|---|---|
| GI083 | RN.. 120400 |
| GI105 | RN.. 150600 |
| GI106 | RN.. 190600 |

| | | | | Nm | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| PR20 | RNU 120300 | PU 02 | US 35 | 6.0 | M 8x1 | 22.5 | NT 05 | MT 05 | HXK 4 |
| PR40 | RNU 150300 | PU 04 | US 36 | 6.0 | M 8x1 | 26 | NT 07 | MT 07 | HXK 4 |
| PR50 | RNU 190400 | PU 05 | US 38 | 8.0 | M 10x1 | 29 | NT 06 | MT 06 | HXK 5 |

NEW

# C.-DRSN(RL) EXT

P M K H

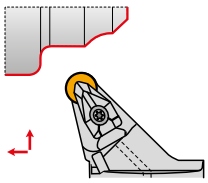
PRAMET

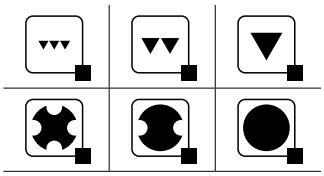
D

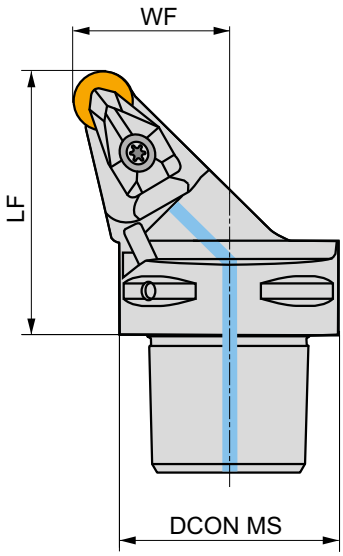


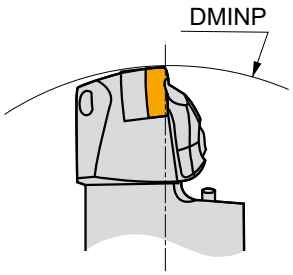
## Eksternt PSC hurtig skift værktøj, dobbelt klemme til RN .. Skær

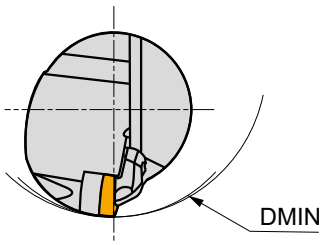
Eksternt højre / venstre dobbeltklemmeværktøj, indvendig kølevæske, til langsgående drejning uden skulder, kopidrejning, konisk drejning og affasning med negativ runde RN .. 12 størrelse skær. Fås med PSC (Polygon Shank Coupling) C6 skaft. Krop behandlet for længere levetid

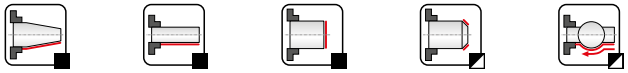






| | Product | DCON MS (mm) | DMIN (mm) | DMINP (mm) | WF (mm) | LF (mm) | LAMS (°) | GAMO (°) | | kg | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| R | C6-DRSNR-45065-12 | 63 | 110 | 190 | 45 | 65 | -6 | -6 | ✓ | 1.11 | GI083 | C-DR12 | – |
| L | C6-DRSNL-45065-12 | 63 | 110 | 190 | 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 |

# SN

09/ 12/ 15/ 19/ 25

## CARBIDE INSERTS

**SNMA**



300

**SNMG**



301

**SNMM**



307

**SNMX**



311

## CER INSERTS

**SNGA CER**



311

**SNGN CER**



312

**MATCH THE RIGHT SIZE (example)**

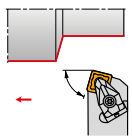
| Insert | Tool Holder |
|---|---|
| SNMG 190616E-RM | DSDNN 3232 P 19 |

## ISO-DREJNING – UDVENDIGT

### DSBN(RL) EXT

75°

SN..: 12, 15, 19



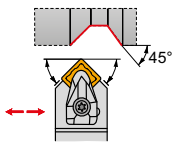
20×20, 40×40

313 | 300 – 312

### DSDNN EXT

45°

SN..: 12, 15, 19, 25



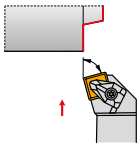

20×20, 40×40

315 | 300 – 312

### DSKN(RL) EXT

75°

SN..: 12, 19



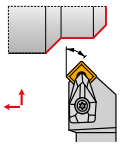
25×25, 32×32

316 | 300 – 312

### DSSN(RL) EXT

45°

SN..: 12, 15, 19



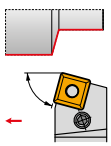
20×20, 40×40

317 | 300 – 312

### PSBN(RL) EXT

75°

SN..: 12, 15, 19, 25



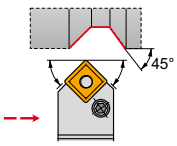
20×20, 50×50

318 | 300 – 312

### PSDNN EXT

45°

SN..: 12, 15, 19, 25



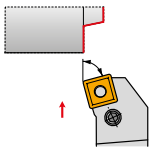

20×20, 50×50

320 | 300 – 312

### PSKN(RL) EXT

75°

SN..: 12, 15, 19, 25



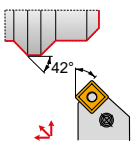
20×20, 50×50

321 | 300 – 312

### PSSN(RL) EXT

45°

SN..: 19, 25




40×40, 50×50

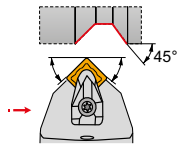
323 | 300 – 312

# SN

09/ 12/ 15/ 19/ 25

## C.-DSDNN EXT NEW

45°




SN..

12
19

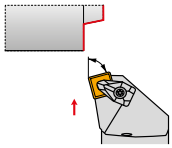
C4 / C6

324

300 – 312

## C.-DSKN(RL) EXT NEW

75°



SN..

12

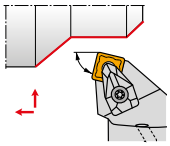
C4

325

300 – 312

## C.-DSRN(RL) EXT NEW

75°



SN..

12
19

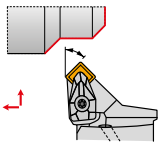
C4 / C6

326

300 – 312

## C.-DSSN(RL) EXT NEW

45°



SN..

12

C4 / C5

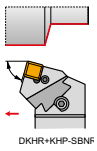
327

300 – 312

## ISO-DREJNING – GROVBEARBEJDNING UDVENDIGT

## KHP-SBNR + DKH(RL)

75°




SN..

25

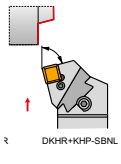
40×50 / 60×80

328, 330

300 – 312

## KHP-SBNL + DKH(RL)

75°




SN..

25

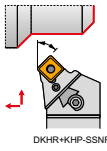
40×50 / 60×80

328, 330

300 – 312

## KHP-SSNR/L + DKH(RL)

45°




SN..

19
25

40×50 / 60×80

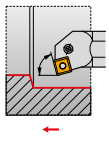
329, 330

300 – 312

## ISO-DREJNING – INDVENDIG

## PSKN(RL) INT

93°



SN..

11
15




32 / 80

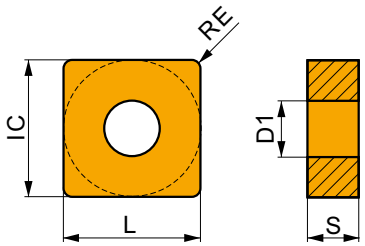
331

300 – 312

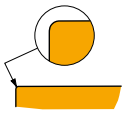
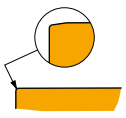
# SNMA

PRAMET

| | IC (mm) | D1 (mm) | L (mm) | S (mm) |
|---|---|---|---|---|
| 1204 | 12.700 | 5.16 | 12.70 | 4.76 |
| 1506 | 15.875 | 6.35 | 15.875 | 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 | 9.525 |



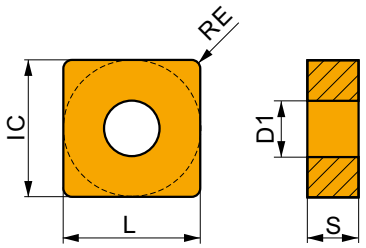

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | |  | | | | | | | | | | | | | | | | | |
| | | | Til fin til halv grov bearbejdning og kontinuerlig til let afbrudt snit. | | | | | | | | | | | | | | | | | |
| **SNMA 120408** | **T5305** | 0.8 | – | – | – | – | – | – | 230 | 0.20 | 4.0 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |
| | **T5315** | 0.8 | – | – | – | – | – | – | 200 | 0.20 | 4.0 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| | **T6310** | 0.8 | – | – | – | – | – | – | 100 | 0.20 | 4.0 | – | – | – | – | – | – | 25 | 0.15 | 1.0 |
| **SNMA 120412** | **T5305** | 1.2 | – | – | – | – | – | – | 205 | 0.30 | 4.0 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| | **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 |
| | **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 |
| | **T5315** | 1.2 | – | – | – | – | – | – | 180 | 0.30 | 6.0 | – | – | – | – | – | – | 35 | 0.15 | 1.0 |
| **SNMA 190616** | **T5305** | 1.6 | – | – | – | – | – | – | 190 | 0.40 | 6.0 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| | **T5315** | 1.6 | – | – | – | – | – | – | 170 | 0.40 | 6.0 | – | – | – | – | – | – | 35 | 0.15 | 1.0 |
| **SNMA 250724** | **T5305** | 2.4 | – | – | – | – | – | – | 95 | 0.60 | 8.0 | – | – | – | – | – | – | 20 | 0.15 | 1.0 |
| | **T5315** | 2.4 | – | – | – | – | – | – | 90 | 0.60 | 8.0 | – | – | – | – | – | – | 15 | 0.15 | 1.0 |
| **SNMA 250924** | **T5305** | 2.4 | – | – | – | – | – | – | 95 | 0.60 | 8.0 | – | – | – | – | – | – | 20 | 0.15 | 1.0 |
| | **T5315** | 2.4 | – | – | – | – | – | – | 90 | 0.60 | 8.0 | – | – | – | – | – | – | 15 | 0.15 | 1.0 |
|  |  | |  | | | | | | | | | | | | | | | | | |
| | | | Til fin til halv grov bearbejdning og kontinuerlig til let afbrudt snit. | | | | | | | | | | | | | | | | | |
| **SNMA 120412S** | **T5305** | 1.2 | – | – | – | – | – | – | 205 | 0.30 | 4.0 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| **SNMA 190616S** | **T5305** | 1.6 | – | – | – | – | – | – | 195 | 0.30 | 6.0 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| **SNMA 250724S** | **T5305** | 2.4 | – | – | – | – | – | – | 95 | 0.60 | 8.0 | – | – | – | – | – | – | 20 | 0.15 | 1.0 |
| **SNMA 250924S** | **T5305** | 2.4 | – | – | – | – | – | – | 95 | 0.60 | 8.0 | – | – | – | – | – | – | 20 | 0.15 | 1.0 |

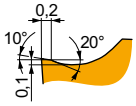
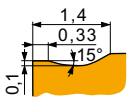
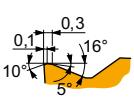
# SNMG

PRAMET

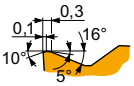
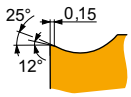
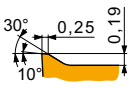
| | IC (mm) | D1 (mm) | L (mm) | S (mm) |
|---|---|---|---|---|
| 1204 | 12.700 | 5.16 | 12.70 | 4.76 |
| 1506 | 15.875 | 6.35 | 15.875 | 6.35 |
| 1906 | 19.050 | 7.94 | 19.05 | 6.35 |
| 2507 | 25.400 | 9.12 | 25.40 | 7.94 |
| 2509 | 25.400 | 9.12 | 25.40 | 9.525 |



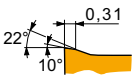
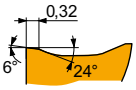

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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-geometri med positivt design til fin til halvgrov bearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | |
| **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 | – | – | – |
| | **T7325** | 0.4 | ◪ 195 | 0.20 | 2.1 | ◪ 150 | 0.18 | 2.1 | – | – | – | – | – | – | ◪ 60 | 0.16 | 1.7 | – | – | – |
| | **T8315** | 0.4 | ◪ 180 | 0.20 | 2.1 | ◪ 105 | 0.18 | 2.1 | ■ 170 | 0.20 | 2.1 | – | – | – | ◪ 45 | 0.14 | 1.7 | – | – | – |
| | **T8330** | 0.4 | ■ 175 | 0.20 | 2.1 | ◪ 105 | 0.18 | 2.1 | ■ 165 | 0.20 | 2.1 | – | – | – | ◪ 40 | 0.14 | 1.7 | – | – | – |
| | **T8430** | 0.4 | ■ 195 | 0.20 | 2.1 | ◪ 105 | 0.18 | 2.1 | ◪ 160 | 0.20 | 2.1 | – | – | – | ◪ 40 | 0.14 | 1.7 | – | – | – |
| | **T9315** | 0.4 | ■ 270 | 0.20 | 2.1 | – | – | – | ◪ 255 | 0.20 | 2.1 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | ■ 240 | 0.20 | 2.1 | ◪ 140 | 0.18 | 2.1 | ◪ 225 | 0.20 | 2.1 | – | – | – | ◪ 50 | 0.16 | 1.7 | – | – | – |
| **SNMG 120408E-FM** | **T7325** | 0.8 | ◪ 235 | 0.20 | 2.1 | ◪ 180 | 0.18 | 2.1 | – | – | – | – | – | – | ◪ 75 | 0.16 | 1.7 | – | – | – |
| | **T8315** | 0.8 | ◪ 215 | 0.20 | 2.1 | ◪ 125 | 0.18 | 2.1 | ■ 200 | 0.20 | 2.1 | – | – | – | ◪ 50 | 0.16 | 1.7 | – | – | – |
| | **T8330** | 0.8 | ■ 205 | 0.20 | 2.1 | ◪ 120 | 0.18 | 2.1 | ■ 190 | 0.20 | 2.1 | – | – | – | ◪ 50 | 0.16 | 1.7 | – | – | – |
| | **T8430** | 0.8 | ■ 235 | 0.20 | 2.1 | ◪ 125 | 0.18 | 2.1 | ◪ 190 | 0.20 | 2.1 | – | – | – | ◪ 50 | 0.16 | 1.7 | – | – | – |
| | **T9310** | 0.8 | ■ 355 | 0.20 | 2.1 | – | – | – | ◪ 335 | 0.20 | 2.1 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.8 | ■ 320 | 0.20 | 2.1 | – | – | – | ◪ 300 | 0.20 | 2.1 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | ■ 290 | 0.20 | 2.1 | ◪ 170 | 0.18 | 2.1 | ◪ 275 | 0.20 | 2.1 | – | – | – | ◪ 65 | 0.16 | 1.7 | – | – | – |
| **SNMG 120412E-FM** | **T8330** | 1.2 | ■ 200 | 0.27 | 2.1 | ◪ 120 | 0.24 | 2.1 | ■ 190 | 0.27 | 2.1 | – | – | – | ◪ 50 | 0.19 | 1.7 | – | – | – |
| | **T8430** | 1.2 | ■ 220 | 0.27 | 2.1 | ◪ 120 | 0.24 | 2.1 | ◪ 180 | 0.27 | 2.1 | – | – | – | ◪ 45 | 0.19 | 1.7 | – | – | – |
| | **T9315** | 1.2 | ■ 300 | 0.27 | 2.1 | – | – | – | ◪ 285 | 0.27 | 2.1 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | ■ 270 | 0.27 | 2.1 | ◪ 160 | 0.24 | 2.1 | ◪ 255 | 0.27 | 2.1 | – | – | – | ◪ 60 | 0.19 | 1.7 | – | – | – |
| **SNMG 120416E-FM** | **T8330** | 1.6 | ■ 200 | 0.32 | 2.1 | ◪ 120 | 0.29 | 2.1 | ■ 190 | 0.32 | 2.1 | – | – | – | ◪ 50 | 0.22 | 1.7 | – | – | – |
| | **T8430** | 1.6 | ■ 220 | 0.32 | 2.1 | ◪ 120 | 0.29 | 2.1 | ◪ 180 | 0.32 | 2.1 | – | – | – | ◪ 45 | 0.22 | 1.7 | – | – | – |
| | **T9325** | 1.6 | ■ 260 | 0.32 | 2.1 | ◪ 155 | 0.29 | 2.1 | ◪ 245 | 0.32 | 2.1 | – | – | – | ◪ 55 | 0.22 | 1.7 | – | – | – |
|  |  | |  | | | | | | | | | | | | | | | | | |
| | | | KR-geometri til semi-grov til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **SNMG 120408E-KR** | **T5305** | 0.8 | ◪ 265 | 0.35 | 3.8 | – | – | – | ■ 250 | 0.35 | 3.8 | – | – | – | – | – | – | ◪ 50 | 0.15 | 1.0 |
| | **T5315** | 0.8 | ◪ 235 | 0.35 | 3.8 | – | – | – | ■ 220 | 0.35 | 3.8 | – | – | – | – | – | – | ◪ 45 | 0.15 | 1.0 |
| **SNMG 120412E-KR** | **T5305** | 1.2 | ◪ 265 | 0.40 | 3.8 | – | – | – | ■ 250 | 0.40 | 3.8 | – | – | – | – | – | – | ◪ 50 | 0.15 | 1.0 |
| | **T5315** | 1.2 | ◪ 240 | 0.40 | 3.8 | – | – | – | ■ 225 | 0.40 | 3.8 | – | – | – | – | – | – | ◪ 45 | 0.15 | 1.0 |
|  |  | |  | | | | | | | | | | | | | | | | | |
| | | | M-geometri til fin til halv grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **SNMG 120408E-M** | **T5305** | 0.8 | ◪ 290 | 0.32 | 2.1 | – | – | – | ■ 275 | 0.32 | 2.1 | – | – | – | – | – | – | ◪ 55 | 0.15 | 1.0 |
| | **T5315** | 0.8 | ◪ 260 | 0.32 | 2.1 | – | – | – | ■ 245 | 0.32 | 2.1 | – | – | – | – | – | – | ◪ 50 | 0.15 | 1.0 |
| | **T9310** | 0.8 | ■ 255 | 0.32 | 2.1 | – | – | – | ◪ 240 | 0.32 | 2.1 | – | – | – | – | – | – | ◪ 50 | 0.15 | 1.0 |
| | **T9315** | 0.8 | ■ 235 | 0.32 | 2.1 | – | – | – | ◪ 220 | 0.32 | 2.1 | – | – | – | – | – | – | ◪ 45 | 0.15 | 1.0 |
| | **T9325** | 0.8 | ■ 210 | 0.32 | 2.1 | – | – | – | ◪ 195 | 0.32 | 2.1 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.8 | ■ 185 | 0.32 | 2.1 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |

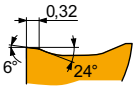
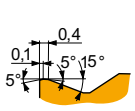
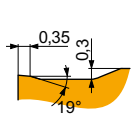
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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-geometri til fin til halv grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **SNMG 120412E-M** | **T9315** | 1.2 | ■ 230 | 0.40 | 2.1 | – | – | – | ◪ 215 | 0.40 | 2.1 | – | – | – | – | – | – | ◪ 45 | 0.15 | 1.0 |
| | **T9325** | 1.2 | ■ 200 | 0.40 | 2.1 | – | – | – | ◪ 190 | 0.40 | 2.1 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.2 | ■ 175 | 0.40 | 2.1 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **SNMG 120416E-M** | **T9325** | 1.6 | ■ 210 | 0.40 | 2.1 | – | – | – | ◪ 195 | 0.40 | 2.1 | – | – | – | – | – | – | – | – | – |
| **SNMG 150612E-M** | **T9315** | 1.2 | ■ 220 | 0.40 | 3.4 | – | – | – | ◪ 205 | 0.40 | 3.4 | – | – | – | – | – | – | ◪ 40 | 0.15 | 1.0 |
| | **T9325** | 1.2 | ■ 195 | 0.40 | 3.4 | – | – | – | ◪ 185 | 0.40 | 3.4 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.2 | ■ 170 | 0.40 | 3.4 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **SNMG 190612E-M** | **T9315** | 1.2 | ■ 215 | 0.40 | 4.0 | – | – | – | ◪ 200 | 0.40 | 4.0 | – | – | – | – | – | – | ◪ 40 | 0.15 | 1.0 |
| | **T9325** | 1.2 | ■ 190 | 0.40 | 4.0 | – | – | – | ◪ 180 | 0.40 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.2 | ■ 165 | 0.40 | 4.0 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **SNMG 190616E-M** | **T9315** | 1.6 | ■ 225 | 0.40 | 4.0 | – | – | – | ◪ 210 | 0.40 | 4.0 | – | – | – | – | – | – | ◪ 45 | 0.15 | 1.0 |
| | **T9325** | 1.6 | ■ 200 | 0.40 | 4.0 | – | – | – | ◪ 190 | 0.40 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.6 | ■ 175 | 0.40 | 4.0 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
|  |  | | NF-geometri med meget positivt design til finbearbejdning til medium bearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | |
| **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 | – | – | – |
| | **T7325** | 0.4 | ◪ 210 | 0.18 | 1.7 | ■ 160 | 0.16 | 1.7 | – | – | – | – | – | – | ◪ 65 | 0.16 | 1.4 | – | – | – |
| | **T7335** | 0.4 | ◪ 205 | 0.18 | 1.7 | ■ 155 | 0.16 | 1.7 | – | – | – | – | – | – | ◪ 65 | 0.16 | 1.4 | – | – | – |
| | **T8330** | 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 | – | – | – |
| | **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 | – | – | – |
| | **T9315** | 0.4 | ■ 300 | 0.17 | 1.7 | – | – | – | ◪ 285 | 0.17 | 1.7 | – | – | – | – | – | – | – | – | – |
| | **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 | – | – | – | – | – | – |
| | **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 | – | – | – |
| | **T7325** | 0.8 | ◪ 245 | 0.19 | 1.7 | ■ 190 | 0.17 | 1.7 | – | – | – | – | – | – | ◪ 75 | 0.15 | 1.4 | – | – | – |
| | **T7335** | 0.8 | ◪ 240 | 0.19 | 1.7 | ■ 185 | 0.17 | 1.7 | – | – | – | – | – | – | ◪ 75 | 0.15 | 1.4 | – | – | – |
| | **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 | – | – | – |
| | **T8330** | 0.8 | ■ 210 | 0.19 | 1.7 | ■ 125 | 0.17 | 1.7 | ◪ 195 | 0.19 | 1.7 | ◪ 630 | 0.23 | 1.7 | ◪ 50 | 0.15 | 1.4 | – | – | – |
| | **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 | – | – | – |
| | **T9315** | 0.8 | ■ 340 | 0.19 | 1.7 | – | – | – | ◪ 320 | 0.19 | 1.7 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | ■ 300 | 0.19 | 1.7 | ■ 180 | 0.17 | 1.7 | ◪ 285 | 0.19 | 1.7 | – | – | – | ◪ 65 | 0.15 | 1.4 | – | – | – |
|  |  | | NM-geometri med meget positivt design til finbearbejdning, mellem og grov bearbejdning i kontinuerlige snit. | | | | | | | | | | | | | | | | | |
| **SNMG 120408E-NM** | **T7325** | 0.8 | ◪ 225 | 0.25 | 2.1 | ■ 175 | 0.23 | 2.1 | – | – | – | – | – | – | ■ 70 | 0.20 | 1.7 | – | – | – |
| | **T7335** | 0.8 | ◪ 220 | 0.25 | 2.1 | ■ 170 | 0.23 | 2.1 | – | – | – | – | – | – | ■ 70 | 0.20 | 1.7 | – | – | – |
| | **T8315** | 0.8 | ◪ 215 | 0.25 | 2.1 | ■ 125 | 0.23 | 2.1 | – | – | – | ◪ 645 | 0.30 | 2.1 | ◪ 50 | 0.20 | 1.7 | – | – | – |
| | **T8330** | 0.8 | ■ 205 | 0.25 | 2.1 | ■ 120 | 0.23 | 2.1 | – | – | – | ◪ 615 | 0.30 | 2.1 | ◪ 50 | 0.20 | 1.7 | – | – | – |
| | **T8430** | 0.8 | ■ 225 | 0.25 | 2.1 | ■ 120 | 0.23 | 2.1 | – | – | – | ◪ 615 | 0.30 | 2.1 | ◪ 45 | 0.20 | 1.7 | – | – | – |
| | **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 | – | – | – |
| | **T7335** | 1.2 | ◪ 220 | 0.30 | 2.1 | ■ 170 | 0.27 | 2.1 | – | – | – | – | – | – | ■ 70 | 0.24 | 1.7 | – | – | – |
| | **T8315** | 1.2 | ◪ 215 | 0.30 | 2.1 | ■ 125 | 0.27 | 2.1 | – | – | – | ◪ 645 | 0.36 | 2.1 | ◪ 50 | 0.24 | 1.7 | – | – | – |
| | **T9325** | 1.2 | ■ 270 | 0.30 | 2.1 | ■ 160 | 0.27 | 2.1 | – | – | – | – | – | – | ◪ 60 | 0.24 | 1.7 | – | – | – |

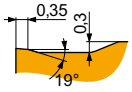
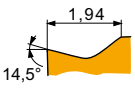
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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-geometri med positivt design til medium til grov bearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | |
| **SNMG 120408E-NMR** | **T6310** | 0.8 | ■ | 155 | 0.35 | 2.6 | ■ | 110 | 0.32 | 2.6 | – | – | – | – | – | – | ■ | 45 | 0.25 | 2.1 | – | – | – |
| | **T7325** | 0.8 | ◪ | 175 | 0.35 | 2.6 | ■ | 135 | 0.32 | 2.6 | – | – | – | – | – | – | ■ | 55 | 0.25 | 2.1 | – | – | – |
| | **T7335** | 0.8 | ◪ | 165 | 0.35 | 2.6 | ■ | 125 | 0.32 | 2.6 | – | – | – | – | – | – | ■ | 50 | 0.25 | 2.1 | – | – | – |
| | **T8330** | 0.8 | ■ | 155 | 0.35 | 2.6 | ■ | 90 | 0.32 | 2.6 | – | – | – | – | – | – | ◪ | 35 | 0.25 | 2.1 | – | – | – |
| | **T8430** | 0.8 | ■ | 165 | 0.35 | 2.6 | ■ | 90 | 0.32 | 2.6 | – | – | – | – | – | – | ◪ | 35 | 0.25 | 2.1 | – | – | – |
| | **T9315** | 0.8 | ■ | 225 | 0.35 | 2.6 | | – | – | – | – | – | – | – | – | – | | – | – | – | – | – | – |
| | **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 | – | – | – |
| | **T7325** | 1.2 | ◪ | 175 | 0.40 | 2.6 | ■ | 135 | 0.36 | 2.6 | – | – | – | – | – | – | ■ | 55 | 0.28 | 2.1 | – | – | – |
| | **T7335** | 1.2 | ◪ | 165 | 0.40 | 2.6 | ■ | 125 | 0.36 | 2.6 | – | – | – | – | – | – | ■ | 50 | 0.28 | 2.1 | – | – | – |
| | **T9315** | 1.2 | ■ | 225 | 0.40 | 2.6 | | – | – | – | – | – | – | – | – | – | | – | – | – | – | – | – |
| | **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 | – | – | – |
| | **T7335** | 1.6 | ◪ | 170 | 0.45 | 2.6 | ■ | 130 | 0.41 | 2.6 | – | – | – | – | – | – | ■ | 55 | 0.32 | 2.1 | – | – | – |
| | **T9325** | 1.6 | ■ | 200 | 0.45 | 2.6 | ■ | 120 | 0.41 | 2.6 | – | – | – | – | – | – | ◪ | 45 | 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 | – | – | – |
| | **T7325** | 1.2 | ◪ | 170 | 0.40 | 3.8 | ■ | 130 | 0.36 | 3.8 | – | – | – | – | – | – | ■ | 55 | 0.28 | 3.0 | – | – | – |
| | **T9315** | 1.2 | ■ | 215 | 0.40 | 3.8 | | – | – | – | – | – | – | – | – | – | | – | – | – | – | – | – |
| | **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 | – | – | – |
| | **T7325** | 1.2 | ◪ | 165 | 0.40 | 5.2 | ■ | 125 | 0.36 | 5.2 | – | – | – | – | – | – | ■ | 50 | 0.28 | 4.2 | – | – | – |
| | **T7335** | 1.2 | ◪ | 155 | 0.40 | 5.2 | ■ | 120 | 0.36 | 5.2 | – | – | – | – | – | – | ■ | 50 | 0.28 | 4.2 | – | – | – |
| | **T9315** | 1.2 | ■ | 210 | 0.40 | 5.2 | | – | – | – | – | – | – | – | – | – | | – | – | – | – | – | – |
| | **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 | – | – | – |
| | **T7325** | 1.6 | ◪ | 170 | 0.45 | 5.2 | ■ | 130 | 0.41 | 5.2 | – | – | – | – | – | – | ■ | 55 | 0.32 | 4.2 | – | – | – |
| | **T7335** | 1.6 | ◪ | 155 | 0.45 | 5.2 | ■ | 120 | 0.41 | 5.2 | – | – | – | – | – | – | ■ | 50 | 0.32 | 4.2 | – | – | – |
| | **T9315** | 1.6 | ■ | 205 | 0.45 | 5.2 | | – | – | – | – | – | – | – | – | – | | – | – | – | – | – | – |
| | **T9325** | 1.6 | ■ | 185 | 0.45 | 5.2 | ■ | 110 | 0.41 | 5.2 | – | – | – | – | – | – | ◪ | 40 | 0.32 | 4.2 | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | NRM-geometri med positivt design til halv grov til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **SNMG 120408-NRM** | **T7325** | 0.8 | ◪ | 175 | 0.35 | 2.6 | ■ | 135 | 0.32 | 2.6 | – | – | – | – | – | – | ■ | 55 | 0.28 | 2.1 | – | – | – |
| | **T7335** | 0.8 | ◪ | 165 | 0.35 | 2.6 | ■ | 125 | 0.32 | 2.6 | – | – | – | – | – | – | ■ | 50 | 0.28 | 2.1 | – | – | – |
| | **T9315** | 0.8 | ■ | 225 | 0.35 | 2.6 | | – | – | – | – | – | – | – | – | – | | – | – | – | – | – | – |
| **SNMG 120412-NRM** | **T7325** | 1.2 | ◪ | 175 | 0.40 | 3.0 | ■ | 135 | 0.36 | 3.0 | – | – | – | – | – | – | ■ | 55 | 0.28 | 2.4 | – | – | – |
| | **T7335** | 1.2 | ◪ | 165 | 0.40 | 3.0 | ■ | 125 | 0.36 | 3.0 | – | – | – | – | – | – | ■ | 50 | 0.28 | 2.4 | – | – | – |
| | **T9315** | 1.2 | ■ | 220 | 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 | – | – | – |
| | **T7335** | 1.2 | ◪ | 160 | 0.40 | 4.0 | ■ | 120 | 0.36 | 4.0 | – | – | – | – | – | – | ■ | 50 | 0.32 | 3.2 | – | – | – |
| | **T9315** | 1.2 | ■ | 215 | 0.40 | 4.0 | | – | – | – | – | – | – | – | – | – | | – | – | – | – | – | – |
| **SNMG 150616-NRM** | **T7325** | 1.6 | ◪ | 170 | 0.45 | 5.0 | ■ | 130 | 0.41 | 5.0 | – | – | – | – | – | – | ■ | 55 | 0.36 | 4.0 | – | – | – |
| | **T7335** | 1.6 | ◪ | 155 | 0.45 | 5.0 | ■ | 120 | 0.41 | 5.0 | – | – | – | – | – | – | ■ | 50 | 0.36 | 4.0 | – | – | – |
| | **T9315** | 1.6 | ■ | 205 | 0.45 | 5.0 | | – | – | – | – | – | – | – | – | – | | – | – | – | – | – | – |
| **SNMG 190612-NRM** | **T7325** | 1.2 | ◪ | 165 | 0.40 | 5.2 | ■ | 125 | 0.36 | 5.2 | – | – | – | – | – | – | ■ | 50 | 0.32 | 4.2 | – | – | – |
| | **T7335** | 1.2 | ◪ | 155 | 0.40 | 5.2 | ■ | 120 | 0.36 | 5.2 | – | – | – | – | – | – | ■ | 50 | 0.32 | 4.2 | – | – | – |
| | **T9315** | 1.2 | ■ | 210 | 0.40 | 5.2 | | – | – | – | – | – | – | – | – | – | | – | – | – | – | – | – |
| **SNMG 190616-NRM** | **T7325** | 1.6 | ◪ | 170 | 0.45 | 5.2 | ■ | 130 | 0.41 | 5.2 | – | – | – | – | – | – | ■ | 55 | 0.36 | 4.2 | – | – | – |
| | **T7335** | 1.6 | ◪ | 155 | 0.45 | 5.2 | ■ | 120 | 0.41 | 5.2 | – | – | – | – | – | – | ■ | 50 | 0.36 | 4.2 | – | – | – |
| | **T9315** | 1.6 | ■ | 205 | 0.45 | 5.2 | | – | – | – | – | – | – | – | – | – | | – | – | – | – | – | – |
| **SNMG 250724-NRM** | **T7325** | 2.4 | ◪ | 105 | 0.65 | 9.0 | ■ | 80 | 0.59 | 9.0 | – | – | – | – | – | – | ■ | 30 | 0.46 | 7.2 | – | – | – |
| | **T7335** | 2.4 | ◪ | 100 | 0.65 | 9.0 | ■ | 75 | 0.59 | 9.0 | – | – | – | – | – | – | ■ | 30 | 0.46 | 7.2 | – | – | – |
| | **T9315** | 2.4 | ■ | 120 | 0.65 | 9.0 | | – | – | – | ◪ | 110 | 0.65 | 9.0 | – | – | – | – | – | – | – | – | – |

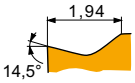
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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-geometri med positivt design til halv grov til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **SNMG 250924-NRM** | **T7325** | 2.4 | ◪ 105 | 0.70 | 9.0 | ■ 80 | 0.63 | 9.0 | – | – | – | – | – | – | ■ 30 | 0.49 | 7.2 | – | – | – |
| | **T7335** | 2.4 | ◪ 95 | 0.70 | 9.0 | ■ 70 | 0.63 | 9.0 | – | – | – | – | – | – | ■ 30 | 0.49 | 7.2 | – | – | – |
| | **T9315** | 2.4 | ■ 120 | 0.70 | 9.0 | – | – | – | ◪ 110 | 0.70 | 9.0 | – | – | – | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | R-geometri til semi-grov til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **SNMG 120408E-R** | **6640** | 0.8 | ■ 145 | 0.40 | 3.8 | – | – | – | ■ 135 | 0.40 | 3.8 | – | – | – | – | – | – | – | – | – |
| | **T5305** | 0.8 | ◪ 250 | 0.40 | 3.8 | – | – | – | ■ 235 | 0.40 | 3.8 | – | – | – | – | – | – | ◪ 50 | 0.15 | 1.0 |
| | **T9315** | 0.8 | ■ 200 | 0.40 | 3.8 | – | – | – | ◪ 190 | 0.40 | 3.8 | – | – | – | – | – | – | ◪ 40 | 0.15 | 1.0 |
| | **T9325** | 0.8 | ■ 180 | 0.40 | 3.8 | – | – | – | ◪ 170 | 0.40 | 3.8 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.8 | ■ 155 | 0.40 | 3.8 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **SNMG 120412E-R** | **T5305** | 1.2 | ◪ 255 | 0.45 | 3.8 | – | – | – | ■ 240 | 0.45 | 3.8 | – | – | – | – | – | – | ◪ 50 | 0.15 | 1.0 |
| | **T9310** | 1.2 | ■ 220 | 0.45 | 3.8 | – | – | – | ◪ 205 | 0.45 | 3.8 | – | – | – | – | – | – | ◪ 40 | 0.15 | 1.0 |
| | **T9325** | 1.2 | ■ 180 | 0.45 | 3.8 | – | – | – | ◪ 170 | 0.45 | 3.8 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.2 | ■ 160 | 0.45 | 3.8 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **SNMG 120416E-R** | **T9315** | 1.6 | ■ 205 | 0.50 | 3.8 | – | – | – | ◪ 190 | 0.50 | 3.8 | – | – | – | – | – | – | ◪ 40 | 0.15 | 1.0 |
| | **T9325** | 1.6 | ■ 185 | 0.50 | 3.8 | – | – | – | ◪ 175 | 0.50 | 3.8 | – | – | – | – | – | – | – | – | – |
| **SNMG 150612E-R** | **T5305** | 1.2 | ◪ 250 | 0.45 | 4.5 | – | – | – | ■ 235 | 0.45 | 4.5 | – | – | – | – | – | – | ◪ 50 | 0.15 | 1.0 |
| | **T5315** | 1.2 | ◪ 230 | 0.45 | 4.5 | – | – | – | ■ 215 | 0.45 | 4.5 | – | – | – | – | – | – | ◪ 45 | 0.15 | 1.0 |
| | **T9315** | 1.2 | ■ 200 | 0.45 | 4.5 | – | – | – | ◪ 190 | 0.45 | 4.5 | – | – | – | – | – | – | ◪ 40 | 0.15 | 1.0 |
| | **T9325** | 1.2 | ■ 180 | 0.45 | 4.5 | – | – | – | ◪ 170 | 0.45 | 4.5 | – | – | – | – | – | – | – | – | – |
| **SNMG 150616E-R** | **T5315** | 1.6 | ◪ 230 | 0.50 | 4.5 | – | – | – | ■ 215 | 0.50 | 4.5 | – | – | – | – | – | – | ◪ 45 | 0.15 | 1.0 |
| | **T9325** | 1.6 | ■ 180 | 0.50 | 4.5 | – | – | – | ◪ 170 | 0.50 | 4.5 | – | – | – | – | – | – | – | – | – |
| **SNMG 190612E-R** | **6640** | 1.2 | ■ 140 | 0.45 | 6.0 | – | – | – | ■ 130 | 0.45 | 6.0 | – | – | – | – | – | – | – | – | – |
| | **T9310** | 1.2 | ■ 210 | 0.45 | 6.0 | – | – | – | ◪ 195 | 0.45 | 6.0 | – | – | – | – | – | – | ◪ 40 | 0.15 | 1.0 |
| | **T9315** | 1.2 | ■ 195 | 0.45 | 6.0 | – | – | – | ◪ 185 | 0.45 | 6.0 | – | – | – | – | – | – | ◪ 35 | 0.15 | 1.0 |
| | **T9325** | 1.2 | ■ 175 | 0.45 | 6.0 | – | – | – | ◪ 165 | 0.45 | 6.0 | – | – | – | – | – | – | – | – | – |
| **SNMG 190616E-R** | **T9310** | 1.6 | ■ 205 | 0.50 | 6.0 | – | – | – | ◪ 190 | 0.50 | 6.0 | – | – | – | – | – | – | ◪ 40 | 0.15 | 1.0 |
| | **T9315** | 1.6 | ■ 195 | 0.50 | 6.0 | – | – | – | ◪ 185 | 0.50 | 6.0 | – | – | – | – | – | – | ◪ 35 | 0.15 | 1.0 |
| | **T9325** | 1.6 | ■ 175 | 0.50 | 6.0 | – | – | – | ◪ 165 | 0.50 | 6.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.6 | ■ 150 | 0.50 | 6.0 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | RM-geometri til semi-grov til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **SNMG 120408E-RM** | **T5305** | 0.8 | ◪ 290 | 0.40 | 4.0 | – | – | – | ◪ 275 | 0.40 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T5315** | 0.8 | ◪ 260 | 0.40 | 4.0 | – | – | – | ◪ 245 | 0.40 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T6310** | 0.8 | ■ 165 | 0.40 | 4.0 | ◪ 115 | 0.36 | 4.0 | ◪ 130 | 0.40 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 0.8 | ◪ 185 | 0.40 | 4.0 | ◪ 140 | 0.36 | 4.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 0.8 | ◪ 175 | 0.40 | 4.0 | ◪ 135 | 0.36 | 4.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.8 | ◪ 175 | 0.40 | 4.0 | ◪ 105 | 0.36 | 4.0 | ◪ 165 | 0.40 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.8 | ■ 165 | 0.40 | 4.0 | ◪ 95 | 0.36 | 4.0 | ◪ 155 | 0.40 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.8 | ■ 175 | 0.40 | 4.0 | ◪ 95 | 0.36 | 4.0 | ◪ 140 | 0.40 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T9310** | 0.8 | ■ 250 | 0.40 | 4.0 | – | – | – | ◪ 235 | 0.40 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.8 | ■ 235 | 0.40 | 4.0 | – | – | – | ◪ 220 | 0.40 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | ■ 210 | 0.40 | 4.0 | ◪ 125 | 0.36 | 4.0 | ◪ 195 | 0.40 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.8 | ■ 180 | 0.40 | 4.0 | ◪ 105 | 0.36 | 4.0 | – | – | – | – | – | – | – | – | – | – | – | – |

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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-geometri til semi-grov til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **SNMG 120412E-RM** | **T5305** | 1.2 | 295 | 0.45 | 4.0 | – | – | – | 280 | 0.45 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T5315** | 1.2 | 265 | 0.45 | 4.0 | – | – | – | 250 | 0.45 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T6310** | 1.2 | 165 | 0.45 | 4.0 | 115 | 0.41 | 4.0 | 130 | 0.45 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 1.2 | 190 | 0.45 | 4.0 | 145 | 0.41 | 4.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 1.2 | 180 | 0.45 | 4.0 | 140 | 0.41 | 4.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9310** | 1.2 | 250 | 0.45 | 4.0 | – | – | – | 235 | 0.45 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 1.2 | 235 | 0.45 | 4.0 | – | – | – | 220 | 0.45 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | 210 | 0.45 | 4.0 | 125 | 0.41 | 4.0 | 195 | 0.45 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.2 | 185 | 0.45 | 4.0 | 110 | 0.41 | 4.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| **SNMG 120416E-RM** | **T5315** | 1.6 | 270 | 0.50 | 4.0 | – | – | – | 255 | 0.50 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T7335** | 1.6 | 180 | 0.50 | 4.0 | 140 | 0.45 | 4.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 1.6 | 170 | 0.50 | 4.0 | 100 | 0.45 | 4.0 | 160 | 0.50 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 1.6 | 175 | 0.50 | 4.0 | 95 | 0.45 | 4.0 | 140 | 0.50 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 1.6 | 230 | 0.50 | 4.0 | – | – | – | 215 | 0.50 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.6 | 215 | 0.50 | 4.0 | 125 | 0.45 | 4.0 | 200 | 0.50 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.6 | 180 | 0.50 | 4.0 | 105 | 0.45 | 4.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| **SNMG 150612E-RM** | **T5315** | 1.2 | 255 | 0.45 | 5.0 | – | – | – | 240 | 0.45 | 5.0 | – | – | – | – | – | – | – | – | – |
| | **T6310** | 1.2 | 165 | 0.45 | 5.0 | 115 | 0.41 | 5.0 | 130 | 0.45 | 5.0 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 1.2 | 185 | 0.45 | 5.0 | 140 | 0.41 | 5.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 1.2 | 175 | 0.45 | 5.0 | 135 | 0.41 | 5.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9310** | 1.2 | 245 | 0.45 | 5.0 | – | – | – | 230 | 0.45 | 5.0 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 1.2 | 225 | 0.45 | 5.0 | – | – | – | 210 | 0.45 | 5.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | 205 | 0.45 | 5.0 | 120 | 0.41 | 5.0 | 190 | 0.45 | 5.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.2 | 180 | 0.45 | 5.0 | 105 | 0.41 | 5.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| **SNMG 150616E-RM** | **T7335** | 1.6 | 175 | 0.50 | 5.0 | 135 | 0.45 | 5.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9315** | 1.6 | 230 | 0.50 | 5.0 | – | – | – | 215 | 0.50 | 5.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.6 | 205 | 0.50 | 5.0 | 120 | 0.45 | 5.0 | 190 | 0.50 | 5.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.6 | 180 | 0.50 | 5.0 | 105 | 0.45 | 5.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| **SNMG 190612E-RM** | **T5305** | 1.2 | 275 | 0.45 | 7.0 | – | – | – | 260 | 0.45 | 7.0 | – | – | – | – | – | – | – | – | – |
| | **T5315** | 1.2 | 250 | 0.45 | 7.0 | – | – | – | 235 | 0.45 | 7.0 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 1.2 | 180 | 0.45 | 7.0 | 140 | 0.41 | 7.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 1.2 | 165 | 0.45 | 7.0 | 125 | 0.41 | 7.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9310** | 1.2 | 240 | 0.45 | 7.0 | – | – | – | 225 | 0.45 | 7.0 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 1.2 | 220 | 0.45 | 7.0 | – | – | – | 205 | 0.45 | 7.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | 195 | 0.45 | 7.0 | 115 | 0.41 | 7.0 | 185 | 0.45 | 7.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.2 | 175 | 0.45 | 7.0 | 105 | 0.41 | 7.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| **SNMG 190616E-RM** | **T5305** | 1.6 | 285 | 0.50 | 7.0 | – | – | – | 270 | 0.50 | 7.0 | – | – | – | – | – | – | – | – | – |
| | **T5315** | 1.6 | 250 | 0.50 | 7.0 | – | – | – | 235 | 0.50 | 7.0 | – | – | – | – | – | – | – | – | – |
| | **T6310** | 1.6 | 160 | 0.50 | 7.0 | 115 | 0.45 | 7.0 | 125 | 0.50 | 7.0 | – | – | – | – | – | – | – | – | – |
| | **T7335** | 1.6 | 170 | 0.50 | 7.0 | 130 | 0.45 | 7.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9310** | 1.6 | 240 | 0.50 | 7.0 | – | – | – | 225 | 0.50 | 7.0 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 1.6 | 220 | 0.50 | 7.0 | – | – | – | 205 | 0.50 | 7.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.6 | 200 | 0.50 | 7.0 | 120 | 0.45 | 7.0 | 190 | 0.50 | 7.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.6 | 175 | 0.50 | 7.0 | 105 | 0.45 | 7.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| **SNMG 250924E-RM** | **T7325** | 2.4 | 110 | 0.80 | 12.0 | 85 | 0.72 | 12.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 2.4 | 105 | 0.80 | 12.0 | 80 | 0.72 | 12.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9226** | 2.4 | 95 | 0.80 | 12.0 | 55 | 0.72 | 12.0 | 90 | 0.80 | 12.0 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 2.4 | 125 | 0.80 | 12.0 | – | – | – | 115 | 0.80 | 12.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 2.4 | 110 | 0.80 | 12.0 | 65 | 0.72 | 12.0 | 100 | 0.80 | 12.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 2.4 | 90 | 0.80 | 12.0 | 50 | 0.72 | 12.0 | – | – | – | – | – | – | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| SF-geometri med positivt design til finbearbejdning af tynde vægge og kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **SNMG 120404E-SF** | **T7325** | 0.4 | 215 | 0.17 | 1.0 | 165 | 0.15 | 1.0 | – | – | – | – | – | – | 65 | 0.15 | 0.8 | – | – | – |
| | **T9325** | 0.4 | 265 | 0.17 | 1.0 | 155 | 0.15 | 1.0 | 250 | 0.17 | 1.0 | – | – | – | 55 | 0.15 | 0.8 | – | – | – |

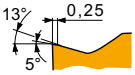
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |  | | | | | | | | | | | | | | | | | | | |

SF-geometri med positivt design til finbearbejdning af tynde vægge og kontinuerlige snit.

| | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **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 | – | – | – |
| | **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 | 0.15 | 1.0 |
| | **T7325** | 0.8 | 245 | 0.20 | 1.0 | 190 | 0.18 | 1.0 | – | – | – | – | – | – | 75 | 0.16 | 0.8 | – | – | – |
| | **T7335** | 0.8 | 235 | 0.20 | 1.0 | 180 | 0.18 | 1.0 | – | – | – | – | – | – | 75 | 0.16 | 0.8 | – | – | – |
| | **T8315** | 0.8 | 225 | 0.20 | 1.0 | 135 | 0.18 | 1.0 | 210 | 0.20 | 1.0 | 675 | 0.24 | 1.0 | 55 | 0.14 | 0.8 | 45 | 0.15 | 1.0 |
| | **T8330** | 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 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| | **T7325** | 1.2 | 230 | 0.25 | 1.5 | 175 | 0.23 | 1.5 | – | – | – | – | – | – | 70 | 0.18 | 1.2 | – | – | – |
| | **T8330** | 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 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |





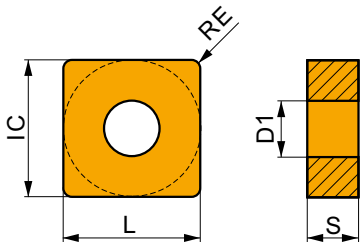
SM-geometri med positivt design til medium bearbejdning og kontinuerlige til afbrudte snit.

| | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **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 | 0.15 | 1.0 |
| | **T7325** | 0.8 | 210 | 0.25 | 1.8 | 160 | 0.23 | 1.8 | – | – | – | – | – | – | 65 | 0.20 | 1.4 | – | – | – |
| | **T7335** | 0.8 | 205 | 0.25 | 1.8 | 155 | 0.23 | 1.8 | – | – | – | – | – | – | 65 | 0.20 | 1.4 | – | – | – |
| | **T8330** | 0.8 | 185 | 0.25 | 1.8 | 110 | 0.23 | 1.8 | 175 | 0.25 | 1.8 | 555 | 0.30 | 1.8 | 45 | 0.20 | 1.4 | 35 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| | **T9315** | 0.8 | 280 | 0.25 | 1.8 | – | – | – | 265 | 0.25 | 1.8 | – | – | – | – | – | – | 55 | 0.15 | 1.0 |
| | **T9325** | 0.8 | 255 | 0.25 | 1.8 | 150 | 0.23 | 1.8 | 240 | 0.25 | 1.8 | – | – | – | 55 | 0.20 | 1.4 | – | – | – |
| **SNMG 120412E-SM** | **T7325** | 1.2 | 210 | 0.30 | 1.8 | 160 | 0.27 | 1.8 | – | – | – | – | – | – | 65 | 0.24 | 1.4 | – | – | – |
| | **T7335** | 1.2 | 200 | 0.30 | 1.8 | 155 | 0.27 | 1.8 | – | – | – | – | – | – | 65 | 0.24 | 1.4 | – | – | – |
| | **T9315** | 1.2 | 275 | 0.30 | 1.8 | – | – | – | 260 | 0.30 | 1.8 | – | – | – | – | – | – | 55 | 0.15 | 1.0 |
| | **T9325** | 1.2 | 245 | 0.30 | 1.8 | 145 | 0.27 | 1.8 | 230 | 0.30 | 1.8 | – | – | – | 55 | 0.24 | 1.4 | – | – | – |
| **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 |
| | **T7325** | 1.2 | 195 | 0.30 | 4.0 | 150 | 0.27 | 4.0 | – | – | – | – | – | – | 60 | 0.27 | 3.2 | – | – | – |
| | **T7335** | 1.2 | 185 | 0.30 | 4.0 | 140 | 0.27 | 4.0 | – | – | – | – | – | – | 60 | 0.27 | 3.2 | – | – | – |
| | **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** | **T7325** | 1.6 | 190 | 0.40 | 4.0 | 145 | 0.36 | 4.0 | – | – | – | – | – | – | 60 | 0.32 | 3.2 | – | – | – |
| | **T7335** | 1.6 | 175 | 0.40 | 4.0 | 135 | 0.36 | 4.0 | – | – | – | – | – | – | 55 | 0.32 | 3.2 | – | – | – |
| | **T9325** | 1.6 | 210 | 0.40 | 4.0 | 125 | 0.36 | 4.0 | 195 | 0.40 | 4.0 | – | – | – | 45 | 0.32 | 3.2 | – | – | – |

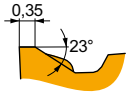
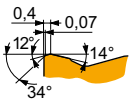
# SNMM

PRAMET

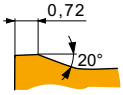
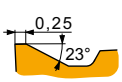
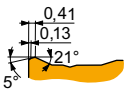
| | IC (mm) | D1 (mm) | L (mm) | S (mm) |
|---|---|---|---|---|
| 1204 | 12.700 | 5.16 | 12.70 | 4.76 |
| 1506 | 15.875 | 6.35 | 15.875 | 6.35 |
| 1906 | 19.050 | 7.94 | 19.05 | 6.35 |
| 2507 | 25.400 | 9.12 | 25.40 | 7.94 |
| 2509 | 25.400 | 9.12 | 25.40 | 9.525 |



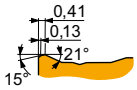
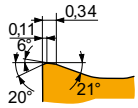
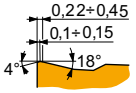

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |   | | | | | | | | | | | | | | | | | | | |
| DR-geometri til hård til ekstra hård bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **SNMM 120412E-DR** | **T9315** | 1.2 | 245 | 0.45 | 4.7 | – | – | – | 230 | 0.45 | 4.7 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | 220 | 0.45 | 4.7 | 130 | 0.41 | 4.7 | 205 | 0.45 | 4.7 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.2 | 185 | 0.45 | 4.7 | 110 | 0.41 | 4.7 | – | – | – | – | – | – | – | – | – | – | – | – |
| **SNMM 150612E-DR** | **T9325** | 1.2 | 210 | 0.45 | 6.0 | 125 | 0.41 | 6.0 | 195 | 0.45 | 6.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.2 | 180 | 0.45 | 6.0 | 105 | 0.41 | 6.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| **SNMM 190612E-DR** | **6640** | 1.2 | 170 | 0.45 | 6.0 | 100 | 0.41 | 6.0 | 160 | 0.45 | 6.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | 210 | 0.45 | 6.0 | 125 | 0.41 | 6.0 | 195 | 0.45 | 6.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.2 | 180 | 0.45 | 6.0 | 105 | 0.41 | 6.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| **SNMM 190616E-DR** | **T9325** | 1.6 | 210 | 0.50 | 6.0 | 125 | 0.45 | 6.0 | 195 | 0.50 | 6.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.6 | 185 | 0.50 | 6.0 | 110 | 0.45 | 6.0 | – | – | – | – | – | – | – | – | – | – | – | – |
|  |   | | | | | | | | | | | | | | | | | | | |
| HR-geometri til hård til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **SNMM 190616E-HR** | **T8345** | 1.6 | 60 | 0.60 | 9.0 | 35 | 0.54 | 9.0 | 55 | 0.60 | 9.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.6 | 110 | 0.60 | 9.0 | 65 | 0.54 | 9.0 | 100 | 0.60 | 9.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.6 | 85 | 0.60 | 9.0 | 50 | 0.54 | 9.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| **SNMM 190624E-HR** | **T8345** | 2.4 | 60 | 0.65 | 9.0 | 35 | 0.59 | 9.0 | 55 | 0.65 | 9.0 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 2.4 | 120 | 0.65 | 9.0 | – | – | – | 110 | 0.65 | 9.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 2.4 | 115 | 0.65 | 9.0 | 65 | 0.59 | 9.0 | 105 | 0.65 | 9.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 2.4 | 90 | 0.65 | 9.0 | 50 | 0.59 | 9.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| **SNMM 250716E-HR** | **T8345** | 1.6 | 60 | 0.60 | 13.0 | 35 | 0.54 | 13.0 | 55 | 0.60 | 13.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.6 | 100 | 0.60 | 13.0 | 60 | 0.54 | 13.0 | 95 | 0.60 | 13.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.6 | 85 | 0.60 | 13.0 | 50 | 0.54 | 13.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| **SNMM 250724E-HR** | **6640** | 2.4 | 80 | 0.65 | 13.0 | 45 | 0.59 | 13.0 | 75 | 0.65 | 13.0 | – | – | – | – | – | – | – | – | – |
| | **T8345** | 2.4 | 55 | 0.65 | 13.0 | 30 | 0.59 | 13.0 | 50 | 0.65 | 13.0 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 2.4 | 120 | 0.65 | 13.0 | – | – | – | 110 | 0.65 | 13.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 2.4 | 105 | 0.65 | 13.0 | 60 | 0.59 | 13.0 | 95 | 0.65 | 13.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 2.4 | 85 | 0.65 | 13.0 | 50 | 0.59 | 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** | **T8345** | 2.4 | 55 | 0.65 | 13.0 | 30 | 0.59 | 13.0 | 50 | 0.65 | 13.0 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 2.4 | 120 | 0.65 | 13.0 | – | – | – | 110 | 0.65 | 13.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 2.4 | 105 | 0.65 | 13.0 | 60 | 0.59 | 13.0 | 95 | 0.65 | 13.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 2.4 | 85 | 0.65 | 13.0 | 50 | 0.59 | 13.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| **SNMM 250932E-HR** | **T9325** | 3.2 | 95 | 0.80 | 13.0 | 55 | 0.72 | 13.0 | 90 | 0.80 | 13.0 | – | – | – | – | – | – | – | – | – |

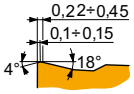
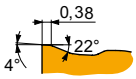
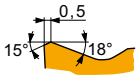
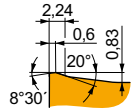
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |   | | HR2-geometri til hård til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **SNMM 190616-HR2** | **T9315** | 1.6 | 115 | 0.65 | 8.9 | – | – | – | 105 | 0.65 | 8.9 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.6 | 85 | 0.65 | 8.9 | 50 | 0.59 | 8.9 | – | – | – | – | – | – | – | – | – | – | – | – |
| **SNMM 190624-HR2** | **T9315** | 2.4 | 105 | 0.85 | 8.9 | – | – | – | 95 | 0.85 | 8.9 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 2.4 | 80 | 0.85 | 8.9 | 45 | 0.77 | 8.9 | – | – | – | – | – | – | – | – | – | – | – | – |
| **SNMM 250724-HR2** | **T9226** | 2.4 | 85 | 0.85 | 11.0 | 50 | 0.77 | 11.0 | 80 | 0.85 | 11.0 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 2.4 | 105 | 0.85 | 11.0 | – | – | – | 95 | 0.85 | 11.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 2.4 | 80 | 0.85 | 11.0 | 45 | 0.77 | 11.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| **SNMM 250732-HR2** | **T9315** | 3.2 | 95 | 1.00 | 11.0 | – | – | – | 90 | 1.00 | 11.0 | – | – | – | – | – | – | – | – | – |
| **SNMM 250924-HR2** | **T9226** | 2.4 | 85 | 0.85 | 11.0 | 50 | 0.77 | 11.0 | 80 | 0.85 | 11.0 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 2.4 | 105 | 0.85 | 11.0 | – | – | – | 95 | 0.85 | 11.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 2.4 | 80 | 0.85 | 11.0 | 45 | 0.77 | 11.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| **SNMM 250932-HR2** | **T9315** | 3.2 | 95 | 1.00 | 11.0 | – | – | – | 90 | 1.00 | 11.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 3.2 | 75 | 1.00 | 11.0 | 45 | 0.90 | 11.0 | – | – | – | – | – | – | – | – | – | – | – | – |
|  |   | | NR-geometri til semi-ru til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **SNMM 120408E-NR** | **T7325** | 0.8 | 185 | 0.40 | 3.0 | 140 | 0.36 | 3.0 | – | – | – | – | – | – | 60 | 0.28 | 2.4 | – | – | – |
| | **T7335** | 0.8 | 175 | 0.40 | 3.0 | 135 | 0.36 | 3.0 | – | – | – | – | – | – | 55 | 0.28 | 2.4 | – | – | – |
| | **T8330** | 0.8 | 160 | 0.40 | 3.0 | 95 | 0.36 | 3.0 | 150 | 0.40 | 3.0 | – | – | – | 40 | 0.28 | 2.4 | – | – | – |
| | **T8430** | 0.8 | 170 | 0.40 | 3.0 | 90 | 0.36 | 3.0 | 135 | 0.40 | 3.0 | – | – | – | 35 | 0.28 | 2.4 | – | – | – |
| | **T9325** | 0.8 | 205 | 0.40 | 3.0 | 120 | 0.36 | 3.0 | 190 | 0.40 | 3.0 | – | – | – | 45 | 0.28 | 2.4 | – | – | – |
|  |   | | NR2-geometri til semi-ru til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **SNMM 120408E-NR2** | **T7325** | 0.8 | 175 | 0.40 | 4.7 | 135 | 0.36 | 4.7 | – | – | – | – | – | – | 55 | 0.32 | 3.8 | – | – | – |
| | **T7335** | 0.8 | 170 | 0.40 | 4.7 | 130 | 0.36 | 4.7 | – | – | – | – | – | – | 55 | 0.32 | 3.8 | – | – | – |
| | **T8330** | 0.8 | 155 | 0.40 | 4.7 | 90 | 0.36 | 4.7 | 145 | 0.40 | 4.7 | – | – | – | 35 | 0.32 | 3.8 | – | – | – |
| | **T8430** | 0.8 | 165 | 0.40 | 4.7 | 90 | 0.36 | 4.7 | 135 | 0.40 | 4.7 | – | – | – | 35 | 0.32 | 3.8 | – | – | – |
| | **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 | – | – | – |
| | **T8330** | 1.2 | 160 | 0.45 | 4.7 | 95 | 0.41 | 4.7 | 150 | 0.45 | 4.7 | – | – | – | 40 | 0.36 | 3.8 | – | – | – |
| | **T8430** | 1.2 | 165 | 0.45 | 4.7 | 90 | 0.41 | 4.7 | 135 | 0.45 | 4.7 | – | – | – | 35 | 0.36 | 3.8 | – | – | – |
| | **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** | **T7325** | 1.2 | 170 | 0.45 | 6.0 | 130 | 0.41 | 6.0 | – | – | – | – | – | – | 55 | 0.36 | 4.8 | – | – | – |
| | **T7335** | 1.2 | 165 | 0.45 | 6.0 | 125 | 0.41 | 6.0 | – | – | – | – | – | – | 50 | 0.36 | 4.8 | – | – | – |
| | **T8330** | 1.2 | 155 | 0.45 | 6.0 | 90 | 0.41 | 6.0 | 145 | 0.45 | 6.0 | – | – | – | 35 | 0.36 | 4.8 | – | – | – |
| | **T8430** | 1.2 | 165 | 0.45 | 6.0 | 90 | 0.41 | 6.0 | 135 | 0.45 | 6.0 | – | – | – | 35 | 0.36 | 4.8 | – | – | – |
| | **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 | – | – | – |
| | **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 | – | – | – |
| | **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 | – | – | – |
| | **T7335** | 1.6 | 160 | 0.50 | 8.0 | 120 | 0.45 | 8.0 | – | – | – | – | – | – | 50 | 0.40 | 6.4 | – | – | – |
| | **T8330** | 1.6 | 155 | 0.50 | 8.0 | 90 | 0.45 | 8.0 | 145 | 0.50 | 8.0 | – | – | – | 35 | 0.40 | 6.4 | – | – | – |
| | **T8430** | 1.6 | 155 | 0.50 | 8.0 | 85 | 0.45 | 8.0 | 130 | 0.50 | 8.0 | – | – | – | 30 | 0.40 | 6.4 | – | – | – |
| | **T9315** | 1.6 | 210 | 0.50 | 8.0 | – | – | – | 195 | 0.50 | 8.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.6 | 185 | 0.50 | 8.0 | 110 | 0.45 | 8.0 | 175 | 0.50 | 8.0 | – | – | – | 40 | 0.40 | 6.4 | – | – | – |
| **SNMM 190624E-NR2** | **T7325** | 2.4 | 155 | 0.80 | 8.0 | 120 | 0.72 | 8.0 | – | – | – | – | – | – | 50 | 0.56 | 6.4 | – | – | – |
| | **T7335** | 2.4 | 145 | 0.80 | 8.0 | 110 | 0.72 | 8.0 | – | – | – | – | – | – | 45 | 0.56 | 6.4 | – | – | – |
| | **T9325** | 2.4 | 165 | 0.80 | 8.0 | 95 | 0.72 | 8.0 | 155 | 0.80 | 8.0 | – | – | – | 35 | 0.56 | 6.4 | – | – | – |

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |  | | | | | | | | | | | | | | | | | | | |
| NR2-geometri til semi-ru til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **SNMM 250724E-NR2** | **T7335** | 2.4 | 100 | 0.80 | 12.0 | 75 | 0.72 | 12.0 | – | – | – | – | – | – | 30 | 0.56 | 9.6 | – | – | – |
| | **T8330** | 2.4 | 85 | 0.80 | 12.0 | 50 | 0.72 | 12.0 | 80 | 0.80 | 12.0 | – | – | – | 20 | 0.56 | 9.6 | – | – | – |
| | **T8430** | 2.4 | 85 | 0.80 | 12.0 | 45 | 0.72 | 12.0 | 70 | 0.80 | 12.0 | – | – | – | 15 | 0.56 | 9.6 | – | – | – |
| | **T9226** | 2.4 | 95 | 0.80 | 12.0 | 55 | 0.72 | 12.0 | 90 | 0.80 | 12.0 | – | – | – | 20 | 0.56 | 9.6 | – | – | – |
| | **T9315** | 2.4 | 120 | 0.80 | 12.0 | – | – | – | 110 | 0.80 | 12.0 | – | – | – | – | – | – | – | – | – |
| | **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** | **T7325** | 2.4 | 105 | 0.80 | 12.0 | 80 | 0.72 | 12.0 | – | – | – | – | – | – | 30 | 0.56 | 9.6 | – | – | – |
| | **T7335** | 2.4 | 100 | 0.80 | 12.0 | 75 | 0.72 | 12.0 | – | – | – | – | – | – | 30 | 0.56 | 9.6 | – | – | – |
| | **T9226** | 2.4 | 95 | 0.80 | 12.0 | 55 | 0.72 | 12.0 | 90 | 0.80 | 12.0 | – | – | – | 20 | 0.56 | 9.6 | – | – | – |
| | **T9315** | 2.4 | 120 | 0.80 | 12.0 | – | – | – | 110 | 0.80 | 12.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 2.4 | 105 | 0.80 | 12.0 | 60 | 0.72 | 12.0 | 95 | 0.80 | 12.0 | – | – | – | 20 | 0.56 | 9.6 | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| NRM-geometri med positivt design til halv grov til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **SNMM 250716-NRM** | **T7325** | 1.6 | 115 | 0.45 | 9.0 | 85 | 0.41 | 9.0 | – | – | – | – | – | – | 35 | 0.36 | 7.2 | – | – | – |
| | **T7335** | 1.6 | 110 | 0.45 | 9.0 | 85 | 0.41 | 9.0 | – | – | – | – | – | – | 35 | 0.36 | 7.2 | – | – | – |
| | **T9315** | 1.6 | 135 | 0.45 | 9.0 | – | – | – | 125 | 0.45 | 9.0 | – | – | – | – | – | – | – | – | – |
| **SNMM 250724-NRM** | **T7325** | 2.4 | 105 | 0.65 | 9.0 | 80 | 0.59 | 9.0 | – | – | – | – | – | – | 30 | 0.46 | 7.2 | – | – | – |
| | **T7335** | 2.4 | 100 | 0.65 | 9.0 | 75 | 0.59 | 9.0 | – | – | – | – | – | – | 30 | 0.46 | 7.2 | – | – | – |
| | **T9315** | 2.4 | 120 | 0.65 | 9.0 | – | – | – | 110 | 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 | – | – | – |
| | **T7335** | 2.4 | 95 | 0.70 | 9.0 | 70 | 0.63 | 9.0 | – | – | – | – | – | – | 30 | 0.49 | 7.2 | – | – | – |
| | **T9315** | 2.4 | 120 | 0.70 | 9.0 | – | – | – | 110 | 0.70 | 9.0 | – | – | – | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| OR geometri til semi-grov til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **SNMM 120408E-OR** | **T9315** | 0.8 | 220 | 0.40 | 4.7 | – | – | – | 205 | 0.40 | 4.7 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 195 | 0.40 | 4.7 | 115 | 0.36 | 4.7 | 185 | 0.40 | 4.7 | – | – | – | 40 | 0.32 | 3.8 | – | – | – |
| | **T9335** | 0.8 | 175 | 0.40 | 4.7 | 105 | 0.36 | 4.7 | – | – | – | – | – | – | 35 | 0.32 | 3.8 | – | – | – |
| **SNMM 120412E-OR** | **T9315** | 1.2 | 225 | 0.45 | 4.7 | – | – | – | 210 | 0.45 | 4.7 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | 200 | 0.45 | 4.7 | 120 | 0.41 | 4.7 | 190 | 0.45 | 4.7 | – | – | – | 45 | 0.36 | 3.8 | – | – | – |
| **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 | 185 | 0.45 | 6.0 | 110 | 0.41 | 6.0 | 175 | 0.45 | 6.0 | – | – | – | 40 | 0.41 | 4.8 | – | – | – |
| | **T9335** | 0.8 | 170 | 0.40 | 6.0 | 100 | 0.36 | 6.0 | – | – | – | – | – | – | 35 | 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 | – | – | – |
| | **T9335** | 1.2 | 165 | 0.45 | 6.0 | 95 | 0.41 | 6.0 | – | – | – | – | – | – | 35 | 0.36 | 4.8 | – | – | – |
| **SNMM 150616E-OR** | **T9315** | 1.6 | 215 | 0.50 | 6.0 | – | – | – | 200 | 0.50 | 6.0 | – | – | – | – | – | – | – | – | – |
| | **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-OR** | **T8330** | 1.2 | 150 | 0.45 | 8.0 | 90 | 0.41 | 8.0 | 140 | 0.45 | 8.0 | – | – | – | 35 | 0.36 | 6.4 | – | – | – |
| | **T8430** | 1.2 | 150 | 0.45 | 8.0 | 80 | 0.41 | 8.0 | 125 | 0.45 | 8.0 | – | – | – | 30 | 0.36 | 6.4 | – | – | – |
| | **T9315** | 1.2 | 210 | 0.45 | 8.0 | – | – | – | 195 | 0.45 | 8.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | 190 | 0.45 | 8.0 | 110 | 0.41 | 8.0 | 180 | 0.45 | 8.0 | – | – | – | 40 | 0.36 | 6.4 | – | – | – |
| | **T9335** | 1.2 | 165 | 0.45 | 8.0 | 95 | 0.41 | 8.0 | – | – | – | – | – | – | 35 | 0.36 | 6.4 | – | – | – |
| **SNMM 190616E-OR** | **T8330** | 1.6 | 155 | 0.50 | 8.0 | 90 | 0.45 | 8.0 | 145 | 0.50 | 8.0 | – | – | – | 35 | 0.40 | 6.4 | – | – | – |
| | **T8345** | 1.6 | 125 | 0.50 | 8.0 | 75 | 0.45 | 8.0 | 115 | 0.50 | 8.0 | – | – | – | 30 | 0.40 | 6.4 | – | – | – |
| | **T8430** | 1.6 | 155 | 0.50 | 8.0 | 85 | 0.45 | 8.0 | 130 | 0.50 | 8.0 | – | – | – | 30 | 0.40 | 6.4 | – | – | – |
| | **T9315** | 1.6 | 210 | 0.50 | 8.0 | – | – | – | 195 | 0.50 | 8.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.6 | 185 | 0.50 | 8.0 | 110 | 0.45 | 8.0 | 175 | 0.50 | 8.0 | – | – | – | 40 | 0.40 | 6.4 | – | – | – |
| | **T9335** | 1.6 | 160 | 0.50 | 8.0 | 95 | 0.45 | 8.0 | – | – | – | – | – | – | 35 | 0.40 | 6.4 | – | – | – |
| **SNMM 190624E-OR** | **T9315** | 2.4 | 180 | 0.80 | 8.0 | – | – | – | 170 | 0.80 | 8.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 2.4 | 165 | 0.80 | 8.0 | 95 | 0.72 | 8.0 | 155 | 0.80 | 8.0 | – | – | – | 35 | 0.56 | 6.4 | – | – | – |
| **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 | – | – | – |
| | **T9325** | 1.6 | 120 | 0.55 | 12.0 | 70 | 0.50 | 12.0 | 110 | 0.55 | 12.0 | – | – | – | 25 | 0.50 | 9.6 | – | – | – |

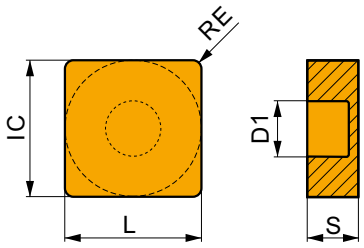
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |   | | | | | | | | | | | | | | | | | | | |
| OR geometri til semi-grov til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **SNMM 250724E-OR** | **T8330** | 2.4 | 80 | 1.00 | 12.0 | 45 | 0.90 | 12.0 | 75 | 1.00 | 12.0 | – | – | – | 20 | 0.70 | 9.6 | – | – | – |
| | **T8345** | 2.4 | 55 | 1.00 | 12.0 | 30 | 0.90 | 12.0 | 50 | 1.00 | 12.0 | – | – | – | 10 | 0.70 | 9.6 | – | – | – |
| | **T8430** | 2.4 | 80 | 1.00 | 12.0 | 45 | 0.90 | 12.0 | 65 | 1.00 | 12.0 | – | – | – | 15 | 0.70 | 9.6 | – | – | – |
| | **T9315** | 2.4 | 105 | 1.00 | 12.0 | – | – | – | 95 | 1.00 | 12.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 2.4 | 100 | 1.00 | 12.0 | 60 | 0.90 | 12.0 | 95 | 1.00 | 12.0 | – | – | – | 20 | 0.70 | 9.6 | – | – | – |
| | **T9335** | 2.4 | 80 | 1.00 | 12.0 | 45 | 0.90 | 12.0 | – | – | – | – | – | – | 15 | 0.70 | 9.6 | – | – | – |
| **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 | – | – | – |
| | **T9226** | 2.4 | 85 | 1.00 | 12.0 | 50 | 0.90 | 12.0 | 80 | 1.00 | 12.0 | – | – | – | 15 | 0.70 | 9.6 | – | – | – |
| | **T9315** | 2.4 | 105 | 1.00 | 12.0 | – | – | – | 95 | 1.00 | 12.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 2.4 | 100 | 1.00 | 12.0 | 60 | 0.90 | 12.0 | 95 | 1.00 | 12.0 | – | – | – | 20 | 0.70 | 9.6 | – | – | – |
| | **T9335** | 2.4 | 80 | 1.00 | 12.0 | 45 | 0.90 | 12.0 | – | – | – | – | – | – | 15 | 0.70 | 9.6 | – | – | – |
|  |   | | | | | | | | | | | | | | | | | | | |
| OR1-geometri til semi-grov til tung-grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **SNMM 190616E-OR1** | **T9325** | 1.6 | 185 | 0.50 | 8.0 | 110 | 0.45 | 8.0 | 175 | 0.50 | 8.0 | – | – | – | 40 | 0.35 | 6.4 | – | – | – |
| | **T9335** | 1.6 | 160 | 0.50 | 8.0 | 95 | 0.45 | 8.0 | – | – | – | – | – | – | 35 | 0.35 | 6.4 | – | – | – |
|  |   | | | | | | | | | | | | | | | | | | | |
| SR-geometri til hård til meget hård bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **SNMM 250724S-SR** | **6640** | 2.4 | 60 | 1.00 | 12.0 | 35 | 0.90 | 12.0 | 55 | 1.00 | 12.0 | – | – | – | – | – | – | – | – | – |
| | **T9226** | 2.4 | 70 | 1.00 | 12.0 | 40 | 0.90 | 12.0 | 65 | 1.00 | 12.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 2.4 | 80 | 1.00 | 12.0 | 45 | 0.90 | 12.0 | 75 | 1.00 | 12.0 | – | – | – | – | – | – | – | – | – |
| **SNMM 250924S-SR** | **T9335** | 2.4 | 65 | 1.00 | 14.0 | 35 | 0.90 | 14.0 | – | – | – | – | – | – | – | – | – | – | – | – |
|  |   | | | | | | | | | | | | | | | | | | | |
| Geometri 923 til semi-grov til tung-hård bearbejdning og kontinuerlig til kraftig afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **SNMM 190616S-923** | **T8330** | 1.6 | 125 | 0.65 | 8.9 | 75 | 0.59 | 8.9 | 115 | 0.65 | 8.9 | – | – | – | 30 | 0.52 | 7.1 | – | – | – |
| | **T8345** | 1.6 | 100 | 0.65 | 8.9 | 60 | 0.59 | 8.9 | 95 | 0.65 | 8.9 | – | – | – | 25 | 0.52 | 7.1 | – | – | – |
| | **T8430** | 1.6 | 125 | 0.65 | 8.9 | 65 | 0.59 | 8.9 | 100 | 0.65 | 8.9 | – | – | – | 25 | 0.52 | 7.1 | – | – | – |
| | **T9335** | 1.6 | 130 | 0.65 | 8.9 | 75 | 0.59 | 8.9 | – | – | – | – | – | – | 25 | 0.52 | 7.1 | – | – | – |
| **SNMM 250724S-923** | **T8330** | 2.4 | 80 | 0.85 | 11.0 | 45 | 0.77 | 11.0 | 75 | 0.85 | 11.0 | – | – | – | 20 | 0.60 | 8.8 | – | – | – |
| | **T8430** | 2.4 | 80 | 0.85 | 11.0 | 45 | 0.77 | 11.0 | 65 | 0.85 | 11.0 | – | – | – | 15 | 0.60 | 8.8 | – | – | – |
| | **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 | – | – | – |
| | **T8430** | 2.4 | 80 | 0.85 | 11.0 | 45 | 0.77 | 11.0 | 65 | 0.85 | 11.0 | – | – | – | 15 | 0.60 | 8.8 | – | – | – |
| | **T9226** | 2.4 | 85 | 0.85 | 11.0 | 50 | 0.77 | 11.0 | 80 | 0.85 | 11.0 | – | – | – | 15 | 0.60 | 8.8 | – | – | – |
| | **T9315** | 2.4 | 105 | 0.85 | 11.0 | – | – | – | 95 | 0.85 | 11.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 2.4 | 80 | 0.85 | 11.0 | 45 | 0.77 | 11.0 | – | – | – | – | – | – | 15 | 0.60 | 8.8 | – | – | – |
| **SNMM 250932S-923** | **T9226** | 3.2 | 80 | 1.00 | 11.0 | 45 | 0.90 | 11.0 | 75 | 1.00 | 11.0 | – | – | – | 15 | 0.70 | 8.8 | – | – | – |

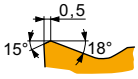
## SNMX

PRAMET

| | IC (mm) | D1 (mm) | L (mm) | S (mm) |
|---|---|---|---|---|
| 2512 | 25.400 | 9.17 | 25.40 | 12.00 |



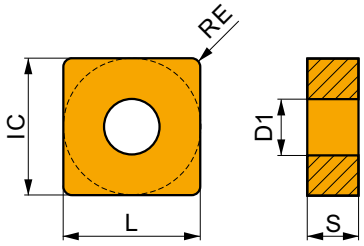

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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 til hård til meget hård bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| SNMX 251224S-SR | T8345 | 2.4 | 45 | 1.00 | 14.0 | 25 | 0.90 | 14.0 | 40 | 1.00 | 14.0 | – | – | – | – | – | – | – | – | – |
| | T9325 | 2.4 | 80 | 1.00 | 14.0 | 45 | 0.90 | 14.0 | 75 | 1.00 | 14.0 | – | – | – | – | – | – | – | – | – |
| | T9335 | 2.4 | 65 | 1.00 | 14.0 | 35 | 0.90 | 14.0 | – | – | – | – | – | – | – | – | – | – | – | – |

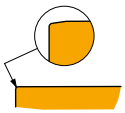
## SNGA CER

PRAMET

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



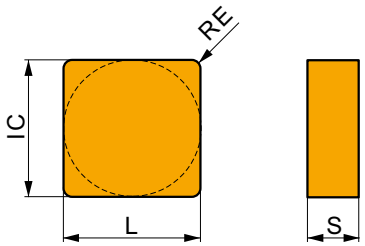

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | |  | | | | | | | | | | | | | | | | | |
| | | | Til bearbejdning med høje hastigheder og kontinuerlige snit. | | | | | | | | | | | | | | | | | |
| SNGA 120408 T01025 | TC100 | 0.8 | – | – | – | – | – | – | 575 | 0.20 | 2.0 | – | – | – | – | – | – | – | – | – |
| SNGA 120412 T01020 | TC100 | 1.2 | – | – | – | – | – | – | 565 | 0.25 | 2.0 | – | – | – | – | – | – | – | – | – |

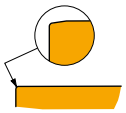
# SNGN CER

PRAMET

| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 0903 | 9.525 | 9.525 | 3.18 |
| 1204 | 12.700 | 12.70 | 4.76 |
| 1207 | 12.700 | 12.70 | 7.94 |




Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | HSC | | T | | | | | | | | | | | | | | | |
| | | | Til bearbejdning med høje hastigheder og kontinuerlige snit. | | | | | | | | | | | | | | | | | |
| 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 | – | – | – | – | – | – | – | – | – |

# DSBN(RL) EXT

P M K N S H

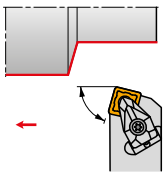
PRAMET

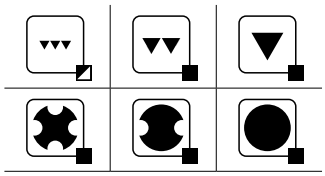
D

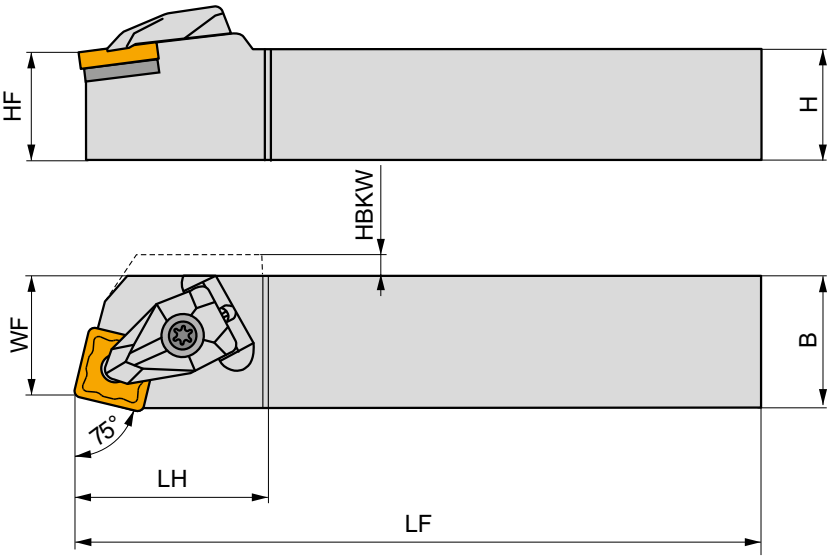


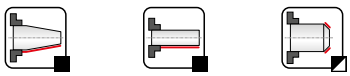
## Ekstern dobbeltholder med 75 ° skærevinkel til SN .. skær

Ekstern højre / venstre dobbeltklemmeværktøjsholder med 75 ° skærevinkel. Velegnet til langsgående drejning uden skulder, tilspidsning og affasning med negativ SN .. 12, 15 eller 19 størrelse skær. Fås i 20x20 op til 40x40 mm skaft. Krop behandlet for længere levetid







| | Product | H (mm) | B (mm) | HF (mm) | WF (mm) | LF (mm) | LH (mm) | HBKW (mm) | LAMS (°) | GAMO (°) | kg | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| R | **DSBNR 2020 K 12** | 20 | 20 | 20 | 17 | 125 | 34.2 | 2.5 | -6 | -6 | 0.43 | GI029 | DS12 | AT003 |
| | **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 | 3.18 | 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 | 1.16 | GI082 | DS15 | AT006 |
| | **DSBNL 3232 P 19** | 32 | 32 | 32 | 27 | 170 | 46.4 | – | -6 | -6 | 1.38 | GI026 | DS19 | – |
| | **DSBNL 4040 S 19** | 40 | 40 | 40 | 35 | 250 | 46.5 | – | -6 | -6 | 3.18 | GI026 | DS19 | – |

| | |
|---|---|
| GI026 | SN.. 1906.. |
| GI029 | SN.. 1204.. |
| GI082 | SN.. 1506.. |

| | | 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

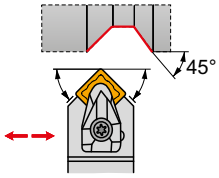
PRAMET

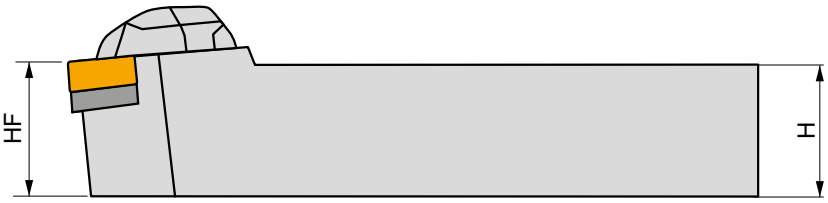
D

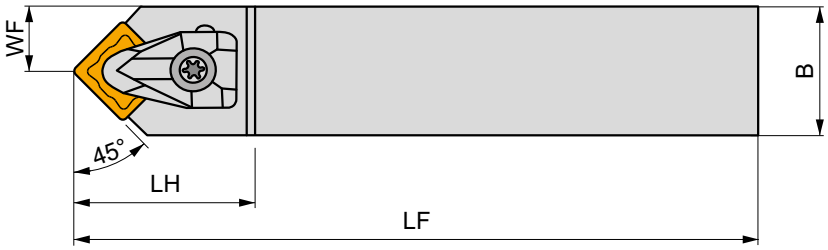


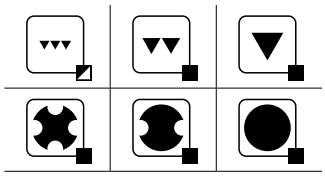
## Ekstern dobbeltholder med 45 ° skærevinkel til SN .. Skær

Ekstern neutral værktøjsholder med dobbelt klemme med 45 ° skærevinkel. Velegnet til langsgående drejning uden skulder, kopi, tilspidsning og affasning med negativ SN .. 12, 15, 19 eller 25 størrelse skær. Fås i 25x25 op til 40x40 mm skaft. Krop behandlet for længere levetid





| | 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 | 1.36 | GI026 | DS19 | – |
| | **DSDNN 4040 S 25** | 40 | 40 | 40 | 21 | 250 | 57.2 | -6 | -6 | 3.13 | GI027 | DS25 | – |

| | |
|---|---|
| GI026 | SN.. 1906.. |
| GI027 | SN.. 2507.. |
| GI029 | SN.. 1204.. |
| GI082 | SN.. 1506.. |

| | | 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

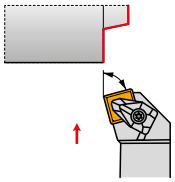
PRAMET

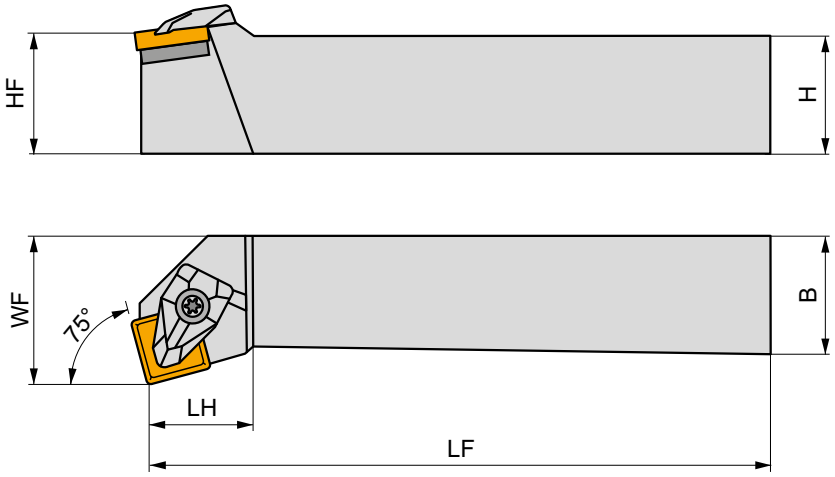
D

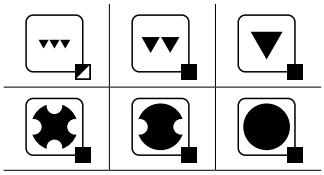


## Ekstern dobbeltholder med 75 ° skærevinkel til SN .. Skær

Ekstern højre / venstre dobbeltklemmeværktøjsholder med 75 ° skærevinkel. Velegnet til endedrejning uden skulder og affasning med SN .. 12 .. eller 19 .. størrelse skær. Fås i 25x25 op til 32x32 mm skaft. Krop behandlet for længere levetid







| | 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 | 0.79 | 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 | – |

| | |
|---|---|
| GI026 | SN.. 1906.. |
| GI029 | SN.. 1204.. |

| | | 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

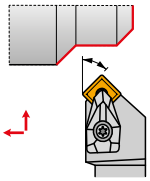
PRAMET

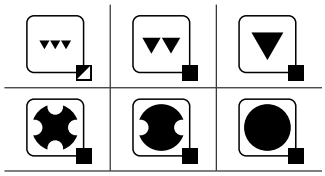
D

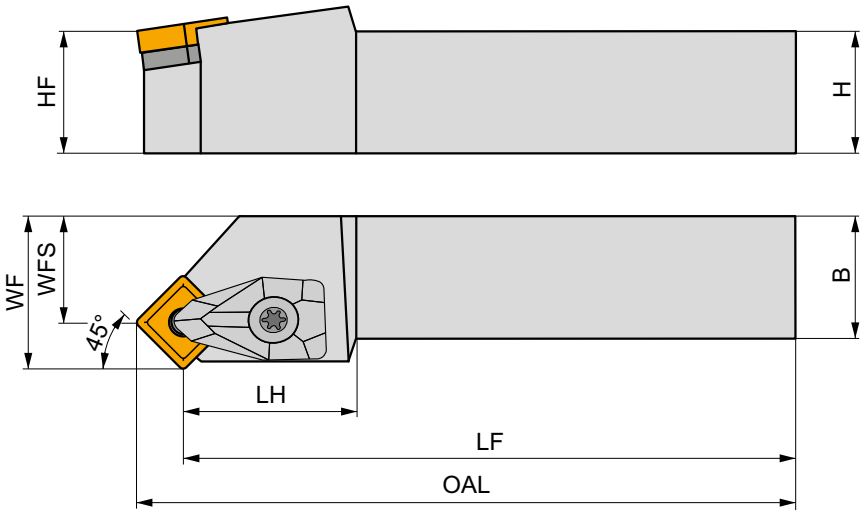


## Ekstern dobbeltholder med 45 ° skærevinkel til SN .. skær

Ekstern højre / venstre værktøjsholder med dobbelt klemme med 45 ° skærevinkel. Velegnet til langsgående og vendt uden skulder, tilspidsning, kopidrejning og affasning med negative SN .. 12, 15 eller 19 størrelse skær. Fås i 20x20 op til 40x40 mm skaft. Krop behandlet for længere levetid










| | Product | H (mm) | B (mm) | HF (mm) | WF (mm) | WFS (mm) | LF (mm) | OAL (mm) | LH (mm) | LAMS (°) | GAMO (°) | kg | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 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 | -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 | -8 | 1.48 | GI026 | DS19 | – |
| | **DSSNR 4040 S 19** | 40 | 40 | 40 | 50 | 37.5 | 250 | 262.5 | 37.7 | 0 | -8 | 3.27 | GI026 | DS19 | – |
| L | **DSSNL 2020 K 12** | 20 | 20 | 20 | 25 | 16.7 | 125 | 133.3 | 27.5 | 0 | -8 | 0.45 | GI029 | DS12 | AT003 |
| | **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 | -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 | -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 | – |

| | |
|---|---|
| GI026 | SN.. 1906.. |
| GI029 | SN.. 1204.. |
| GI082 | SN.. 1506.. |

| | | 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 | – |

# PSBN(RL) EXT

P M K N S H

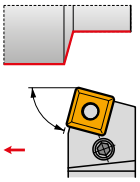
PRAMET

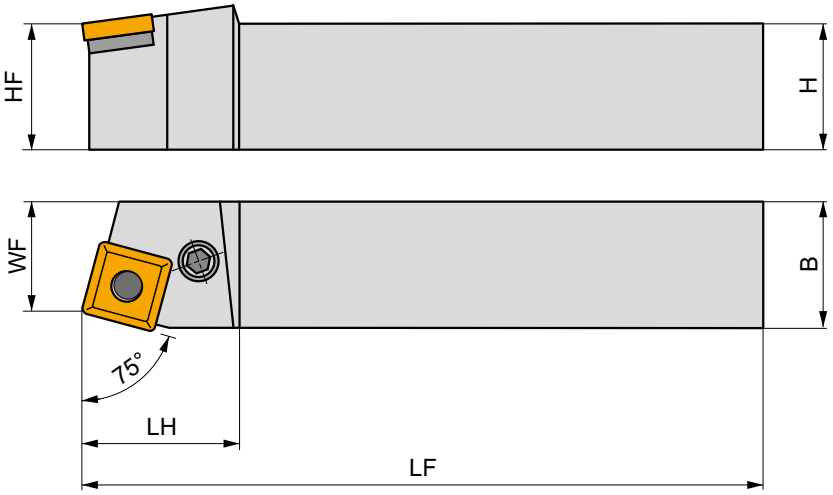
P

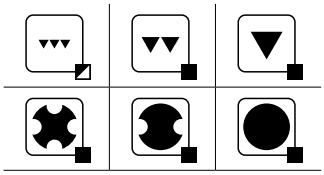


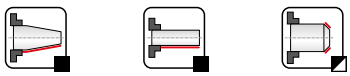
## Ekstern Lever Lock Drejeholder med 75 ° skærevinkel til SN .. Skær

Ekstern højre / venstre hånd værktøjsholder med 75 ° skærevinkel. Velegnet til langsgående drejning uden skulder, konisk drejning og affasning med negativ SN .. 12, 15, 19 eller 25 størrelse skær. Fås i 20x20 op til 50x50 mm skaft. Krop behandlet for længere levetid







| | Product | H (mm) | B (mm) | HF (mm) | WF (mm) | LF (mm) | LH (mm) | LAMS (°) | GAMO (°) | kg | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| R | PSBNR 2020 K 12 | 20 | 20 | 20 | 17 | 125 | 36 | -6 | -6 | 0.43 | GI029 | PS22 |
| | PSBNR 2525 M 12 | 25 | 25 | 25 | 22 | 150 | 36 | -6 | -6 | 0.75 | GI029 | PS20 |
| | PSBNR 3225 P 15 | 32 | 25 | 32 | 22 | 170 | 40 | -6 | -6 | 1.05 | GI082 | PS40 |
| | PSBNR 3232 P 19 | 32 | 32 | 32 | 27 | 170 | 45 | -6 | -6 | 1.30 | GI026 | PS50 |
| | PSBNR 4040 R 19 | 40 | 40 | 40 | 35 | 200 | 45 | -6 | -6 | 2.40 | GI026 | PS50 |
| | PSBNR 4040 S 19 | 40 | 40 | 40 | 35 | 250 | 45 | -6 | -6 | 3.12 | GI026 | PS50 |
| | PSBNR 4040 R 25 | 40 | 40 | 40 | 35 | 200 | 45 | -6 | -6 | 2.45 | GI027 | PS60 |
| | PSBNR 4040 S 25 | 40 | 40 | 40 | 35 | 250 | 50 | -6 | -6 | 2.85 | GI027 | PS60 |
| | PSBNR 4040 S 2509 | 40 | 40 | 40 | 35 | 250 | 50 | -6 | -6 | 2.50 | GI040 | PS70 |
| | PSBNR 4040 S 2512-A | 40 | 40 | 40 | 35 | 250 | 50 | -6 | -6 | 3.08 | GI162 | PS72 |
| | PSBNR 5050 S 25 | 50 | 50 | 50 | 43 | 250 | 50 | -6 | -6 | 4.70 | GI027 | PS60 |
| | PSBNR 5050 T 25 | 50 | 50 | 50 | 43 | 300 | 50 | -6 | -6 | 5.83 | GI027 | PS60 |
| | PSBNR 5050 T 2509 | 50 | 50 | 50 | 43 | 300 | 50 | -6 | -6 | 5.50 | GI040 | PS70 |
| | PSBNR 5050 T 2512-A | 50 | 50 | 50 | 43 | 300 | 50 | -6 | -6 | 5.83 | GI162 | PS72 |
| L | PSBNL 2020 K 12 | 20 | 20 | 20 | 17 | 125 | 36 | -6 | -6 | 0.42 | GI029 | PS22 |
| | PSBNL 2525 M 12 | 25 | 25 | 25 | 22 | 150 | 36 | -6 | -6 | 0.75 | GI029 | PS20 |
| | PSBNL 3225 P 15 | 32 | 25 | 32 | 22 | 170 | 40 | -6 | -6 | 1.05 | GI082 | PS40 |
| | PSBNL 3232 P 19 | 32 | 32 | 32 | 27 | 170 | 45 | -6 | -6 | 1.36 | GI026 | PS50 |
| | PSBNL 4040 R 19 | 40 | 40 | 40 | 35 | 200 | 45 | -6 | -6 | 2.50 | GI026 | PS50 |
| | PSBNL 4040 S 19 | 40 | 40 | 40 | 35 | 250 | 45 | -6 | -6 | 3.13 | GI026 | PS50 |
| | PSBNL 4040 R 25 | 40 | 40 | 40 | 35 | 200 | 45 | -6 | -6 | 2.45 | GI027 | PS60 |
| | PSBNL 4040 S 25 | 40 | 40 | 40 | 35 | 250 | 50 | -6 | -6 | 3.10 | GI027 | PS60 |
| | PSBNL 4040 S 2509 | 40 | 40 | 40 | 35 | 250 | 50 | -6 | -6 | 2.50 | GI040 | PS70 |
| | PSBNL 4040 S 2512-A | 40 | 40 | 40 | 35 | 250 | 50 | -6 | -6 | 3.11 | GI162 | PS72 |
| | PSBNL 5050 S 25 | 50 | 50 | 50 | 43 | 250 | 50 | -6 | -6 | 4.70 | GI027 | PS60 |
| | PSBNL 5050 T 25 | 50 | 50 | 50 | 43 | 300 | 50 | -6 | -6 | 5.84 | GI027 | PS60 |
| | PSBNL 5050 T 2509 | 50 | 50 | 50 | 43 | 300 | 50 | -6 | -6 | 5.80 | GI040 | PS70 |

| | Product | H (mm) | B (mm) | HF (mm) | WF (mm) | LF (mm) | LH (mm) | LAMS (°) | GAMO (°) | kg | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| L | **PSBNL 5050 T 2512-A** | 50 | 50 | 50 | 43 | 300 | 50 | -6 | -6 | 5.82 | GI162 | PS72 |

| | |
|---|---|
| GI026 | SN.. 1906.. |
| GI027 | SN.. 2507.. |
| GI029 | SN.. 1204.. |
| GI040 | SN.. 2509.. |
| GI082 | SN.. 1506.. |
| GI162 | SN.. 2512.. |

| | | | | Nm | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| PS20 | SNU 120312 | PU 02 | US 35 | 6.0 | M 8x1 | 22.5 | NT 05 | MT 05 | HXK 4 |
| PS22 | SNU 120312 | PU 02 | US 42 | 6.0 | M 8x1 | 21 | NT 05 | MT 05 | HXK 4 |
| PS40 | SNU 150312 | PU 04 | US 36 | 6.0 | M 8x1 | 26 | NT 07 | MT 07 | HXK 4 |
| 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 |
| PS72 | 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

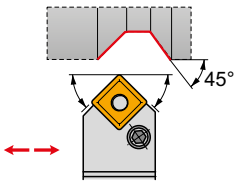
PRAMET

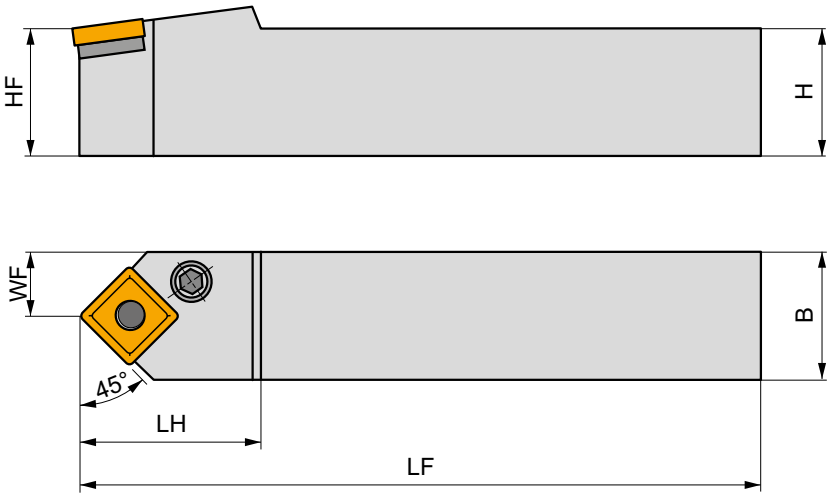
P

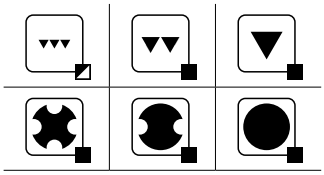


## Ekstern holder med 45 ° skærevinkel til SN .. Skær

Ekstern neutral værktøjsholder til låsehåndtag med 45 ° skærevinkel. Velegnet til langsgående drejning uden skulder, kopiering og konisk drejning og affasning med negativ SN .. 12, 15, 19 eller 25 størrelse skær. Fås i 20x20 op til 50x50 mm skaft. Krop behandlet for længere levetid





| | 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 | 36 | -6 | -6 | 0.42 | GI029 | PS22 |
| | **PSDNN 2525 M 12** | 25 | 25 | 25 | 12.5 | 150 | 36 | -6 | -6 | 0.68 | GI029 | PS20 |
| | **PSDNN 3232 P 15** | 32 | 32 | 32 | 16 | 170 | 40 | -6 | -6 | 1.32 | GI082 | PS40 |
| | **PSDNN 3232 P 19** | 32 | 32 | 32 | 16 | 170 | 45 | -6 | -6 | 1.25 | GI026 | PS50 |
| | **PSDNN 4040 S 19** | 40 | 40 | 40 | 20 | 250 | 45 | -6 | -6 | 3.05 | GI026 | PS50 |
| | **PSDNN 4040 S 25** | 40 | 40 | 40 | 20 | 250 | 50 | -6 | -6 | 3.02 | GI027 | PS60 |
| | **PSDNN 5050 T 25** | 50 | 50 | 50 | 25 | 300 | 50 | -6 | -6 | 5.65 | GI027 | PS60 |

| | |
|---|---|
| GI026 | SN.. 1906.. |
| GI027 | SN.. 2507.. |
| GI029 | SN.. 1204.. |
| GI082 | SN.. 1506.. |

| | | | | Nm | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| PS20 | SNU 120312 | PU 02 | US 35 | 6.0 | M 8x1 | 22.5 | NT 05 | MT 05 | HXK 4 |
| PS22 | SNU 120312 | PU 02 | US 42 | 6.0 | M 8x1 | 21 | NT 05 | MT 05 | HXK 4 |
| PS40 | SNU 150312 | PU 04 | US 36 | 6.0 | M 8x1 | 26 | NT 07 | MT 07 | HXK 4 |
| 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 |

# PSKN(RL) EXT

P M K N S H

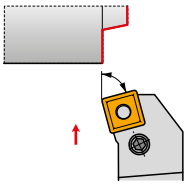
PRAMET

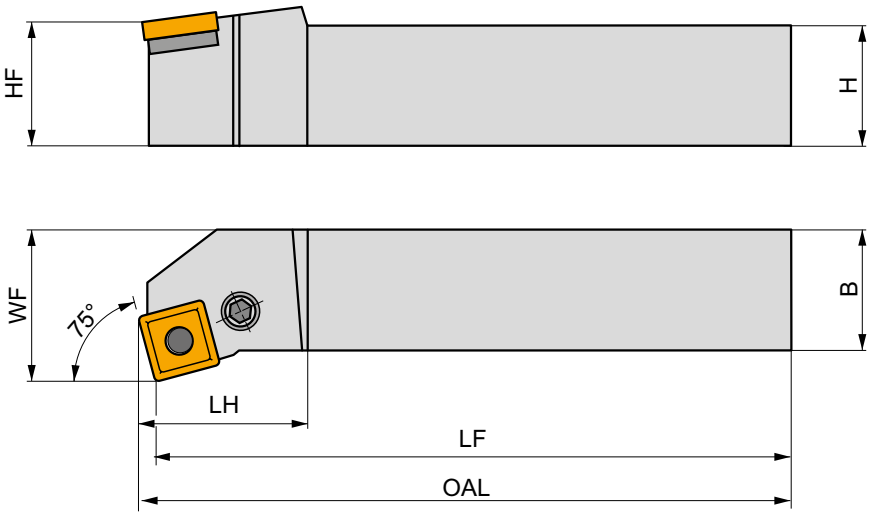
P

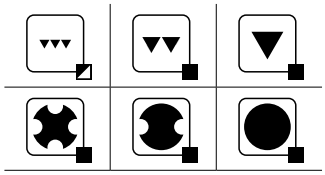


## Ekstern Lever Lock Drejeholder med 75 ° skærevinkel til SN .. Skær

Ekstern højre / venstre hånd værktøjsholder med 75 ° skærevinkel. Velegnet til endedrejning uden skulder og affasning med negativ SN .. 12, 15, 19 eller 25 størrelse skær. Fås i 20x20 op til 50x50 mm skaft. Krop behandlet for længere levetid







| | Product | H (mm) | B (mm) | HF (mm) | WF (mm) | LF (mm) | OAL (mm) | LH (mm) | LAMS (°) | GAMO (°) | kg | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| R | **PSKNR 2020 K 12** | 20 | 20 | 20 | 25 | 125 | 128.1 | 36 | -6 | -6 | 0.43 | GI029 | PS22 |
| | **PSKNR 2525 M 12** | 25 | 25 | 25 | 32 | 150 | 153.1 | 36 | -6 | -6 | 0.79 | GI029 | PS20 |
| | **PSKNR 3225 P 15** | 32 | 25 | 32 | 32 | 170 | 173.9 | 40 | -6 | -6 | 0.40 | GI082 | PS40 |
| | **PSKNR 3232 P 19** | 32 | 32 | 32 | 40 | 170 | 174.6 | 45 | -6 | -6 | 1.40 | GI026 | PS50 |
| | **PSKNR 4040 S 19** | 40 | 40 | 40 | 50 | 250 | 254.6 | 45 | -6 | -6 | 3.25 | GI026 | PS50 |
| | **PSKNR 4040 S 25** | 40 | 40 | 40 | 50 | 250 | 256.5 | 50 | -6 | -6 | 3.40 | GI027 | PS60 |
| | **PSKNR 5050 T 25** | 50 | 50 | 50 | 60 | 300 | 306.5 | 50 | -6 | -6 | 6.05 | GI027 | PS60 |
| | **PSKNR 5050 T 2509** | 50 | 50 | 50 | 60 | 300 | 306.5 | 50 | -6 | -6 | 6.20 | GI040 | PS70 |
| L | **PSKNL 2020 K 12** | 20 | 20 | 20 | 25 | 125 | 128.1 | 36 | -6 | -6 | 0.43 | GI029 | PS22 |
| | **PSKNL 2525 M 12** | 25 | 25 | 25 | 32 | 150 | 153.1 | 36 | -6 | -6 | 0.79 | GI029 | PS20 |
| | **PSKNL 3225 P 15** | 32 | 25 | 32 | 32 | 170 | 173.9 | 40 | -6 | -6 | 1.05 | GI082 | PS40 |
| | **PSKNL 3232 P 19** | 32 | 32 | 32 | 40 | 170 | 174.6 | 45 | -6 | -6 | 1.40 | GI026 | PS50 |
| | **PSKNL 4040 S 19** | 40 | 40 | 40 | 50 | 250 | 254.6 | 45 | -6 | -6 | 3.26 | GI026 | PS50 |
| | **PSKNL 4040 S 25** | 40 | 40 | 40 | 50 | 250 | 256.5 | 50 | -6 | -6 | 3.40 | GI027 | PS60 |
| | **PSKNL 5050 T 25** | 50 | 50 | 50 | 60 | 300 | 306.5 | 50 | -6 | -6 | 6.00 | GI027 | PS60 |
| | **PSKNL 5050 T 2509** | 50 | 50 | 50 | 60 | 300 | 306.5 | 50 | -6 | -6 | 6.20 | GI040 | PS70 |

| | |
|---|---|
| GI026 | SN.. 1906.. |
| GI027 | SN.. 2507.. |
| GI029 | SN.. 1204.. |
| GI040 | SN.. 2509.. |
| GI082 | SN.. 1506.. |

|  |  |  |  |  |  |  |  |  |  |
|---|---|---|---|---|---|---|---|---|---|
| PS20 | SNU 120312 | PU 02 | US 35 | 6.0 | M 8x1 | 22.5 | NT 05 | MT 05 | HXK 4 |
| PS22 | SNU 120312 | PU 02 | US 42 | 6.0 | M 8x1 | 21 | NT 05 | MT 05 | HXK 4 |
| PS40 | SNU 150312 | PU 04 | US 36 | 6.0 | M 8x1 | 26 | NT 07 | MT 07 | HXK 4 |
| 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 |

# PSSN(RL) EXT

P M K N S H

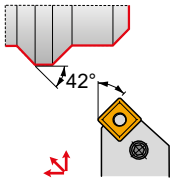
PRAMET

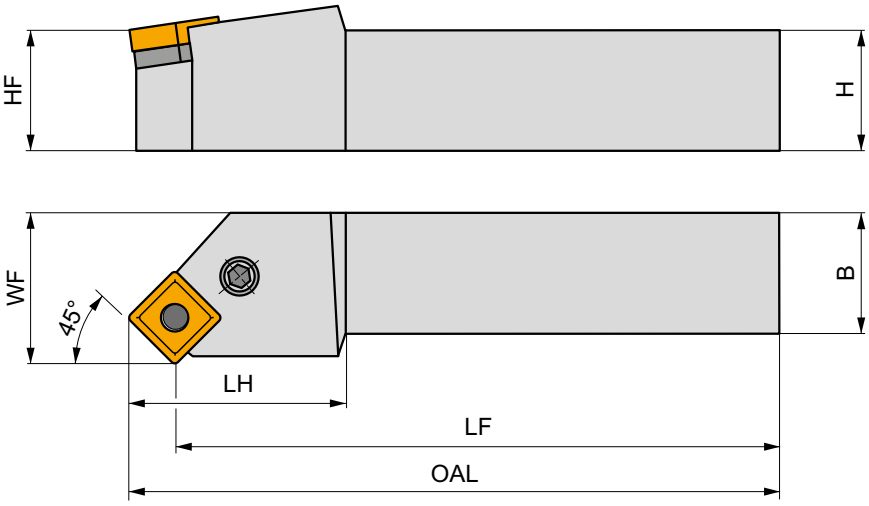
P

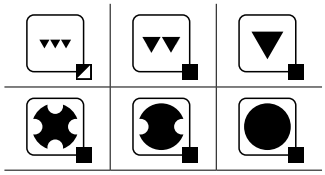


## Ekstern Lever Lock Drejeholder med 45 ° skærevinkel til SN .. Skær

Ekstern højre / venstre hånd værktøjsholder med 45 ° skærevinkel. Velegnet til længde- og endedrejning uden skulder, kopiering og konisk drejning og affasning med negativ SN .. 12, 15, 19 eller 25 størrelse skær. Fås i 20x20 op til 50x50 mm skaft. Krop behandlet for længere levetid





| | Product | H (mm) | B (mm) | HF (mm) | WF (mm) | LF (mm) | OAL (mm) | LH (mm) | LAMS (°) | GAMO (°) | kg | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| R | **PSSNR 2020 K 12** | 20 | 20 | 20 | 25 | 125 | 133.3 | 36 | 0 | -8 | 0.41 | GI029 | PS22 |
| | **PSSNR 2525 M 12** | 25 | 25 | 25 | 32 | 150 | 158.3 | 36 | 0 | -8 | 0.75 | GI029 | PS20 |
| | **PSSNR 3225 P 15** | 32 | 25 | 32 | 32 | 170 | 180.2 | 40 | 0 | -8 | 1.13 | GI082 | PS40 |
| | **PSSNR 3232 P 19** | 32 | 32 | 32 | 40 | 170 | 182.5 | 45 | 0 | -8 | 1.34 | GI026 | PS50 |
| | **PSSNR 4040 R 19** | 40 | 40 | 40 | 50 | 200 | 212.5 | 45 | 0 | -8 | 2.50 | GI026 | PS50 |
| | **PSSNR 5050 T 25** | 50 | 50 | 50 | 60 | 300 | 316 | 50 | 0 | -8 | 6.00 | GI027 | PS60 |
| | **PSSNR 5050 T 2509** | 50 | 50 | 50 | 60 | 300 | 316 | 50 | 0 | -8 | 6.05 | GI040 | PS70 |
| L | **PSSNL 2020 K 12** | 20 | 20 | 20 | 25 | 125 | 133.3 | 36 | 0 | -8 | 0.41 | GI029 | PS22 |
| | **PSSNL 2525 M 12** | 25 | 25 | 25 | 32 | 150 | 158.3 | 36 | 0 | -8 | 0.67 | GI029 | PS20 |
| | **PSSNL 3225 P 15** | 32 | 25 | 32 | 32 | 170 | 180.2 | 40 | 0 | -8 | 1.15 | GI082 | PS40 |
| | **PSSNL 3232 P 19** | 32 | 32 | 32 | 40 | 170 | 182.5 | 45 | 0 | -8 | 1.44 | GI026 | PS50 |
| | **PSSNL 4040 R 19** | 40 | 40 | 40 | 50 | 200 | 212.5 | 45 | 0 | -8 | 2.58 | GI026 | PS50 |
| | **PSSNL 5050 T 25** | 50 | 50 | 50 | 60 | 300 | 316 | 50 | 0 | -8 | 6.00 | GI027 | PS60 |
| | **PSSNL 5050 T 2509** | 50 | 50 | 50 | 60 | 300 | 316 | 50 | 0 | -8 | 6.08 | GI040 | PS70 |

| | |
|---|---|
| GI026 | SN.. 1906.. |
| GI027 | SN.. 2507.. |
| GI029 | SN.. 1204.. |
| GI040 | SN.. 2509.. |
| GI082 | SN.. 1506.. |

| | | | | Nm | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| PS20 | SNU 120312 | PU 02 | US 35 | 6.0 | M 8x1 | 22.5 | NT 05 | MT 05 | HXK 4 |
| PS22 | SNU 120312 | PU 02 | US 42 | 6.0 | M 8x1 | 21 | NT 05 | MT 05 | HXK 4 |
| PS40 | SNU 150312 | PU 04 | US 36 | 6.0 | M 8x1 | 26 | NT 07 | MT 07 | HXK 4 |
| 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 |

NEW

# C.-DSDNN EXT

P M K N S H

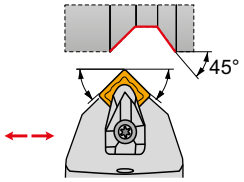
PRAMET

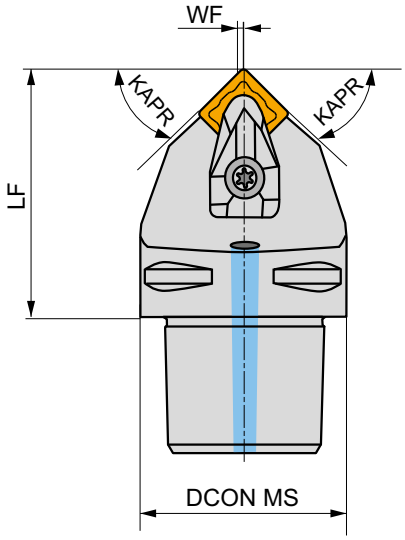
D

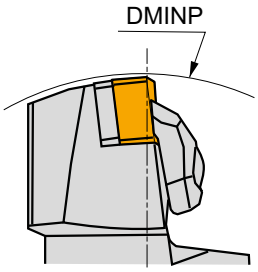


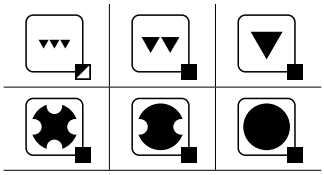
## Eksternt PSC Quick Change Tool, dobbelt klemme, 45 ° skærevinkel, SN .. Skær

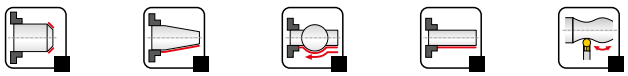
Eksternt neutralt dobbeltklemmeværktøj, gennem kølevæske, med 45° skærevinkel til langsgående drejning uden skulder, kopidrejning, konisk drejning og affasedrejning med negative SN .. 12 eller 19 størrelse skær. Fås med PSC (Polygon Shank Coupling) C4 op til C6 skaft. Krop behandlet for længere levetid





| | 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 | – |

| | |
|---|---|
| GI026 | SN.. 1906.. |
| GI029 | SN.. 1204.. |

| | | 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 | – |

NEW

# C.-DSKN(RL) EXT

P M K N S H

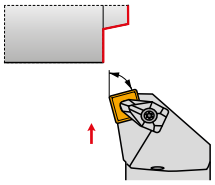
PRAMET

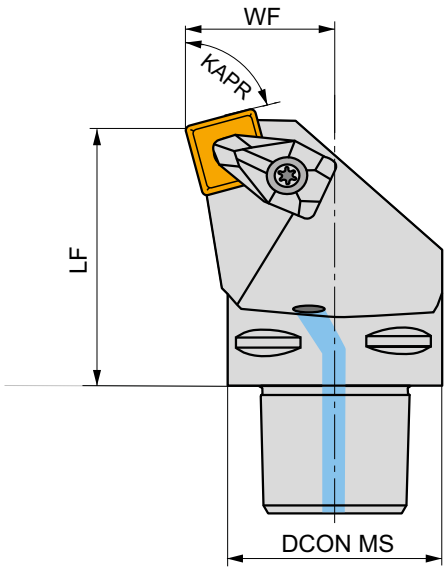
D

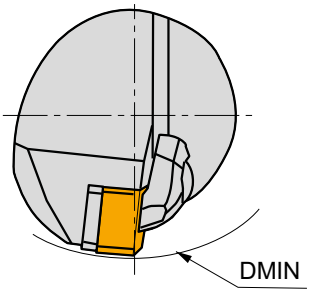


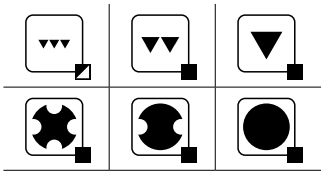
## Eksternt PSC hurtig skift værktøj, dobbelt klemme, 75 ° skærevinkel, SN .. Skær

Eksternt højre / venstre hånd dobbelt klemmeværktøj, indvendig kølevæske, med 75° skærevinkel til endedrejning uden skulder og affasning med negativ SN .. 12 .. størrelse skær. Fås med PSC (Polygon Shank Coupling) C4. Krop behandlet for længere levetid







| | 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.. |

| | | Nm | | | | |
|---|---|---|---|---|---|---|
| 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 | – |

NEW

# C.-DSRN(RL) EXT

P M K N S H

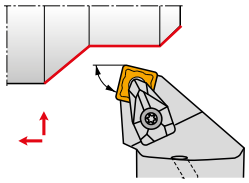
PRAMET

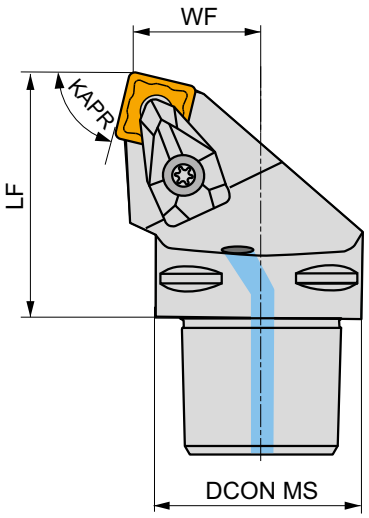
D

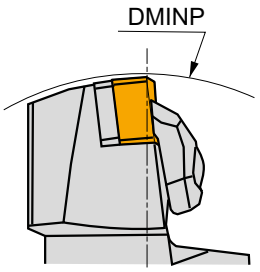


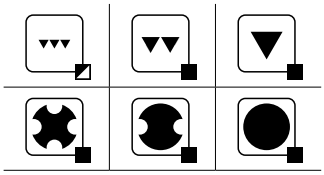
## Eksternt PSC hurtig skift værktøj, dobbelt klemme, 75 ° skærevinkel, SN .. Skær

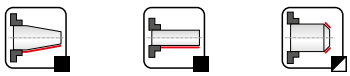
Eksternt højre / venstre hånd dobbelt klemme værktøj, indvendig kølemiddel, med 75° skærevinkel til langsgående drejning uden skulder, konisk drejning og affasning med negative SN .. 12 eller 19 størrelse skær. Fås med PSC (Polygon Shank Coupling) C4 op til C6 skaft. Krop behandlet for længere levetid







| | 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 | ✓ | 0.42 | GI029 | C-DS12-1 | AT003 |
| | **C6-DSRNL-35065-19** | 63 | 190 | 35 | 65 | 75 | -6 | -6 | ✓ | 1.30 | GI026 | C-DS19 | – |

| | |
|---|---|
| GI026 | SN.. 1906.. |
| GI029 | SN.. 1204.. |

| | | | | | | | |
|---|---|---|---|---|---|---|---|
| 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 | – |

NEW

# C.-DSSN(RL) EXT

P M K N S H

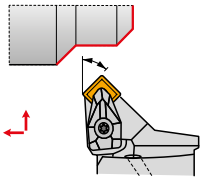
PRAMET

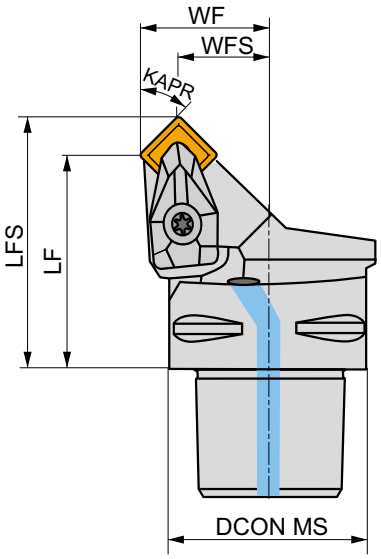
D

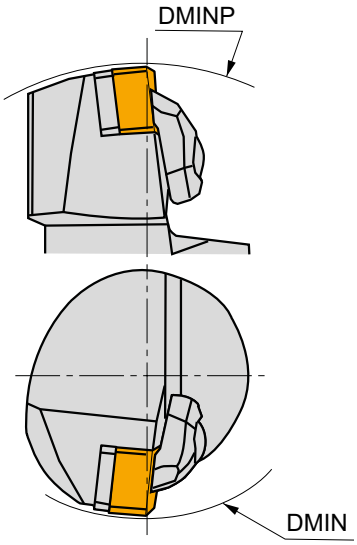


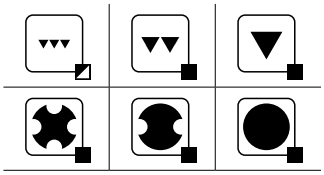
## Eksternt PSC hurtig skift værktøj, dobbelt klemme, 45 ° skærevinkel, SN .. Skær

Eksternt højre / venstre dobbeltklemmeværktøj, indvendig kølevæske, med 45° skærevinkel til langsgående og endedrejning uden skulder, konisk drejning, kopidrejning og affasning med negativ SN .. 12 størrelse skær. Fås med PSC (Polygon Shank Coupling) C4 og C5 skaft. Krop behandlet for længere levetid







| | 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 |
| R | **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 |
| L | **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

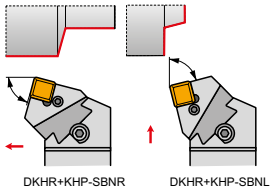
PRAMET

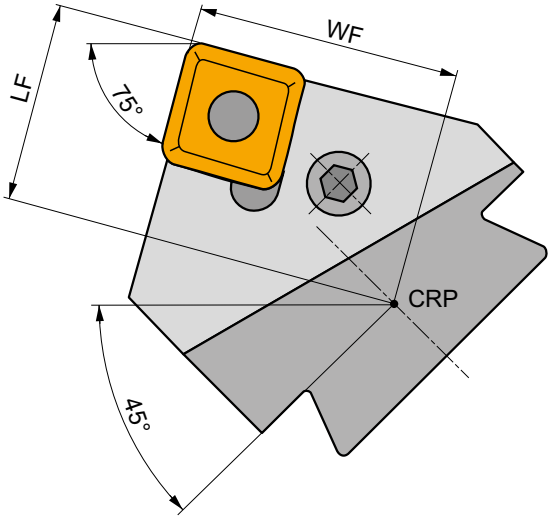
P

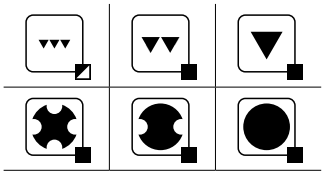


## Modulær KHP drejeholder, 75 ° skærevinkel til SN .. Skær

Drejeholder højre / venstre håndlås drejepatron, 75 ° skærevinkel, til montering på DKH værktøjsholderskaft. Velegnet til kraftig langsgående drejning uden hjørne, plandrejning, konisk drejning med fasning med negativ SN .. 19 skær. Værktøjsholder behandlet for længere værktøjslevetid.





| | 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 |
| | KHP-SBNR 2512-A | 47 | 36 | -6 | -6 | 1.71 | GI162 | PS72 |
| L | KHP-SBNL 19 | 47 | 36 | -6 | -6 | 1.96 | GI026 | PS50 |
| | KHP-SBNL 25 | 47 | 36 | -6 | -6 | 1.48 | GI027 | PS60 |
| | KHP-SBNL 2509 | 47 | 36 | -6 | -6 | 1.46 | GI040 | PS70 |
| | KHP-SBNL 2512-A | 47 | 36 | -6 | -6 | 1.45 | GI162 | PS72 |

| | |
|---|---|
| GI026 | SN.. 1906.. |
| GI027 | SN.. 2507.. |
| GI040 | SN.. 2509.. |
| GI162 | SN.. 2512.. |

| | | | | 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 |
| PS72 | SNU 250624 | PU 10-N | PS 12040 | 8.0 | M 12x1 | 40 | NT 08 | MT 08 | HXK 5 |

# KHP-SSN(RL)

P M K

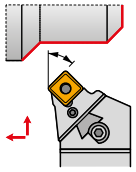
PRAMET

P

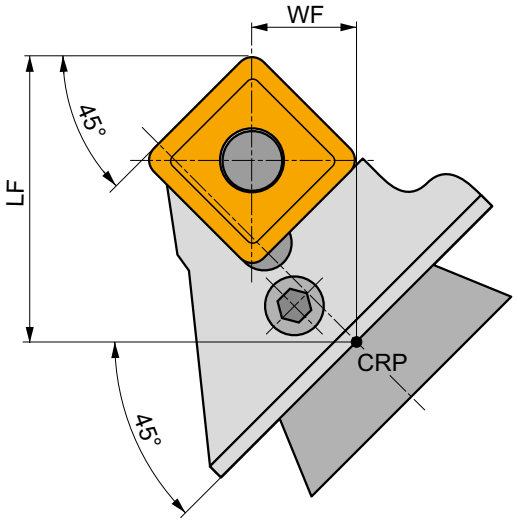


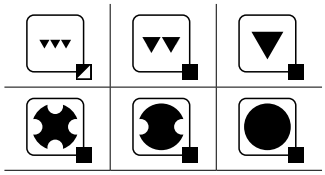
## Modulær KHP drejeholder, 45 ° skærevinkel til SN .. Skær

Drejeholder højre / venstre håndlås, drejepatron, 45 ° skærevinkel, til montering på DKH værktøjsholderskaft. Velegnet til kraftig langsgående drejning uden hjørne, plandrejning, kopiering, tilspidsning og affasning med negativ SN .. 19 eller 25 skær. Værktøjsholder behandlet for længere værktøjslevetid.



DKHR+KHP-SSNR





| | Product | WF (mm) | LF (mm) | LAMS (°) | GAMO (°) | kg | | |
|---|---|---|---|---|---|---|---|---|
| R | **KHP-SSNR 19** | 15 | 45 | -6 | -6 | 1.28 | GI026 | PS50 |
| | **KHP-SSNR 25** | 15 | 45 | -6 | -6 | 0.98 | GI027 | PS60 |
| L | **KHP-SSNL 19** | 15 | 45 | -6 | -6 | 1.03 | GI026 | PS50 |
| | **KHP-SSNL 25** | 15 | 45 | -6 | -6 | 1.30 | GI027 | PS60 |

| | |
|---|---|
| GI026 | SN.. 1906.. |
| GI027 | SN.. 2507.. |

| | | | | 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 |

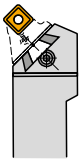
# DKH(RL)

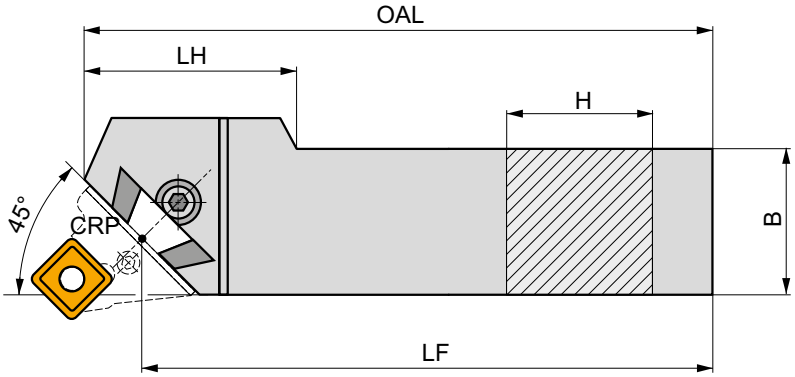
PRAMET

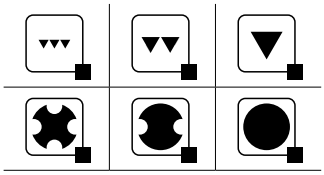


## Eksternt værktøjsholderskaft til KHP / KHS tung drejening

Drejeholder højre / venstre modulære værktøjsskaft til KHP / KHS patroner. Velegnet til tunge drejeprogrammer. Fås med skaftstørrelse 40x50 op til 60x80 mm. Krop behandlet for længere levetid





| | Product | H (mm) | B (mm) | LF (mm) | OAL (mm) | LH (mm) | kg | | |
|---|---|---|---|---|---|---|---|---|---|
| R | **DKHR 4050 V** | 40 | 50 | 400 | 425 | 100 | 7.10 | GI098 | DKH10 |
| | **DKHR 5060 W** | 50 | 60 | 450 | 475 | 110 | 11.30 | GI098 | DKH10 |
| | **DKHR 6080 W-A** | 60 | 80 | 450 | 485 | 90 | 19.65 | GI098 | DKH10 |
| L | **DKHL 4050 V** | 40 | 50 | 400 | 425 | 100 | 7.10 | GI098 | DKH10 |
| | **DKHL 5060 W** | 50 | 60 | 450 | 475 | 110 | 11.30 | GI098 | DKH10 |
| | **DKHL 6080 W-A** | 60 | 80 | 450 | 485 | 90 | 19.28 | GI098 | DKH10 |

| | | |
|---|---|---|
| GI098 | KHP | KHS |

| | | |
|---|---|---|
| DKH10 | SR 14 | HXK 10 |

# PSKN(RL) INT

P M K N S H

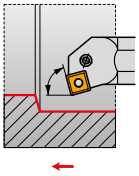
PRAMET

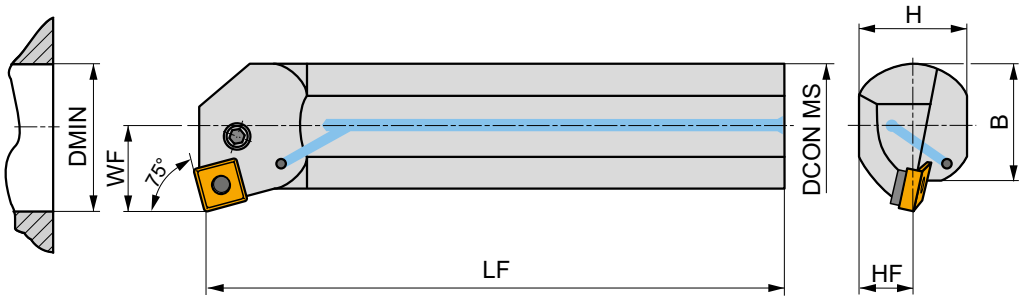
P

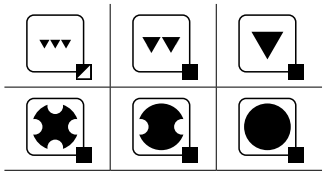


## Intern låseholder med 75 ° skærevinkel til SN .. Skær

Intern højre / venstre hånd, indvendig kølevæske, 75° skærevinkel til SN .. 12, 15 og 19 skær. Mindste indvendige drejediameter Ø40 mm. Til indvendig tilspidsning og langsgående drejning uden skulder- og affasedrejning. Fås med skaftstørrelse Ø32 op til Ø60 mm. Krop behandlet for længere levetid på værktøjet.







| | Product | DCON MS (mm) | DMIN (mm) | WF (mm) | H (mm) | B (mm) | LF (mm) | LAMS (°) | GAMO (°) | | kg | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| R | **A32S-PSKNR 12** | 32 | 40 | 22 | 30 | 30 | 250 | -12 | -6 | ✓ | 1.50 | GI029 | PS21 |
| | **A40T-PSKNR 15** | 40 | 50 | 27 | 38 | 38 | 300 | -12 | -6 | ✓ | 2.90 | GI082 | PS41 |
| | **A50U-PSKNR 15** | 50 | 63 | 35 | 47 | 48.5 | 350 | -12 | -6 | ✓ | 5.20 | GI082 | PS40 |
| | **A50U-PSKNR 19** | 50 | 63 | 35 | 47 | 48.5 | 350 | -12 | -6 | ✓ | 5.20 | GI026 | PS50 |
| | **A60V-PSKNR 19** | 60 | 80 | 43 | 57 | 58.5 | 400 | -12 | -6 | ✓ | 8.70 | GI026 | PS50 |
| L | **A32S-PSKNL 12** | 32 | 40 | 22 | 30 | 30 | 250 | -12 | -6 | ✓ | 1.40 | GI029 | PS21 |
| | **A40T-PSKNL 15** | 40 | 50 | 27 | 38 | 38 | 300 | -12 | -6 | ✓ | 2.90 | GI082 | PS41 |
| | **A50U-PSKNL 15** | 50 | 63 | 35 | 47 | 48.5 | 350 | -12 | -6 | ✓ | 5.20 | GI082 | PS40 |
| | **A50U-PSKNL 19** | 50 | 63 | 35 | 47 | 48.5 | 350 | -12 | -6 | ✓ | 5.20 | GI026 | PS50 |

| | |
|---|---|
| GI026 | SN.. 1906.. |
| GI029 | SN.. 1204.. |
| GI082 | SN.. 1506.. |

| | | | | Nm | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| PS21 | SNU 120312 | PU 02 | US 41 | 6.0 | M 8x1 | 17 | NT 05 | MT 05 | HXK 4 |
| PS40 | SNU 150312 | PU 04 | US 36 | 6.0 | M 8x1 | 26 | NT 07 | MT 07 | HXK 4 |
| PS41 | SNU 150312 | PU 04 | US 40 | 6.0 | M 8x1 | 20.5 | NT 07 | MT 07 | HXK 4 |
| PS50 | SNU 190416 | PU 05 | US 38 | 8.0 | M 10x1 | 29 | NT 06 | MT 06 | HXK 5 |

# TN

16/ 22/ 27/ 33

## CARBIDE INSERTS

**TNMA**



334

**TNMG**



335

**TNMM**



342

## CER AND CBN INSERTS

**TNGA CER**



343

**TNGN CER**



344

**TNGA CBN**



344

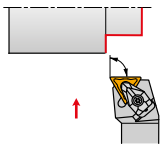
| MATCH THE RIGHT SIZE (example) | |
|---|---|
| **Insert** | **Tool Holder** |
| TNMM 160412E-OR | DTFNR 2525 M 16 |

## ISO-DREJNING – UDVENDIGT

### DTFN(RL) EXT

90°

TN..: 16, 22



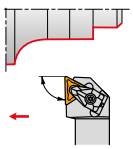
20×20 / 25×25

345 | 334 – 344

### DTGN(RL) EXT

90°

TN..: 16, 22



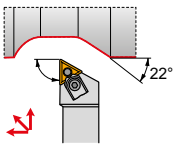
20×20 / 32×25

346 | 334 – 344

### MTJN(RL) EXT

93°

TN..: 16, 22



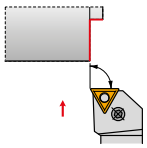

16×16 / 32×32

347 | 334 – 344

### PTFN(RL) EXT

90°

TN..: 16, 22, 27



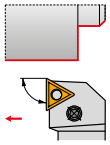
16×16 / 40×40

348 | 334 – 344

### PTGN(RL) EXT

90°

TN..: 16, 22, 27



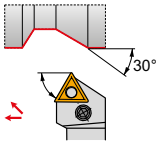
16×16 / 40×40

349 | 334 – 344

### PTTN(RL) EXT

60°

TN..: 16, 22



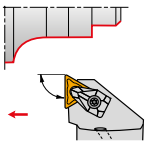

20×20 / 32×25

350 | 334 – 344

### C.-DTJN(RL) EXT NEW

93°

TN..: 16



C4 / C5

351 | 334 – 344

# TN

16/ 22/ 27/ 33

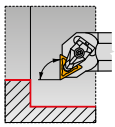
## ISO-DREJNING – INDVENDIG

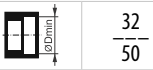
### DTFN(RL) INT

90°

TN..

16
22






352

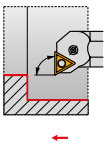
334 – 344

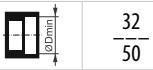
### PTFN(RL) INT

90°

TN..

16
22






353

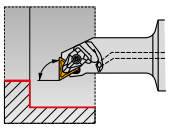
334 – 344

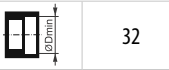
### C.-DTFN(RL) INT NEW

91°

TN..

16





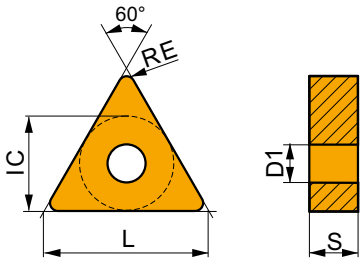

354

334 – 344

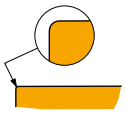
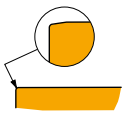
# TNMA

PRAMET

| | 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 |



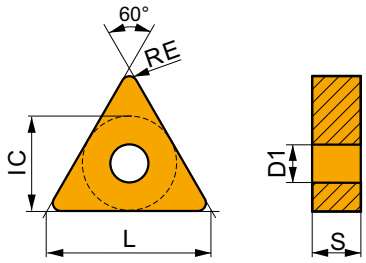

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | Til fin til halv grov bearbejdning og kontinuerlig til let afbrudt snit. | | | | | | | | | | | | | | | | | |
| **TNMA 160404** | **T5305** | 0.4 | – | – | – | – | – | – | 220 | 0.10 | 1.5 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |
| | **T5315** | 0.4 | – | – | – | – | – | – | 190 | 0.10 | 1.5 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| **TNMA 160408** | **T5305** | 0.8 | – | – | – | – | – | – | 205 | 0.20 | 1.5 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| | **T5315** | 0.8 | – | – | – | – | – | – | 180 | 0.20 | 1.5 | – | – | – | – | – | – | 35 | 0.15 | 1.0 |
| | **T6310** | 0.8 | – | – | – | – | – | – | 90 | 0.20 | 1.5 | – | – | – | – | – | – | 20 | 0.15 | 1.0 |
| **TNMA 160412** | **T5305** | 1.2 | – | – | – | – | – | – | 215 | 0.20 | 1.5 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |
| | **T5315** | 1.2 | – | – | – | – | – | – | 190 | 0.20 | 1.5 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| **TNMA 220408** | **T5305** | 0.8 | – | – | – | – | – | – | 195 | 0.20 | 2.0 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| | **T5315** | 0.8 | – | – | – | – | – | – | 175 | 0.20 | 2.0 | – | – | – | – | – | – | 35 | 0.15 | 1.0 |
| | **T6310** | 0.8 | – | – | – | – | – | – | 90 | 0.20 | 2.0 | – | – | – | – | – | – | 20 | 0.15 | 1.0 |
| **TNMA 220412** | **T5305** | 1.2 | – | – | – | – | – | – | 205 | 0.20 | 2.0 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| | **T5315** | 1.2 | – | – | – | – | – | – | 185 | 0.20 | 2.0 | – | – | – | – | – | – | 35 | 0.15 | 1.0 |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | Til fin til halv grov bearbejdning og kontinuerlig til let afbrudt snit. | | | | | | | | | | | | | | | | | |
| **TNMA 160408S** | **T5305** | 0.8 | – | – | – | – | – | – | 205 | 0.20 | 1.5 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |

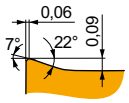
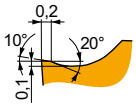
# TNMG

PRAMET

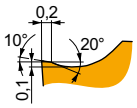
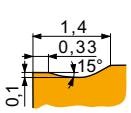
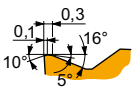
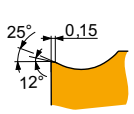
| | IC (mm) | D1 (mm) | L (mm) | S (mm) |
|---|---|---|---|---|
| 1604 | 9.525 | 3.81 | 16.50 | 4.76 |
| 2204 | 12.700 | 5.16 | 22.00 | 4.76 |
| 2706 | 15.875 | 6.35 | 27.50 | 6.35 |
| 3309 | 19.050 | 7.94 | 33.00 | 9.525 |



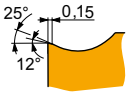
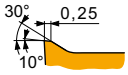
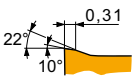

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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-geometri med meget positivt design til finbearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | |
| **TNMG 160404E-FF** | **T7325** | 0.4 | 200 | 0.12 | 1.0 | 155 | 0.11 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.4 | 185 | 0.12 | 1.0 | 110 | 0.11 | 1.0 | 175 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.4 | 175 | 0.12 | 1.0 | 105 | 0.11 | 1.0 | 165 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.4 | 210 | 0.12 | 1.0 | 115 | 0.11 | 1.0 | 175 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| **TNMG 160408E-FF** | **T7325** | 0.8 | 225 | 0.15 | 1.0 | 175 | 0.14 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.8 | 205 | 0.15 | 1.0 | 120 | 0.14 | 1.0 | 190 | 0.15 | 1.0 | – | – | – | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | FM-geometri med positivt design til fin til halvgrov bearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | |
| **TNMG 160404E-FM** | **T7325** | 0.4 | 160 | 0.20 | 1.7 | 120 | 0.18 | 1.7 | – | – | – | – | – | – | 50 | 0.20 | 1.4 | – | – | – |
| | **T7335** | 0.4 | 160 | 0.20 | 1.7 | 120 | 0.18 | 1.7 | – | – | – | – | – | – | 50 | 0.20 | 1.4 | – | – | – |
| | **T8315** | 0.4 | 150 | 0.20 | 1.7 | 90 | 0.18 | 1.7 | 140 | 0.20 | 1.7 | – | – | – | 35 | 0.14 | 1.4 | – | – | – |
| | **T8330** | 0.4 | 145 | 0.20 | 1.7 | 85 | 0.18 | 1.7 | 135 | 0.20 | 1.7 | – | – | – | 35 | 0.14 | 1.4 | – | – | – |
| | **T8430** | 0.4 | 165 | 0.20 | 1.7 | 90 | 0.18 | 1.7 | 135 | 0.20 | 1.7 | – | – | – | 35 | 0.14 | 1.4 | – | – | – |
| | **T9310** | 0.4 | 245 | 0.20 | 1.7 | – | – | – | 230 | 0.20 | 1.7 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.4 | 220 | 0.20 | 1.7 | – | – | – | 205 | 0.20 | 1.7 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 200 | 0.20 | 1.7 | 120 | 0.18 | 1.7 | 190 | 0.20 | 1.7 | – | – | – | 45 | 0.20 | 1.4 | – | – | – |
| | **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 | – | – | – |
| | **T7335** | 0.8 | 190 | 0.20 | 1.7 | 145 | 0.18 | 1.7 | – | – | – | – | – | – | 60 | 0.16 | 1.4 | – | – | – |
| | **T8315** | 0.8 | 180 | 0.20 | 1.7 | 105 | 0.18 | 1.7 | 170 | 0.20 | 1.7 | – | – | – | 45 | 0.16 | 1.4 | – | – | – |
| | **T8330** | 0.8 | 170 | 0.20 | 1.7 | 100 | 0.18 | 1.7 | 160 | 0.20 | 1.7 | – | – | – | 40 | 0.16 | 1.4 | – | – | – |
| | **T8430** | 0.8 | 195 | 0.20 | 1.7 | 105 | 0.18 | 1.7 | 160 | 0.20 | 1.7 | – | – | – | 40 | 0.16 | 1.4 | – | – | – |
| | **T9310** | 0.8 | 290 | 0.20 | 1.7 | – | – | – | 275 | 0.20 | 1.7 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.8 | 265 | 0.20 | 1.7 | – | – | – | 250 | 0.20 | 1.7 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 235 | 0.20 | 1.7 | 140 | 0.18 | 1.7 | 220 | 0.20 | 1.7 | – | – | – | 50 | 0.16 | 1.4 | – | – | – |
| | **TT310** | 0.8 | 270 | 0.20 | 1.7 | 160 | 0.18 | 1.7 | – | – | – | – | – | – | – | – | – | – | – | – |
| **TNMG 160412E-FM** | **T7325** | 1.2 | 190 | 0.25 | 1.7 | 145 | 0.23 | 1.7 | – | – | – | – | – | – | 60 | 0.18 | 1.4 | – | – | – |
| | **T8330** | 1.2 | 165 | 0.25 | 1.7 | 95 | 0.23 | 1.7 | 155 | 0.25 | 1.7 | – | – | – | 40 | 0.18 | 1.4 | – | – | – |
| | **T8430** | 1.2 | 185 | 0.25 | 1.7 | 100 | 0.23 | 1.7 | 150 | 0.25 | 1.7 | – | – | – | 40 | 0.18 | 1.4 | – | – | – |
| | **T9310** | 1.2 | 280 | 0.25 | 1.7 | – | – | – | 265 | 0.25 | 1.7 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 1.2 | 255 | 0.25 | 1.7 | – | – | – | 240 | 0.25 | 1.7 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | 225 | 0.25 | 1.7 | 135 | 0.23 | 1.7 | 210 | 0.25 | 1.7 | – | – | – | 50 | 0.18 | 1.4 | – | – | – |
| **TNMG 220404E-FM** | **T8330** | 0.4 | 145 | 0.20 | 1.7 | 85 | 0.18 | 1.7 | 135 | 0.20 | 1.7 | – | – | – | 35 | 0.20 | 1.4 | – | – | – |
| | **T8430** | 0.4 | 150 | 0.24 | 1.7 | 80 | 0.22 | 1.7 | 125 | 0.24 | 1.7 | – | – | – | 30 | 0.22 | 1.4 | – | – | – |
| | **T9315** | 0.4 | 220 | 0.20 | 1.7 | – | – | – | 205 | 0.20 | 1.7 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 200 | 0.20 | 1.7 | 120 | 0.18 | 1.7 | 190 | 0.20 | 1.7 | – | – | – | 45 | 0.20 | 1.4 | – | – | – |

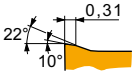
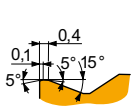
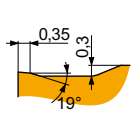
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | FM-geometri med positivt design til fin til halvgrov bearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | |
| **TNMG 220408E-FM** | **T8330** | 0.8 | ■ 170 | 0.20 | 1.7 | ◪ 100 | 0.18 | 1.7 | ■ 160 | 0.20 | 1.7 | – | – | – | ◪ 40 | 0.16 | 1.4 | – | – | – |
| | **T8430** | 0.8 | ■ 195 | 0.20 | 1.7 | ◪ 105 | 0.18 | 1.7 | ◪ 160 | 0.20 | 1.7 | – | – | – | ◪ 40 | 0.16 | 1.4 | – | – | – |
| | **T9315** | 0.8 | ■ 265 | 0.20 | 1.7 | – | – | – | ◪ 250 | 0.20 | 1.7 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | ■ 235 | 0.20 | 1.7 | ◪ 140 | 0.18 | 1.7 | ◪ 220 | 0.20 | 1.7 | – | – | – | ◪ 50 | 0.16 | 1.4 | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | KR-geometri til semi-grov til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **TNMG 160408E-KR** | **T5305** | 0.8 | ◪ 220 | 0.35 | 3.0 | – | – | – | ■ 205 | 0.35 | 3.0 | – | – | – | – | – | – | ◪ 40 | 0.15 | 1.0 |
| | **T5315** | 0.8 | ◪ 200 | 0.35 | 3.0 | – | – | – | ■ 190 | 0.35 | 3.0 | – | – | – | – | – | – | ◪ 40 | 0.15 | 1.0 |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | M-geometri til fin til halv grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **TNMG 160404E-M** | **T5315** | 0.4 | ◪ 215 | 0.20 | 1.6 | – | – | – | ■ 200 | 0.20 | 1.6 | – | – | – | – | – | – | ◪ 40 | 0.15 | 1.0 |
| | **T9315** | 0.4 | ■ 205 | 0.20 | 1.6 | – | – | – | ◪ 190 | 0.20 | 1.6 | – | – | – | – | – | – | ◪ 40 | 0.15 | 1.0 |
| | **T9325** | 0.4 | ■ 180 | 0.20 | 1.6 | – | – | – | ◪ 170 | 0.20 | 1.6 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.4 | ■ 155 | 0.20 | 1.6 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **TNMG 160408E-M** | **T5305** | 0.8 | ◪ 250 | 0.30 | 1.6 | – | – | – | ■ 235 | 0.30 | 1.6 | – | – | – | – | – | – | ◪ 50 | 0.15 | 1.0 |
| | **T5315** | 0.8 | ◪ 225 | 0.30 | 1.6 | – | – | – | ■ 210 | 0.30 | 1.6 | – | – | – | – | – | – | ◪ 45 | 0.15 | 1.0 |
| | **T9310** | 0.8 | ■ 220 | 0.30 | 1.6 | – | – | – | ◪ 205 | 0.30 | 1.6 | – | – | – | – | – | – | ◪ 40 | 0.15 | 1.0 |
| | **T9315** | 0.8 | ■ 205 | 0.30 | 1.6 | – | – | – | ◪ 190 | 0.30 | 1.6 | – | – | – | – | – | – | ◪ 40 | 0.15 | 1.0 |
| | **T9325** | 0.8 | ■ 185 | 0.30 | 1.6 | – | – | – | ◪ 175 | 0.30 | 1.6 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.8 | ■ 160 | 0.30 | 1.6 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **TNMG 160412E-M** | **T5315** | 1.2 | ◪ 215 | 0.40 | 1.6 | – | – | – | ■ 200 | 0.40 | 1.6 | – | – | – | – | – | – | ◪ 40 | 0.15 | 1.0 |
| | **T9315** | 1.2 | ■ 190 | 0.40 | 1.6 | – | – | – | ◪ 180 | 0.40 | 1.6 | – | – | – | – | – | – | ◪ 35 | 0.15 | 1.0 |
| | **T9325** | 1.2 | ■ 170 | 0.40 | 1.6 | – | – | – | ◪ 160 | 0.40 | 1.6 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.2 | ■ 145 | 0.40 | 1.6 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **TNMG 220408E-M** | **T5305** | 0.8 | ◪ 245 | 0.30 | 2.1 | – | – | – | ■ 230 | 0.30 | 2.1 | – | – | – | – | – | – | ◪ 45 | 0.15 | 1.0 |
| | **T5315** | 0.8 | ◪ 215 | 0.30 | 2.1 | – | – | – | ■ 200 | 0.30 | 2.1 | – | – | – | – | – | – | ◪ 40 | 0.15 | 1.0 |
| | **T9310** | 0.8 | ■ 215 | 0.30 | 2.1 | – | – | – | ◪ 200 | 0.30 | 2.1 | – | – | – | – | – | – | ◪ 40 | 0.15 | 1.0 |
| | **T9315** | 0.8 | ■ 200 | 0.30 | 2.1 | – | – | – | ◪ 190 | 0.30 | 2.1 | – | – | – | – | – | – | ◪ 40 | 0.15 | 1.0 |
| | **T9325** | 0.8 | ■ 180 | 0.30 | 2.1 | – | – | – | ◪ 170 | 0.30 | 2.1 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.8 | ■ 155 | 0.30 | 2.1 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **TNMG 220412E-M** | **T5315** | 1.2 | ◪ 205 | 0.40 | 2.1 | – | – | – | ■ 190 | 0.40 | 2.1 | – | – | – | – | – | – | ◪ 40 | 0.15 | 1.0 |
| | **T9315** | 1.2 | ■ 185 | 0.40 | 2.1 | – | – | – | ◪ 175 | 0.40 | 2.1 | – | – | – | – | – | – | ◪ 35 | 0.15 | 1.0 |
| | **T9325** | 1.2 | ■ 165 | 0.40 | 2.1 | – | – | – | ◪ 155 | 0.40 | 2.1 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.2 | ■ 140 | 0.40 | 2.1 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | NF-geometri med meget positivt design til finbearbejdning til medium bearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | |
| **TNMG 160404E-NF** | **HF7** | 0.4 | – | – | – | ◪ 90 | 0.14 | 1.4 | ◪ 140 | 0.15 | 1.4 | ◪ 450 | 0.18 | 1.4 | – | – | – | – | – | – |
| | **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 | – | – | – |
| | **T7325** | 0.4 | ◪ 170 | 0.18 | 1.4 | ■ 130 | 0.16 | 1.4 | – | – | – | – | – | – | ◪ 55 | 0.16 | 1.1 | – | – | – |
| | **T7335** | 0.4 | ◪ 165 | 0.18 | 1.4 | ■ 125 | 0.16 | 1.4 | – | – | – | – | – | – | ◪ 50 | 0.16 | 1.1 | – | – | – |
| | **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 | – | – | – |
| | **T8330** | 0.4 | ■ 155 | 0.17 | 1.4 | ■ 90 | 0.15 | 1.4 | ◪ 145 | 0.17 | 1.4 | ◪ 465 | 0.20 | 1.4 | ◪ 35 | 0.15 | 1.1 | – | – | – |
| | **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 | – | – | – |
| | **T9315** | 0.4 | ■ 255 | 0.15 | 1.4 | – | – | – | ◪ 240 | 0.15 | 1.4 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | ■ 215 | 0.18 | 1.4 | ■ 125 | 0.16 | 1.4 | ◪ 200 | 0.18 | 1.4 | – | – | – | ◪ 45 | 0.16 | 1.1 | – | – | – |

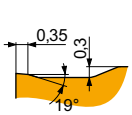
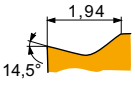
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |   | | | | | | | | | | | | | | | | | | | |
| | | | NF-geometri med meget positivt design til finbearbejdning til medium bearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | |
| **TNMG 160408E-NF** | **HF7** | 0.8 | – | – | – | ◪ 100 | 0.15 | 1.4 | ◪ 160 | 0.17 | 1.4 | ◪ 510 | 0.20 | 1.4 | – | – | – | – | – | – |
| | **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 | – | – | – |
| | **T7325** | 0.8 | ◪ 200 | 0.18 | 1.4 | ■ 155 | 0.16 | 1.4 | – | – | – | – | – | – | ◪ 65 | 0.16 | 1.1 | – | – | – |
| | **T7335** | 0.8 | ◪ 195 | 0.18 | 1.4 | ■ 150 | 0.16 | 1.4 | – | – | – | – | – | – | ◪ 60 | 0.16 | 1.1 | – | – | – |
| | **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 | – | – | – |
| | **T8330** | 0.8 | ■ 180 | 0.18 | 1.4 | ■ 105 | 0.16 | 1.4 | ◪ 170 | 0.18 | 1.4 | ◪ 540 | 0.22 | 1.4 | ◪ 45 | 0.16 | 1.1 | – | – | – |
| | **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 | – | – | – |
| | **T9315** | 0.8 | ■ 290 | 0.17 | 1.4 | – | – | – | ◪ 275 | 0.17 | 1.4 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | ■ 255 | 0.18 | 1.4 | ■ 150 | 0.16 | 1.4 | ◪ 240 | 0.18 | 1.4 | – | – | – | ◪ 55 | 0.16 | 1.1 | – | – | – |
|  |   | | | | | | | | | | | | | | | | | | | |
| | | | NM-geometri med meget positivt design til finbearbejdning, mellem og grov bearbejdning i kontinuerlige snit. | | | | | | | | | | | | | | | | | |
| **TNMG 160404E-NM** | **T7325** | 0.4 | ◪ 170 | 0.20 | 1.9 | ■ 130 | 0.18 | 1.9 | – | – | – | – | – | – | ■ 55 | 0.20 | 1.5 | – | – | – |
| | **T7335** | 0.4 | ◪ 160 | 0.20 | 1.9 | ■ 120 | 0.18 | 1.9 | – | – | – | – | – | – | ■ 50 | 0.20 | 1.5 | – | – | – |
| | **T8315** | 0.4 | ◪ 160 | 0.20 | 1.9 | ■ 95 | 0.18 | 1.9 | – | – | – | ◪ 480 | 0.24 | 1.9 | ◪ 40 | 0.20 | 1.5 | – | – | – |
| | **T8330** | 0.4 | ■ 145 | 0.20 | 1.9 | ■ 85 | 0.18 | 1.9 | – | – | – | ◪ 435 | 0.24 | 1.9 | ◪ 35 | 0.20 | 1.5 | – | – | – |
| | **T8430** | 0.4 | ■ 170 | 0.20 | 1.9 | ■ 90 | 0.18 | 1.9 | – | – | – | ◪ 465 | 0.24 | 1.9 | ◪ 35 | 0.20 | 1.5 | – | – | – |
| | **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 | – | – | – |
| | **T7335** | 0.8 | ◪ 180 | 0.25 | 1.9 | ■ 140 | 0.23 | 1.9 | – | – | – | – | – | – | ■ 55 | 0.20 | 1.5 | – | – | – |
| | **T8315** | 0.8 | ◪ 175 | 0.25 | 1.9 | ■ 105 | 0.23 | 1.9 | – | – | – | ◪ 525 | 0.30 | 1.9 | ◪ 40 | 0.20 | 1.5 | – | – | – |
| | **T8330** | 0.8 | ■ 165 | 0.25 | 1.9 | ■ 95 | 0.23 | 1.9 | – | – | – | ◪ 495 | 0.30 | 1.9 | ◪ 40 | 0.20 | 1.5 | – | – | – |
| | **T8430** | 0.8 | ■ 185 | 0.25 | 1.9 | ■ 100 | 0.23 | 1.9 | – | – | – | ◪ 510 | 0.30 | 1.9 | ◪ 40 | 0.20 | 1.5 | – | – | – |
| | **T9315** | 0.8 | ■ 250 | 0.25 | 1.9 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | ■ 225 | 0.25 | 1.9 | ■ 135 | 0.23 | 1.9 | – | – | – | – | – | – | ◪ 50 | 0.20 | 1.5 | – | – | – |
| **TNMG 220408E-NM** | **T7325** | 0.8 | ◪ 190 | 0.25 | 1.7 | ■ 145 | 0.23 | 1.7 | – | – | – | – | – | – | ■ 60 | 0.20 | 1.4 | – | – | – |
| | **T7335** | 0.8 | ◪ 185 | 0.25 | 1.7 | ■ 140 | 0.23 | 1.7 | – | – | – | – | – | – | ■ 60 | 0.20 | 1.4 | – | – | – |
| | **T8315** | 0.8 | ◪ 175 | 0.25 | 1.7 | ■ 105 | 0.23 | 1.7 | – | – | – | ◪ 525 | 0.30 | 1.7 | ◪ 40 | 0.20 | 1.4 | – | – | – |
| | **T8330** | 0.8 | ■ 165 | 0.25 | 1.7 | ■ 95 | 0.23 | 1.7 | – | – | – | ◪ 495 | 0.30 | 1.7 | ◪ 40 | 0.20 | 1.4 | – | – | – |
| | **T8430** | 0.8 | ■ 185 | 0.25 | 1.7 | ■ 100 | 0.23 | 1.7 | – | – | – | ◪ 510 | 0.30 | 1.7 | ◪ 40 | 0.20 | 1.4 | – | – | – |
| | **T9315** | 0.8 | ■ 255 | 0.25 | 1.7 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **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 | – | – | – |
| | **T7335** | 1.2 | ◪ 180 | 0.30 | 2.1 | ■ 140 | 0.27 | 2.1 | – | – | – | – | – | – | ■ 55 | 0.24 | 1.7 | – | – | – |
| | **T9325** | 1.2 | ■ 215 | 0.30 | 2.1 | ■ 125 | 0.27 | 2.1 | – | – | – | – | – | – | ◪ 45 | 0.24 | 1.7 | – | – | – |
|  |   | | | | | | | | | | | | | | | | | | | |
| | | | NMR-geometri med positivt design til medium til grov bearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | |
| **TNMG 160404E-NMR** | **T6310** | 0.4 | ■ 130 | 0.20 | 1.7 | ■ 90 | 0.18 | 1.7 | – | – | – | – | – | – | ■ 35 | 0.18 | 1.4 | – | – | – |
| | **T7325** | 0.4 | ◪ 145 | 0.20 | 1.7 | ■ 110 | 0.18 | 1.7 | – | – | – | – | – | – | ■ 45 | 0.18 | 1.4 | – | – | – |
| | **T7335** | 0.4 | ◪ 145 | 0.20 | 1.7 | ■ 110 | 0.18 | 1.7 | – | – | – | – | – | – | ■ 45 | 0.18 | 1.4 | – | – | – |
| | **T8330** | 0.4 | ■ 130 | 0.20 | 1.7 | ■ 75 | 0.18 | 1.7 | – | – | – | – | – | – | ◪ 30 | 0.18 | 1.4 | – | – | – |
| | **T8430** | 0.4 | ■ 145 | 0.20 | 1.7 | ■ 80 | 0.18 | 1.7 | – | – | – | – | – | – | ◪ 30 | 0.18 | 1.4 | – | – | – |
| | **T9315** | 0.4 | ■ 200 | 0.20 | 1.7 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | ■ 180 | 0.20 | 1.7 | ■ 105 | 0.18 | 1.7 | – | – | – | – | – | – | ◪ 40 | 0.18 | 1.4 | – | – | – |
| **TNMG 160408E-NMR** | **T6310** | 0.8 | ■ 140 | 0.30 | 1.7 | ■ 100 | 0.27 | 1.7 | – | – | – | – | – | – | ■ 40 | 0.24 | 1.4 | – | – | – |
| | **T7325** | 0.8 | ◪ 155 | 0.30 | 1.7 | ■ 120 | 0.27 | 1.7 | – | – | – | – | – | – | ■ 50 | 0.24 | 1.4 | – | – | – |
| | **T7335** | 0.8 | ◪ 145 | 0.30 | 1.7 | ■ 110 | 0.27 | 1.7 | – | – | – | – | – | – | ■ 45 | 0.24 | 1.4 | – | – | – |
| | **T8330** | 0.8 | ■ 140 | 0.30 | 1.7 | ■ 80 | 0.27 | 1.7 | – | – | – | – | – | – | ◪ 35 | 0.24 | 1.4 | – | – | – |
| | **T8430** | 0.8 | ■ 150 | 0.30 | 1.7 | ■ 80 | 0.27 | 1.7 | – | – | – | – | – | – | ◪ 30 | 0.24 | 1.4 | – | – | – |
| | **T9315** | 0.8 | ■ 205 | 0.30 | 1.7 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | ■ 185 | 0.30 | 1.7 | ■ 110 | 0.27 | 1.7 | – | – | – | – | – | – | ◪ 40 | 0.24 | 1.4 | – | – | – |

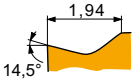
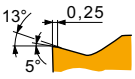
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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-geometri med positivt design til medium til grov bearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **TNMG 160412E-NMR** | **T7325** | 1.2 | 165 | 0.30 | 1.7 | 125 | 0.27 | 1.7 | – | – | – | – | – | – | 50 | 0.24 | 1.4 | – | – | – |
| | **T9315** | 1.2 | 215 | 0.30 | 1.7 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | 195 | 0.30 | 1.7 | 115 | 0.27 | 1.7 | – | – | – | – | – | – | 40 | 0.24 | 1.4 | – | – | – |
| **TNMG 220408E-NMR** | **T6310** | 0.8 | 135 | 0.30 | 2.1 | 95 | 0.27 | 2.1 | – | – | – | – | – | – | 40 | 0.24 | 1.7 | – | – | – |
| | **T7325** | 0.8 | 150 | 0.30 | 2.1 | 115 | 0.27 | 2.1 | – | – | – | – | – | – | 45 | 0.24 | 1.7 | – | – | – |
| | **T7335** | 0.8 | 145 | 0.30 | 2.1 | 110 | 0.27 | 2.1 | – | – | – | – | – | – | 45 | 0.24 | 1.7 | – | – | – |
| | **T8330** | 0.8 | 135 | 0.30 | 2.1 | 80 | 0.27 | 2.1 | – | – | – | – | – | – | 30 | 0.24 | 1.7 | – | – | – |
| | **T8430** | 0.8 | 145 | 0.30 | 2.1 | 80 | 0.27 | 2.1 | – | – | – | – | – | – | 30 | 0.24 | 1.7 | – | – | – |
| | **T9315** | 0.8 | 200 | 0.30 | 2.1 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **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 | – | – | – |
| | **T7325** | 1.2 | 160 | 0.30 | 2.1 | 120 | 0.27 | 2.1 | – | – | – | – | – | – | 50 | 0.24 | 1.7 | – | – | – |
| | **T9315** | 1.2 | 210 | 0.30 | 2.1 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | 190 | 0.30 | 2.1 | 110 | 0.27 | 2.1 | – | – | – | – | – | – | 40 | 0.24 | 1.7 | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| R-geometri til semi-grov til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **TNMG 160408E-R** | **T5305** | 0.8 | 210 | 0.40 | 3.0 | – | – | – | 195 | 0.40 | 3.0 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| | **T5315** | 0.8 | 185 | 0.40 | 3.0 | – | – | – | 175 | 0.40 | 3.0 | – | – | – | – | – | – | 35 | 0.15 | 1.0 |
| | **T9310** | 0.8 | 185 | 0.40 | 3.0 | – | – | – | 175 | 0.40 | 3.0 | – | – | – | – | – | – | 35 | 0.15 | 1.0 |
| | **T9315** | 0.8 | 165 | 0.40 | 3.0 | – | – | – | 155 | 0.40 | 3.0 | – | – | – | – | – | – | 30 | 0.15 | 1.0 |
| | **T9325** | 0.8 | 150 | 0.40 | 3.0 | – | – | – | 140 | 0.40 | 3.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.8 | 130 | 0.40 | 3.0 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **TNMG 160412E-R** | **T5315** | 1.2 | 195 | 0.40 | 3.0 | – | – | – | 185 | 0.40 | 3.0 | – | – | – | – | – | – | 35 | 0.15 | 1.0 |
| | **T9310** | 1.2 | 195 | 0.40 | 3.0 | – | – | – | 185 | 0.40 | 3.0 | – | – | – | – | – | – | 35 | 0.15 | 1.0 |
| | **T9325** | 1.2 | 160 | 0.40 | 3.0 | – | – | – | 150 | 0.40 | 3.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.2 | 140 | 0.40 | 3.0 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **TNMG 220408E-R** | **T9315** | 0.8 | 165 | 0.40 | 4.0 | – | – | – | 155 | 0.40 | 4.0 | – | – | – | – | – | – | 30 | 0.15 | 1.0 |
| | **T9325** | 0.8 | 145 | 0.40 | 4.0 | – | – | – | 135 | 0.40 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.8 | 125 | 0.40 | 4.0 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **TNMG 220412E-R** | **T9310** | 1.2 | 185 | 0.40 | 4.0 | – | – | – | 175 | 0.40 | 4.0 | – | – | – | – | – | – | 35 | 0.15 | 1.0 |
| | **T9315** | 1.2 | 170 | 0.40 | 4.0 | – | – | – | 160 | 0.40 | 4.0 | – | – | – | – | – | – | 30 | 0.15 | 1.0 |
| | **T9325** | 1.2 | 155 | 0.40 | 4.0 | – | – | – | 145 | 0.40 | 4.0 | – | – | – | – | – | – | – | – | – |
| **TNMG 220416E-R** | **T9315** | 1.6 | 180 | 0.40 | 4.0 | – | – | – | 170 | 0.40 | 4.0 | – | – | – | – | – | – | 35 | 0.15 | 1.0 |
| | **T9325** | 1.6 | 165 | 0.40 | 4.0 | – | – | – | 155 | 0.40 | 4.0 | – | – | – | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| RM-geometri til semi-grov til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **TNMG 160408E-RM** | **T5305** | 0.8 | 245 | 0.40 | 3.0 | – | – | – | 230 | 0.40 | 3.0 | – | – | – | – | – | – | – | – | – |
| | **T5315** | 0.8 | 215 | 0.40 | 3.0 | – | – | – | 200 | 0.40 | 3.0 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 0.8 | 155 | 0.40 | 3.0 | 120 | 0.36 | 3.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 0.8 | 145 | 0.40 | 3.0 | 110 | 0.36 | 3.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9310** | 0.8 | 210 | 0.40 | 3.0 | – | – | – | 195 | 0.40 | 3.0 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.8 | 195 | 0.40 | 3.0 | – | – | – | 185 | 0.40 | 3.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 175 | 0.40 | 3.0 | 105 | 0.36 | 3.0 | 165 | 0.40 | 3.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.8 | 150 | 0.40 | 3.0 | 90 | 0.36 | 3.0 | – | – | – | – | – | – | – | – | – | – | – | – |

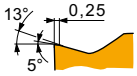
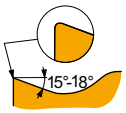
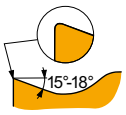
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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-geometri til semi-grov til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **TNMG 160412E-RM** | **T5305** | 1.2 | 255 | 0.40 | 3.0 | – | – | – | 240 | 0.40 | 3.0 | – | – | – | – | – | – | – | – | – |
| | **T5315** | 1.2 | 225 | 0.40 | 3.0 | – | – | – | 210 | 0.40 | 3.0 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 1.2 | 165 | 0.40 | 3.0 | 125 | 0.36 | 3.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 1.2 | 155 | 0.40 | 3.0 | 120 | 0.36 | 3.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 1.2 | 145 | 0.40 | 3.0 | 85 | 0.36 | 3.0 | 135 | 0.40 | 3.0 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 1.2 | 150 | 0.40 | 3.0 | 80 | 0.36 | 3.0 | 125 | 0.40 | 3.0 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 1.2 | 205 | 0.40 | 3.0 | – | – | – | 190 | 0.40 | 3.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | 185 | 0.40 | 3.0 | 110 | 0.36 | 3.0 | 175 | 0.40 | 3.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.2 | 160 | 0.40 | 3.0 | 95 | 0.36 | 3.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| **TNMG 220408E-RM** | **T5305** | 0.8 | 235 | 0.40 | 4.0 | – | – | – | 220 | 0.40 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T5315** | 0.8 | 210 | 0.40 | 4.0 | – | – | – | 195 | 0.40 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 0.8 | 150 | 0.40 | 4.0 | 115 | 0.36 | 4.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 0.8 | 140 | 0.40 | 4.0 | 105 | 0.36 | 4.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9310** | 0.8 | 200 | 0.40 | 4.0 | – | – | – | 190 | 0.40 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.8 | 190 | 0.40 | 4.0 | – | – | – | 180 | 0.40 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 170 | 0.40 | 4.0 | 100 | 0.36 | 4.0 | 160 | 0.40 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.8 | 145 | 0.40 | 4.0 | 85 | 0.36 | 4.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| **TNMG 220412E-RM** | **T5305** | 1.2 | 245 | 0.40 | 4.0 | – | – | – | 230 | 0.40 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T5315** | 1.2 | 220 | 0.40 | 4.0 | – | – | – | 205 | 0.40 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 1.2 | 160 | 0.40 | 4.0 | 120 | 0.36 | 4.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 1.2 | 150 | 0.40 | 4.0 | 115 | 0.36 | 4.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9315** | 1.2 | 200 | 0.40 | 4.0 | – | – | – | 190 | 0.40 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | 180 | 0.40 | 4.0 | 105 | 0.36 | 4.0 | 170 | 0.40 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.2 | 155 | 0.40 | 4.0 | 90 | 0.36 | 4.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| **TNMG 220416E-RM** | **T7325** | 1.6 | 165 | 0.40 | 4.0 | 125 | 0.36 | 4.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9315** | 1.6 | 210 | 0.40 | 4.0 | – | – | – | 195 | 0.40 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.6 | 185 | 0.40 | 4.0 | 110 | 0.36 | 4.0 | 175 | 0.40 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.6 | 160 | 0.40 | 4.0 | 95 | 0.36 | 4.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| **TNMG 270612E-RM** | **T7325** | 1.2 | 110 | 0.40 | 6.0 | 85 | 0.36 | 6.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | 120 | 0.40 | 6.0 | 70 | 0.36 | 6.0 | 110 | 0.40 | 6.0 | – | – | – | – | – | – | – | – | – |
| **TNMG 270616E-RM** | **T7325** | 1.6 | 115 | 0.40 | 6.0 | 85 | 0.36 | 6.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9226** | 1.6 | 115 | 0.40 | 6.0 | 65 | 0.36 | 6.0 | 105 | 0.40 | 6.0 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 1.6 | 135 | 0.40 | 6.0 | – | – | – | 125 | 0.40 | 6.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.6 | 125 | 0.40 | 6.0 | 75 | 0.36 | 6.0 | 115 | 0.40 | 6.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.6 | 100 | 0.40 | 6.0 | 60 | 0.36 | 6.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| **TNMG 270624E-RM** | **T7325** | 2.4 | 115 | 0.50 | 6.0 | 85 | 0.45 | 6.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9325** | 2.4 | 120 | 0.50 | 6.0 | 70 | 0.45 | 6.0 | 110 | 0.50 | 6.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 2.4 | 95 | 0.50 | 6.0 | 55 | 0.45 | 6.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| **TNMG 270632E-RM** | **T9335** | 3.2 | 90 | 0.60 | 6.0 | 50 | 0.54 | 6.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| **TNMG 330924E-RM** | **T9226** | 2.4 | 100 | 0.50 | 10.0 | 60 | 0.45 | 10.0 | 95 | 0.50 | 10.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 2.4 | 90 | 0.50 | 10.0 | 50 | 0.45 | 10.0 | – | – | – | – | – | – | – | – | – | – | – | – |
|  |  | |  SF-geometri med positivt design til finbearbejdning af tynde vægge og kontinuerlige snit. | | | | | | | | | | | | | | | | | |
| **TNMG 160404E-SF** | **H07** | 0.4 | – | – | – | 75 | 0.14 | 1.3 | 120 | 0.15 | 1.3 | 390 | 0.18 | 1.3 | 35 | 0.12 | 1.0 | – | – | – |
| | **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 | 0.15 | 1.0 |
| | **T7325** | 0.4 | 170 | 0.17 | 1.3 | 130 | 0.15 | 1.3 | – | – | – | – | – | – | 55 | 0.15 | 1.0 | – | – | – |
| | **T7335** | 0.4 | 165 | 0.17 | 1.3 | 125 | 0.15 | 1.3 | – | – | – | – | – | – | 50 | 0.15 | 1.0 | – | – | – |
| | **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 | 0.15 | 1.0 |
| | **T8330** | 0.4 | 150 | 0.15 | 1.3 | 90 | 0.14 | 1.3 | 140 | 0.15 | 1.3 | 450 | 0.18 | 1.3 | 35 | 0.12 | 1.0 | 30 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| | **T9315** | 0.4 | 245 | 0.15 | 1.3 | – | – | – | 230 | 0.15 | 1.3 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |
| | **T9325** | 0.4 | 210 | 0.17 | 1.3 | 125 | 0.15 | 1.3 | 195 | 0.17 | 1.3 | – | – | – | 45 | 0.15 | 1.0 | – | – | – |

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |   | | | | | | | | | | | | | | | | | | | |
| SF-geometri med positivt design til finbearbejdning af tynde vægge og kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **TNMG 160408E-SF** | **H07** | 0.8 | – | – | – | 85 | 0.15 | 1.3 | 140 | 0.17 | 1.3 | 445 | 0.20 | 1.3 | 45 | 0.14 | 1.0 | – | – | – |
| | **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 | 0.15 | 1.0 |
| | **T7325** | 0.8 | 200 | 0.17 | 1.3 | 155 | 0.15 | 1.3 | – | – | – | – | – | – | 65 | 0.15 | 1.0 | – | – | – |
| | **T7335** | 0.8 | 195 | 0.17 | 1.3 | 150 | 0.15 | 1.3 | – | – | – | – | – | – | 60 | 0.15 | 1.0 | – | – | – |
| | **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 | 0.15 | 1.0 |
| | **T8330** | 0.8 | 175 | 0.17 | 1.3 | 105 | 0.15 | 1.3 | 165 | 0.17 | 1.3 | 525 | 0.20 | 1.3 | 40 | 0.14 | 1.0 | 35 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| | **T9315** | 0.8 | 275 | 0.17 | 1.3 | – | – | – | 260 | 0.17 | 1.3 | – | – | – | – | – | – | 55 | 0.15 | 1.0 |
| | **T9325** | 0.8 | 250 | 0.17 | 1.3 | 150 | 0.15 | 1.3 | 235 | 0.17 | 1.3 | – | – | – | 55 | 0.15 | 1.0 | – | – | – |
| **TNMG 160412E-SF** | **T6310** | 1.2 | 160 | 0.30 | 1.3 | 115 | 0.27 | 1.3 | 125 | 0.30 | 1.3 | 480 | 0.36 | 1.3 | 45 | 0.21 | 1.0 | 30 | 0.15 | 1.0 |
| | **T7325** | 1.2 | 175 | 0.30 | 1.3 | 135 | 0.27 | 1.3 | – | – | – | – | – | – | 55 | 0.21 | 1.0 | – | – | – |
| | **T9325** | 1.2 | 205 | 0.30 | 1.3 | 120 | 0.27 | 1.3 | 190 | 0.30 | 1.3 | – | – | – | 45 | 0.21 | 1.0 | – | – | – |
| **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 | 0.15 | 1.0 |
| | **T7325** | 0.4 | 160 | 0.17 | 1.7 | 120 | 0.15 | 1.7 | – | – | – | – | – | – | 50 | 0.15 | 1.4 | – | – | – |
| | **T9325** | 0.4 | 205 | 0.17 | 1.7 | 120 | 0.15 | 1.7 | 190 | 0.17 | 1.7 | – | – | – | 45 | 0.15 | 1.4 | – | – | – |
| **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 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| **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 | 1.0 |
| | **T7325** | 1.2 | 170 | 0.30 | 1.7 | 130 | 0.27 | 1.7 | – | – | – | – | – | – | 55 | 0.21 | 1.4 | – | – | – |
| | **T9325** | 1.2 | 205 | 0.30 | 1.7 | 120 | 0.27 | 1.7 | 190 | 0.30 | 1.7 | – | – | – | 45 | 0.21 | 1.4 | – | – | – |
|  |   | | | | | | | | | | | | | | | | | | | |
| SM-geometri med positivt design til medium bearbejdning og kontinuerlige til afbrudte snit. | | | | | | | | | | | | | | | | | | | | |
| **TNMG 160404E-SM** | **T6310** | 0.4 | 135 | 0.22 | 1.7 | 95 | 0.20 | 1.7 | 105 | 0.22 | 1.7 | 405 | 0.26 | 1.7 | 40 | 0.20 | 1.4 | 25 | 0.15 | 1.0 |
| | **T7325** | 0.4 | 150 | 0.22 | 1.7 | 115 | 0.20 | 1.7 | – | – | – | – | – | – | 45 | 0.20 | 1.4 | – | – | – |
| | **T7335** | 0.4 | 145 | 0.22 | 1.7 | 110 | 0.20 | 1.7 | – | – | – | – | – | – | 45 | 0.20 | 1.4 | – | – | – |
| | **T8330** | 0.4 | 135 | 0.22 | 1.7 | 80 | 0.20 | 1.7 | 125 | 0.22 | 1.7 | 405 | 0.26 | 1.7 | 30 | 0.20 | 1.4 | 25 | 0.15 | 1.0 |
| | **T8430** | 0.4 | 145 | 0.22 | 1.7 | 80 | 0.20 | 1.7 | 120 | 0.22 | 1.7 | 405 | 0.26 | 1.7 | 30 | 0.20 | 1.4 | 25 | 0.15 | 1.0 |
| | **T9315** | 0.4 | 210 | 0.20 | 1.7 | – | – | – | 195 | 0.20 | 1.7 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| | **T9325** | 0.4 | 185 | 0.22 | 1.7 | 110 | 0.20 | 1.7 | 175 | 0.22 | 1.7 | – | – | – | 40 | 0.20 | 1.4 | – | – | – |
| **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 | 0.15 | 1.0 |
| | **T7325** | 0.8 | 170 | 0.25 | 1.7 | 130 | 0.23 | 1.7 | – | – | – | – | – | – | 55 | 0.20 | 1.4 | – | – | – |
| | **T7335** | 0.8 | 165 | 0.25 | 1.7 | 125 | 0.23 | 1.7 | – | – | – | – | – | – | 50 | 0.20 | 1.4 | – | – | – |
| | **T8330** | 0.8 | 150 | 0.25 | 1.7 | 90 | 0.23 | 1.7 | 140 | 0.25 | 1.7 | 450 | 0.30 | 1.7 | 35 | 0.20 | 1.4 | 30 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| | **T9315** | 0.8 | 230 | 0.25 | 1.7 | – | – | – | 215 | 0.25 | 1.7 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |
| | **T9325** | 0.8 | 205 | 0.25 | 1.7 | 120 | 0.23 | 1.7 | 190 | 0.25 | 1.7 | – | – | – | 45 | 0.20 | 1.4 | – | – | – |
| **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 | 1.0 |
| | **T7325** | 1.2 | 170 | 0.30 | 1.7 | 130 | 0.27 | 1.7 | – | – | – | – | – | – | 55 | 0.24 | 1.4 | – | – | – |
| | **T7335** | 1.2 | 165 | 0.30 | 1.7 | 125 | 0.27 | 1.7 | – | – | – | – | – | – | 50 | 0.24 | 1.4 | – | – | – |
| | **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 | 130 | 0.24 | 1.7 | 90 | 0.22 | 1.7 | 100 | 0.24 | 1.7 | 390 | 0.29 | 1.7 | 35 | 0.22 | 1.4 | 25 | 0.15 | 1.0 |
| | **T7325** | 0.4 | 145 | 0.24 | 1.7 | 110 | 0.22 | 1.7 | – | – | – | – | – | – | 45 | 0.22 | 1.4 | – | – | – |
| | **T8330** | 0.4 | 130 | 0.24 | 1.7 | 75 | 0.22 | 1.7 | 120 | 0.24 | 1.7 | 390 | 0.29 | 1.7 | 30 | 0.22 | 1.4 | 25 | 0.15 | 1.0 |
| | **T8430** | 0.4 | 145 | 0.24 | 1.7 | 80 | 0.22 | 1.7 | 120 | 0.24 | 1.7 | 405 | 0.29 | 1.7 | 30 | 0.22 | 1.4 | 25 | 0.15 | 1.0 |
| | **T9325** | 0.4 | 175 | 0.24 | 1.7 | 105 | 0.22 | 1.7 | 165 | 0.24 | 1.7 | – | – | – | 35 | 0.22 | 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 | 0.15 | 1.0 |
| | **T7325** | 0.8 | 170 | 0.25 | 1.7 | 130 | 0.23 | 1.7 | – | – | – | – | – | – | 55 | 0.20 | 1.4 | – | – | – |
| | **T7335** | 0.8 | 165 | 0.25 | 1.7 | 125 | 0.23 | 1.7 | – | – | – | – | – | – | 50 | 0.20 | 1.4 | – | – | – |
| | **T8330** | 0.8 | 150 | 0.25 | 1.7 | 90 | 0.23 | 1.7 | 140 | 0.25 | 1.7 | 450 | 0.30 | 1.7 | 35 | 0.20 | 1.4 | 30 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| | **T9315** | 0.8 | 230 | 0.25 | 1.7 | – | – | – | 215 | 0.25 | 1.7 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |
| | **T9325** | 0.8 | 205 | 0.25 | 1.7 | 120 | 0.23 | 1.7 | 190 | 0.25 | 1.7 | – | – | – | 45 | 0.20 | 1.4 | – | – | – |

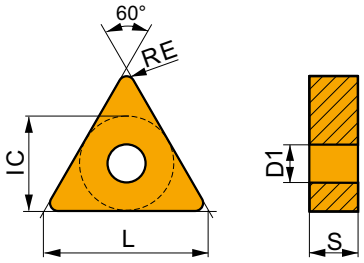
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | S | | | | | | | | | | | | | | | | | |
| SM-geometri med positivt design til medium bearbejdning og kontinuerlige til afbrudte snit. | | | | | | | | | | | | | | | | | | | | |
| **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 | 1.0 |
| | **T7325** | 1.2 | ◪ 170 | 0.30 | 1.7 | ■ 130 | 0.27 | 1.7 | – | – | – | – | – | – | ■ 55 | 0.24 | 1.4 | – | – | – |
| | **T7335** | 1.2 | ◪ 165 | 0.30 | 1.7 | ■ 125 | 0.27 | 1.7 | – | – | – | – | – | – | ■ 50 | 0.24 | 1.4 | – | – | – |
| | **T9315** | 1.2 | ■ 225 | 0.30 | 1.7 | – | – | – | ◪ 210 | 0.30 | 1.7 | – | – | – | – | – | – | ◪ 45 | 0.15 | 1.0 |
| | **T9325** | 1.2 | ■ 205 | 0.30 | 1.7 | ■ 120 | 0.27 | 1.7 | ◪ 190 | 0.30 | 1.7 | – | – | – | ◪ 45 | 0.24 | 1.4 | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | E | | | | | | | | | | | | | | | | | |
| ER-SI geometri med positivt venstrehåndet design til finbearbejdning til halv grov bearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **TNMG 160404ER-SI** | **T7325** | 0.4 | ◪ 190 | 0.20 | 1.5 | ■ 145 | 0.18 | 1.5 | – | – | – | – | – | – | ◪ 60 | 0.18 | 1.2 | – | – | – |
| | **T7335** | 0.4 | ◪ 180 | 0.20 | 1.5 | ■ 140 | 0.18 | 1.5 | – | – | – | – | – | – | ◪ 55 | 0.18 | 1.2 | – | – | – |
| | **T8315** | 0.4 | ◪ 175 | 0.20 | 1.5 | ■ 105 | 0.18 | 1.5 | – | – | – | ◪ 525 | 0.24 | 1.5 | ◪ 40 | 0.18 | 1.2 | – | – | – |
| | **T8330** | 0.4 | ■ 165 | 0.20 | 1.5 | ■ 95 | 0.18 | 1.5 | – | – | – | ◪ 495 | 0.24 | 1.5 | ◪ 40 | 0.18 | 1.2 | – | – | – |
| | **T8430** | 0.4 | ■ 185 | 0.20 | 1.5 | ■ 100 | 0.18 | 1.5 | – | – | – | ◪ 510 | 0.24 | 1.5 | ◪ 40 | 0.18 | 1.2 | – | – | – |
| | **T9325** | 0.4 | ■ 230 | 0.20 | 1.5 | ■ 135 | 0.18 | 1.5 | – | – | – | – | – | – | ◪ 50 | 0.18 | 1.2 | – | – | – |
| | **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 | – | – | – |
| | **T7335** | 0.8 | ◪ 180 | 0.35 | 1.5 | ■ 140 | 0.32 | 1.5 | – | – | – | – | – | – | ◪ 55 | 0.25 | 1.2 | – | – | – |
| | **T8315** | 0.8 | ◪ 175 | 0.35 | 1.5 | ■ 105 | 0.32 | 1.5 | – | – | – | ◪ 525 | 0.42 | 1.5 | ◪ 40 | 0.25 | 1.2 | – | – | – |
| | **T8330** | 0.8 | ■ 170 | 0.35 | 1.5 | ■ 100 | 0.32 | 1.5 | – | – | – | ◪ 510 | 0.42 | 1.5 | ◪ 40 | 0.25 | 1.2 | – | – | – |
| | **T8430** | 0.8 | ■ 180 | 0.35 | 1.5 | ■ 95 | 0.32 | 1.5 | – | – | – | ◪ 495 | 0.42 | 1.5 | ◪ 35 | 0.25 | 1.2 | – | – | – |
| | **T9325** | 0.8 | ■ 215 | 0.35 | 1.5 | ■ 125 | 0.32 | 1.5 | – | – | – | – | – | – | ◪ 45 | 0.25 | 1.2 | – | – | – |
| | **T9335** | 0.8 | ■ 190 | 0.35 | 1.5 | ■ 110 | 0.32 | 1.5 | – | – | – | – | – | – | ◪ 40 | 0.25 | 1.2 | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | E | | | | | | | | | | | | | | | | | |
| EL-SI geometri med positivt venstrehåndet design til finbearbejdning til halv grov bearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **TNMG 160404EL-SI** | **T7325** | 0.4 | ◪ 190 | 0.20 | 1.5 | ■ 145 | 0.18 | 1.5 | – | – | – | – | – | – | ◪ 60 | 0.18 | 1.2 | – | – | – |
| | **T7335** | 0.4 | ◪ 180 | 0.20 | 1.5 | ■ 140 | 0.18 | 1.5 | – | – | – | – | – | – | ◪ 55 | 0.18 | 1.2 | – | – | – |
| | **T8315** | 0.4 | ◪ 175 | 0.20 | 1.5 | ■ 105 | 0.18 | 1.5 | – | – | – | ◪ 525 | 0.24 | 1.5 | ◪ 40 | 0.18 | 1.2 | – | – | – |
| | **T8330** | 0.4 | ■ 165 | 0.20 | 1.5 | ■ 95 | 0.18 | 1.5 | – | – | – | ◪ 495 | 0.24 | 1.5 | ◪ 40 | 0.18 | 1.2 | – | – | – |
| | **T8430** | 0.4 | ■ 185 | 0.20 | 1.5 | ■ 100 | 0.18 | 1.5 | – | – | – | ◪ 510 | 0.24 | 1.5 | ◪ 40 | 0.18 | 1.2 | – | – | – |
| | **T9325** | 0.4 | ■ 230 | 0.20 | 1.5 | ■ 135 | 0.18 | 1.5 | – | – | – | – | – | – | ◪ 50 | 0.18 | 1.2 | – | – | – |
| | **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 | – | – | – |
| | **T7335** | 0.8 | ◪ 180 | 0.35 | 1.5 | ■ 140 | 0.32 | 1.5 | – | – | – | – | – | – | ◪ 55 | 0.25 | 1.2 | – | – | – |
| | **T8315** | 0.8 | ◪ 175 | 0.35 | 1.5 | ■ 105 | 0.32 | 1.5 | – | – | – | ◪ 525 | 0.42 | 1.5 | ◪ 40 | 0.25 | 1.2 | – | – | – |
| | **T8330** | 0.8 | ■ 170 | 0.35 | 1.5 | ■ 100 | 0.32 | 1.5 | – | – | – | ◪ 510 | 0.42 | 1.5 | ◪ 40 | 0.25 | 1.2 | – | – | – |
| | **T8430** | 0.8 | ■ 180 | 0.35 | 1.5 | ■ 95 | 0.32 | 1.5 | – | – | – | ◪ 495 | 0.42 | 1.5 | ◪ 35 | 0.25 | 1.2 | – | – | – |
| | **T9325** | 0.8 | ■ 215 | 0.35 | 1.5 | ■ 125 | 0.32 | 1.5 | – | – | – | – | – | – | ◪ 45 | 0.25 | 1.2 | – | – | – |
| | **T9335** | 0.8 | ■ 190 | 0.35 | 1.5 | ■ 110 | 0.32 | 1.5 | – | – | – | – | – | – | ◪ 40 | 0.25 | 1.2 | – | – | – |

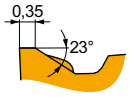
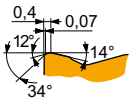
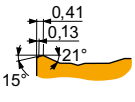
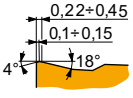
# TNMM

PRAMET

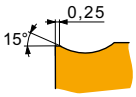
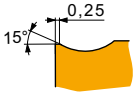
| | IC (mm) | D1 (mm) | L (mm) | S (mm) |
|---|---|---|---|---|
| 1604 | 9.525 | 3.81 | 16.50 | 4.76 |
| 2204 | 12.700 | 5.16 | 22.00 | 4.76 |
| 2706 | 15.875 | 6.35 | 27.50 | 6.35 |




Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |   | | | | | | | | | | | | | | | | | | | |
| DR-geometri til hård til ekstra hård bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **TNMM 160408E-DR** | **T9325** | 0.8 | 175 | 0.40 | 4.0 | 105 | 0.36 | 4.0 | 165 | 0.40 | 4.0 | – | – | – | – | – | – | – | – | – |
| **TNMM 220408E-DR** | **T9325** | 0.8 | 175 | 0.40 | 4.0 | 105 | 0.36 | 4.0 | 165 | 0.40 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.8 | 155 | 0.40 | 4.0 | 90 | 0.36 | 4.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| **TNMM 220412E-DR** | **T9315** | 1.2 | 205 | 0.40 | 4.0 | – | – | – | 190 | 0.40 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | 185 | 0.40 | 4.0 | 110 | 0.36 | 4.0 | 175 | 0.40 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.2 | 160 | 0.40 | 4.0 | 95 | 0.36 | 4.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| **TNMM 220416E-DR** | **T9325** | 1.6 | 195 | 0.40 | 4.0 | 115 | 0.36 | 4.0 | 185 | 0.40 | 4.0 | – | – | – | – | – | – | – | – | – |
| **TNMM 270616E-DR** | **T9325** | 1.6 | 135 | 0.40 | 4.0 | 80 | 0.36 | 4.0 | 125 | 0.40 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.6 | 110 | 0.40 | 4.0 | 65 | 0.36 | 4.0 | – | – | – | – | – | – | – | – | – | – | – | – |
|  |   | | | | | | | | | | | | | | | | | | | |
| HR-geometri til hård til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **TNMM 270616E-HR** | **T9325** | 1.6 | 90 | 0.60 | 7.0 | 50 | 0.54 | 7.0 | 85 | 0.60 | 7.0 | – | – | – | – | – | – | – | – | – |
| | **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 | – | – | – | – | – | – | – | – | – |
|  |   | | | | | | | | | | | | | | | | | | | |
| NR2-geometri til semi-ru til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **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** | **T7325** | 0.8 | 145 | 0.40 | 4.0 | 110 | 0.36 | 4.0 | – | – | – | – | – | – | 45 | 0.28 | 3.2 | – | – | – |
| | **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** | **T7325** | 1.2 | 150 | 0.40 | 4.0 | 115 | 0.36 | 4.0 | – | – | – | – | – | – | 45 | 0.32 | 3.2 | – | – | – |
| | **T8330** | 1.2 | 135 | 0.40 | 4.0 | 80 | 0.36 | 4.0 | 125 | 0.40 | 4.0 | – | – | – | 30 | 0.32 | 3.2 | – | – | – |
| | **T8430** | 1.2 | 140 | 0.40 | 4.0 | 75 | 0.36 | 4.0 | 115 | 0.40 | 4.0 | – | – | – | 30 | 0.32 | 3.2 | – | – | – |
| | **T9325** | 1.2 | 170 | 0.40 | 4.0 | 100 | 0.36 | 4.0 | 160 | 0.40 | 4.0 | – | – | – | 35 | 0.32 | 3.2 | – | – | – |
|  |   | | | | | | | | | | | | | | | | | | | |
| OR geometri til semi-grov til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **TNMM 160408E-OR** | **T9315** | 0.8 | 185 | 0.40 | 3.0 | – | – | – | 175 | 0.40 | 3.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 165 | 0.40 | 3.0 | 95 | 0.36 | 3.0 | 155 | 0.40 | 3.0 | – | – | – | 35 | 0.28 | 2.4 | – | – | – |
| **TNMM 160412E-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 220408E-OR** | **T9315** | 0.8 | 180 | 0.40 | 4.0 | – | – | – | 170 | 0.40 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 160 | 0.40 | 4.0 | 95 | 0.36 | 4.0 | 150 | 0.40 | 4.0 | – | – | – | 35 | 0.32 | 3.2 | – | – | – |
| | **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 | – | – | – |
| | **T9335** | 1.2 | 150 | 0.40 | 3.0 | 90 | 0.36 | 3.0 | – | – | – | – | – | – | 30 | 0.32 | 2.4 | – | – | – |

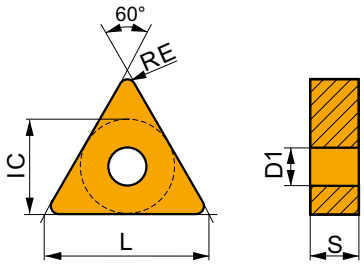
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | |  | | | | | | | | | | | | | | | | | |
| | | | ER-geometri med højrehåndet design til medium til halvhårdbearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | |
| **TNMM 220412ER** | **T9335** | 1.2 | ■ 190 | 0.35 | 2.1 | ■ 110 | 0.32 | 2.1 | – | – | – | – | – | – | ◪ 40 | 0.25 | 1.7 | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | |  | | | | | | | | | | | | | | | | | |
| | | | EL-geometri med venstrehåndet design til mellemhård til hård bearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | |
| **TNMM 220412EL** | **T9335** | 1.2 | ■ 190 | 0.35 | 2.1 | ■ 110 | 0.32 | 2.1 | – | – | – | – | – | – | ◪ 40 | 0.25 | 1.7 | – | – | – |

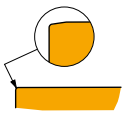
## TNGA CER

PRAMET

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



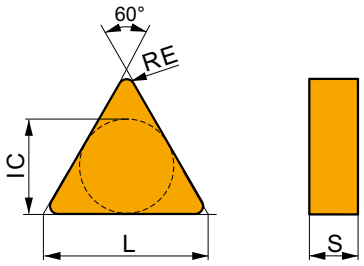

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | |  | | | | | | | | | | | | | | | | | |
| | | | Til bearbejdning med høje hastigheder og kontinuerlige snit. | | | | | | | | | | | | | | | | | |
| **TNGA 160408 T01020** | **TC100** | 0.8 | – | – | – | – | – | – | ◪ 475 | 0.20 | 1.5 | – | – | – | – | – | – | – | – | – |
| **TNGA 160412 T01020** | **TC100** | 1.2 | – | – | – | – | – | – | ◪ 500 | 0.20 | 1.5 | – | – | – | – | – | – | – | – | – |

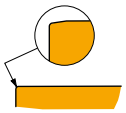
# TNGN CER

PRAMET

| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 1604 | 9.525 | 16.50 | 4.76 |
| 1607 | 9.525 | 16.50 | 7.94 |



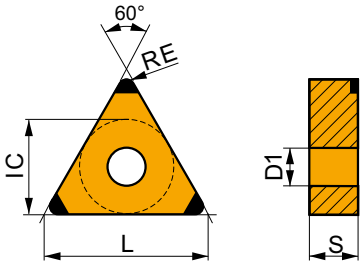

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|   HSC T Til bearbejdning med høje hastigheder og kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **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 | – | – | – | – | – | – | – | – | – |

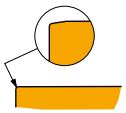
# TNGA CBN

PRAMET

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




Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|   HSC S Til færdigbearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **TNGA 160408S01020C** | **TB310** | 0.8 | – | – | – | – | – | – | 450 | 0.15 | 0.6 | – | – | – | 115 | 0.11 | 0.5 | 95 | 0.15 | 1.0 |

# DTFN(RL) EXT

P M K N S H

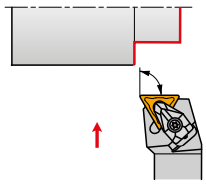
PRAMET

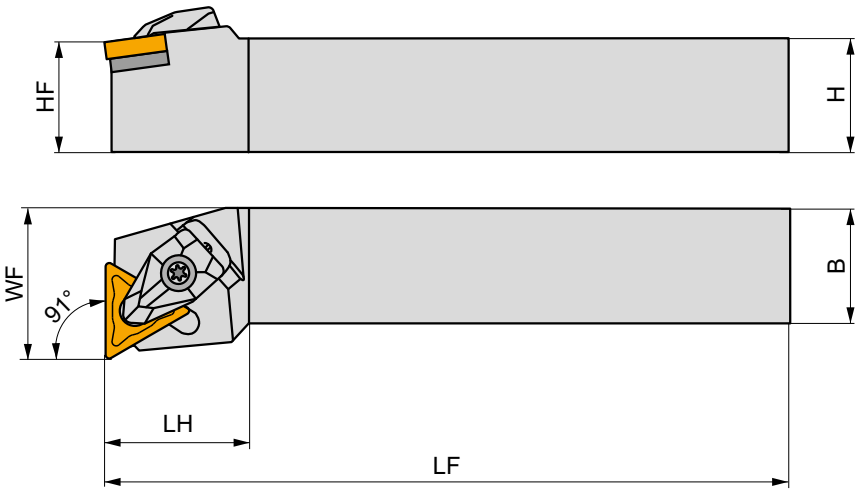
D

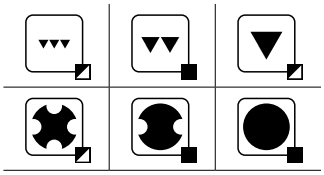


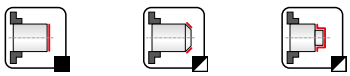
## Ekstern dobbeltklemmeholder med 91 ° skærevinkel til TN .. Skær

Ekstern højre / venstre værktøjsholder med dobbelt klemme med skærevinkel på 91 °. Velegnet til endedrejning med skulder og affasning med negativ TN .. 16 eller 22 størrelse skær. Fås i 20x20 og 25x25 mm skaft. Krop behandlet for længere levetid







| | Product | H (mm) | B (mm) | HF (mm) | WF (mm) | LF (mm) | LH (mm) | LAMS (°) | GAMO (°) | kg | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 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 |
| | **DTFNL 2525 M 22** | 25 | 25 | 25 | 32 | 150 | 30.5 | -6 | -6 | 0.79 | 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 |

# DTGN(RL) EXT

P M K N S H

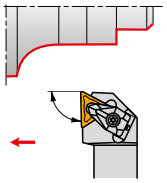
PRAMET

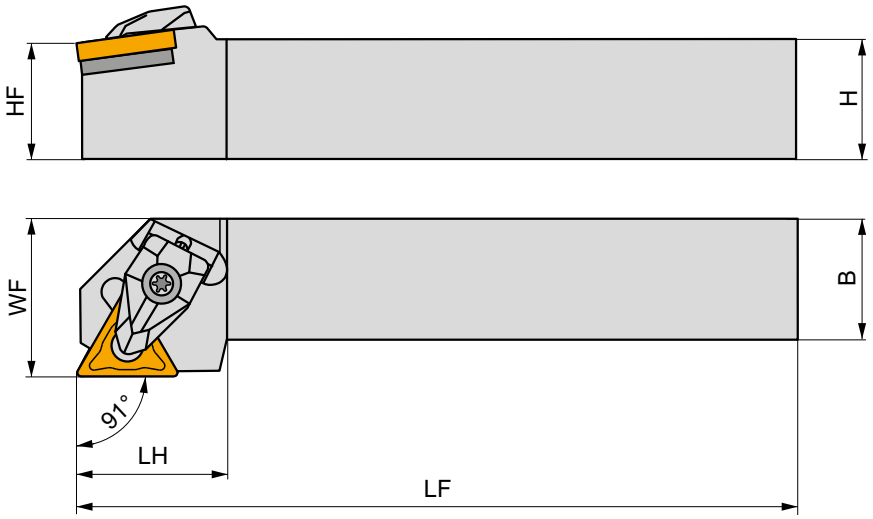
D

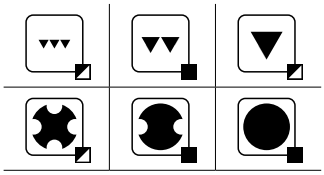


## Ekstern dobbeltholder med 91 ° skærevinkel til TN .. Skær

Ekstern højre / venstre værktøjsholder med dobbelt klemme med skærevinkel på 91 °. Velegnet til langsgående drejning med skulder, konisk drejning og affasning med negative TN .. 16 eller 22 størrelse skær. Fås i 20x20 op til 32x32 mm skaft. Krop behandlet for længere levetid







| | Product | H (mm) | B (mm) | HF (mm) | WF (mm) | LF (mm) | LH (mm) | LAMS (°) | GAMO (°) | kg | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| R | **DTGNR 2020 K 16** | 20 | 20 | 20 | 25 | 125 | 25.4 | -6 | -6 | 0.43 | 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 | 0.83 | GI025 | DT22 |
| | **DTGNR 3232 P 22** | 32 | 32 | 32 | 40 | 170 | 33.1 | -6 | -6 | 1.42 | 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 |
| | **DTGNL 3232 P 22** | 32 | 32 | 32 | 40 | 170 | 33.1 | -6 | -6 | 1.42 | 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

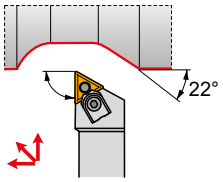
PRAMET

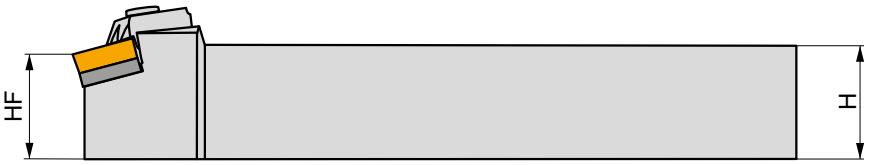
M

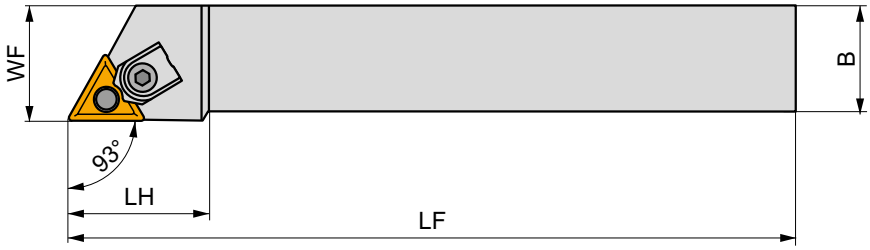


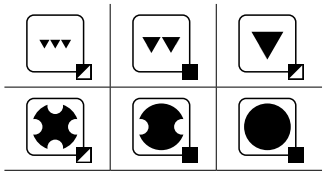
## Ekstern multiklemmeholder med 93 ° skærevinkel til TN .. Skær

Ekstern værktøjsholder med multiklemme til højre / venstre med skærevinkel på 93 °. Velegnet til langsgående drejning med skulder, tilspidsning og kopiering, der drejer op til 22 °, og affasning med negativ TN .. 16 eller 22 størrelse skær. Fås i 20x20 op til 32x32 mm skaft. Krop behandlet for længere levetid





| | 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 | -6 | -6 | 0.42 | GI024 | MT16 |
| | **MTJNR 2525 M 16** | 25 | 25 | 25 | 32 | 150 | 34 | -6 | -6 | 0.73 | GI024 | MT16 |
| | **MTJNR 3232 P 22** | 32 | 32 | 32 | 40 | 175 | 42 | -6 | -6 | 1.37 | GI025 | MT22 |
| L | **MTJNL 2020 K 16** | 20 | 20 | 20 | 25 | 125 | 34 | -6 | -6 | 0.43 | GI024 | MT16 |
| | **MTJNL 2525 M 16** | 25 | 25 | 25 | 32 | 150 | 34 | -6 | -6 | 0.75 | GI024 | MT16 |
| | **MTJNL 3232 P 22** | 32 | 32 | 32 | 40 | 175 | 42 | -6 | -6 | 1.38 | 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 53 | HS 94 | HXK 5 |

# PTFN(RL) EXT

P M K N S H

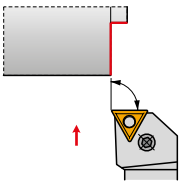
PRAMET

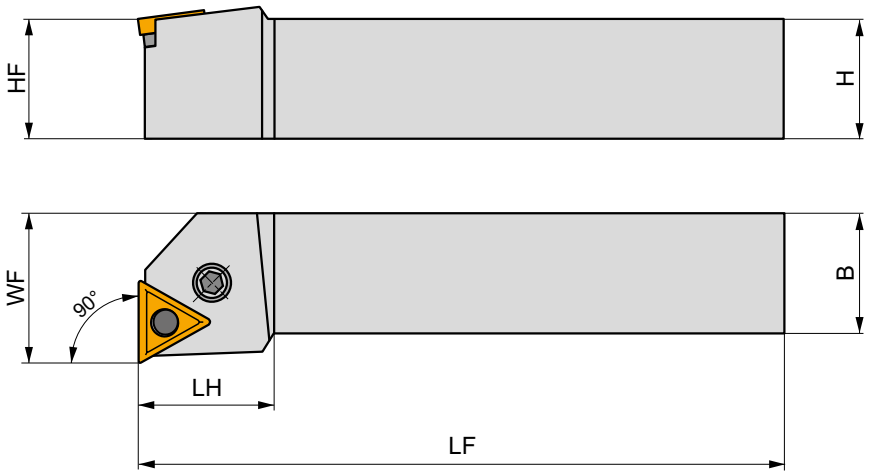
P

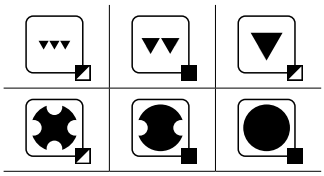


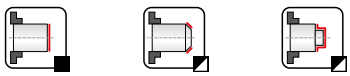
## Ekstern Lever Lock Drejeholder med 90 ° skærevinkel til TN .. Skær

Ekstern højre / venstre hånd værktøjsholder med 90 ° skærevinkel. Velegnet til endedrejning med skulder og affasning med negativ TN .. 16, 22 eller 27 størrelse skær. Fås i 16x16 op til 40x40 mm skaft. Krop behandlet for længere levetid







| | Product | H (mm) | B (mm) | HF (mm) | WF (mm) | LF (mm) | LH (mm) | LAMS (°) | GAMO (°) | kg | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| R | **PTFNR 1616 H 16** | 16 | 16 | 16 | 20 | 100 | 32 | -6 | -6 | 0.23 | GI024 | PT11 |
| | **PTFNR 2020 K 16** | 20 | 20 | 20 | 25 | 125 | 32 | -6 | -6 | 0.44 | GI024 | PT10 |
| | **PTFNR 2525 M 16** | 25 | 25 | 25 | 32 | 150 | 32 | -6 | -6 | 0.76 | GI024 | PT10 |
| | **PTFNR 2525 M 22** | 25 | 25 | 25 | 32 | 150 | 36 | -6 | -6 | 0.79 | GI025 | PT20 |
| | **PTFNR 3225 P 22** | 32 | 25 | 32 | 32 | 170 | 36 | -6 | -6 | 1.05 | GI025 | PT20 |
| | **PTFNR 4040 R 27** | 40 | 40 | 40 | 50 | 200 | 40 | -6 | -6 | 2.55 | GI077 | PT40 |
| L | **PTFNL 1616 H 16** | 16 | 16 | 16 | 20 | 100 | 32 | -6 | -6 | 0.24 | GI024 | PT11 |
| | **PTFNL 2020 K 16** | 20 | 20 | 20 | 25 | 125 | 32 | -6 | -6 | 0.43 | GI024 | PT10 |
| | **PTFNL 2525 M 16** | 25 | 25 | 25 | 32 | 150 | 32 | -6 | -6 | 0.65 | GI024 | PT10 |
| | **PTFNL 2525 M 22** | 25 | 25 | 25 | 32 | 150 | 36 | -6 | -6 | 0.79 | GI025 | PT20 |
| | **PTFNL 3225 P 22** | 32 | 25 | 32 | 32 | 170 | 36 | -6 | -6 | 1.14 | GI025 | PT20 |
| | **PTFNL 4040 R 27** | 40 | 40 | 40 | 50 | 200 | 40 | -6 | -6 | 2.55 | GI077 | PT40 |

| | |
|---|---|
| GI024 | TN.. 1604.. |
| GI025 | TN.. 2204.. |
| GI077 | TN.. 2706.. |

| | | | | Nm | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| PT10 | TNU 160308 | PU 01 | US 34 | 5.0 | M 6x0.75 | 19 | NT 04 | MT 04 | HXK 3 |
| PT11 | TNU 160308 | PU 01 | US 46 | 5.0 | M 6x0.75 | 13.2 | NT 04 | MT 04 | HXK 3 |
| PT20 | TNU 220312 | PU 02 | US 35 | 6.0 | M 8x1 | 22.5 | NT 05 | MT 05 | HXK 4 |
| PT40 | TNU 270416 | PU 04 | US 36 | 6.0 | M 8x1 | 26 | NT 07 | MT 07 | HXK 4 |

# PTGN(RL) EXT

P M K N S H

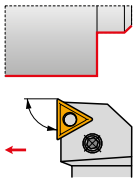
PRAMET

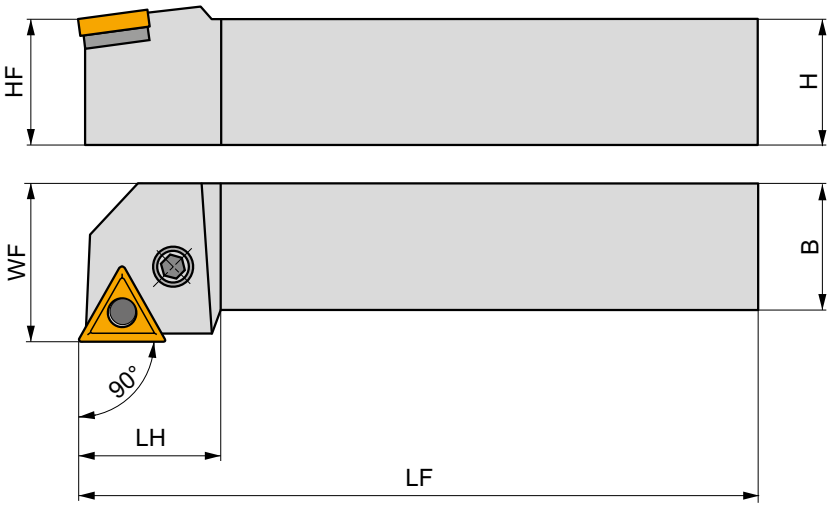
P

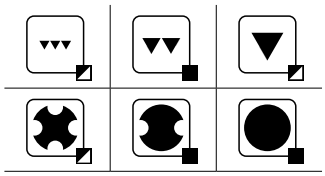


## Ekstern Lever Lock Drejeholder med 90 ° skærevinkel til TN .. Skær

Ekstern højre / venstre hånd værktøjsholder med 90 ° skærevinkel. Velegnet til langsgående drejning med skulder, konisk drejning og affasning med negative TN .. 16, 22 eller 27 størrelse skær. Fås i 16x16 op til 40x40 mm skaft. Krop behandlet for længere levetid







| | Product | H (mm) | B (mm) | HF (mm) | WF (mm) | LF (mm) | LH (mm) | LAMS (°) | GAMO (°) | kg | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| R | **PTGNR 1616 H 16** | 16 | 16 | 16 | 20 | 100 | 32 | -6 | -6 | 0.24 | GI024 | PT11 |
| | **PTGNR 2020 K 16** | 20 | 20 | 20 | 25 | 125 | 32 | -6 | -6 | 0.40 | GI024 | PT10 |
| | **PTGNR 2525 M 16** | 25 | 25 | 25 | 32 | 150 | 32 | -6 | -6 | 0.73 | GI024 | PT10 |
| | **PTGNR 2525 M 22** | 25 | 25 | 25 | 32 | 150 | 36 | -6 | -6 | 0.75 | GI025 | PT20 |
| | **PTGNR 3225 P 22** | 32 | 25 | 32 | 32 | 170 | 36 | -6 | -6 | 1.11 | GI025 | PT20 |
| | **PTGNR 3232 P 22** | 32 | 32 | 32 | 40 | 170 | 36 | -6 | -6 | 1.39 | GI025 | PT20 |
| | **PTGNR 4040 R 27** | 40 | 40 | 40 | 50 | 200 | 40 | -6 | -6 | 2.55 | GI077 | PT40 |
| L | **PTGNL 1616 H 16** | 16 | 16 | 16 | 20 | 100 | 32 | -6 | -6 | 0.25 | GI024 | PT11 |
| | **PTGNL 2020 K 16** | 20 | 20 | 20 | 25 | 125 | 32 | -6 | -6 | 0.40 | GI024 | PT10 |
| | **PTGNL 2525 M 16** | 25 | 25 | 25 | 32 | 150 | 32 | -6 | -6 | 0.77 | GI024 | PT10 |
| | **PTGNL 2525 M 22** | 25 | 25 | 25 | 32 | 150 | 36 | -6 | -6 | 0.79 | GI025 | PT20 |
| | **PTGNL 3225 P 22** | 32 | 25 | 32 | 32 | 170 | 36 | -6 | -6 | 1.11 | GI025 | PT20 |
| | **PTGNL 3232 P 22** | 32 | 32 | 32 | 40 | 170 | 36 | -6 | -6 | 1.40 | GI025 | PT20 |
| | **PTGNL 4040 R 27** | 40 | 40 | 40 | 50 | 200 | 40 | -6 | -6 | 2.40 | GI077 | PT40 |

| | |
|---|---|
| GI024 | TN.. 1604.. |
| GI025 | TN.. 2204.. |
| GI077 | TN.. 2706.. |

| | | | | Nm | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| PT10 | TNU 160308 | PU 01 | US 34 | 5.0 | M 6x0.75 | 19 | NT 04 | MT 04 | HXK 3 |
| PT11 | TNU 160308 | PU 01 | US 46 | 5.0 | M 6x0.75 | 13.2 | NT 04 | MT 04 | HXK 3 |
| PT20 | TNU 220312 | PU 02 | US 35 | 6.0 | M 8x1 | 22.5 | NT 05 | MT 05 | HXK 4 |
| PT40 | TNU 270416 | PU 04 | US 36 | 6.0 | M 8x1 | 26 | NT 07 | MT 07 | HXK 4 |

# PTTN(RL) EXT

P M K N S H

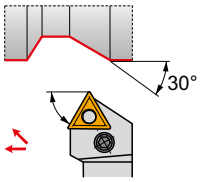
PRAMET

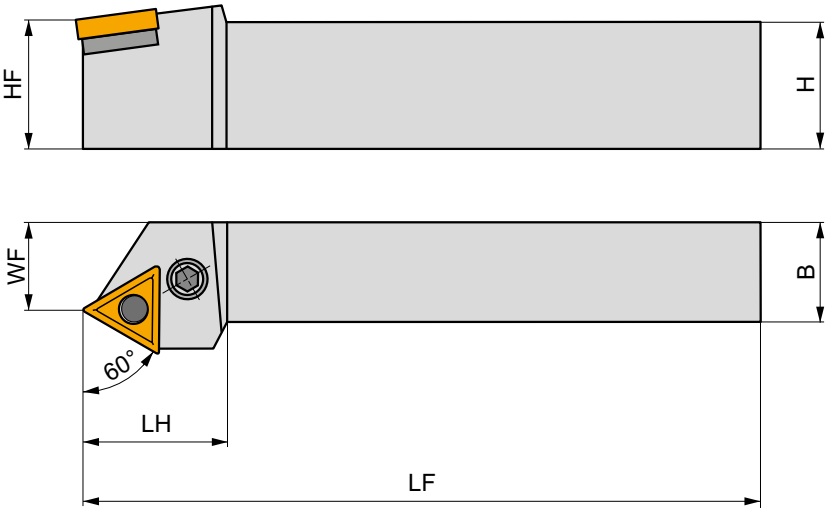
P

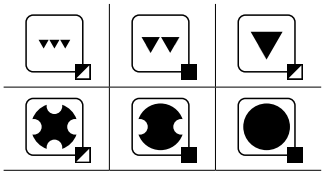


## Ekstern Lever Lock Drejeholder med 60 ° skærevinkel til TN .. Skær

Ekstern højre / venstre hånd værktøjsholder med 60 ° skærevinkel. Velegnet til langsgående drejning med skulder, tilspidsning og kopidrejning op til 30 ° og affasning med negative TN .. 16 og 22 størrelse skær. Fås i 20x20 op til 32x25 mm skaft. Krop behandlet for længere levetid





| | 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 | 32 | -6 | -6 | 0.43 | GI024 | PT10 |
| | **PTTNR 2525 M 16** | 25 | 25 | 25 | 22 | 150 | 32 | -6 | -6 | 0.63 | GI024 | PT10 |
| | **PTTNR 2525 M 22** | 25 | 25 | 25 | 22 | 150 | 36 | -6 | -6 | 0.73 | GI025 | PT20 |
| | **PTTNR 3225 P 22** | 32 | 25 | 32 | 22 | 170 | 36 | -6 | -6 | 1.07 | GI025 | PT20 |
| L | **PTTNL 2020 K 16** | 20 | 20 | 20 | 17 | 125 | 32 | -6 | -6 | 0.38 | GI024 | PT10 |
| | **PTTNL 3225 P 22** | 32 | 25 | 32 | 22 | 170 | 36 | -6 | -6 | 1.04 | GI025 | PT20 |

| | |
|---|---|
| GI024 | TN.. 1604.. |
| GI025 | TN.. 2204.. |

| | | | | Nm | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| PT10 | TNU 160308 | PU 01 | US 34 | 5.0 | M 6x0.75 | 19 | NT 04 | MT 04 | HXK 3 |
| PT20 | TNU 220312 | PU 02 | US 35 | 6.0 | M 8x1 | 22.5 | NT 05 | MT 05 | HXK 4 |

NEW

# C.-DTJN(RL) EXT

P M K N S H

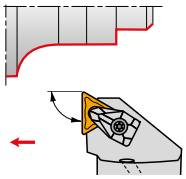
PRAMET

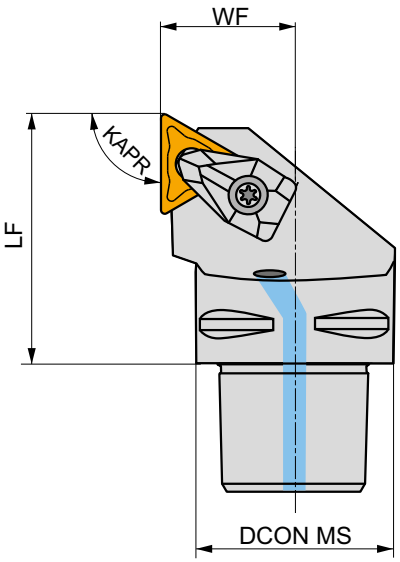
D

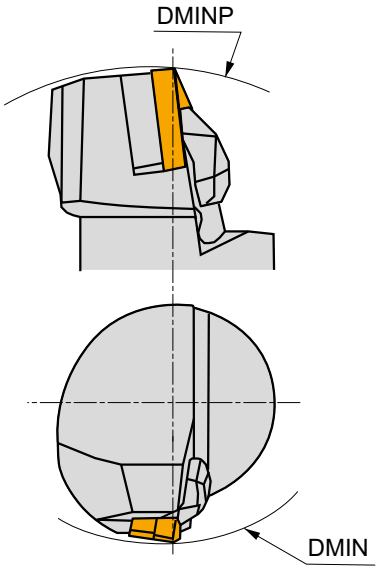


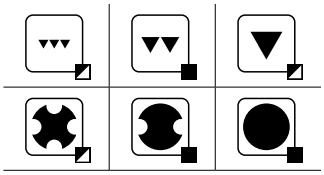
## Eksternt PSC hurtig skift værktøj, dobbelt klemme, 93 ° skærevinkel, TN .. skær

Eksternt højre / venstre hånd dobbelt klemme værktøj, indvendig kølemiddel, med 93° skærevinkel til langsgående drejning med skulder, konisk drejning og affasning med negativ TN .. 16 størrelse skær. Fås med PSC (Polygon Shank Coupling) C4 og C5 skaft. Krop behandlet for længere levetid







| | 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 | ✓ | 0.44 | 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

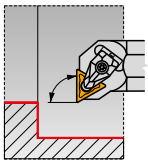
PRAMET

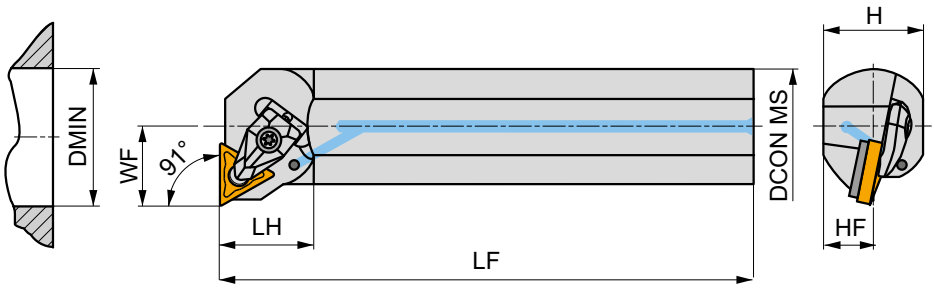
D

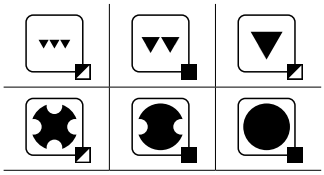


## Intern dobbeltklemmeholder med 91 ° skærevinkel til TN .. Skær

Intern højre / venstre hånds bøjleskinne, indvendig kølevæske, 91° skærevinkel til TN .. 16 og 22 skær. Mindste indvendige drejediameter Ø32 mm. Til indvendig konisk og langsgående drejning med drejning af skulder og affasning. Fås med skaftstørrelse Ø25 op til Ø40 mm. Krop behandlet for længere levetid på værktøjet.







| | 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 | -12 | -6 | ✓ | 0.96 | GI024 | DTI16 |
| | **A32T-DTFNR 16** | 32 | 40 | 22 | 30 | 15 | 300 | 33 | -10 | -6 | ✓ | 1.67 | GI024 | DTI16 |
| | **A40T-DTFNR 22** | 40 | 50 | 27 | 37 | 18.5 | 300 | 36 | -13 | -6 | ✓ | 2.58 | GI025 | DT22 |
| L | **A25T-DTFNL 16** | 25 | 32 | 17 | 23 | 11.5 | 300 | 32 | -12 | -6 | ✓ | 0.96 | GI024 | DTI16 |
| | **A32T-DTFNL 16** | 32 | 40 | 22 | 30 | 15 | 300 | 33 | -10 | -6 | ✓ | 1.67 | GI024 | DTI16 |
| | **A40T-DTFNL 22** | 40 | 50 | 27 | 37 | 18.5 | 300 | 36 | -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

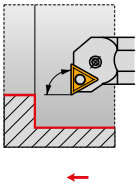
PRAMET

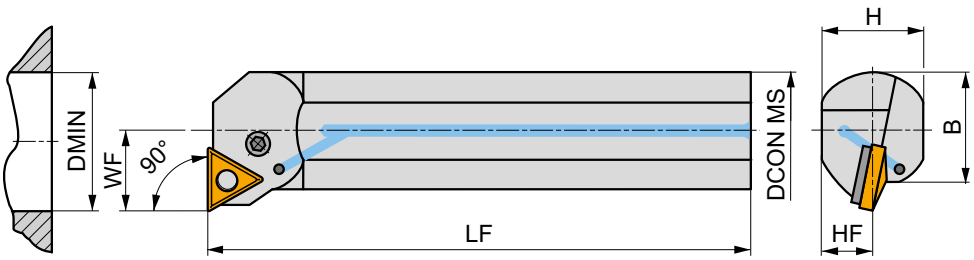
P

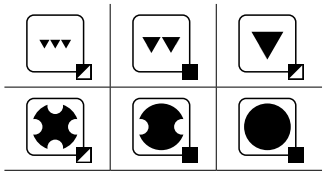


## Intern låseholder med 90 ° skærevinkel til TN .. Skær

Intern højre / venstre hånd, indvendig kølevæske til rådighed, 90° skærevinkel til TN .. 16 og 22 skær. Mindste indvendige drejediameter Ø32 mm. Til indvendig konisk og langsgående drejning med drejning af skulder og affasning. Ø25 op til Ø40 mm skaft fås. Krop behandlet for længere levetid på værktøjet.







| | Product | DCON MS (mm) | DMIN (mm) | WF (mm) | H (mm) | B (mm) | LF (mm) | LAMS (°) | GAMO (°) | | kg | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| R | **A25R-PTFNR 16** | 25 | 32 | 17 | 23 | 23 | 200 | -12 | -6 | ✓ | 0.74 | GI024 | PT11 |
| | **A32S-PTFNR 16** | 32 | 40 | 22 | 30 | 30 | 250 | -12 | -6 | ✓ | 1.49 | GI024 | PT10 |
| | **A40T-PTFNR 22** | 40 | 50 | 27 | 38 | 38 | 300 | -12 | -6 | ✓ | 2.58 | GI025 | PT20 |
| L | **A25R-PTFNL 16** | 25 | 32 | 17 | 23 | 23 | 200 | -12 | -6 | ✓ | 0.74 | GI024 | PT11 |
| | **A32S-PTFNL 16** | 32 | 40 | 22 | 30 | 30 | 250 | -12 | -6 | ✓ | 1.48 | GI024 | PT10 |
| | **A40T-PTFNL 22** | 40 | 50 | 27 | 38 | 38 | 300 | -12 | -6 | ✓ | 2.90 | GI025 | PT20 |

| | |
|---|---|
| GI024 | TN.. 1604.. |
| GI025 | TN.. 2204.. |

| | | | | Nm | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| PT10 | TNU 160308 | PU 01 | US 34 | 5.0 | M 6x0.75 | 19 | NT 04 | MT 04 | HXK 3 |
| PT11 | TNU 160308 | PU 01 | US 46 | 5.0 | M 6x0.75 | 13.2 | NT 04 | MT 04 | HXK 3 |
| PT20 | TNU 220312 | PU 02 | US 35 | 6.0 | M 8x1 | 22.5 | NT 05 | MT 05 | HXK 4 |

NEW

# C.-DTFN(RL) INT

P M K N S H

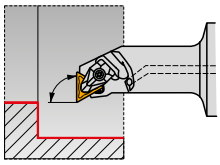
PRAMET

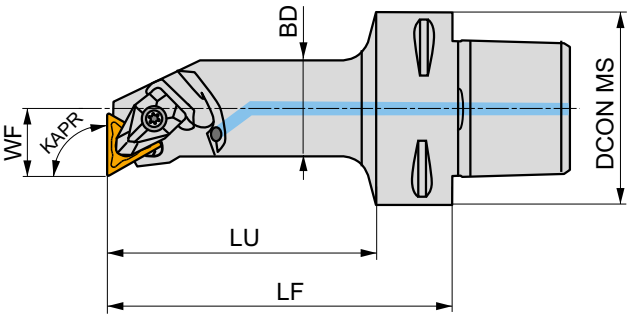
D

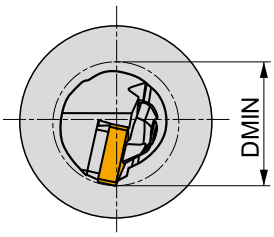


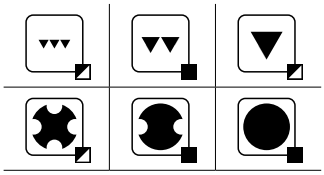
## Internt PSC Hurtig skift Værktøj, dobbelt klemme, 91 ° skærevinkel, TN .. Skær

Internt højre / venstre dobbeltklemmeværktøj, indvendig kølemiddel, med 91° skærevinkel til en bred vifte af indvendige drejeanvendelser med TN .. 16 skær, minimum drejediameter Ø32mm. PSC-skaft (Polygon Shank Coupling) størrelse C4 med drejelængde på 68 mm. Krop behandlet for længere levetid på værktøjet.







| | 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 |

# VN 16

## CARBIDE INSERTS

### VNMG



356

## CER AND CBN INSERTS

### VNGA CER



359

### VNGA CBN

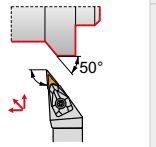


359

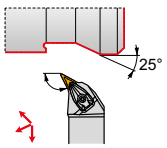
| MATCH THE RIGHT SIZE (example) | |
|---|---|
| **Insert** | **Tool Holder** |
| VNMG 160404E-SF | DVJNL 2020 K 16 |

## ISO-DREJNING – UDVENDIGT

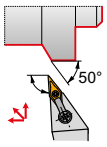
### DVJN(RL) EXT

| 93° | VN.. |
|---|---|
|  | 16 |
| 20×20 / 32×25 | |
| 360 | 356 – 359 |

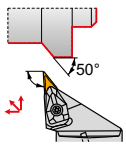
### DVPN(RL) EXT

| 62°30´ | VN.. |
|---|---|
|  | 16 |
| 20×20 / 32×25 | |
| 361 | 356 – 359 |

### MVJN(RL) EXT

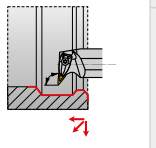
| 93° | VN.. |
|---|---|
|  | 16 |
| 20×20 / 32×25 | |
| 362 | 356 – 359 |

### C.-DVJN(RL) EXT NEW

| 93° | VN.. |
|---|---|
|  | 16 |
| C4 / C6 | |
| 363 | 356 – 359 |

## ISO-DREJNING – INDVENDIG

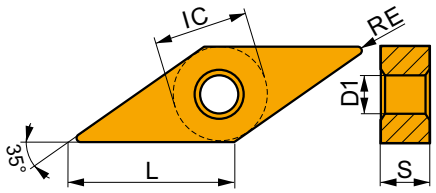
### DVUN(RL) INT

| | VN.. |
|---|---|
|  | 16 |
| ØDmin 50 | |
| 364 | 356 – 359 |

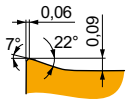
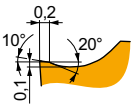
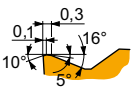
# VNMG

PRAMET

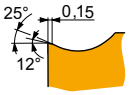
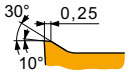
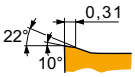
| | IC (mm) | D1 (mm) | L (mm) | S (mm) |
|---|---|---|---|---|
| 1604 | 9.525 | 3.81 | 16.60 | 4.76 |



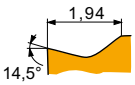
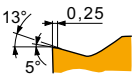

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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-geometri med meget positivt design til finbearbejdning og kontinuerlige til let afbrudte snit.** | | | | | | | | | | | | | | | | | | | | |
| **VNMG 160404E-FF** | **T7325** | 0.4 | 165 | 0.12 | 1.0 | 125 | 0.11 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.4 | 150 | 0.12 | 1.0 | 90 | 0.11 | 1.0 | 140 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.4 | 140 | 0.12 | 1.0 | 80 | 0.11 | 1.0 | 130 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.4 | 175 | 0.12 | 1.0 | 95 | 0.11 | 1.0 | 140 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | | | | | | | | | | | | | | | | | | |
| **FM-geometri med positivt design til fin til halvgrov bearbejdning og kontinuerlige til let afbrudte snit.** | | | | | | | | | | | | | | | | | | | | |
| **VNMG 160404E-FM** | **T7325** | 0.4 | 140 | 0.20 | 1.2 | 105 | 0.18 | 1.2 | – | – | – | – | – | – | 45 | 0.20 | 1.0 | – | – | – |
| | **T8330** | 0.4 | 120 | 0.20 | 1.2 | 70 | 0.18 | 1.2 | 110 | 0.20 | 1.2 | – | – | – | 30 | 0.14 | 1.0 | – | – | – |
| | **T8430** | 0.4 | 135 | 0.20 | 1.2 | 75 | 0.18 | 1.2 | 110 | 0.20 | 1.2 | – | – | – | 25 | 0.14 | 1.0 | – | – | – |
| | **T9310** | 0.4 | 210 | 0.20 | 1.2 | – | – | – | 195 | 0.20 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.4 | 190 | 0.20 | 1.2 | – | – | – | 180 | 0.20 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 170 | 0.20 | 1.2 | 100 | 0.18 | 1.2 | 160 | 0.20 | 1.2 | – | – | – | 35 | 0.20 | 1.0 | – | – | – |
| **VNMG 160408E-FM** | **T7325** | 0.8 | 160 | 0.20 | 1.4 | 120 | 0.18 | 1.4 | – | – | – | – | – | – | 50 | 0.16 | 1.1 | – | – | – |
| | **T8330** | 0.8 | 145 | 0.20 | 1.4 | 85 | 0.18 | 1.4 | 135 | 0.20 | 1.4 | – | – | – | 35 | 0.16 | 1.1 | – | – | – |
| | **T8430** | 0.8 | 165 | 0.20 | 1.4 | 90 | 0.18 | 1.4 | 135 | 0.20 | 1.4 | – | – | – | 35 | 0.16 | 1.1 | – | – | – |
| | **T9310** | 0.8 | 245 | 0.20 | 1.4 | – | – | – | 230 | 0.20 | 1.4 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.8 | 220 | 0.20 | 1.4 | – | – | – | 205 | 0.20 | 1.4 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 200 | 0.20 | 1.4 | 120 | 0.18 | 1.4 | 190 | 0.20 | 1.4 | – | – | – | 45 | 0.16 | 1.1 | – | – | – |
| **VNMG 160412E-FM** | **T7325** | 1.2 | 165 | 0.22 | 1.4 | 125 | 0.20 | 1.4 | – | – | – | – | – | – | 50 | 0.18 | 1.1 | – | – | – |
| | **T8330** | 1.2 | 150 | 0.22 | 1.4 | 90 | 0.20 | 1.4 | 140 | 0.22 | 1.4 | – | – | – | 35 | 0.18 | 1.1 | – | – | – |
| | **T8430** | 1.2 | 165 | 0.22 | 1.4 | 90 | 0.20 | 1.4 | 135 | 0.22 | 1.4 | – | – | – | 35 | 0.18 | 1.1 | – | – | – |
| | **T9315** | 1.2 | 225 | 0.22 | 1.4 | – | – | – | 210 | 0.22 | 1.4 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | 200 | 0.22 | 1.4 | 120 | 0.20 | 1.4 | 190 | 0.22 | 1.4 | – | – | – | 45 | 0.18 | 1.1 | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | | | | | | | | | | | | | | | | | | |
| **M-geometri til fin til halv grov bearbejdning og kontinuerlig til afbrudt snit.** | | | | | | | | | | | | | | | | | | | | |
| **VNMG 160404E-M** | **T5315** | 0.4 | 180 | 0.20 | 1.2 | – | – | – | 170 | 0.20 | 1.2 | – | – | – | – | – | – | 35 | 0.15 | 1.0 |
| | **T9315** | 0.4 | 170 | 0.20 | 1.2 | – | – | – | 160 | 0.20 | 1.2 | – | – | – | – | – | – | 30 | 0.15 | 1.0 |
| | **T9325** | 0.4 | 155 | 0.20 | 1.2 | – | – | – | 145 | 0.20 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.4 | 130 | 0.20 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **VNMG 160408E-M** | **T5305** | 0.8 | 205 | 0.30 | 1.4 | – | – | – | 190 | 0.30 | 1.4 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| | **T5315** | 0.8 | 185 | 0.30 | 1.4 | – | – | – | 175 | 0.30 | 1.4 | – | – | – | – | – | – | 35 | 0.15 | 1.0 |
| | **T9310** | 0.8 | 185 | 0.30 | 1.4 | – | – | – | 175 | 0.30 | 1.4 | – | – | – | – | – | – | 35 | 0.15 | 1.0 |
| | **T9315** | 0.8 | 170 | 0.30 | 1.4 | – | – | – | 160 | 0.30 | 1.4 | – | – | – | – | – | – | 30 | 0.15 | 1.0 |
| | **T9325** | 0.8 | 150 | 0.30 | 1.4 | – | – | – | 140 | 0.30 | 1.4 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.8 | 130 | 0.30 | 1.4 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **VNMG 160412E-M** | **T9325** | 1.2 | 140 | 0.40 | 1.4 | – | – | – | 130 | 0.40 | 1.4 | – | – | – | – | – | – | – | – | – |

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) | | | | | | | | | | | | | | | | | | |
| | | | NF-geometri med meget positivt design til finbearbejdning til medium bearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | |
| **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 | – | – | – |
| | **T7325** | 0.4 | 140 | 0.18 | 1.2 | 105 | 0.16 | 1.2 | – | – | – | – | – | – | 45 | 0.16 | 1.0 | – | – | – |
| | **T7335** | 0.4 | 140 | 0.18 | 1.2 | 105 | 0.16 | 1.2 | – | – | – | – | – | – | 45 | 0.16 | 1.0 | – | – | – |
| | **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 | – | – | – |
| | **T8330** | 0.4 | 140 | 0.12 | 1.2 | 80 | 0.11 | 1.2 | 130 | 0.12 | 1.2 | 420 | 0.14 | 1.2 | 35 | 0.11 | 1.0 | – | – | – |
| | **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 | – | – | – |
| | **T9315** | 0.4 | 235 | 0.12 | 1.2 | – | – | – | 220 | 0.12 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 180 | 0.18 | 1.2 | 105 | 0.16 | 1.2 | 170 | 0.18 | 1.2 | – | – | – | 40 | 0.16 | 1.0 | – | – | – |
| **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 | – | – | – |
| | **T7325** | 0.8 | 165 | 0.18 | 1.4 | 125 | 0.16 | 1.4 | – | – | – | – | – | – | 50 | 0.16 | 1.1 | – | – | – |
| | **T7335** | 0.8 | 160 | 0.18 | 1.4 | 120 | 0.16 | 1.4 | – | – | – | – | – | – | 50 | 0.16 | 1.1 | – | – | – |
| | **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 | – | – | – |
| | **T8330** | 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 | – | – | – |
| | **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 | – | – | – |
| | **T9315** | 0.8 | 240 | 0.17 | 1.4 | – | – | – | 225 | 0.17 | 1.4 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 210 | 0.18 | 1.4 | 125 | 0.16 | 1.4 | 195 | 0.18 | 1.4 | – | – | – | 45 | 0.16 | 1.1 | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | NM-geometri med meget positivt design til finbearbejdning, mellem og grov bearbejdning i kontinuerlige snit. | | | | | | | | | | | | | | | | | |
| **VNMG 160404E-NM** | **T7325** | 0.4 | 145 | 0.20 | 1.2 | 110 | 0.18 | 1.2 | – | – | – | – | – | – | 45 | 0.20 | 1.0 | – | – | – |
| | **T7335** | 0.4 | 140 | 0.20 | 1.2 | 105 | 0.18 | 1.2 | – | – | – | – | – | – | 45 | 0.20 | 1.0 | – | – | – |
| | **T8315** | 0.4 | 135 | 0.20 | 1.2 | 80 | 0.18 | 1.2 | – | – | – | 405 | 0.24 | 1.2 | 30 | 0.20 | 1.0 | – | – | – |
| | **T8330** | 0.4 | 125 | 0.20 | 1.2 | 75 | 0.18 | 1.2 | – | – | – | 375 | 0.24 | 1.2 | 30 | 0.20 | 1.0 | – | – | – |
| | **T8430** | 0.4 | 145 | 0.20 | 1.2 | 80 | 0.18 | 1.2 | – | – | – | 405 | 0.24 | 1.2 | 30 | 0.20 | 1.0 | – | – | – |
| | **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 | – | – | – |
| | **T7335** | 0.8 | 155 | 0.25 | 1.4 | 120 | 0.23 | 1.4 | – | – | – | – | – | – | 50 | 0.20 | 1.1 | – | – | – |
| | **T8315** | 0.8 | 145 | 0.25 | 1.4 | 85 | 0.23 | 1.4 | – | – | – | 435 | 0.30 | 1.4 | 35 | 0.20 | 1.1 | – | – | – |
| | **T8330** | 0.8 | 140 | 0.25 | 1.4 | 80 | 0.23 | 1.4 | – | – | – | 420 | 0.30 | 1.4 | 35 | 0.20 | 1.1 | – | – | – |
| | **T8430** | 0.8 | 155 | 0.25 | 1.4 | 85 | 0.23 | 1.4 | – | – | – | 435 | 0.30 | 1.4 | 30 | 0.20 | 1.1 | – | – | – |
| | **T9325** | 0.8 | 190 | 0.25 | 1.4 | 110 | 0.23 | 1.4 | – | – | – | – | – | – | 40 | 0.20 | 1.1 | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | NMR-geometri med positivt design til medium til grov bearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | |
| **VNMG 160404E-NMR** | **T7325** | 0.4 | 125 | 0.20 | 1.2 | 95 | 0.18 | 1.2 | – | – | – | – | – | – | 40 | 0.18 | 1.0 | – | – | – |
| | **T7335** | 0.4 | 120 | 0.20 | 1.2 | 90 | 0.18 | 1.2 | – | – | – | – | – | – | 35 | 0.18 | 1.0 | – | – | – |
| | **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 | – | – | – |
| | **T7335** | 0.8 | 125 | 0.30 | 1.4 | 95 | 0.27 | 1.4 | – | – | – | – | – | – | 40 | 0.24 | 1.1 | – | – | – |
| | **T8430** | 0.8 | 125 | 0.30 | 1.4 | 65 | 0.27 | 1.4 | – | – | – | – | – | – | 25 | 0.24 | 1.1 | – | – | – |
| | **T9315** | 0.8 | 170 | 0.30 | 1.4 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 150 | 0.30 | 1.4 | 90 | 0.27 | 1.4 | – | – | – | – | – | – | 30 | 0.24 | 1.1 | – | – | – |
| **VNMG 160412E-NMR** | **T7325** | 1.2 | 140 | 0.30 | 1.4 | 105 | 0.27 | 1.4 | – | – | – | – | – | – | 45 | 0.24 | 1.1 | – | – | – |
| | **T8330** | 1.2 | 120 | 0.30 | 1.4 | 70 | 0.27 | 1.4 | – | – | – | – | – | – | 30 | 0.24 | 1.1 | – | – | – |
| | **T8430** | 1.2 | 130 | 0.30 | 1.4 | 70 | 0.27 | 1.4 | – | – | – | – | – | – | 25 | 0.24 | 1.1 | – | – | – |
| | **T9325** | 1.2 | 160 | 0.30 | 1.4 | 95 | 0.27 | 1.4 | – | – | – | – | – | – | 35 | 0.24 | 1.1 | – | – | – |

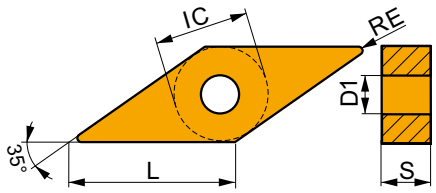
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |   | | | | | | | | | | | | | | | | | | | |
| SF-geometri med positivt design til finbearbejdning og til bearbejdning af tynde vægge med kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **VNMG 160404E-SF** | **T6310** | 0.4 | ■ 135 | 0.12 | 1.2 | ■ 95 | 0.11 | 1.2 | ■ 105 | 0.12 | 1.2 | ◪ 405 | 0.14 | 1.2 | ■ 40 | 0.11 | 1.0 | ■ 25 | 0.15 | 1.0 |
| | **T7325** | 0.4 | ◪ 140 | 0.17 | 1.2 | ■ 105 | 0.15 | 1.2 | – | – | – | – | – | – | ■ 45 | 0.15 | 1.0 | – | – | – |
| | **T8315** | 0.4 | ◪ 140 | 0.12 | 1.2 | ■ 80 | 0.11 | 1.2 | ■ 130 | 0.12 | 1.2 | ◪ 420 | 0.14 | 1.2 | ◪ 35 | 0.11 | 1.0 | ■ 25 | 0.15 | 1.0 |
| | **T8330** | 0.4 | ■ 135 | 0.12 | 1.2 | ■ 80 | 0.11 | 1.2 | ■ 125 | 0.12 | 1.2 | ◪ 405 | 0.14 | 1.2 | ◪ 30 | 0.11 | 1.0 | ◪ 25 | 0.15 | 1.0 |
| | **T8430** | 0.4 | ■ 165 | 0.12 | 1.2 | ■ 90 | 0.11 | 1.2 | ◪ 135 | 0.12 | 1.2 | ◪ 450 | 0.14 | 1.2 | ◪ 35 | 0.11 | 1.0 | ◪ 25 | 0.15 | 1.0 |
| | **T9315** | 0.4 | ■ 225 | 0.12 | 1.2 | – | – | – | ◪ 210 | 0.12 | 1.2 | – | – | – | – | – | – | ◪ 45 | 0.15 | 1.0 |
| | **T9325** | 0.4 | ■ 175 | 0.17 | 1.2 | ■ 105 | 0.15 | 1.2 | ◪ 165 | 0.17 | 1.2 | – | – | – | ◪ 35 | 0.15 | 1.0 | – | – | – |
| **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 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| | **T8330** | 0.8 | ■ 145 | 0.17 | 1.4 | ■ 85 | 0.15 | 1.4 | ■ 135 | 0.17 | 1.4 | ◪ 435 | 0.20 | 1.4 | ◪ 35 | 0.14 | 1.1 | ◪ 25 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| | **T9315** | 0.8 | ■ 230 | 0.17 | 1.4 | – | – | – | ◪ 215 | 0.17 | 1.4 | – | – | – | – | – | – | ◪ 45 | 0.15 | 1.0 |
| | **T9325** | 0.8 | ■ 205 | 0.17 | 1.4 | ■ 120 | 0.15 | 1.4 | ◪ 190 | 0.17 | 1.4 | – | – | – | ◪ 45 | 0.15 | 1.1 | – | – | – |
| **VNMG 160412E-SF** | **T6310** | 1.2 | ■ 145 | 0.20 | 1.4 | ■ 100 | 0.18 | 1.4 | ■ 115 | 0.20 | 1.4 | ◪ 435 | 0.24 | 1.4 | ■ 40 | 0.16 | 1.1 | ■ 25 | 0.15 | 1.0 |
| | **T7325** | 1.2 | ◪ 165 | 0.20 | 1.4 | ■ 125 | 0.18 | 1.4 | – | – | – | – | – | – | ■ 50 | 0.16 | 1.1 | – | – | – |
|  |   | | | | | | | | | | | | | | | | | | | |
| SM-geometri med positivt design til medium bearbejdning og kontinuerlige til afbrudte snit. | | | | | | | | | | | | | | | | | | | | |
| **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 | 0.15 | 1.0 |
| | **T7325** | 0.4 | ◪ 135 | 0.18 | 1.2 | ■ 105 | 0.16 | 1.2 | – | – | – | – | – | – | ■ 40 | 0.16 | 1.0 | – | – | – |
| | **T7335** | 0.4 | ◪ 135 | 0.18 | 1.2 | ■ 105 | 0.16 | 1.2 | – | – | – | – | – | – | ■ 40 | 0.16 | 1.0 | – | – | – |
| | **T8330** | 0.4 | ■ 120 | 0.18 | 1.2 | ■ 70 | 0.16 | 1.2 | ■ 110 | 0.18 | 1.2 | ◪ 360 | 0.22 | 1.2 | ◪ 30 | 0.16 | 1.0 | ◪ 20 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| | **T9315** | 0.4 | ■ 190 | 0.18 | 1.2 | – | – | – | ◪ 180 | 0.18 | 1.2 | – | – | – | – | – | – | ◪ 35 | 0.15 | 1.0 |
| | **T9325** | 0.4 | ■ 170 | 0.18 | 1.2 | ■ 100 | 0.16 | 1.2 | ◪ 160 | 0.18 | 1.2 | – | – | – | ◪ 35 | 0.16 | 1.0 | – | – | – |
| **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 | 0.15 | 1.0 |
| | **T7325** | 0.8 | ◪ 145 | 0.25 | 1.4 | ■ 110 | 0.23 | 1.4 | – | – | – | – | – | – | ■ 45 | 0.20 | 1.1 | – | – | – |
| | **T8330** | 0.8 | ■ 125 | 0.25 | 1.4 | ■ 75 | 0.23 | 1.4 | ■ 115 | 0.25 | 1.4 | ◪ 375 | 0.30 | 1.4 | ◪ 30 | 0.20 | 1.1 | ◪ 25 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| | **T9315** | 0.8 | ■ 195 | 0.25 | 1.4 | – | – | – | ◪ 185 | 0.25 | 1.4 | – | – | – | – | – | – | ◪ 35 | 0.15 | 1.0 |
| | **T9325** | 0.8 | ■ 170 | 0.25 | 1.4 | ■ 100 | 0.23 | 1.4 | ◪ 160 | 0.25 | 1.4 | – | – | – | ◪ 35 | 0.20 | 1.1 | – | – | – |
| **VNMG 160412E-SM** | **T6310** | 1.2 | ■ 125 | 0.30 | 1.4 | ■ 90 | 0.27 | 1.4 | ■ 100 | 0.30 | 1.4 | ◪ 375 | 0.36 | 1.4 | ■ 35 | 0.24 | 1.1 | ◪ 25 | 0.15 | 1.0 |

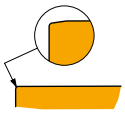
# VNGA CER

PRAMET

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



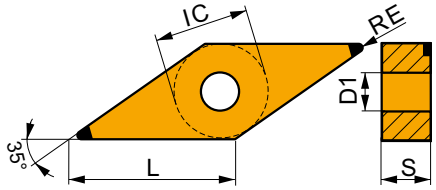

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | HSC T | | | | | | | | | | | | | | | | | |
| | | | Til bearbejdning med høje hastigheder og kontinuerlige snit. | | | | | | | | | | | | | | | | | |
| VNGA 160404 T01020 | TC100 | 0.4 | – | – | – | – | – | – | 425 | 0.10 | 1.0 | – | – | – | – | – | – | – | – | – |
| VNGA 160408 T01020 | TC100 | 0.8 | – | – | – | – | – | – | 395 | 0.20 | 1.0 | – | – | – | – | – | – | – | – | – |

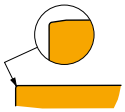
# VNGA CBN

PRAMET

| | IC (mm) | D1 (mm) | L (mm) | S (mm) |
|---|---|---|---|---|
| 1604 | 9.525 | 3.81 | 16.00 | 4.76 |




Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | HSC S | | | | | | | | | | | | | | | | | |
| | | | Til færdigbearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | |
| VNGA 160404S01020B | TB310 | 0.4 | – | – | – | – | – | – | 360 | 0.10 | 0.4 | – | – | – | 95 | 0.07 | 0.3 | 75 | 0.15 | 1.0 |
| VNGA 160408S01020B | TB310 | 0.8 | – | – | – | – | – | – | 370 | 0.15 | 0.6 | – | – | – | 95 | 0.11 | 0.5 | 75 | 0.15 | 1.0 |

# DVJN(RL) EXT

P M K N S H

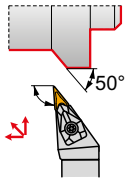
PRAMET

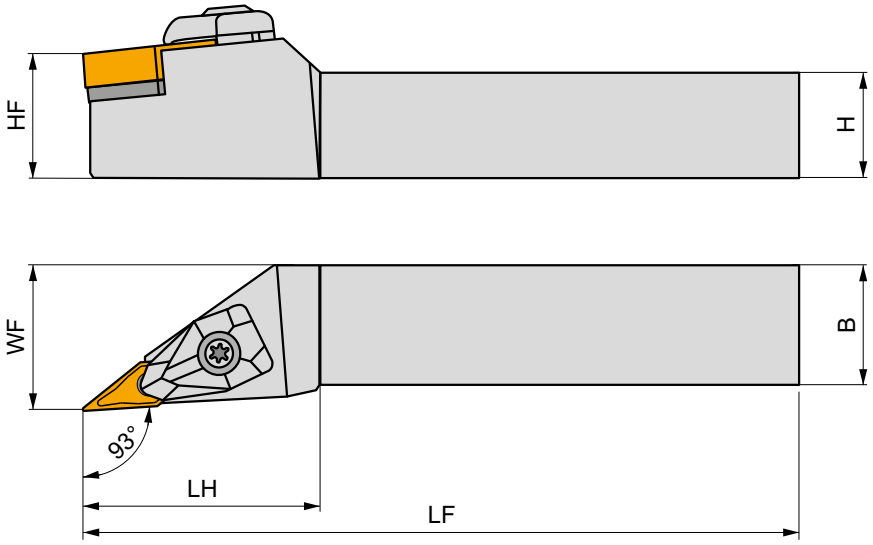
D

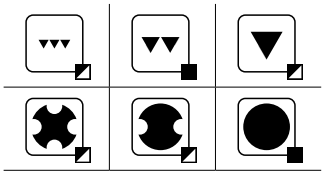


## Ekstern dobbeltholder med 93 ° skærevinkel til VN .. Skær

Ekstern højre / venstre værktøjsholder med dobbelt klemme med skærevinkel på 93 °. Velegnet til langsgående drejning med skulder, konisk drejning og affasning med negative TN .. 16 eller 22 størrelse skær. Fås i 20x20 op til 32x32 mm skaft. Krop behandlet for længere levetid





| | Product | H (mm) | B (mm) | HF (mm) | WF (mm) | LF (mm) | LH (mm) | LAMS (°) | GAMO (°) | kg | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 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 | 0.75 | 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

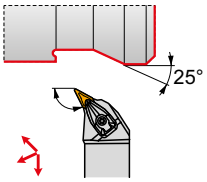
PRAMET

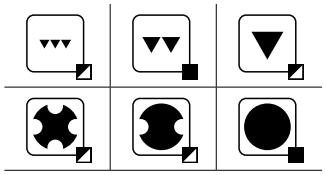
D

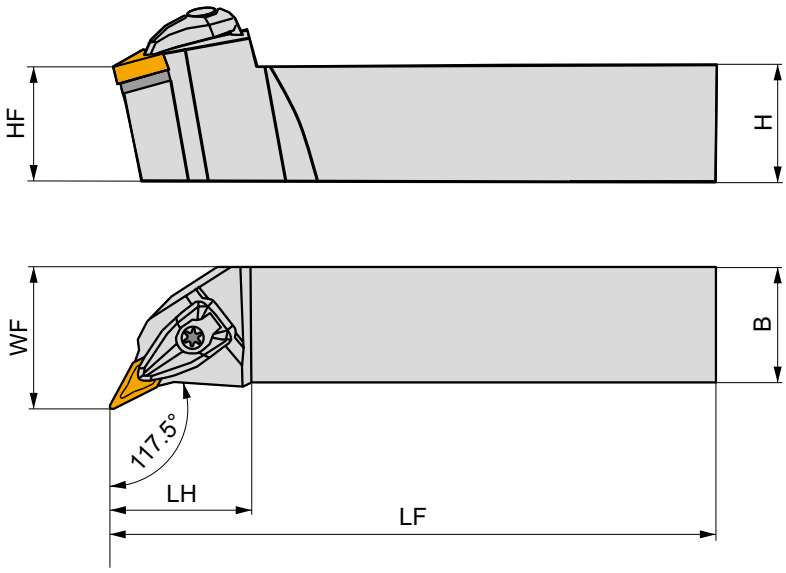


## Ekstern dobbeltholder, 117.5 ° skærevinkel til VN .. skær

Ekstern højre / venstre hånds værktøjsholder med dobbelt klemme med 117,5 ° skærevinkel. Velegnet til drejning i længderetningen og endedrejning med skulderen, kopiering og konisk drejning og affasning med negativ VN .. 16 størrelse skær. Fås i skaftet 25x25 og 32x25 mm. Krop behandlet for længere levetid








| | 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 |
| | **DVPNR 3225 P 16** | 32 | 25 | 32 | 32 | 170 | 39.2 | -13 | -4 | 1.06 | GI048 | DV16 |
| L | **DVPNL 2525 M 16** | 25 | 25 | 25 | 32 | 150 | 39.2 | -13 | -4 | 0.74 | GI048 | DV16 |
| | **DVPNL 3225 P 16** | 32 | 25 | 32 | 32 | 170 | 39.2 | -13 | -4 | 1.06 | 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

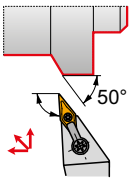
PRAMET

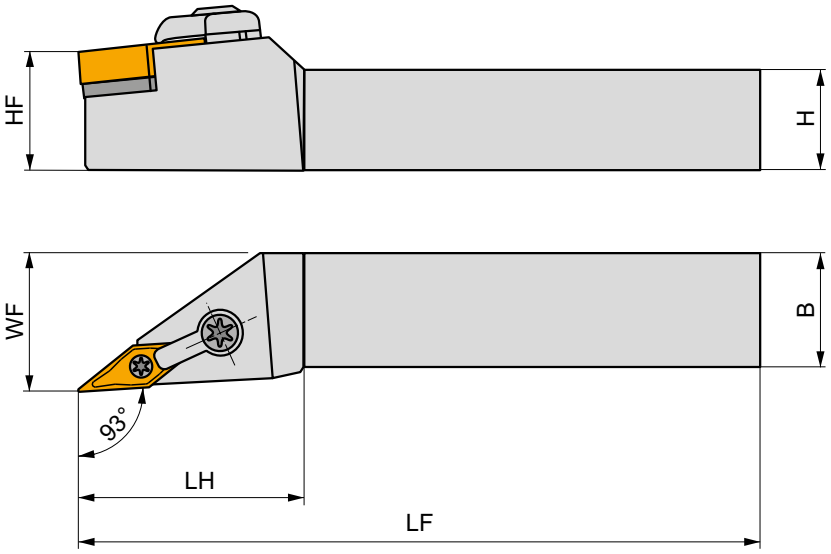
M

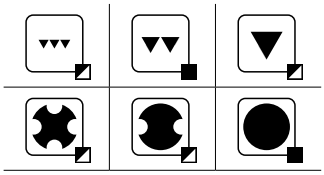


## Ekstern multiklemmeholder med 93 ° skærevinkel til VN .. Skær

kstern højre / venstre drejeholder med flere klemmer med 93 ° skærevinkel. Velegnet til langsgående drejning med skulder, kopidrejning op til 50 °, konisk drejning og affasning med negativ VN .. 16 skær. Fås med skaftstørrelse 20x20 op til 32x25 mm. Krop behandlet for længere værktøjstid.





| | 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 | -4.5 | -13.5 | 0.40 | GI048 | MV2 |
| | **MVJNR 2525 M 16-A** | 25 | 25 | 25 | 32 | 150 | 41 | -4.5 | -13.5 | 0.70 | GI048 | MV2 |
| | **MVJNR 3225 P 16-A** | 32 | 25 | 32 | 32 | 170 | 41 | -4.5 | -13.5 | 0.98 | GI048 | MV2 |
| L | **MVJNL 2020 K 16-A** | 20 | 20 | 20 | 25 | 125 | 41 | -4.5 | -13.5 | 0.40 | GI048 | MV2 |
| | **MVJNL 2525 M 16-A** | 25 | 25 | 25 | 32 | 150 | 41 | -4.5 | -13.5 | 0.70 | GI048 | MV2 |
| | **MVJNL 3225 P 16-A** | 32 | 25 | 32 | 32 | 170 | 41 | -4.5 | -13.5 | 0.96 | GI048 | MV2 |

| | |
|---|---|
| GI048 | VN.. 1604.. |

| | | | | Nm | | Nm | |
|---|---|---|---|---|---|---|---|
| MV2 | UPC 22 | MVN 160316 | UP 0909-T09P | 2.0 | PS 6026-T09P | 2.0 | FLAG T09P |

NEW

# C.-DVJN(RL) EXT

P M K N S H

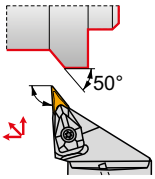
PRAMET

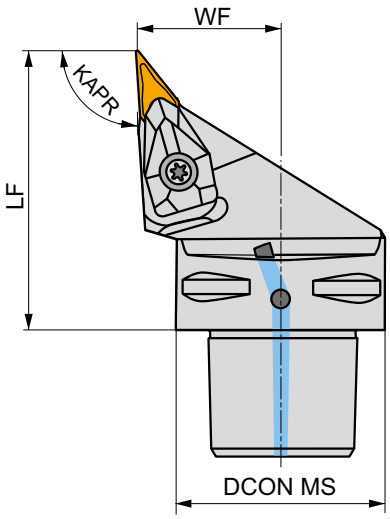
D

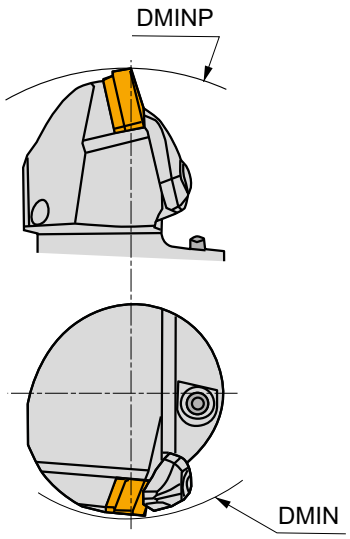


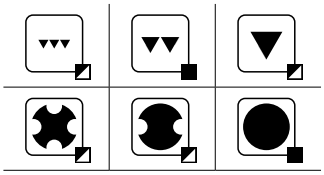
## Eksternt PSC hurtig skift værktøj, dobbelt klemme, 93 ° skærevinkel, VN .. Skær

Eksternt højre / venstre hånd dobbelt klemme værktøj, indvendig kølevæske, med 93° skærevinkel til langsgående drejning med skulder, kopiering og konisk drejning og affasning med negative VN .. 16 størrelse skær. Fås med PSC (Polygon Shank Coupling) C4 op til C6 skaft. Krop behandlet for længere levetid





| | 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 | ✓ | 0.72 | 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

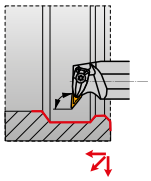
PRAMET

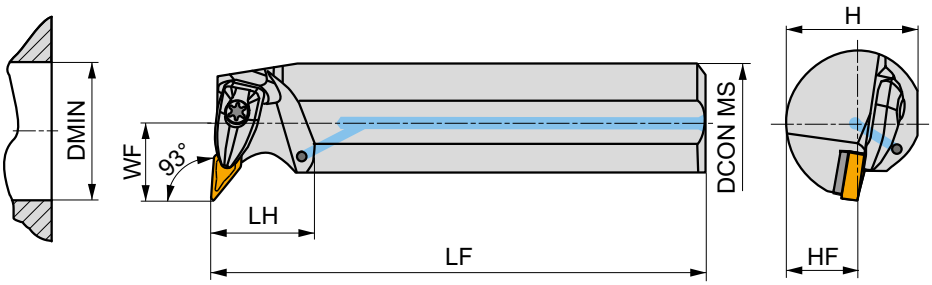
D

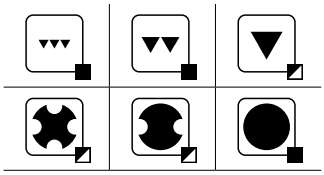


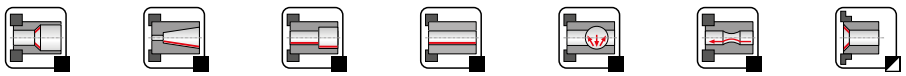
## Intern dobbeltklemmeholder med 93 ° skærevinkel til VN .. Skær

Indvendigt højre / venstre dobbelt klemme borestang, indvendig kølevæske, med 93° skærevinkel til VN .. 16 skær. Mindste indvendige drejediameter Ø50 mm. Velegnet til indvendig tilspidsning, langsgående drejning med skulder, kopiering og affasning. Fås kun med skaftstørrelse Ø40 mm. Krop behandlet for længere levetid på værktøjet.







| | 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 | -9 | -6 | ✓ | 2.59 | GI048 | DV16 |
| L | **A40T-DVUNL 16** | 40 | 50 | 27 | 37 | 18.5 | 300 | 36 | -9 | -6 | ✓ | 2.59 | GI048 | DV16 |

| | |
|---|---|
| GI048 | VN.. 1604.. |

| | | | | | |
|---|---|---|---|---|---|
| DV16 | DCS 16V | 3.0 Nm | DVS 269-01 | US 2009-T15P | FLAG T15P/3,5 |

# WN

06/ 08/ 10/ 13

## CARBIDE INSERTS

**WNMA**



366

**WNMG**



366

**WNMM**



375

## CER AND CBN INSERTS

**WNGA CBN**



376

| MATCH THE RIGHT SIZE (example) | |
|---|---|
| **Insert** | **Tool Holder** |
| WNMA **08**0408 | DWLNL 2020 K **08** |

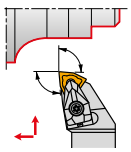
## ISO-DREJNING – UDVENDIGT

**DWLN(RL) EXT**

95°

WN..

06
08
10
13



16×16
40×40

377

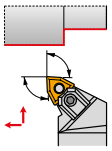
366 – 376

**MWLN(RL) EXT**

95°

WN..

08



25×25
40×40

379

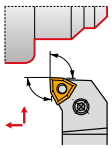
366 – 376

**PWLN(RL) EXT**

95°

WN..

06
08



16×16
32×25

380

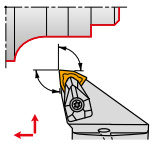
366 – 376

**C.-DWLN(RL) EXT** NEW

95°

WN..

06
08



C4
C6

381

366 – 376

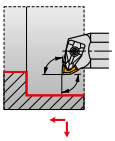
## ISO-DREJNING – INDVENDIG

**DWLN(RL) INT**

95°

WN..

06
08



32
63

382

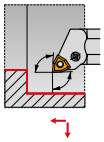
366 – 376

**PWLN(RL) INT**

95°

WN..

06
08



20
80

383

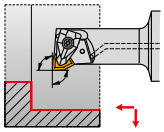
366 – 376

**C.-DWLN(RL) INT** NEW

95°

WN..

06
08



27
33

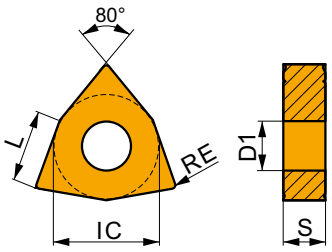
385

366 – 376

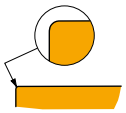
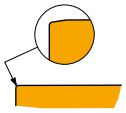
# WNMA

PRAMET

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



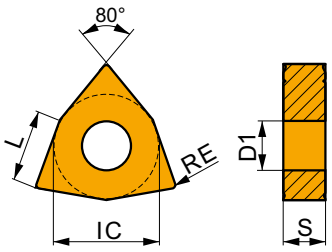

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | E | | | | | | | | | | | | | | | | | |
| | | | Til fin til halv grov bearbejdning og kontinuerlig til let afbrudt snit. | | | | | | | | | | | | | | | | | |
| **WNMA 080404** | **T5305** | 0.4 | – | – | – | – | – | – | 235 | 0.10 | 4.0 | – | – | – | – | – | – | 50 | 0.15 | 1.0 |
| | **T5315** | 0.4 | – | – | – | – | – | – | 200 | 0.10 | 4.0 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| **WNMA 080408** | **T5305** | 0.8 | – | – | – | – | – | – | 220 | 0.20 | 4.0 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |
| | **T5315** | 0.8 | – | – | – | – | – | – | 190 | 0.20 | 4.0 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| | **T6310** | 0.8 | – | – | – | – | – | – | 100 | 0.20 | 4.0 | – | – | – | – | – | – | 25 | 0.15 | 1.0 |
| **WNMA 080412** | **T5305** | 1.2 | – | – | – | – | – | – | 195 | 0.30 | 4.0 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| | **T5315** | 1.2 | – | – | – | – | – | – | 180 | 0.30 | 4.0 | – | – | – | – | – | – | 35 | 0.15 | 1.0 |
| | **T6310** | 1.2 | – | – | – | – | – | – | 95 | 0.30 | 4.0 | – | – | – | – | – | – | 20 | 0.15 | 1.0 |
|  |  | | S | | | | | | | | | | | | | | | | | |
| | | | Til fin til halv grov bearbejdning og kontinuerlig til let afbrudt snit. | | | | | | | | | | | | | | | | | |
| **WNMA 080408S** | **T5305** | 0.8 | – | – | – | – | – | – | 220 | 0.20 | 4.0 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |

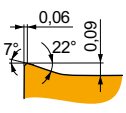
# WNMG

PRAMET

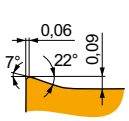
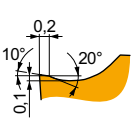
| | IC (mm) | D1 (mm) | L (mm) | S (mm) |
|---|---|---|---|---|
| 0604 | 9.525 | 3.81 | 6.50 | 4.76 |
| 06T3 | 9.525 | 3.81 | 6.50 | 3.97 |
| 0804 | 12.700 | 5.16 | 8.70 | 4.76 |



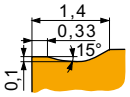

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | U | S | | | | | | | | | | | | | | | | |
| | | | FF-geometri med meget positivt design til finbearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | |
| **WNMG 060402E-FF** | **T8315** | 0.2 | 215 | 0.10 | 1.0 | 125 | 0.09 | 1.0 | 200 | 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 | – | – | – | – | – | – | – | – | – |

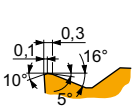
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | FF-geometri med meget positivt design til finbearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | |
| **WNMG 080404E-FF** | **T7325** | 0.4 | 235 | 0.12 | 1.0 | 180 | 0.11 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.4 | 220 | 0.12 | 1.0 | 130 | 0.11 | 1.0 | 205 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| **WNMG 080408E-FF** | **T7325** | 0.8 | 265 | 0.15 | 1.0 | 205 | 0.14 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.8 | 245 | 0.15 | 1.0 | 145 | 0.14 | 1.0 | 230 | 0.15 | 1.0 | – | – | – | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | FM-geometri med positivt design til fin til halvgrov bearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | |
| **WNMG 060404E-FM** | **T7325** | 0.4 | 195 | 0.20 | 1.4 | 150 | 0.18 | 1.4 | – | – | – | – | – | – | 60 | 0.16 | 1.1 | – | – | – |
| | **T8315** | 0.4 | 180 | 0.20 | 1.4 | 105 | 0.18 | 1.4 | 170 | 0.20 | 1.4 | – | – | – | 45 | 0.14 | 1.1 | – | – | – |
| | **T8330** | 0.4 | 175 | 0.20 | 1.4 | 105 | 0.18 | 1.4 | 165 | 0.20 | 1.4 | – | – | – | 40 | 0.14 | 1.1 | – | – | – |
| | **T8430** | 0.4 | 195 | 0.20 | 1.4 | 105 | 0.18 | 1.4 | 160 | 0.20 | 1.4 | – | – | – | 40 | 0.14 | 1.1 | – | – | – |
| | **T9315** | 0.4 | 265 | 0.20 | 1.4 | – | – | – | 250 | 0.20 | 1.4 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 240 | 0.20 | 1.4 | 140 | 0.18 | 1.4 | 225 | 0.20 | 1.4 | – | – | – | 50 | 0.16 | 1.1 | – | – | – |
| | **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 | – | – | – |
| | **T8330** | 0.8 | 205 | 0.20 | 1.4 | 120 | 0.18 | 1.4 | 190 | 0.20 | 1.4 | – | – | – | 50 | 0.14 | 1.1 | – | – | – |
| | **T8430** | 0.8 | 235 | 0.20 | 1.4 | 125 | 0.18 | 1.4 | 190 | 0.20 | 1.4 | – | – | – | 50 | 0.14 | 1.1 | – | – | – |
| | **T9315** | 0.8 | 315 | 0.20 | 1.4 | – | – | – | 295 | 0.20 | 1.4 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 285 | 0.20 | 1.4 | 170 | 0.18 | 1.4 | 270 | 0.20 | 1.4 | – | – | – | 60 | 0.16 | 1.1 | – | – | – |
| **WNMG 060412E-FM** | **T9315** | 1.2 | 300 | 0.27 | 1.2 | – | – | – | 285 | 0.27 | 1.2 | – | – | – | – | – | – | – | – | – |
| **WNMG 06T304E-FM** | **T7325** | 0.4 | 195 | 0.20 | 1.4 | 150 | 0.18 | 1.4 | – | – | – | – | – | – | 60 | 0.16 | 1.1 | – | – | – |
| | **T8330** | 0.4 | 175 | 0.20 | 1.4 | 105 | 0.18 | 1.4 | 165 | 0.20 | 1.4 | – | – | – | 40 | 0.14 | 1.1 | – | – | – |
| | **T8430** | 0.4 | 195 | 0.20 | 1.4 | 105 | 0.18 | 1.4 | 160 | 0.20 | 1.4 | – | – | – | 40 | 0.14 | 1.1 | – | – | – |
| | **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** | **T8330** | 0.8 | 205 | 0.20 | 1.4 | 120 | 0.18 | 1.4 | 190 | 0.20 | 1.4 | – | – | – | 50 | 0.14 | 1.1 | – | – | – |
| | **T8430** | 0.8 | 235 | 0.20 | 1.4 | 125 | 0.18 | 1.4 | 190 | 0.20 | 1.4 | – | – | – | 50 | 0.14 | 1.1 | – | – | – |
| | **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 | – | – | – |
| | **T7335** | 0.4 | 180 | 0.20 | 1.9 | 140 | 0.18 | 1.9 | – | – | – | – | – | – | 55 | 0.16 | 1.5 | – | – | – |
| | **T8315** | 0.4 | 180 | 0.20 | 1.9 | 105 | 0.18 | 1.9 | 170 | 0.20 | 1.9 | – | – | – | 45 | 0.14 | 1.5 | – | – | – |
| | **T8330** | 0.4 | 165 | 0.20 | 1.9 | 95 | 0.18 | 1.9 | 155 | 0.20 | 1.9 | – | – | – | 40 | 0.14 | 1.5 | – | – | – |
| | **T8430** | 0.4 | 190 | 0.20 | 1.9 | 105 | 0.18 | 1.9 | 155 | 0.20 | 1.9 | – | – | – | 40 | 0.14 | 1.5 | – | – | – |
| | **T9310** | 0.4 | 285 | 0.20 | 1.9 | – | – | – | 270 | 0.20 | 1.9 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.4 | 270 | 0.20 | 1.2 | – | – | – | 255 | 0.20 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 245 | 0.20 | 1.2 | 145 | 0.18 | 1.2 | 230 | 0.20 | 1.2 | – | – | – | 55 | 0.16 | 1.0 | – | – | – |
| **WNMG 080408E-FM** | **T7325** | 0.8 | 225 | 0.20 | 1.9 | 175 | 0.18 | 1.9 | – | – | – | – | – | – | 70 | 0.16 | 1.5 | – | – | – |
| | **T7335** | 0.8 | 215 | 0.20 | 1.9 | 165 | 0.18 | 1.9 | – | – | – | – | – | – | 65 | 0.16 | 1.5 | – | – | – |
| | **T8315** | 0.8 | 210 | 0.20 | 1.9 | 125 | 0.18 | 1.9 | 195 | 0.20 | 1.9 | – | – | – | 50 | 0.16 | 1.5 | – | – | – |
| | **T8330** | 0.8 | 195 | 0.20 | 1.9 | 115 | 0.18 | 1.9 | 185 | 0.20 | 1.9 | – | – | – | 45 | 0.16 | 1.5 | – | – | – |
| | **T8430** | 0.8 | 225 | 0.20 | 1.9 | 120 | 0.18 | 1.9 | 185 | 0.20 | 1.9 | – | – | – | 45 | 0.16 | 1.5 | – | – | – |
| | **T9310** | 0.8 | 335 | 0.20 | 1.9 | – | – | – | 315 | 0.20 | 1.9 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.8 | 310 | 0.20 | 1.9 | – | – | – | 290 | 0.20 | 1.9 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 280 | 0.20 | 1.9 | 165 | 0.18 | 1.9 | 265 | 0.20 | 1.9 | – | – | – | 60 | 0.16 | 1.5 | – | – | – |
| **WNMG 080412E-FM** | **T7325** | 1.2 | 220 | 0.27 | 1.9 | 170 | 0.24 | 1.9 | – | – | – | – | – | – | 70 | 0.19 | 1.5 | – | – | – |
| | **T7335** | 1.2 | 205 | 0.27 | 1.9 | 155 | 0.24 | 1.9 | – | – | – | – | – | – | 65 | 0.19 | 1.5 | – | – | – |
| | **T8330** | 1.2 | 190 | 0.27 | 1.9 | 110 | 0.24 | 1.9 | 180 | 0.27 | 1.9 | – | – | – | 45 | 0.19 | 1.5 | – | – | – |
| | **T8430** | 1.2 | 210 | 0.27 | 1.9 | 115 | 0.24 | 1.9 | 175 | 0.27 | 1.9 | – | – | – | 45 | 0.19 | 1.5 | – | – | – |
| | **T9310** | 1.2 | 310 | 0.27 | 1.9 | – | – | – | 290 | 0.27 | 1.9 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 1.2 | 285 | 0.27 | 1.9 | – | – | – | 270 | 0.27 | 1.9 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | 255 | 0.27 | 1.9 | 150 | 0.24 | 1.9 | 240 | 0.27 | 1.9 | – | – | – | 55 | 0.19 | 1.5 | – | – | – |

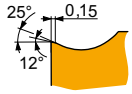
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |  | | | | | | | | | | | | | | | | | | | |

KR-geometri til semi-grov til grov bearbejdning og kontinuerlig til afbrudt snit.

| | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **WNMG 080408E-KR** | **T5305** | 0.8 | 255 | 0.35 | 3.5 | – | – | – | 240 | 0.35 | 3.5 | – | – | – | – | – | – | 50 | 0.15 | 1.0 |
| | **T5315** | 0.8 | 230 | 0.35 | 3.5 | – | – | – | 215 | 0.35 | 3.5 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |
| **WNMG 080412E-KR** | **T5305** | 1.2 | 260 | 0.40 | 3.5 | – | – | – | 245 | 0.40 | 3.5 | – | – | – | – | – | – | 50 | 0.15 | 1.0 |
| | **T5315** | 1.2 | 235 | 0.40 | 3.5 | – | – | – | 220 | 0.40 | 3.5 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |
|  |  | | | | | | | | | | | | | | | | | | | |

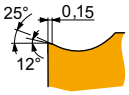
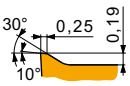
M-geometri til fin til halv grov bearbejdning og kontinuerlig til afbrudt snit.

| | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **WNMG 060404E-M** | **T5315** | 0.4 | 250 | 0.20 | 1.8 | – | – | – | 235 | 0.20 | 1.8 | – | – | – | – | – | – | 50 | 0.15 | 1.0 |
| | **T9315** | 0.4 | 240 | 0.20 | 1.8 | – | – | – | 225 | 0.20 | 1.8 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |
| | **T9325** | 0.4 | 215 | 0.20 | 1.8 | – | – | – | 200 | 0.20 | 1.8 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.4 | 180 | 0.20 | 1.8 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **WNMG 060408E-M** | **T5315** | 0.8 | 255 | 0.32 | 1.8 | – | – | – | 240 | 0.32 | 1.8 | – | – | – | – | – | – | 50 | 0.15 | 1.0 |
| | **T9310** | 0.8 | 250 | 0.32 | 1.8 | – | – | – | 235 | 0.32 | 1.8 | – | – | – | – | – | – | 50 | 0.15 | 1.0 |
| | **T9315** | 0.8 | 230 | 0.32 | 1.8 | – | – | – | 215 | 0.32 | 1.8 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |
| | **T9325** | 0.8 | 205 | 0.32 | 1.8 | – | – | – | 190 | 0.32 | 1.8 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.8 | 180 | 0.32 | 1.8 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **WNMG 080404E-M** | **T5315** | 0.4 | 260 | 0.20 | 1.2 | – | – | – | 245 | 0.20 | 1.2 | – | – | – | – | – | – | 50 | 0.15 | 1.0 |
| | **T9315** | 0.4 | 235 | 0.20 | 2.1 | – | – | – | 220 | 0.20 | 2.1 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |
| | **T9325** | 0.4 | 210 | 0.20 | 2.1 | – | – | – | 195 | 0.20 | 2.1 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.4 | 180 | 0.20 | 2.1 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **WNMG 080408E-M** | **T5305** | 0.8 | 280 | 0.32 | 2.1 | – | – | – | 265 | 0.32 | 2.1 | – | – | – | – | – | – | 55 | 0.15 | 1.0 |
| | **T5315** | 0.8 | 250 | 0.32 | 2.1 | – | – | – | 235 | 0.32 | 2.1 | – | – | – | – | – | – | 50 | 0.15 | 1.0 |
| | **T8330** | 0.8 | 155 | 0.32 | 2.1 | – | – | – | 145 | 0.32 | 2.1 | – | – | – | – | – | – | 30 | 0.15 | 1.0 |
| | **T8430** | 0.8 | 170 | 0.32 | 2.1 | – | – | – | 135 | 0.32 | 2.1 | – | – | – | – | – | – | 25 | 0.15 | 1.0 |
| | **T9310** | 0.8 | 245 | 0.32 | 2.1 | – | – | – | 230 | 0.32 | 2.1 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |
| | **T9315** | 0.8 | 225 | 0.32 | 2.1 | – | – | – | 210 | 0.32 | 2.1 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |
| | **T9325** | 0.8 | 200 | 0.32 | 2.1 | – | – | – | 190 | 0.32 | 2.1 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.8 | 180 | 0.32 | 2.1 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **WNMG 080412E-M** | **T5305** | 1.2 | 275 | 0.40 | 2.1 | – | – | – | 260 | 0.40 | 2.1 | – | – | – | – | – | – | 55 | 0.15 | 1.0 |
| | **T5315** | 1.2 | 245 | 0.40 | 2.1 | – | – | – | 230 | 0.40 | 2.1 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |
| | **T9310** | 1.2 | 235 | 0.40 | 2.1 | – | – | – | 220 | 0.40 | 2.1 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |
| | **T9315** | 1.2 | 220 | 0.40 | 2.1 | – | – | – | 205 | 0.40 | 2.1 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| | **T9325** | 1.2 | 195 | 0.40 | 2.1 | – | – | – | 185 | 0.40 | 2.1 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.2 | 170 | 0.40 | 2.1 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |

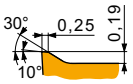
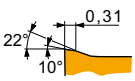
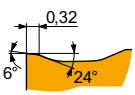
NF-geometri med meget positivt design til finbearbejdning til medium bearbejdning og kontinuerlige snit.

| | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **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 | – | – | – |
| | **T7325** | 0.4 | 215 | 0.18 | 0.8 | 165 | 0.16 | 0.8 | – | – | – | – | – | – | 65 | 0.16 | 0.6 | – | – | – |
| | **T7335** | 0.4 | 210 | 0.18 | 0.8 | 160 | 0.16 | 0.8 | – | – | – | – | – | – | 65 | 0.16 | 0.6 | – | – | – |
| | **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 | – | – | – |
| | **T8330** | 0.4 | 190 | 0.17 | 0.8 | 110 | 0.15 | 0.8 | 180 | 0.17 | 0.8 | 570 | 0.20 | 0.8 | 45 | 0.12 | 0.6 | – | – | – |
| | **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 | – | – | – |
| | **T9315** | 0.4 | 305 | 0.17 | 0.8 | – | – | – | 285 | 0.17 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 265 | 0.18 | 0.8 | 155 | 0.16 | 0.8 | 250 | 0.18 | 0.8 | – | – | – | 55 | 0.16 | 0.6 | – | – | – |
| **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 | – | – | – |
| | **T7325** | 0.8 | 245 | 0.19 | 1.0 | 190 | 0.17 | 1.0 | – | – | – | – | – | – | 75 | 0.15 | 0.8 | – | – | – |
| | **T8330** | 0.8 | 215 | 0.19 | 1.0 | 125 | 0.17 | 1.0 | 200 | 0.19 | 1.0 | 645 | 0.23 | 1.0 | 50 | 0.15 | 0.8 | – | – | – |
| | **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 | – | – | – |
| | **T9315** | 0.8 | 335 | 0.19 | 1.0 | – | – | – | 315 | 0.19 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 300 | 0.19 | 1.0 | 180 | 0.17 | 1.0 | 285 | 0.19 | 1.0 | – | – | – | 65 | 0.15 | 0.8 | – | – | – |

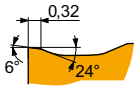
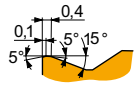
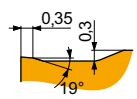
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) | | | | | | | | | | | | | | | | | | |
|  |  | | | | | | | | | | | | | | | | | | | |
| NF-geometri med meget positivt design til finbearbejdning til medium bearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **WNMG 080404E-NF** | **HF7** | 0.4 | – | – | – | 95 | 0.15 | 1.7 | 155 | 0.17 | 1.7 | 495 | 0.20 | 1.7 | – | – | – | – | – | – |
| | **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 | – | – | – |
| | **T7325** | 0.4 | 200 | 0.18 | 1.7 | 155 | 0.16 | 1.7 | – | – | – | – | – | – | 65 | 0.16 | 1.4 | – | – | – |
| | **T7335** | 0.4 | 195 | 0.18 | 1.7 | 150 | 0.16 | 1.7 | – | – | – | – | – | – | 60 | 0.16 | 1.4 | – | – | – |
| | **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 | – | – | – |
| | **T8330** | 0.4 | 180 | 0.17 | 1.7 | 105 | 0.15 | 1.7 | 170 | 0.17 | 1.7 | 540 | 0.20 | 1.7 | 45 | 0.14 | 1.4 | – | – | – |
| | **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 | – | – | – |
| | **T9315** | 0.4 | 285 | 0.17 | 1.7 | – | – | – | 270 | 0.17 | 1.7 | – | – | – | – | – | – | – | – | – |
| | **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 | – | – | – | – | – | – |
| | **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 | – | – | – |
| | **T7325** | 0.8 | 235 | 0.19 | 1.7 | 180 | 0.17 | 1.7 | – | – | – | – | – | – | 75 | 0.15 | 1.4 | – | – | – |
| | **T7335** | 0.8 | 225 | 0.19 | 1.7 | 175 | 0.17 | 1.7 | – | – | – | – | – | – | 70 | 0.15 | 1.4 | – | – | – |
| | **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 | – | – | – |
| | **T8330** | 0.8 | 200 | 0.19 | 1.7 | 120 | 0.17 | 1.7 | 190 | 0.19 | 1.7 | 600 | 0.23 | 1.7 | 50 | 0.15 | 1.4 | – | – | – |
| | **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 | – | – | – |
| | **T9315** | 0.8 | 320 | 0.19 | 1.7 | – | – | – | 300 | 0.19 | 1.7 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 285 | 0.19 | 1.7 | 170 | 0.17 | 1.7 | 270 | 0.19 | 1.7 | – | – | – | 60 | 0.15 | 1.4 | – | – | – |
| **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 | – | – | – |
| | **T7325** | 1.2 | 205 | 0.30 | 2.1 | 155 | 0.27 | 2.1 | – | – | – | – | – | – | 65 | 0.21 | 1.7 | – | – | – |
| | **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 | – | – | – |
| | **T9315** | 1.2 | 275 | 0.30 | 2.1 | – | – | – | 260 | 0.30 | 2.1 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | 245 | 0.30 | 2.1 | 145 | 0.27 | 2.1 | 230 | 0.30 | 2.1 | – | – | – | 55 | 0.21 | 1.7 | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| NM-geometri med meget positivt design til finbearbejdning, mellem og grov bearbejdning i kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **WNMG 060404E-NM** | **T7325** | 0.4 | 200 | 0.20 | 1.8 | 155 | 0.18 | 1.8 | – | – | – | – | – | – | 65 | 0.16 | 1.4 | – | – | – |
| | **T7335** | 0.4 | 195 | 0.20 | 1.8 | 150 | 0.18 | 1.8 | – | – | – | – | – | – | 60 | 0.16 | 1.4 | – | – | – |
| | **T8315** | 0.4 | 185 | 0.20 | 1.8 | 110 | 0.18 | 1.8 | – | – | – | 555 | 0.24 | 1.8 | 45 | 0.16 | 1.4 | – | – | – |
| | **T8330** | 0.4 | 175 | 0.20 | 1.8 | 105 | 0.18 | 1.8 | – | – | – | 525 | 0.24 | 1.8 | 40 | 0.16 | 1.4 | – | – | – |
| | **T8430** | 0.4 | 185 | 0.25 | 1.8 | 100 | 0.23 | 1.8 | – | – | – | 510 | 0.30 | 1.8 | 40 | 0.20 | 1.4 | – | – | – |
| | **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 | – | – | – |
| | **T7335** | 0.8 | 215 | 0.25 | 1.8 | 165 | 0.23 | 1.8 | – | – | – | – | – | – | 65 | 0.20 | 1.4 | – | – | – |
| | **T8315** | 0.8 | 205 | 0.25 | 1.8 | 120 | 0.23 | 1.8 | – | – | – | 615 | 0.30 | 1.8 | 50 | 0.20 | 1.4 | – | – | – |
| | **T8330** | 0.8 | 195 | 0.25 | 1.8 | 115 | 0.23 | 1.8 | – | – | – | 585 | 0.30 | 1.8 | 45 | 0.20 | 1.4 | – | – | – |
| | **T8430** | 0.8 | 220 | 0.25 | 1.8 | 120 | 0.23 | 1.8 | – | – | – | 600 | 0.30 | 1.8 | 45 | 0.20 | 1.4 | – | – | – |
| | **T9315** | 0.8 | 290 | 0.25 | 1.8 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **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 | – | – | – |
| | **T7335** | 1.2 | 220 | 0.30 | 1.2 | 170 | 0.27 | 1.2 | – | – | – | – | – | – | 70 | 0.24 | 1.0 | – | – | – |
| | **T9315** | 1.2 | 285 | 0.30 | 1.8 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **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 | – | – | – |
| | **T7335** | 0.4 | 190 | 0.20 | 2.1 | 145 | 0.18 | 2.1 | – | – | – | – | – | – | 60 | 0.16 | 1.7 | – | – | – |
| | **T8315** | 0.4 | 180 | 0.20 | 2.1 | 105 | 0.18 | 2.1 | – | – | – | 540 | 0.24 | 2.1 | 45 | 0.16 | 1.7 | – | – | – |
| | **T8330** | 0.4 | 170 | 0.20 | 2.1 | 100 | 0.18 | 2.1 | – | – | – | 510 | 0.24 | 2.1 | 40 | 0.16 | 1.7 | – | – | – |
| | **T8430** | 0.4 | 180 | 0.25 | 2.1 | 95 | 0.23 | 2.1 | – | – | – | 495 | 0.30 | 2.1 | 35 | 0.20 | 1.7 | – | – | – |
| | **T9315** | 0.4 | 270 | 0.20 | 2.1 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 240 | 0.20 | 2.1 | 140 | 0.18 | 2.1 | – | – | – | – | – | – | 50 | 0.16 | 1.7 | – | – | – |

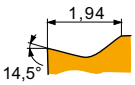
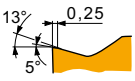
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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-geometri med meget positivt design til finbearbejdning, mellem og grov bearbejdning i kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **WNMG 080408E-NM** | **T7325** | 0.8 | 215 | 0.25 | 2.1 | 165 | 0.23 | 2.1 | – | – | – | – | – | – | 65 | 0.20 | 1.7 | – | – | – |
| | **T7335** | 0.8 | 210 | 0.25 | 2.1 | 160 | 0.23 | 2.1 | – | – | – | – | – | – | 65 | 0.20 | 1.7 | – | – | – |
| | **T8315** | 0.8 | 205 | 0.25 | 2.1 | 120 | 0.23 | 2.1 | – | – | – | 615 | 0.30 | 2.1 | 50 | 0.20 | 1.7 | – | – | – |
| | **T8330** | 0.8 | 195 | 0.25 | 2.1 | 115 | 0.23 | 2.1 | – | – | – | 585 | 0.30 | 2.1 | 45 | 0.20 | 1.7 | – | – | – |
| | **T8430** | 0.8 | 210 | 0.25 | 2.1 | 115 | 0.23 | 2.1 | – | – | – | 585 | 0.30 | 2.1 | 45 | 0.20 | 1.7 | – | – | – |
| | **T9315** | 0.8 | 290 | 0.25 | 2.1 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 260 | 0.25 | 2.1 | 155 | 0.23 | 2.1 | – | – | – | – | – | – | 55 | 0.20 | 1.7 | – | – | – |
| **WNMG 080412E-NM** | **T7325** | 1.2 | 215 | 0.30 | 2.1 | 165 | 0.27 | 2.1 | – | – | – | – | – | – | 65 | 0.24 | 1.7 | – | – | – |
| | **T7335** | 1.2 | 210 | 0.30 | 2.1 | 160 | 0.27 | 2.1 | – | – | – | – | – | – | 65 | 0.24 | 1.7 | – | – | – |
| | **T8315** | 1.2 | 205 | 0.30 | 2.1 | 120 | 0.27 | 2.1 | – | – | – | 615 | 0.36 | 2.1 | 50 | 0.24 | 1.7 | – | – | – |
| | **T9325** | 1.2 | 255 | 0.30 | 2.1 | 150 | 0.27 | 2.1 | – | – | – | – | – | – | 55 | 0.24 | 1.7 | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| NMR-geometri med positivt design til medium til grov bearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **WNMG 060404E-NMR** | **T6310** | 0.4 | 145 | 0.25 | 1.6 | 100 | 0.23 | 1.6 | – | – | – | – | – | – | 40 | 0.20 | 1.3 | – | – | – |
| | **T7325** | 0.4 | 160 | 0.25 | 1.6 | 120 | 0.23 | 1.6 | – | – | – | – | – | – | 50 | 0.20 | 1.3 | – | – | – |
| | **T8430** | 0.4 | 145 | 0.31 | 1.6 | 80 | 0.28 | 1.6 | – | – | – | – | – | – | 30 | 0.25 | 1.3 | – | – | – |
| | **T9325** | 0.4 | 200 | 0.25 | 1.6 | 120 | 0.23 | 1.6 | – | – | – | – | – | – | 45 | 0.20 | 1.3 | – | – | – |
| **WNMG 060408E-NMR** | **T6310** | 0.8 | 155 | 0.35 | 1.6 | 110 | 0.32 | 1.6 | – | – | – | – | – | – | 45 | 0.25 | 1.3 | – | – | – |
| | **T7325** | 0.8 | 175 | 0.35 | 1.6 | 135 | 0.32 | 1.6 | – | – | – | – | – | – | 55 | 0.25 | 1.3 | – | – | – |
| | **T7335** | 0.8 | 170 | 0.35 | 1.6 | 130 | 0.32 | 1.6 | – | – | – | – | – | – | 55 | 0.25 | 1.3 | – | – | – |
| | **T9315** | 0.8 | 225 | 0.35 | 1.6 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **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 | – | – | – |
| | **T7325** | 0.4 | 155 | 0.25 | 2.7 | 120 | 0.23 | 2.7 | – | – | – | – | – | – | 50 | 0.20 | 2.2 | – | – | – |
| | **T7335** | 0.4 | 150 | 0.25 | 2.7 | 115 | 0.23 | 2.7 | – | – | – | – | – | – | 45 | 0.20 | 2.2 | – | – | – |
| | **T8330** | 0.4 | 140 | 0.25 | 2.7 | 80 | 0.23 | 2.7 | – | – | – | – | – | – | 35 | 0.20 | 2.2 | – | – | – |
| | **T8430** | 0.4 | 140 | 0.31 | 2.7 | 75 | 0.28 | 2.7 | – | – | – | – | – | – | 30 | 0.25 | 2.2 | – | – | – |
| | **T9315** | 0.4 | 205 | 0.25 | 2.7 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 185 | 0.25 | 2.7 | 110 | 0.23 | 2.7 | – | – | – | – | – | – | 40 | 0.20 | 2.2 | – | – | – |
| **WNMG 080408E-NMR** | **T6310** | 0.8 | 150 | 0.35 | 2.7 | 105 | 0.32 | 2.7 | – | – | – | – | – | – | 45 | 0.25 | 2.2 | – | – | – |
| | **T7325** | 0.8 | 170 | 0.35 | 2.7 | 130 | 0.32 | 2.7 | – | – | – | – | – | – | 55 | 0.25 | 2.2 | – | – | – |
| | **T7335** | 0.8 | 160 | 0.35 | 2.7 | 120 | 0.32 | 2.7 | – | – | – | – | – | – | 50 | 0.25 | 2.2 | – | – | – |
| | **T8330** | 0.8 | 150 | 0.35 | 2.7 | 90 | 0.32 | 2.7 | – | – | – | – | – | – | 35 | 0.25 | 2.2 | – | – | – |
| | **T8430** | 0.8 | 155 | 0.35 | 2.7 | 85 | 0.32 | 2.7 | – | – | – | – | – | – | 30 | 0.25 | 2.2 | – | – | – |
| | **T9315** | 0.8 | 210 | 0.35 | 2.7 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 190 | 0.35 | 2.7 | 110 | 0.32 | 2.7 | – | – | – | – | – | – | 40 | 0.25 | 2.2 | – | – | – |
| **WNMG 080412E-NMR** | **T6310** | 1.2 | 150 | 0.40 | 2.7 | 105 | 0.36 | 2.7 | – | – | – | – | – | – | 45 | 0.28 | 2.2 | – | – | – |
| | **T7325** | 1.2 | 170 | 0.40 | 2.7 | 130 | 0.36 | 2.7 | – | – | – | – | – | – | 55 | 0.28 | 2.2 | – | – | – |
| | **T7335** | 1.2 | 160 | 0.40 | 2.7 | 120 | 0.36 | 2.7 | – | – | – | – | – | – | 50 | 0.28 | 2.2 | – | – | – |
| | **T8330** | 1.2 | 150 | 0.40 | 2.7 | 90 | 0.36 | 2.7 | – | – | – | – | – | – | 35 | 0.28 | 2.2 | – | – | – |
| | **T8430** | 1.2 | 155 | 0.40 | 2.7 | 85 | 0.36 | 2.7 | – | – | – | – | – | – | 30 | 0.28 | 2.2 | – | – | – |
| | **T9315** | 1.2 | 215 | 0.40 | 2.7 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | 190 | 0.40 | 2.7 | 110 | 0.36 | 2.7 | – | – | – | – | – | – | 40 | 0.28 | 2.2 | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| NRM-geometri med positivt design til halv grov til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **WNMG 080404-NRM** | **T7325** | 0.4 | 155 | 0.25 | 2.7 | 120 | 0.23 | 2.7 | – | – | – | – | – | – | 50 | 0.18 | 2.2 | – | – | – |
| | **T7335** | 0.4 | 150 | 0.25 | 2.7 | 115 | 0.23 | 2.7 | – | – | – | – | – | – | 45 | 0.18 | 2.2 | – | – | – |
| | **T9315** | 0.4 | 205 | 0.25 | 2.7 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **WNMG 080408-NRM** | **T7325** | 0.8 | 170 | 0.35 | 2.7 | 130 | 0.32 | 2.7 | – | – | – | – | – | – | 55 | 0.28 | 2.2 | – | – | – |
| | **T7335** | 0.8 | 160 | 0.35 | 2.7 | 120 | 0.32 | 2.7 | – | – | – | – | – | – | 50 | 0.28 | 2.2 | – | – | – |
| | **T9315** | 0.8 | 210 | 0.35 | 2.7 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |

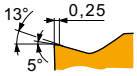
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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-geometri med positivt design til halv grov til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **WNMG 080412-NRM** | **T7325** | 1.2 | 170 | 0.40 | 2.7 | 130 | 0.36 | 2.7 | – | – | – | – | – | – | 55 | 0.28 | 2.2 | – | – | – |
| | **T7335** | 1.2 | 160 | 0.40 | 2.7 | 120 | 0.36 | 2.7 | – | – | – | – | – | – | 50 | 0.28 | 2.2 | – | – | – |
| | **T9315** | 1.2 | 215 | 0.40 | 2.7 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | R-geometri til semi-grov til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **WNMG 080408E-R** | **T5305** | 0.8 | 245 | 0.40 | 3.5 | – | – | – | 230 | 0.40 | 3.5 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |
| | **T5315** | 0.8 | 220 | 0.40 | 3.5 | – | – | – | 205 | 0.40 | 3.5 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| | **T9310** | 0.8 | 210 | 0.40 | 3.5 | – | – | – | 195 | 0.40 | 3.5 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| | **T9315** | 0.8 | 195 | 0.40 | 3.5 | – | – | – | 185 | 0.40 | 3.5 | – | – | – | – | – | – | 35 | 0.15 | 1.0 |
| | **T9325** | 0.8 | 175 | 0.40 | 3.5 | – | – | – | 165 | 0.40 | 3.5 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.8 | 155 | 0.40 | 3.5 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **WNMG 080412E-R** | **T5305** | 1.2 | 250 | 0.45 | 3.5 | – | – | – | 235 | 0.45 | 3.5 | – | – | – | – | – | – | 50 | 0.15 | 1.0 |
| | **T5315** | 1.2 | 225 | 0.45 | 3.5 | – | – | – | 210 | 0.45 | 3.5 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |
| | **T9310** | 1.2 | 215 | 0.45 | 3.5 | – | – | – | 200 | 0.45 | 3.5 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| | **T9315** | 1.2 | 200 | 0.45 | 3.5 | – | – | – | 190 | 0.45 | 3.5 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| | **T9325** | 1.2 | 180 | 0.45 | 3.5 | – | – | – | 170 | 0.45 | 3.5 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.2 | 155 | 0.45 | 3.5 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | RM-geometri til semi-grov til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **WNMG 060412E-RM** | **T9310** | 1.2 | 245 | 0.45 | 3.0 | – | – | – | 230 | 0.45 | 3.0 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 1.2 | 230 | 0.45 | 3.0 | – | – | – | 215 | 0.45 | 3.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | 230 | 0.45 | 1.2 | 135 | 0.41 | 1.2 | 215 | 0.45 | 1.2 | – | – | – | – | – | – | – | – | – |
| **WNMG 080408E-RM** | **T5305** | 0.8 | 275 | 0.40 | 4.0 | – | – | – | 260 | 0.40 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T5315** | 0.8 | 250 | 0.40 | 4.0 | – | – | – | 235 | 0.40 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 0.8 | 180 | 0.40 | 4.0 | 140 | 0.36 | 4.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 0.8 | 165 | 0.40 | 4.0 | 125 | 0.36 | 4.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.8 | 165 | 0.40 | 4.0 | 95 | 0.36 | 4.0 | 155 | 0.40 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.8 | 155 | 0.40 | 4.0 | 90 | 0.36 | 4.0 | 145 | 0.40 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.8 | 165 | 0.40 | 4.0 | 90 | 0.36 | 4.0 | 135 | 0.40 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T9310** | 0.8 | 240 | 0.40 | 4.0 | – | – | – | 225 | 0.40 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.8 | 220 | 0.40 | 4.0 | – | – | – | 205 | 0.40 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 200 | 0.40 | 4.0 | 120 | 0.36 | 4.0 | 190 | 0.40 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.8 | 170 | 0.40 | 4.0 | 100 | 0.36 | 4.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| **WNMG 080412E-RM** | **T5305** | 1.2 | 280 | 0.45 | 4.0 | – | – | – | 265 | 0.45 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T5315** | 1.2 | 250 | 0.45 | 4.0 | – | – | – | 235 | 0.45 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 1.2 | 180 | 0.45 | 4.0 | 140 | 0.41 | 4.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 1.2 | 170 | 0.45 | 4.0 | 130 | 0.41 | 4.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 1.2 | 170 | 0.45 | 4.0 | 100 | 0.41 | 4.0 | 160 | 0.45 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T9310** | 1.2 | 240 | 0.45 | 4.0 | – | – | – | 225 | 0.45 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 1.2 | 220 | 0.45 | 4.0 | – | – | – | 205 | 0.45 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | 200 | 0.45 | 4.0 | 120 | 0.41 | 4.0 | 190 | 0.45 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.2 | 175 | 0.45 | 4.0 | 105 | 0.41 | 4.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| **WNMG 080416E-RM** | **T5305** | 1.6 | 280 | 0.50 | 4.0 | – | – | – | 265 | 0.50 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T5315** | 1.6 | 255 | 0.50 | 4.0 | – | – | – | 240 | 0.50 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T7335** | 1.6 | 175 | 0.50 | 4.0 | 135 | 0.45 | 4.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8430** | 1.6 | 170 | 0.50 | 4.0 | 90 | 0.45 | 4.0 | 135 | 0.50 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T9310** | 1.6 | 240 | 0.50 | 4.0 | – | – | – | 225 | 0.50 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 1.6 | 220 | 0.50 | 4.0 | – | – | – | 205 | 0.50 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.6 | 205 | 0.50 | 4.0 | 120 | 0.45 | 4.0 | 190 | 0.50 | 4.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.6 | 175 | 0.50 | 4.0 | 105 | 0.45 | 4.0 | – | – | – | – | – | – | – | – | – | – | – | – |

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |   | | | | | | | | | | | | | | | | | | | |
| | | | SF-geometri med positivt design til finbearbejdning og til bearbejdning af tynde vægge med kontinuerlige snit. | | | | | | | | | | | | | | | | | |
| **WNMG 060404E-SF** | **H07** | 0.4 | – | – | – | 90 | 0.14 | 1.0 | 145 | 0.15 | 1.0 | 470 | 0.18 | 1.0 | 45 | 0.12 | 0.8 | – | – | – |
| | **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 | 0.15 | 1.0 |
| | **T7325** | 0.4 | 205 | 0.17 | 1.0 | 155 | 0.15 | 1.0 | – | – | – | – | – | – | 65 | 0.15 | 0.8 | – | – | – |
| | **T7335** | 0.4 | 200 | 0.17 | 1.0 | 155 | 0.15 | 1.0 | – | – | – | – | – | – | 65 | 0.15 | 0.8 | – | – | – |
| | **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 | 0.15 | 1.0 |
| | **T8330** | 0.4 | 180 | 0.15 | 1.0 | 105 | 0.14 | 1.0 | 170 | 0.15 | 1.0 | 540 | 0.18 | 1.0 | 45 | 0.12 | 0.8 | 35 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| | **T9325** | 0.4 | 255 | 0.17 | 1.0 | 150 | 0.15 | 1.0 | 240 | 0.17 | 1.0 | – | – | – | 55 | 0.15 | 0.8 | – | – | – |
| **WNMG 060408E-SF** | **H07** | 0.8 | – | – | – | 95 | 0.18 | 1.0 | 155 | 0.20 | 1.0 | 495 | 0.24 | 1.0 | 50 | 0.14 | 0.8 | – | – | – |
| | **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 | 0.15 | 1.0 |
| | **T7335** | 0.8 | 220 | 0.20 | 1.0 | 170 | 0.18 | 1.0 | – | – | – | – | – | – | 70 | 0.16 | 0.8 | – | – | – |
| | **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 | 0.15 | 1.0 |
| | **T8330** | 0.8 | 200 | 0.20 | 1.0 | 120 | 0.18 | 1.0 | 190 | 0.20 | 1.0 | 600 | 0.24 | 1.0 | 50 | 0.14 | 0.8 | 40 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| | **T9315** | 0.8 | 315 | 0.20 | 1.0 | – | – | – | 295 | 0.20 | 1.0 | – | – | – | – | – | – | 60 | 0.15 | 1.0 |
| | **T9325** | 0.8 | 280 | 0.20 | 1.0 | 165 | 0.18 | 1.0 | 265 | 0.20 | 1.0 | – | – | – | 60 | 0.16 | 0.8 | – | – | – |
| **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 | – | – | – |
| | **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 | 0.15 | 1.0 |
| | **T7325** | 0.4 | 205 | 0.17 | 1.0 | 155 | 0.15 | 1.0 | – | – | – | – | – | – | 65 | 0.15 | 0.8 | – | – | – |
| | **T7335** | 0.4 | 200 | 0.17 | 1.0 | 155 | 0.15 | 1.0 | – | – | – | – | – | – | 65 | 0.15 | 0.8 | – | – | – |
| | **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 | 0.15 | 1.0 |
| | **T8330** | 0.4 | 180 | 0.15 | 1.0 | 105 | 0.14 | 1.0 | 170 | 0.15 | 1.0 | 540 | 0.18 | 1.0 | 45 | 0.12 | 0.8 | 35 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| | **T9315** | 0.4 | 300 | 0.15 | 1.0 | – | – | – | 285 | 0.15 | 1.0 | – | – | – | – | – | – | 60 | 0.15 | 1.0 |
| | **T9325** | 0.4 | 255 | 0.17 | 1.0 | 150 | 0.15 | 1.0 | 240 | 0.17 | 1.0 | – | – | – | 55 | 0.15 | 0.8 | – | – | – |
| **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 | – | – | – |
| | **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 | 0.15 | 1.0 |
| | **T7325** | 0.8 | 230 | 0.20 | 1.0 | 175 | 0.18 | 1.0 | – | – | – | – | – | – | 70 | 0.16 | 0.8 | – | – | – |
| | **T7335** | 0.8 | 220 | 0.20 | 1.0 | 170 | 0.18 | 1.0 | – | – | – | – | – | – | 70 | 0.16 | 0.8 | – | – | – |
| | **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 | 0.15 | 1.0 |
| | **T8330** | 0.8 | 200 | 0.20 | 1.0 | 120 | 0.18 | 1.0 | 190 | 0.20 | 1.0 | 600 | 0.24 | 1.0 | 50 | 0.14 | 0.8 | 40 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| | **T9315** | 0.8 | 315 | 0.20 | 1.0 | – | – | – | 295 | 0.20 | 1.0 | – | – | – | – | – | – | 60 | 0.15 | 1.0 |
| | **T9325** | 0.8 | 280 | 0.20 | 1.0 | 165 | 0.18 | 1.0 | 265 | 0.20 | 1.0 | – | – | – | 60 | 0.16 | 0.8 | – | – | – |
| **WNMG 080412E-SF** | **T7325** | 1.2 | 220 | 0.25 | 1.5 | 170 | 0.23 | 1.5 | – | – | – | – | – | – | 70 | 0.18 | 1.2 | – | – | – |
|  |   | | | | | | | | | | | | | | | | | | | |
| | | | SM-geometri med positivt design til medium bearbejdning og kontinuerlige til afbrudte snit. | | | | | | | | | | | | | | | | | |
| **WNMG 060404E-SM** | **T7325** | 0.4 | 180 | 0.22 | 1.7 | 140 | 0.20 | 1.7 | – | – | – | – | – | – | 55 | 0.20 | 1.4 | – | – | – |
| | **T7335** | 0.4 | 175 | 0.22 | 1.7 | 135 | 0.20 | 1.7 | – | – | – | – | – | – | 55 | 0.20 | 1.4 | – | – | – |
| | **T8330** | 0.4 | 155 | 0.22 | 1.7 | 90 | 0.20 | 1.7 | 145 | 0.22 | 1.7 | 465 | 0.26 | 1.7 | 35 | 0.20 | 1.4 | 30 | 0.15 | 1.0 |
| | **T8430** | 0.4 | 175 | 0.22 | 1.7 | 95 | 0.20 | 1.7 | 140 | 0.22 | 1.7 | 480 | 0.26 | 1.7 | 35 | 0.20 | 1.4 | 30 | 0.15 | 1.0 |
| | **T9315** | 0.4 | 250 | 0.20 | 1.7 | – | – | – | 235 | 0.20 | 1.7 | – | – | – | – | – | – | 50 | 0.15 | 1.0 |
| | **T9325** | 0.4 | 215 | 0.22 | 1.7 | 125 | 0.20 | 1.7 | 200 | 0.22 | 1.7 | – | – | – | 45 | 0.20 | 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 | 0.15 | 1.0 |
| | **T7325** | 0.8 | 200 | 0.25 | 1.7 | 155 | 0.23 | 1.7 | – | – | – | – | – | – | 65 | 0.20 | 1.4 | – | – | – |
| | **T7335** | 0.8 | 195 | 0.25 | 1.7 | 150 | 0.23 | 1.7 | – | – | – | – | – | – | 60 | 0.20 | 1.4 | – | – | – |
| | **T8330** | 0.8 | 175 | 0.25 | 1.7 | 105 | 0.23 | 1.7 | 165 | 0.25 | 1.7 | 525 | 0.30 | 1.7 | 40 | 0.20 | 1.4 | 35 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| | **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 | – | – | – |
| | **T8330** | 1.2 | 180 | 0.30 | 1.7 | 105 | 0.27 | 1.7 | 170 | 0.30 | 1.7 | 540 | 0.36 | 1.7 | 45 | 0.24 | 1.4 | 35 | 0.15 | 1.0 |
| | **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 |
| | **T9325** | 1.2 | 240 | 0.30 | 1.7 | 140 | 0.27 | 1.7 | 225 | 0.30 | 1.7 | – | – | – | 50 | 0.24 | 1.4 | – | – | – |

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

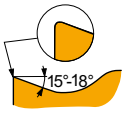
| Product | | RE | P | | | M | | | K | | | N | | | S | | | H | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | vc (m/min) | f (mm/rev) | ap (mm) | vc (m/min) | f (mm/rev) | ap (mm) | vc (m/min) | f (mm/rev) | ap (mm) | vc (m/min) | f (mm/rev) | ap (mm)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



SM-geometri med positivt design til medium bearbejdning og kontinuerlige til afbrudte snit.

| | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **WNMG 080404E-SM** | **T6310** | 0.4 | 155 | 0.22 | 2.0 | 110 | 0.20 | 2.0 | 125 | 0.22 | 2.0 | 465 | 0.26 | 2.0 | 45 | 0.20 | 1.6 | 30 | 0.15 | 1.0 |
| | **T7325** | 0.4 | 175 | 0.22 | 2.0 | 135 | 0.20 | 2.0 | – | – | – | – | – | – | 55 | 0.20 | 1.6 | – | – | – |
| | **T7335** | 0.4 | 170 | 0.22 | 2.0 | 130 | 0.20 | 2.0 | – | – | – | – | – | – | 55 | 0.20 | 1.6 | – | – | – |
| | **T8330** | 0.4 | 155 | 0.22 | 2.0 | 90 | 0.20 | 2.0 | 145 | 0.22 | 2.0 | 465 | 0.26 | 2.0 | 35 | 0.20 | 1.6 | 30 | 0.15 | 1.0 |
| | **T8430** | 0.4 | 170 | 0.22 | 2.0 | 90 | 0.20 | 2.0 | 135 | 0.22 | 2.0 | 465 | 0.26 | 2.0 | 35 | 0.20 | 1.6 | 25 | 0.15 | 1.0 |
| | **T9315** | 0.4 | 245 | 0.20 | 2.0 | – | – | – | 230 | 0.20 | 2.0 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |
| | **T9325** | 0.4 | 210 | 0.22 | 2.0 | 125 | 0.20 | 2.0 | 195 | 0.22 | 2.0 | – | – | – | 45 | 0.20 | 1.6 | – | – | – |
| **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 | 0.15 | 1.0 |
| | **T7325** | 0.8 | 200 | 0.25 | 2.0 | 155 | 0.23 | 2.0 | – | – | – | – | – | – | 65 | 0.20 | 1.6 | – | – | – |
| | **T7335** | 0.8 | 190 | 0.25 | 2.0 | 145 | 0.23 | 2.0 | – | – | – | – | – | – | 60 | 0.20 | 1.6 | – | – | – |
| | **T8330** | 0.8 | 175 | 0.25 | 2.0 | 105 | 0.23 | 2.0 | 165 | 0.25 | 2.0 | 525 | 0.30 | 2.0 | 40 | 0.20 | 1.6 | 35 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| | **T9315** | 0.8 | 265 | 0.25 | 2.0 | – | – | – | 250 | 0.25 | 2.0 | – | – | – | – | – | – | 50 | 0.15 | 1.0 |
| | **T9325** | 0.8 | 235 | 0.25 | 2.0 | 140 | 0.23 | 2.0 | 220 | 0.25 | 2.0 | – | – | – | 50 | 0.20 | 1.6 | – | – | – |
| **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 |
| | **T7325** | 1.2 | 195 | 0.30 | 2.0 | 150 | 0.27 | 2.0 | – | – | – | – | – | – | 60 | 0.24 | 1.6 | – | – | – |
| | **T7335** | 1.2 | 190 | 0.30 | 2.0 | 145 | 0.27 | 2.0 | – | – | – | – | – | – | 60 | 0.24 | 1.6 | – | – | – |
| | **T8330** | 1.2 | 175 | 0.30 | 2.0 | 105 | 0.27 | 2.0 | 165 | 0.30 | 2.0 | 525 | 0.36 | 2.0 | 40 | 0.24 | 1.6 | 35 | 0.15 | 1.0 |
| | **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 |
| | **T9315** | 1.2 | 260 | 0.30 | 2.0 | – | – | – | 245 | 0.30 | 2.0 | – | – | – | – | – | – | 50 | 0.15 | 1.0 |
| | **T9325** | 1.2 | 235 | 0.30 | 2.0 | 140 | 0.27 | 2.0 | 220 | 0.30 | 2.0 | – | – | – | 50 | 0.24 | 1.6 | – | – | – |



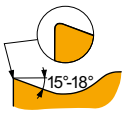




ER-SI geometri med positiv højrehåndet geometri til fin og halv grov bearbejdning og kontinuerlige snit.

| | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **WNMG 060404ER-SI** | **T8330** | 0.4 | 195 | 0.20 | 1.7 | 115 | 0.18 | 1.7 | – | – | – | 585 | 0.24 | 1.7 | 45 | 0.18 | 1.4 | – | – | – |
| | **T8430** | 0.4 | 225 | 0.20 | 1.7 | 120 | 0.18 | 1.7 | – | – | – | 615 | 0.24 | 1.7 | 45 | 0.18 | 1.4 | – | – | – |
| | **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 | – | – | – |
| | **T7335** | 0.4 | 215 | 0.20 | 1.7 | 165 | 0.18 | 1.7 | – | – | – | – | – | – | 65 | 0.18 | 1.4 | – | – | – |
| | **T8315** | 0.4 | 205 | 0.20 | 1.7 | 120 | 0.18 | 1.7 | – | – | – | 615 | 0.24 | 1.7 | 50 | 0.18 | 1.4 | – | – | – |
| | **T8330** | 0.4 | 195 | 0.20 | 1.7 | 115 | 0.18 | 1.7 | – | – | – | 585 | 0.24 | 1.7 | 45 | 0.18 | 1.4 | – | – | – |
| | **T8430** | 0.4 | 225 | 0.20 | 1.7 | 120 | 0.18 | 1.7 | – | – | – | 615 | 0.24 | 1.7 | 45 | 0.18 | 1.4 | – | – | – |
| | **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 | – | – | – |
| | **T7335** | 0.8 | 205 | 0.35 | 1.7 | 155 | 0.32 | 1.7 | – | – | – | – | – | – | 65 | 0.25 | 1.4 | – | – | – |
| | **T8315** | 0.8 | 205 | 0.35 | 1.7 | 120 | 0.32 | 1.7 | – | – | – | 615 | 0.42 | 1.7 | 50 | 0.25 | 1.4 | – | – | – |
| | **T8330** | 0.8 | 195 | 0.35 | 1.7 | 115 | 0.32 | 1.7 | – | – | – | 585 | 0.42 | 1.7 | 45 | 0.25 | 1.4 | – | – | – |
| | **T8430** | 0.8 | 210 | 0.35 | 1.7 | 115 | 0.32 | 1.7 | – | – | – | 585 | 0.42 | 1.7 | 45 | 0.25 | 1.4 | – | – | – |
| | **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 | – | – | – |
| | **T9325** | 1.2 | 265 | 0.35 | 1.7 | 155 | 0.32 | 1.7 | – | – | – | – | – | – | 55 | 0.25 | 1.4 | – | – | – |



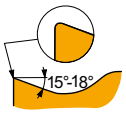
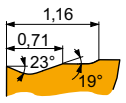
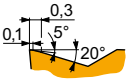
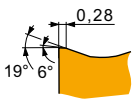
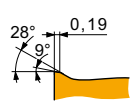




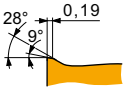
EL-SI geometri med positivt venstrehåndet design til finbearbejdning til halv grov bearbejdning og kontinuerlige snit.

| | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **WNMG 060404EL-SI** | **T8330** | 0.4 | 195 | 0.20 | 1.7 | 115 | 0.18 | 1.7 | – | – | – | 585 | 0.24 | 1.7 | 45 | 0.18 | 1.4 | – | – | – |
| | **T8430** | 0.4 | 225 | 0.20 | 1.7 | 120 | 0.18 | 1.7 | – | – | – | 615 | 0.24 | 1.7 | 45 | 0.18 | 1.4 | – | – | – |
| | **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 | – | – | – |
| | **T7335** | 0.4 | 215 | 0.20 | 1.7 | 165 | 0.18 | 1.7 | – | – | – | – | – | – | 65 | 0.18 | 1.4 | – | – | – |
| | **T8315** | 0.4 | 205 | 0.20 | 1.7 | 120 | 0.18 | 1.7 | – | – | – | 615 | 0.24 | 1.7 | 50 | 0.18 | 1.4 | – | – | – |
| | **T8330** | 0.4 | 195 | 0.20 | 1.7 | 115 | 0.18 | 1.7 | – | – | – | 585 | 0.24 | 1.7 | 45 | 0.18 | 1.4 | – | – | – |
| | **T8430** | 0.4 | 225 | 0.20 | 1.7 | 120 | 0.18 | 1.7 | – | – | – | 615 | 0.24 | 1.7 | 45 | 0.18 | 1.4 | – | – | – |
| | **T9325** | 0.4 | 270 | 0.20 | 1.7 | 160 | 0.18 | 1.7 | – | – | – | – | – | – | 60 | 0.18 | 1.4 | – | – | – |

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | E | | | | | | | | | | | | | | | | | |
| EL-SI geometri med positivt venstrehåndet design til finbearbejdning til halv grov bearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **WNMG 080408EL-SI** | **T7325** | 0.8 | 215 | 0.35 | 1.7 | 165 | 0.32 | 1.7 | – | – | – | – | – | – | 65 | 0.25 | 1.4 | – | – | – |
| | **T7335** | 0.8 | 205 | 0.35 | 1.7 | 155 | 0.32 | 1.7 | – | – | – | – | – | – | 65 | 0.25 | 1.4 | – | – | – |
| | **T8315** | 0.8 | 205 | 0.35 | 1.7 | 120 | 0.32 | 1.7 | – | – | – | 615 | 0.42 | 1.7 | 50 | 0.25 | 1.4 | – | – | – |
| | **T8330** | 0.8 | 195 | 0.35 | 1.7 | 115 | 0.32 | 1.7 | – | – | – | 585 | 0.42 | 1.7 | 45 | 0.25 | 1.4 | – | – | – |
| | **T8430** | 0.8 | 210 | 0.35 | 1.7 | 115 | 0.32 | 1.7 | – | – | – | 585 | 0.42 | 1.7 | 45 | 0.25 | 1.4 | – | – | – |
| | **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 | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | W | E | | | | | | | | | | | | | | | | |
| W-F wiper geometri til finbearbejdning med øget tilspænding og forbedret overfladefinish. | | | | | | | | | | | | | | | | | | | | |
| **WNMG 060408W-F** | **T9315** | 0.8 | 215 | 0.45 | 0.8 | – | – | – | 200 | 0.45 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 190 | 0.45 | 0.8 | – | – | – | 180 | 0.45 | 0.8 | – | – | – | – | – | – | – | – | – |
| **WNMG 080404W-F** | **T9315** | 0.4 | 250 | 0.25 | 0.4 | – | – | – | 235 | 0.25 | 0.4 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 225 | 0.25 | 0.4 | – | – | – | 210 | 0.25 | 0.4 | – | – | – | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | W | S | | | | | | | | | | | | | | | | |
| W-M wiper geometri til halv grov til hård bearbejdning med øget tilspænding og forbedret overfladefinish. | | | | | | | | | | | | | | | | | | | | |
| **WNMG 060408W-M** | **T9310** | 0.8 | 220 | 0.45 | 1.2 | – | – | – | 205 | 0.45 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.8 | 205 | 0.45 | 1.2 | – | – | – | 190 | 0.45 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 190 | 0.45 | 1.2 | – | – | – | 180 | 0.45 | 1.2 | – | – | – | – | – | – | – | – | – |
| **WNMG 060412W-M** | **T5315** | 1.2 | 235 | 0.55 | 1.2 | – | – | – | 220 | 0.55 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 1.2 | 205 | 0.55 | 1.2 | – | – | – | 190 | 0.55 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | 180 | 0.55 | 1.2 | – | – | – | 170 | 0.55 | 1.2 | – | – | – | – | – | – | – | – | – |
| **WNMG 080408W-M** | **T9315** | 0.8 | 200 | 0.45 | 1.5 | – | – | – | 190 | 0.45 | 1.5 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 185 | 0.45 | 1.5 | – | – | – | 175 | 0.45 | 1.5 | – | – | – | – | – | – | – | – | – |
| **WNMG 080412W-M** | **T9325** | 1.2 | 180 | 0.55 | 1.5 | – | – | – | 170 | 0.55 | 1.5 | – | – | – | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | W | S | | | | | | | | | | | | | | | | |
| W-MR wiper geometri til halv grov til hård bearbejdning med øget tilspænding og forbedret overfladefinish. | | | | | | | | | | | | | | | | | | | | |
| **WNMG 060408W-MR** | **T9315** | 0.8 | 205 | 0.45 | 1.2 | – | – | – | 190 | 0.45 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 190 | 0.45 | 1.2 | 110 | 0.41 | 1.2 | 180 | 0.45 | 1.2 | – | – | – | – | – | – | – | – | – |
| **WNMG 080404W-MR** | **T9315** | 0.4 | 200 | 0.30 | 1.5 | – | – | – | 190 | 0.30 | 1.5 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 180 | 0.30 | 1.5 | 105 | 0.27 | 1.5 | 170 | 0.30 | 1.5 | – | – | – | – | – | – | – | – | – |
| **WNMG 080408W-MR** | **T5315** | 0.8 | 230 | 0.45 | 1.5 | – | – | – | 215 | 0.45 | 1.5 | – | – | – | – | – | – | – | – | – |
| | **T9310** | 0.8 | 215 | 0.45 | 1.5 | – | – | – | 200 | 0.45 | 1.5 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.8 | 200 | 0.45 | 1.5 | – | – | – | 190 | 0.45 | 1.5 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 185 | 0.45 | 1.5 | 110 | 0.41 | 1.5 | 175 | 0.45 | 1.5 | – | – | – | – | – | – | – | – | – |
| **WNMG 080412W-MR** | **T5315** | 1.2 | 230 | 0.55 | 1.5 | – | – | – | 215 | 0.55 | 1.5 | – | – | – | – | – | – | – | – | – |
| | **T9310** | 1.2 | 210 | 0.55 | 1.5 | – | – | – | 195 | 0.55 | 1.5 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 1.2 | 200 | 0.55 | 1.5 | – | – | – | 190 | 0.55 | 1.5 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | 180 | 0.55 | 1.5 | 105 | 0.50 | 1.5 | 170 | 0.55 | 1.5 | – | – | – | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | W | S | | | | | | | | | | | | | | | | |
| W-NM wiper geometri til halv grov til hård bearbejdning med øget tilspænding og forbedret overfladefinish. | | | | | | | | | | | | | | | | | | | | |
| **WNMG 060408W-NM** | **T7325** | 0.8 | 220 | 0.25 | 1.8 | 170 | 0.23 | 1.8 | – | – | – | – | – | – | 70 | 0.20 | 1.4 | – | – | – |
| | **T7335** | 0.8 | 215 | 0.25 | 1.8 | 165 | 0.23 | 1.8 | – | – | – | – | – | – | 65 | 0.20 | 1.4 | – | – | – |
| | **T9315** | 0.8 | 290 | 0.25 | 1.8 | – | – | – | 275 | 0.25 | 1.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 265 | 0.25 | 1.8 | 155 | 0.23 | 1.8 | 250 | 0.25 | 1.8 | – | – | – | 55 | 0.20 | 1.4 | – | – | – |

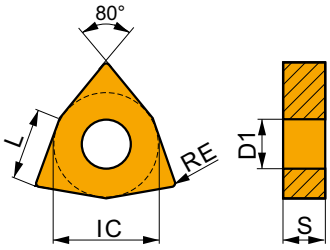
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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-NM wiper geometri til halv grov til hård bearbejdning med øget tilspænding og forbedret overfladefinish. | | | | | | | | | | | | | | | | | | | | |
| **WNMG 080404W-NM** | **T7325** | 0.4 | 195 | 0.20 | 2.1 | 150 | 0.18 | 2.1 | – | – | – | – | – | – | 60 | 0.16 | 1.7 | – | – | – |
| | **T7335** | 0.4 | 190 | 0.20 | 2.1 | 145 | 0.18 | 2.1 | – | – | – | – | – | – | 60 | 0.16 | 1.7 | – | – | – |
| | **T9315** | 0.4 | 270 | 0.20 | 2.1 | – | – | – | 255 | 0.20 | 2.1 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 240 | 0.20 | 2.1 | 140 | 0.18 | 2.1 | 225 | 0.20 | 2.1 | – | – | – | 50 | 0.16 | 1.7 | – | – | – |
| **WNMG 080408W-NM** | **T7325** | 0.8 | 215 | 0.25 | 2.1 | 165 | 0.23 | 2.1 | – | – | – | – | – | – | 65 | 0.20 | 1.7 | – | – | – |
| | **T7335** | 0.8 | 210 | 0.25 | 2.1 | 160 | 0.23 | 2.1 | – | – | – | – | – | – | 65 | 0.20 | 1.7 | – | – | – |
| | **T9315** | 0.8 | 290 | 0.25 | 2.1 | – | – | – | 275 | 0.25 | 2.1 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 260 | 0.25 | 2.1 | 155 | 0.23 | 2.1 | 245 | 0.25 | 2.1 | – | – | – | 55 | 0.20 | 1.7 | – | – | – |
| **WNMG 080412W-NM** | **T7325** | 1.2 | 215 | 0.30 | 2.1 | 165 | 0.27 | 2.1 | – | – | – | – | – | – | 65 | 0.24 | 1.7 | – | – | – |
| | **T7335** | 1.2 | 210 | 0.30 | 2.1 | 160 | 0.27 | 2.1 | – | – | – | – | – | – | 65 | 0.24 | 1.7 | – | – | – |
| | **T9315** | 1.2 | 285 | 0.30 | 2.1 | – | – | – | 270 | 0.30 | 2.1 | – | – | – | – | – | – | – | – | – |

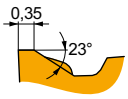
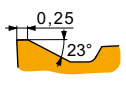
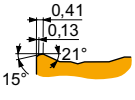
# WNMM

PRAMET

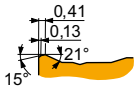
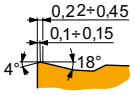
| | IC (mm) | D1 (mm) | L (mm) | S (mm) |
|---|---|---|---|---|
| 0804 | 12.700 | 5.16 | 8.70 | 4.76 |
| 1006 | 15.875 | 6.35 | 10.80 | 6.35 |
| 1306 | 19.050 | 7.94 | 13.00 | 6.35 |




Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | |  | | | | | | | | | | | | | | | | | |
| DR-geometri til hård til ekstra hård bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **WNMM 100608E-DR** | **T9325** | 0.8 | 205 | 0.40 | 5.0 | 120 | 0.36 | 5.0 | 190 | 0.40 | 5.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.8 | 175 | 0.40 | 5.0 | 105 | 0.36 | 5.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| **WNMM 130612E-DR** | **T9325** | 1.2 | 200 | 0.45 | 6.0 | 120 | 0.41 | 6.0 | 190 | 0.45 | 6.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 1.2 | 170 | 0.45 | 6.0 | 100 | 0.41 | 6.0 | – | – | – | – | – | – | – | – | – | – | – | – |
|  |  | |  | | | | | | | | | | | | | | | | | |
| NR-geometri til semi-ru til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **WNMM 080408E-NR** | **T7325** | 0.8 | 175 | 0.40 | 3.0 | 135 | 0.36 | 3.0 | – | – | – | – | – | – | 55 | 0.28 | 2.4 | – | – | – |
| | **T8330** | 0.8 | 155 | 0.40 | 3.0 | 90 | 0.36 | 3.0 | 145 | 0.40 | 3.0 | – | – | – | 35 | 0.28 | 2.4 | – | – | – |
| | **T8430** | 0.8 | 165 | 0.40 | 3.0 | 90 | 0.36 | 3.0 | 135 | 0.40 | 3.0 | – | – | – | 35 | 0.28 | 2.4 | – | – | – |
| | **T9325** | 0.8 | 195 | 0.40 | 3.0 | 115 | 0.36 | 3.0 | 185 | 0.40 | 3.0 | – | – | – | 40 | 0.28 | 2.4 | – | – | – |
|  |  | |  | | | | | | | | | | | | | | | | | |
| NR2-geometri til semi-ru til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **WNMM 080408E-NR2** | **T7335** | 0.8 | 160 | 0.40 | 4.0 | 120 | 0.36 | 4.0 | – | – | – | – | – | – | 50 | 0.28 | 3.2 | – | – | – |
| | **T9325** | 0.8 | 190 | 0.40 | 4.0 | 110 | 0.36 | 4.0 | 180 | 0.40 | 4.0 | – | – | – | 40 | 0.28 | 3.2 | – | – | – |

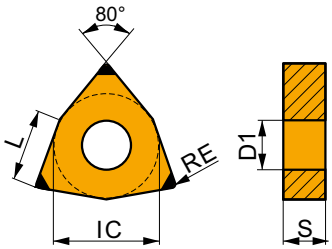
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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-geometri til semi-ru til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **WNMM 080412E-NR2** | **T7325** | 1.2 | 175 | 0.45 | 4.0 | 135 | 0.41 | 4.0 | – | – | – | – | – | – | 55 | 0.32 | 3.2 | – | – | – |
| | **T9325** | 1.2 | 190 | 0.45 | 4.0 | 110 | 0.41 | 4.0 | 180 | 0.45 | 4.0 | – | – | – | 40 | 0.32 | 3.2 | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| OR geometri til semi-grov til grov bearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **WNMM 080408E-OR** | **T8330** | 0.8 | 150 | 0.40 | 4.0 | 90 | 0.36 | 4.0 | 140 | 0.40 | 4.0 | – | – | – | 35 | 0.28 | 3.2 | – | – | – |
| | **T8430** | 0.8 | 155 | 0.40 | 4.0 | 85 | 0.36 | 4.0 | 130 | 0.40 | 4.0 | – | – | – | 30 | 0.28 | 3.2 | – | – | – |
| | **T9325** | 0.8 | 190 | 0.40 | 4.0 | 110 | 0.36 | 4.0 | 180 | 0.40 | 4.0 | – | – | – | 40 | 0.28 | 3.2 | – | – | – |
| | **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 | – | – | – |
| | **T9335** | 1.2 | 170 | 0.45 | 4.0 | 100 | 0.41 | 4.0 | – | – | – | – | – | – | 35 | 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 | – | – | – |

# WNGA CBN

PRAMET

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




Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |  | | | | | | | | | | | | | | | | | | | |
| Til færdigbearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **WNGA 080408S01020C** | **TB310** | 0.8 | – | – | – | – | – | – | 530 | 0.15 | 0.6 | – | – | – | 140 | 0.11 | 0.5 | 110 | 0.15 | 1.0 |
|  |  | | | | | | | | | | | | | | | | | | | |
| Til færdigbearbejdning og kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | |
| **WNGA080408S01020WC** | **TB310** | 0.8 | – | – | – | – | – | – | 530 | 0.15 | 0.6 | – | – | – | 140 | 0.11 | 0.5 | 110 | 0.15 | 1.0 |

# DWLN(RL) EXT

P M K N S H

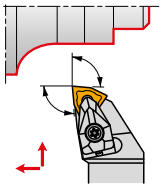
PRAMET

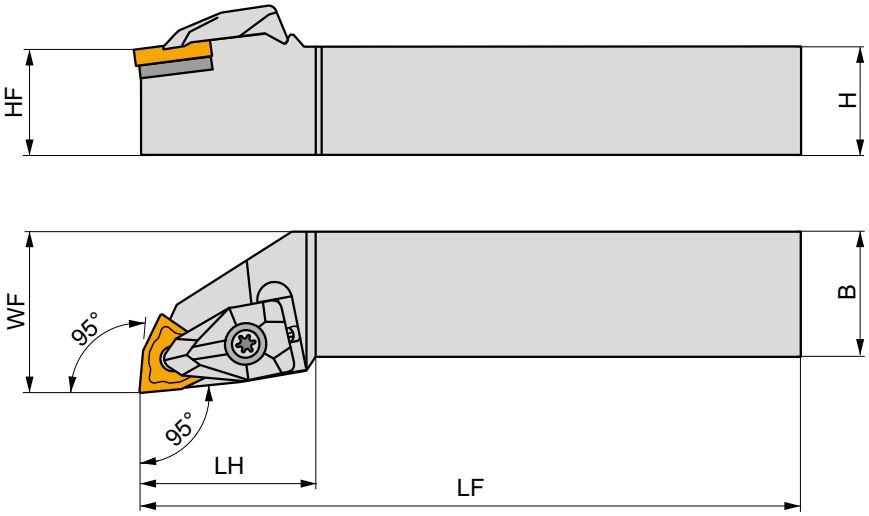
D

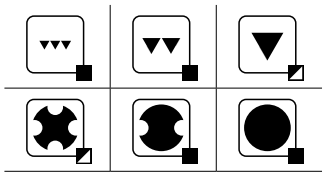


## Ekstern dobbeltholder med 95 ° skærevinkel til WN .. Skær

Ekstern højre / venstre drejebeslag med dobbelt klemme med 95 ° skærevinkel. Velegnet til langsgående drejning med skulder, ende, tilspidsning og affasning med negativ WN .. 06 til 13 skær. Fås med skaftstørrelse 16x16 op til 40x40 mm. Krop behandlet for længere levetid







| | Product | H (mm) | B (mm) | HF (mm) | WF (mm) | LF (mm) | LH (mm) | LAMS (°) | GAMO (°) | kg | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 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 | -6 | -6 | 0.75 | GI072 | DW08 | AT004 |
| | DWLNR 3225 P 08 | 32 | 25 | 32 | 32 | 170 | 35 | -6 | -6 | 1.01 | GI072 | DW08 | AT004 |
| | DWLNR 3225 P 10 | 32 | 25 | 32 | 32 | 170 | 38 | -6 | -6 | 1.06 | GI166 | DW10 | – |
| | DWLNR 3232 P 13 | 32 | 32 | 32 | 40 | 170 | 40 | -6 | -6 | 1.44 | GI167 | DW13 | – |
| | DWLNR 4040 S 13 | 40 | 40 | 40 | 50 | 250 | 41 | -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 | -6 | -6 | 0.75 | GI072 | DW08 | AT004 |
| | DWLNL 3225 P 08 | 32 | 25 | 32 | 32 | 170 | 35 | -6 | -6 | 1.10 | GI072 | DW08 | AT004 |
| | DWLNL 3225 P 10 | 32 | 25 | 32 | 32 | 170 | 38 | -6 | -6 | 1.14 | GI166 | DW10 | – |
| | DWLNL 3232 P 13 | 32 | 32 | 32 | 40 | 170 | 40 | -6 | -6 | 1.45 | GI167 | DW13 | – |
| | DWLNL 4040 S 13 | 40 | 40 | 40 | 50 | 250 | 41 | -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

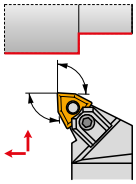
PRAMET

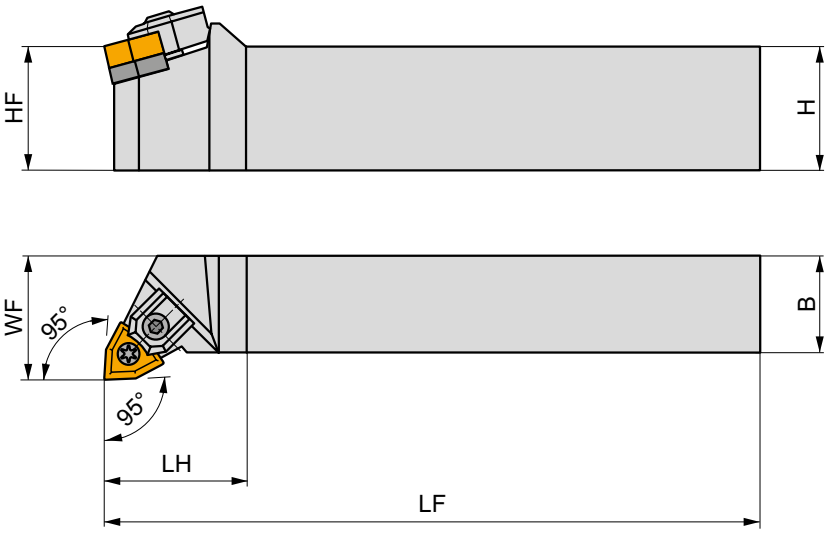
M

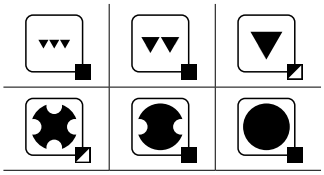


## Ekstern multiklemmeholder med 95 ° skærevinkel til WN .. Skær

Ekstern højre / venstre drejeholder med flere klemmer med 95 ° skærevinkel. Velegnet til langsgående drejning med skulder, endedrejning, tilspidsning og affasning med negativ WN .. 08 skær. Fås med skaftstørrelse 25x25 op til 40x40 mm. Krop behandlet for længere værktøjstid.







| | Product | H (mm) | B (mm) | HF (mm) | WF (mm) | LF (mm) | LH (mm) | LAMS (°) | GAMO (°) | kg | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| R | **MWLNR 2525 M 08** | 25 | 25 | 25 | 32 | 150 | 32 | -6 | -6 | 0.73 | GI072 | MW1 |
| | **MWLNR 3225 P 08** | 32 | 25 | 32 | 32 | 170 | 32 | -6 | -6 | 1.30 | GI072 | MW1 |
| | **MWLNR 4040 R 08** | 40 | 40 | 40 | 50 | 200 | 32 | -6 | -6 | 2.50 | GI072 | MW1 |
| L | **MWLNL 2525 M 08** | 25 | 25 | 25 | 32 | 150 | 32 | -6 | -6 | 0.70 | GI072 | MW1 |
| | **MWLNL 3225 P 08** | 32 | 25 | 32 | 32 | 170 | 32 | -6 | -6 | 1.02 | GI072 | MW1 |
| | **MWLNL 4040 R 08** | 40 | 40 | 40 | 50 | 200 | 32 | -6 | -6 | 2.50 | GI072 | MW1 |

| | |
|---|---|
| GI072 | WN.. 0804.. |

| | | | | | | |
|---|---|---|---|---|---|---|
| MW1 | UE 05 | 5.0 Nm | WNW 080412 | UC 51 | HS 0408 | HXK 3 |

# PWLN(RL) EXT

P M K N S H

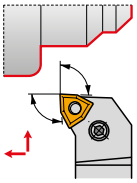
PRAMET

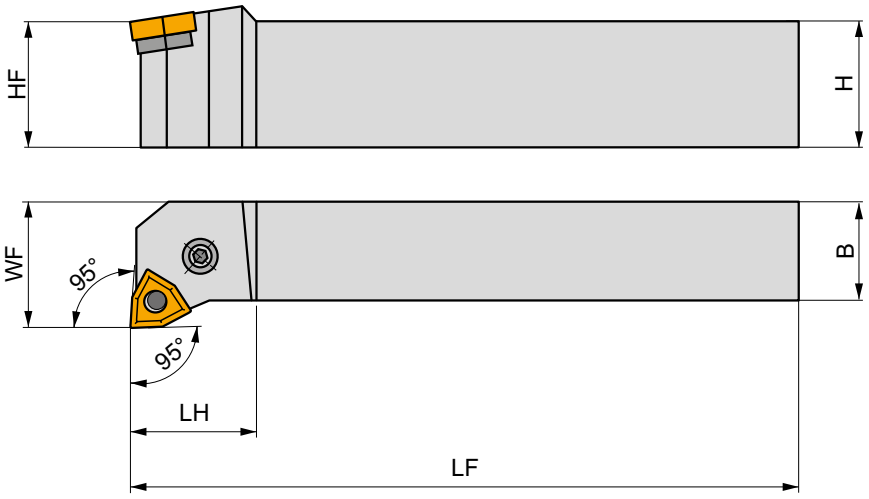
P

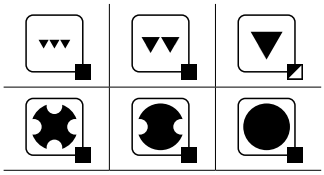


## Ekstern Lever Lock Drejeholder med 95 ° skærevinkel til WN .. Skær

Ekstern højre / venstre hånd drejeholder med 95 ° skærevinkel. Velegnet til langsgående drejning med skulder, ansigt, tilspidsning og affasning med negativ WN .. 06 og 08 skær. Fås med skaftstørrelse 16x16 op til 32x25 mm. Krop behandlet for længere levetid







| | Product | H (mm) | B (mm) | HF (mm) | WF (mm) | LF (mm) | LH (mm) | LAMS (°) | GAMO (°) | kg | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| R | **PWLNR 1616 H 0604** | 16 | 16 | 16 | 20 | 100 | 20 | -6 | -6 | 0.23 | GI028 | PW11 |
| | **PWLNR 2020 K 0604** | 20 | 20 | 20 | 25 | 125 | 20 | -6 | -6 | 0.40 | GI028 | PW10 |
| | **PWLNR 2525 M 0604** | 25 | 25 | 25 | 32 | 150 | 20 | -6 | -6 | 0.78 | GI028 | PW10 |
| | **PWLNR 2020 K 08** | 20 | 20 | 20 | 25 | 125 | 22 | -6 | -6 | 0.42 | GI072 | PW22 |
| | **PWLNR 2525 M 08** | 25 | 25 | 25 | 32 | 150 | 22 | -6 | -6 | 0.73 | GI072 | PW20 |
| | **PWLNR 3225 P 08** | 32 | 25 | 32 | 32 | 170 | 22 | -6 | -6 | 1.05 | GI072 | PW20 |
| L | **PWLNL 1616 H 0604** | 16 | 16 | 16 | 20 | 100 | 20 | -6 | -6 | 0.21 | GI028 | PW11 |
| | **PWLNL 2020 K 0604** | 20 | 20 | 20 | 25 | 125 | 20 | -6 | -6 | 0.40 | GI028 | PW10 |
| | **PWLNL 2525 M 0604** | 25 | 25 | 25 | 32 | 150 | 20 | -6 | -6 | 0.75 | GI028 | PW10 |
| | **PWLNL 2020 K 08** | 20 | 20 | 20 | 25 | 125 | 22 | -6 | -6 | 0.40 | GI072 | PW22 |
| | **PWLNL 2525 M 08** | 25 | 25 | 25 | 32 | 150 | 22 | -6 | -6 | 0.74 | GI072 | PW20 |
| | **PWLNL 3225 P 08** | 32 | 25 | 32 | 32 | 170 | 22 | -6 | -6 | 1.05 | GI072 | PW20 |

| | |
|---|---|
| GI028 | WN.. 0604.. |
| GI072 | WN.. 0804.. |

| | | | | Nm | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| PW10 | WNU 060308 | PU 01 | US 34 | 5.0 | M 6x0.75 | 19 | NT 04 | MT 04 | HXK 3 |
| PW11 | WNU 060308 | PU 01 | US 46 | 5.0 | M 6x0.75 | 13.2 | NT 04 | MT 04 | HXK 3 |
| PW20 | WNU 080312 | PU 02 | US 35 | 6.0 | M 8x1 | 22.5 | NT 05 | MT 05 | HXK 4 |
| PW22 | WNU 080312 | PU 02 | US 42 | 6.0 | M 8x1 | 21 | NT 05 | MT 05 | HXK 4 |

NEW

# C.-DWLN(RL) EXT

P M K N S H

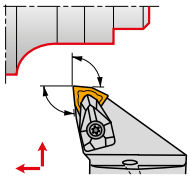
PRAMET

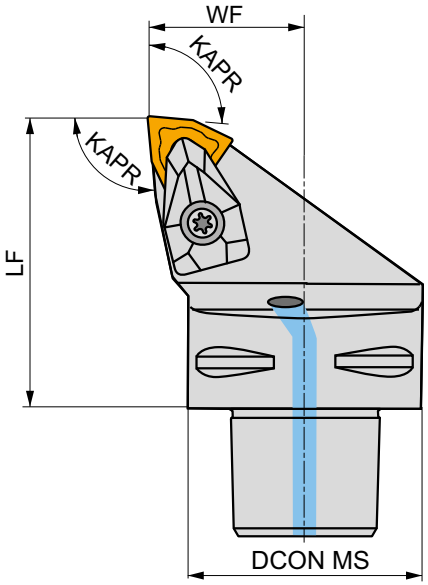
D

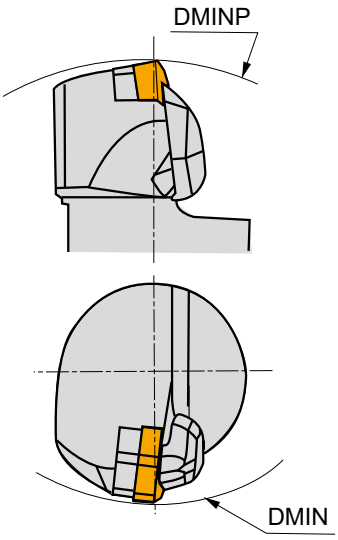


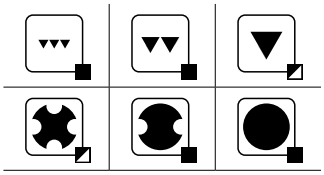
## Eksternt PSC hurtig skift værktøj, dobbelt klemme, 95 ° skærevinkel, WN .. Skær

Eksternt højre / venstre dobbeltklemmeværktøj, indvendig kølemiddel, med 95 ° skærevinkel til ende og langsgående drejning med skulder, tilspidsning og affasning med negative WN .. 06 og 08 skær. Fås med PSC (Polygon Shank Coupling) størrelse C4 op til C6. Krop behandlet for længere levetid







| | 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

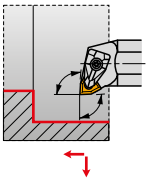
PRAMET

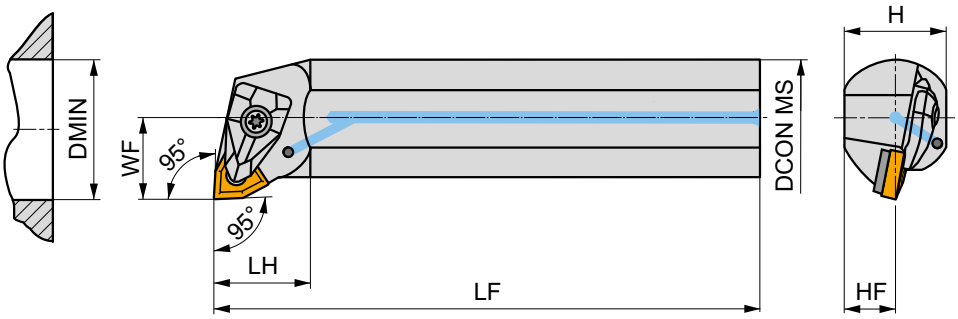
D

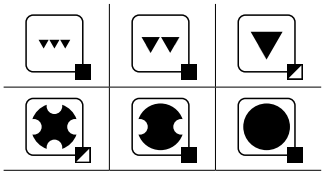


## Intern dobbeltklemmeholder med 95 ° skærevinkel til WN .. Skær

Intern højre / venstre hånd dobbelt klemme, indvendig kølemiddel, 95° skærevinkel for negative WN .. 06 og 08 skær. Mindste indvendige drejediameter Ø32 mm. Til indvendig tilspidsning, langsgående drejning med skulder- og affasedrejning. skaftstørrelser Ø25 op til Ø50 mm til rådighed. Krop behandlet for længere levetid på værktøjet.







| | 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 | -14 | -6 | ✓ | 0.97 | GI028 | DW06 |
| | A25T-DWLNR 08 | 25 | 33 | 17 | 23 | 11.5 | 300 | 31 | -12 | -6 | ✓ | 0.98 | GI072 | DWI08 |
| | A32T-DWLNR 08 | 32 | 40 | 22 | 30 | 15 | 300 | 33 | -10 | -6 | ✓ | 1.71 | GI072 | DWI08 |
| | A40T-DWLNR 08 | 40 | 50 | 27 | 37 | 18.5 | 300 | 36 | -13 | -6 | ✓ | 2.59 | GI072 | DW08 |
| | A50U-DWLNR 08 | 50 | 63 | 35 | 47 | 23.5 | 350 | 39 | -11 | -6 | ✓ | 5.24 | GI072 | DW08 |
| L | A25T-DWLNL 06 | 25 | 32 | 17 | 23 | 11.5 | 300 | 31 | -14 | -6 | ✓ | 0.97 | GI028 | DW06 |
| | A25T-DWLNL 08 | 25 | 33 | 17 | 23 | 11.5 | 300 | 31 | -12 | -6 | ✓ | 0.98 | GI072 | DWI08 |
| | A32T-DWLNL 08 | 32 | 40 | 22 | 30 | 15 | 300 | 33 | -10 | -6 | ✓ | 1.70 | GI072 | DWI08 |
| | A40T-DWLNL 08 | 40 | 50 | 27 | 37 | 18.5 | 300 | 36 | -13 | -6 | ✓ | 2.59 | GI072 | DW08 |
| | A50U-DWLNL 08 | 50 | 63 | 35 | 47 | 23.5 | 350 | 39 | -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

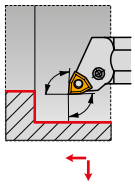
PRAMET

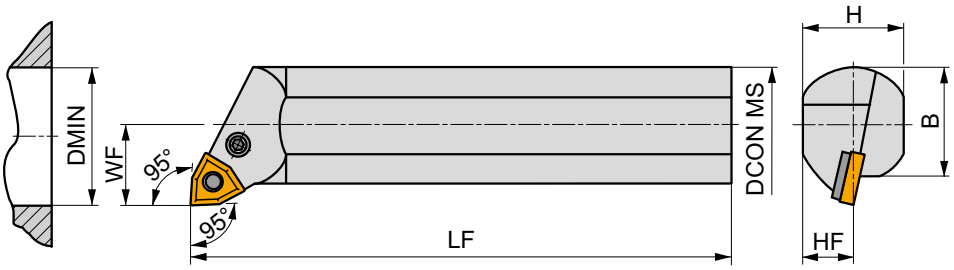
P

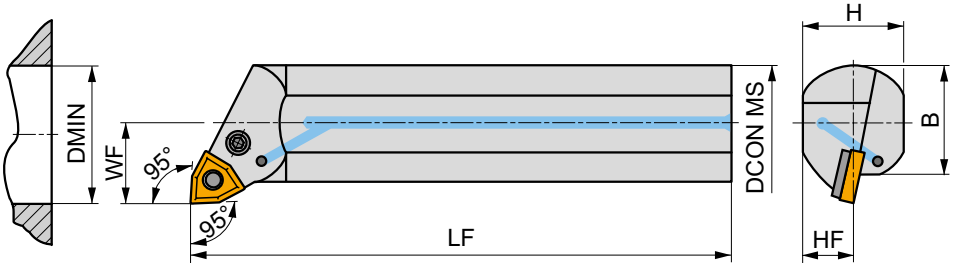


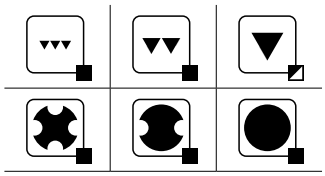
## Intern låseholder med 905° skærevinkel til WN .. Skær

Intern højre / venstre hånd borestang, indvendig kølevæske, 95° skærevinkel til WN .. 06 og 08 skær. Mindste indvendige drejediameter Ø20 mm. Til indvendig konisk og langsgående drejning med drejning af skulder og affasning. Skaftstørrelser Ø16 til Ø60 mm fås. Krop behandlet for længere levetid på værktøjet.







| | 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 | 15 | 150 | -13.5 | -6 | ✓ | 0.22 | GI028 | PW09 |
| | A20Q-PWLNR 0604 | 20 | 27 | 13 | 18 | 18 | 180 | -13.5 | -6 | ✓ | 0.36 | GI028 | PW09 |
| | S25T-PWLNR 0604 | 25 | 32 | 17 | 23 | 23 | 300 | -12 | -6 | – | 1.10 | GI028 | PW11 |
| | A32S-PWLNR 0604 | 32 | 40 | 22 | 30 | 30 | 250 | -12 | -6 | ✓ | 1.30 | GI028 | PW11 |
| | A25R-PWLNR 08 | 25 | 32 | 17 | 23 | 23 | 200 | -12 | -6 | ✓ | 0.66 | GI072 | PW25 |
| | S25T-PWLNR 08 | 25 | 32 | 17 | 23 | 23 | 300 | -12 | -6 | – | 1.10 | GI072 | PW25 |
| | A32S-PWLNR 08 | 32 | 40 | 22 | 30 | 30 | 250 | -12 | -6 | ✓ | 1.46 | GI072 | PW21 |
| | S32U-PWLNR 08 | 32 | 40 | 22 | 30 | 30 | 350 | -12 | -6 | – | 2.09 | GI072 | PW21 |
| | A40T-PWLNR 08 | 40 | 50 | 27 | 38 | 38 | 300 | -12 | -6 | ✓ | 2.40 | GI072 | PW20 |
| | A50U-PWLNR 08 | 50 | 63 | 35 | 47 | 48.5 | 350 | -12 | -6 | ✓ | 4.88 | GI072 | PW20 |
| | A60V-PWLNR 08 | 60 | 80 | 43 | 57 | 58.5 | 400 | -12 | -6 | ✓ | 8.10 | GI072 | PW20 |
| L | A16M-PWLNL 0604 | 16 | 20 | 11 | 15 | 15 | 150 | -13.5 | -6 | ✓ | 0.22 | GI028 | PW09 |
| | A20Q-PWLNL 0604 | 20 | 27 | 13 | 18 | 18 | 180 | -13.5 | -6 | ✓ | 0.36 | GI028 | PW09 |
| | S25T-PWLNL 0604 | 25 | 32 | 17 | 23 | 23 | 300 | -12 | -6 | – | 0.98 | GI028 | PW11 |
| | A32S-PWLNL 0604 | 32 | 40 | 22 | 30 | 30 | 250 | -12 | -6 | ✓ | 1.28 | GI028 | PW11 |
| | A25R-PWLNL 08 | 25 | 32 | 17 | 23 | 23 | 200 | -12 | -6 | ✓ | 0.75 | GI072 | PW25 |
| | S25T-PWLNL 08 | 25 | 32 | 17 | 23 | 23 | 300 | -12 | -6 | – | 1.01 | GI072 | PW25 |
| | A32S-PWLNL 08 | 32 | 40 | 22 | 30 | 30 | 250 | -12 | -6 | ✓ | 1.47 | GI072 | PW21 |
| | S32U-PWLNL 08 | 32 | 40 | 22 | 30 | 30 | 350 | -12 | -6 | – | 2.08 | GI072 | PW21 |
| | A40T-PWLNL 08 | 40 | 50 | 27 | 38 | 38 | 300 | -12 | -6 | ✓ | 2.90 | GI072 | PW20 |
| | A50U-PWLNL 08 | 50 | 63 | 35 | 47 | 48.5 | 350 | -12 | -6 | ✓ | 4.88 | GI072 | PW20 |
| | A60V-PWLNL 08 | 60 | 80 | 43 | 57 | 58.5 | 400 | -12 | -6 | ✓ | 8.70 | GI072 | PW20 |

| | |
|---|---|
| GI028 | WN.. 0604.. |
| GI072 | WN.. 0804.. |

|  |  |  |  |  |  |  |  |  |  |
|---|---|---|---|---|---|---|---|---|---|
| PW09 | – | PU 3611-A | PS 0512-A | 2.0 | M 5 | 12 | – | – | HXK 2 |
| PW11 | WNU 060308 | PU 01 | US 46 | 5.0 | M 6x0.75 | 13.2 | NT 04 | MT 04 | HXK 3 |
| PW20 | WNU 080312 | PU 02 | US 35 | 6.0 | M 8x1 | 22.5 | NT 05 | MT 05 | HXK 4 |
| PW21 | WNU 080312 | PU 02 | US 41 | 6.0 | M 8x1 | 17 | NT 05 | MT 05 | HXK 4 |
| PW25 | – | PU 32 | US 46 | 5.0 | M 6x0.75 | 13.2 | – | – | HXK 3 |

NEW

# C.-DWLN(RL) INT

P M K N S H

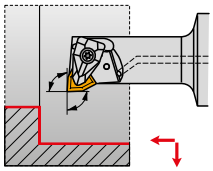
PRAMET

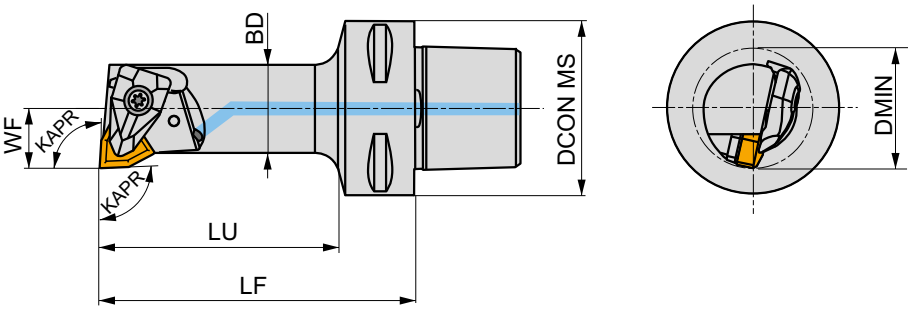
D

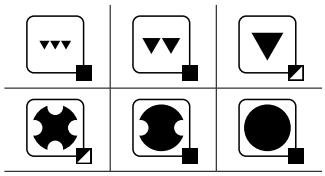


## Internt PSC Hurtig skift Værktøj, dobbelt klemme, 95 ° skærevinkel, WN .. Skær

Internt højre / venstre dobbeltklemmeværktøj, indvendig kølemiddel, med 95° skærevinkel til indvendig tilspidsning og langsgående drejning med skulder og affasning med WN .. 06 og 08 skær, minimum indvendig diameter Ø27 mm. Fås med PSC-skaft (Polygon Shank Coupling) størrelse C4. Krop behandlet for længere levetid på værktøjet.







| | 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 |
| R | 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 |
| L | 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 |

# PARTING-OFF & GROOVING



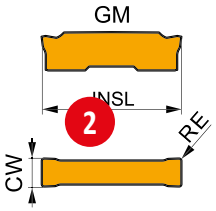
| | | |
|---|---|---|
| 📖 6 | | WMG & ISO 13399 |
| 📖 10 | ISO TURNING | INSTRUCTIONS |
| 📖 18 | | NAVIGATORS |
| 📖 57 | | POSITIVE INSERTS |
| 📖 219 | | NEGATIVE INSERTS |
| 📖 386 | | **PARTING – OFF & GROOVING** |
| 📖 482 | | THREAD TURNING |
| 📖 528 | | BROACHING |
| 📖 536 | | GENERAL TECHNICAL INFORMATION |

## 1 GL. D - GM

PRAMET

| | CW [mm] | CWTOLL [mm] | CWTOLU [mm] | INSL [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 |

3




Workpiece material suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap).

| 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] |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 4 | 5 | | U | 6 | | | | | | | | | | | | | | | | |
| | | | 10 GM geometry for grooving and longitudinal turning, and continuous to interrupted cuts. | | | | | | | | | | | | | | | | | |
| 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 | – | – | – |
| 7 | T7325 | 9 | 220 | 0.10 | 0.8 | 170 | 0.09 | 0.8 | – | – | – | – | – | – | 70 | 0.08 | 0.6 | – | – | – |
| G[illegible]00M02-GM | [illegible]30 | [illegible]2 | 150 | 0.20 | 1.0 | 90 | 0.18 | 1.0 | 140 | [illegible]20 | 1.0 | – | – | – | 35 | 0.14 | 0.8 | – | – | – |
| | T7325 | 0.2 | 175 | 0.20 | 1.0 | 135 | 0.18 | 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 | – | – | – |
| | T7325 | 0.4 | 185 | 0.20 | 1.0 | 140 | 0.18 | 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 | – | – | – |
| | T7325 | 0.4 | 170 | 0.25 | 1.2 | 130 | 0.23 | 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 | – | – | – |
| | T7325 | 0.8 | 200 | 0.25 | 1.2 | 155 | 0.23 | 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 | – | – | – |
| | T7325 | 0.8 | 190 | 0.30 | 1.2 | 145 | 0.27 | 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 | – | – | – |

**GL5-D500M08-GM:T7325** Use full insert specification code when ordering!

Grade

Include colon

ISO insert code

| Pos. | Description |
|---|---|
| 1 | Designation of insert |
| 2 | Schematic drawing of insert |
| 3 | Table with insert sizes (mm) |
| 4 | Picture of representative insert |
| 5 | Profile of main cutting edge |
| 6 | Icons – specific features and cutting edge type |

| Pos. | Description |
|---|---|
| 7 | ISO insert code |
| 8 | Grade |
| 9 | Insert radii (mm) |
| 10 | Geometry description |
| 11 | Application area of insert |

1 **GG.(RL) INT** P M K N S H 2

PRAMET 3 G

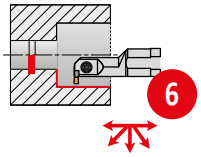


4

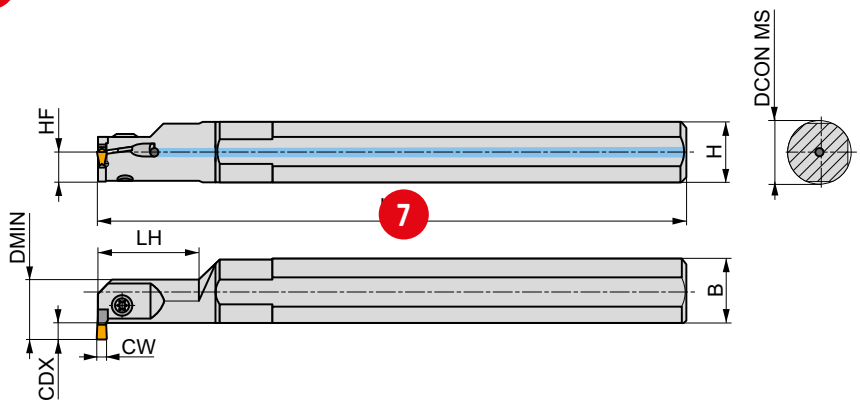
5

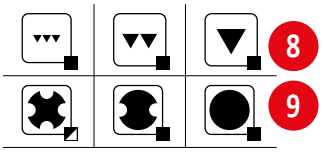
**LCM. Uç için Delik Kanal Kateri**

LCM. 0313 veya 0413 uçlar için Sağ/Sol delik kanal kateri. Minimum kanal açma çapı Ø16mm. Delik içi kanal açma ve çok yönlü tornalama için uygundur. Ø16-32mm şaft ölçülerinde bulunur. Gövde uzun takım ömrü için işlem görmüştür.



6



8 9

10

| | 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 | 3.00 | 3 | 16 | ✓ | 0.26 | GI143 | GL06 |
| | A16Q-GGER 0313-04 | 16 | 7.5 | 15 | 15.5 | 180 | 25 | 3.00 | 3 | 16 | ✓ | 0.26 | GI190 | GL06 |
| | A20R-GGFR 0313 | 20 | 9 | 18 | 19 | 200 | 30 | 3.00 | 4.5 | 20 | ✓ | 0.36 | GI143 | GL06 |
| | A20R-GGFR 0313-04 | 20 | 9 | 18 | 19 | 200 | 30 | 3.00 | 4.5 | 20 | ✓ | 0.39 | GI190 | GL06 |
| | A25S-GGHR 0313 | 25 | 11.5 | 23 | 24 | 250 | 40 | 3.00 | 6.5 | 25 | ✓ | 0.78 | GI143 | GL06 |
| | A25S-GG[illegible]3 | 25 | 11.5 | 23 | 24 | 250 | 40 | 4.00 | 6.5 | 25 | ✓ | 0.78 | GI143 | GL06 |
| | A32T-GGHR 0413 | 32 | 15 | 30 | 31 | 300 | 50 | 4.00 | 9.5 | 32 | ✓ | 1.59 | GI170 | GL06 |
| L | A16Q-GGEL 0313 | 16 | 7.5 | 15 | 15.5 | 180 | 25 | 3.00 | 3 | 16 | ✓ | 0.29 | GI143 | GL06 |
| | A16Q-GGEL 0313-04 | 16 | 7.5 | 15 | 15.5 | 180 | 25 | 3.00 | 3 | 16 | ✓ | 0.28 | GI190 | GL06 |
| | A20R-GGFL 0313 | 20 | 9 | 18 | 19 | 200 | 30 | 3.00 | 4.5 | 20 | ✓ | 0.38 | GI143 | GL06 |
| | A20R-GGFL 0313-04 | 20 | 9 | 18 | 19 | 200 | 30 | 3.00 | 4.5 | 20 | ✓ | 0.38 | GI190 | GL06 |
| | A25S-GGHL 0313 | 25 | 11.5 | 23 | 24 | 250 | 40 | 3.00 | 6.5 | 25 | ✓ | 0.81 | GI143 | GL06 |
| | A25S-GGFL 0413 | 25 | 11.5 | 23 | 24 | 250 | 40 | 4.00 | 6.5 | 25 | ✓ | 0.82 | GI170 | GL06 |
| | A32T-GGHL 0413 | 32 | 15 | 30 | 31 | 300 | 50 | 4.00 | 9.5 | 32 | ✓ | 1.59 | GI170 | GL06 |

11 12 13 14 15 16 17

| | 18 |
|---|---|
| GI143 | LCM. 0313.. |
| GI170 | LCM. 0413.. |
| GI190 | LCM. 0313…..-04 |

| | | Nm | 19 | | |
|---|---|---|---|---|---|
| GL06 | SR 85011-T15P | 5.0 | M 5 | 9 | FLAG T15P |

Typical page with turning holders displayed – specific page details will differ.

## PARTING – OFF & GROOVING HOLDERS – PAGE OVERVIEW

| Pos. | Description |
|---|---|
| 1 | Designation of parting-off & grooving holder |
| 2 | Material group recommendations |
| 3 | Clamping system of insert |
| 4 | Illustrative picture [1] |
| 5 | Tool description |
| 6 | Workpiece profile |
| 7 | Schematic drawing of tool |
| 8 | Achievable quality of surface |
| 9 | Character of cut/working conditions |
| 10 | Product applications |

| Pos. | Description |
|---|---|
| 11 | Tool design |
| 12 | Code of holder |
| 13 | Dimensions (mm) and angles [2] (°) of holder |
| 14 | Internal coolant supply |
| 15 | Weight (kg) |
| 16 | Group of compatible inserts [3] |
| 17 | Group of spare parts [3], [4] |
| 18 | Compatible inserts |
| 19 | Spare parts |

[1] Drejeholderen vises primært med højreopsætning (R)

[2] GAMO = retvinklet hældningsvinkel (se den tekniske del)
LAMS = stigningsvinkel for hovedskær (se den tekniske del)

[3] Gruppekoden for kompatible vendeskær, reservedele og specialtilbehør bruges kun til dette katalog. Den kan ikke bruges til ordrer.

[4] Reservedels- og specialtilbehørsikoner er designet skematisk, så de er nemme at forstå. De er ikke inkluderet på listen over ikoner. Skruer er i visse tilfælde forsynet med oplysninger om tilspændingsmoment i Nm, skruelængde og gevindstørrelse.

## GENERAL ICONS

- Primary use
- Possible use
- Finishing – very good surface quality
- Medium machining – good surface quality
- Roughing – unlimited surface roughness
- Suitable for stable working conditions
- Suitable for unstable working conditions
- Suitable for very unstable working conditions

## TURNING OPERATIONS

- Copy turning (multi directional machining)
- Deep and wide axial groove (with following expansion)
- Deep axial groove
- Deep radial groove
- Face copy turning
- Internal grooving
- Internal grooving (with following expansion)
- Parting off
- Shallow and wide axial groove (with following expansion)
- Shallow axial groove
- Shallow radial groove
- Tube parting off
- Wide radial groove (with following expansion)

## FEATURES

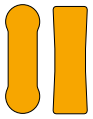
- First choice
- Large overhang
- Universal wide range option
- Heavy working conditions
- Rounded edge
- Rounded edge with facet

## OTHER

- Clamping torque of screw (Nm)
- Internal supply of coolant

GL. D NEW

406

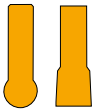
LCMF 13

418

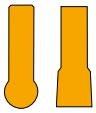
LCMF 16, LCMF 30

432

LCMF 20

453

LCMR 13

419

LCMR 16, LCMR 30

435

LFMX

456

LFUX

464

TN R EXT

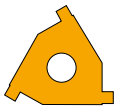
475

TN R INT

475

TN ZZ EXT

476

TN ZZ INT

477

X 61 NEW

468

X 61 R NEW

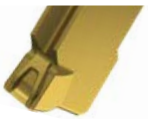
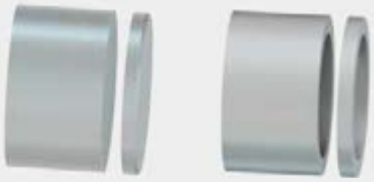
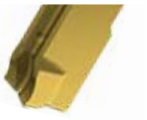
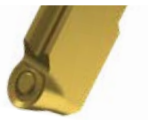
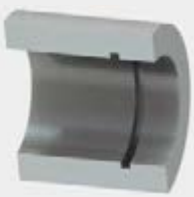
469

X 61 R-1 NEW

473

X 61-1 NEW

472

| | | Type of operation | insert family choice | | | |
|---|---|---|---|---|---|---|
| | | | First choice | | Optional choice | |
| EXTERNAL |  | Grooving | GL. D NEW | | LCMF16, LCMF30 | |
| | | | GM |  | F |  |
| | | | 406 | | 432 | |
| |  | Parting off | GL. D NEW | | LFMX | |
| | | | PM |  | M2 |  |
| | | | 407 | | 457 | |
| |  | Face grooving | LCMF13 | | LCMF16, LCMF30 | |
| | | | F |  | F |  |
| | | | 418 | | 432 | |
| |  | Copy profiling | GL. D NEW | | LCMF16, LCMF30 | |
| | | | MM |  | MP |  |
| | | | 406 | | 433 | |
| |  | Circlips grooving | X61 NEW | | TN ZZ EXT | |
| | | |  | |  | |
| | | | 469 | | 476 | |
| INTERNAL |  | Grooving | LCMF13 | | | |
| | | | F |  | | |
| | | | 418 | | | |
| |  | Copy profiling | LCMF13 | | | |
| | | | MP |  | | |
| | | | 419 | | | |
| |  | Circlips grooving | X61 NEW | | TN ZZ INT | |
| | | |  | |  | |
| | | | 468 | | 477 | |

| Grade Identification | Area of Application | Application | Feed | Cutting speed | Resistance to adverse Working Conditions | Coating | Colour | Substrate | Coolant benefit | Grade description |
|---|---|---|---|---|---|---|---|---|---|---|
| **T9325** | P15 - P35<br>M10 - M30<br>K15 - K35<br>S10 - S20 | ■<br>■<br>◪<br>◪ |  |  |  | MT-CVD | | FGM | + + | From a technological perspective this is an extremely versatile grade with high resistance to mechanical damage in adverse cutting conditions and retains excellent wear resistance. The correct application of this material requires high cutting speeds. |
| **T7325** | P15 - P35<br>M10 - M25<br>S10 - S25 | ◪<br>■<br>■ |  |  |  | MT-CVD | | FGM | + + + | One of the most universal turning grades. Especially designed for stainless steel machining. Optimal balance between wear resistance and performance reliability. Suitable for broad variety of application in turning operations. |
| **6640** | P20 - P40<br>M20 - M35<br>K25 - K40 | ■<br>■<br>■ |  |  |  | MT-CVD | | H | + + + | One of the toughest turning materials which can be used especially in roughing operations, or where operational reliability under adverse cutting conditions is a priority. Another ideal choice for machines working with low to medium cutting speeds and medium to high feed rates. |
| | | | | | | | | | | |
| **T8330** | P25 - P40<br>M20 - M35<br>K20 - K40<br>N15 - N30<br>S15 - S25<br>H15 - H25 | ■<br>■<br>■<br>◪<br>◪<br>◪ |  |  |  | PVD | | submicron H | + + + | Versatile cutting material, this is useful for machining of all types of machined materials and is practically applicable in almost all types of turning operations. Its main benefits are its high operational reliability and very good frictional properties; it is therefore suitable for applications at medium and lower cutting speeds. |
| **G8330** | P25 - P40<br>M20 - M35<br>K20 - K40<br>S15 - S25 | ■<br>■<br>■<br>◪ |  |  |  | PVD | | submicron H | + + + | Universal cutting grade for grooving and parting-off applications. This grade is characterized by its exceptional reliability and versatility. Developed to fit machining conditions for most workpiece materials. |

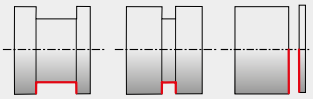
| Substrat | |
|---|---|
| **H** | WC-Co-baseret substrat |
| **submicron H** | WC-Co-baseret substrat fintkornet (< 1 µm) |
| **FGM** | Substrat med funktionel klassificering |

| Coating | |
|---|---|
| **MT-CVD** | Kemikaliemetode til belægning ved mellemhøj temperatur |
| **PVD** | Fysisk metode til coating ved lav temperatur |

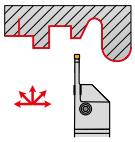
| Benefits of cutting fluid | |
|---|---|
| + + + | Use of coolant is essential |
| + + | Highly recommended |

# UDVENDIG SPORSTIK OG AFSTIK



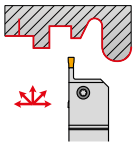


## GLSF(RL) EXT NEW



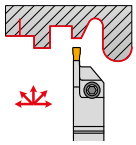
| GL.D |
|---|
| GL2<br>GL3<br>GL4<br>GL5<br>GL6 |
| 20×20<br>25×25 |
| 410 |
| 406 – 408 |

## GLSF(RL) EXT-G NEW



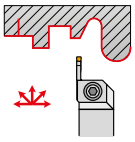
| GL.D |
|---|
| GL2<br>GL3<br>GL4<br>GL5<br>GL6 |
| 20×20<br>25×25 |
| 412 |
| 406 – 408 |

## GLSF(RL) EXT-S NEW



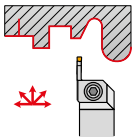
| GL.D |
|---|
| GL2<br>GL3<br>GL4 |
| 12×12<br>16×16 |
| 413 |
| 406 – 408 |

## GFK(RL) EXT



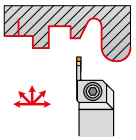
| LCMF |
|---|
| 0220 |
| 16×16<br>25×25 |
| 455 |
| 418 – 454 |

## GFI(RL) EXT



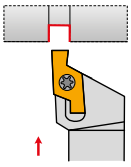
| LCMF, LCMR |
|---|
| 0316<br>0416<br>0516<br>0616<br>0830 |
| 16×16<br>32×25 |
| 437 |
| 418 – 454 |

## GFM(RL) EXT



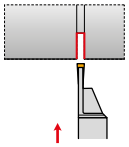
| LCMF, LCMR |
|---|
| 0316<br>0416<br>0516<br>0616<br>0830 |
| 20×20<br>32×25 |
| 439 |
| 418 – 454 |

## P61 (RL) EXT NEW



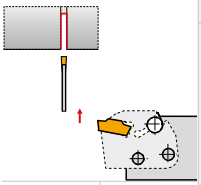
| X61 |
|---|
| 16×16<br>25×25 |
| 470 |
| 468 – 469 |

## XLCF(RL)



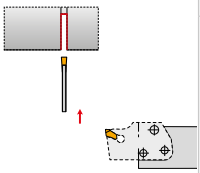
| LFUX |
|---|
| 03<br>04<br>05<br>06 |
| 16×12<br>32×25 |
| 465 |
| 464 |

## XLCCN 25 BS + MS-EN



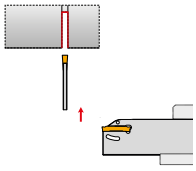
| LCMF, LCMR |
|---|
| 0316<br>0416<br>0516<br>0616 |
| 25×25<br>32×25 |
| 442, 443 |
| 418 – 454 |

## XLCF(NRL) BS + MS-EN



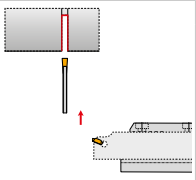
| LFMX |
|---|
| 1.50<br>1.60<br>2.00<br>2.20<br>3.10<br>4.10<br>5.10<br>6.35 |
| 12×12<br>32×25 |
| 461, 463 |
| 456 – 458 |

## GLS B + DU, D NEW



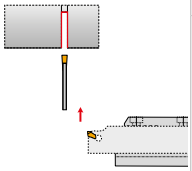
| GL.D |
|---|
| GL2<br>GL3<br>GL4<br>GL5<br>GL6 |
| 20×20<br>32×29 |
| 414, 415 |
| 406 – 409 |

## XLCCN B + DU, D



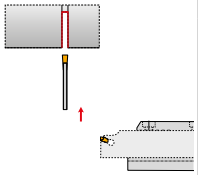
| LCMF, LCMR |
|---|
| 0316<br>0416<br>0516<br>0616 |
| 20×20<br>32×29 |
| 440, 441 |
| 418 – 454 |

## XLCFN B + DU, D



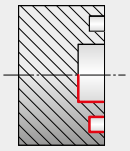
| LFMX |
|---|
| 1.50<br>1.60<br>2.00<br>2.20<br>3.10<br>4.10<br>5.10<br>6.35 |
| 20×20<br>40×36 |
| 459, 460 |
| 456 – 458 |

## XLCFN B LFUX + DU, D



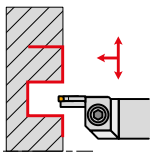
| LFUX |
|---|
| 03<br>04<br>05<br>06 |
| 20×20<br>40×40 |
| 466, 467 |
| 464 |

## SPORSTK AXIA



### GFIL-L AXIAL

LCMF, LCMR



0313
0316

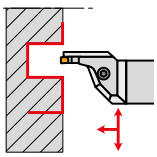
17-30
140-230

422, 444

418 – 454

### GFIL-R AXIAL

LCMF, LCMR



0313
0316
0413
0416

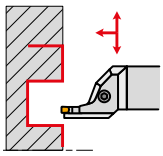
17-30
140-230

423, 445

418 – 454

### GFIR-L AXIAL

LCMF, LCMR



0313
0316
0413
0416

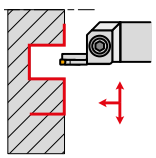
17-30
140-230

424, 446

418 – 454

### GFIR-R AXIAL

LCMF, LCMR



0313
0316

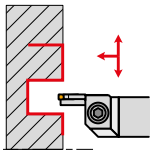
17-30
140-230

425, 447

418 – 454

### GFML-L AXIAL

LCMF, LCMR



0413
0416

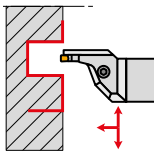
17-30
140-230

426, 448

418 – 454

### GFML-R AXIAL

LCMF, LCMR



0413
0416

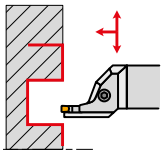
17-30
140-230

427, 449

418 – 454

### GFMR-L AXIAL

LCMF, LCMR



0413
0416

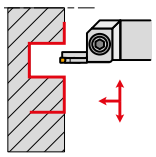
17-30
140-230

428, 450

418 – 454

### GFMR-R AXIAL

LCMF, LCMR



0413
0416

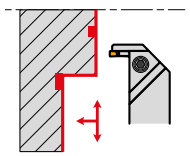
17-30
140-230

429, 451

418 – 454

### GGI(RL)-90 AXIAL

LCMF, LCMR



0313
0316

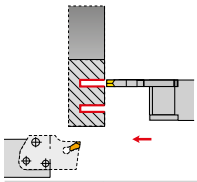
17-30
110-170

430, 452

418 – 454

### XLXFL BS AXIAL + MS-EN

LFMX



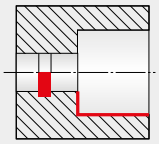
3.10

60-85
150-280

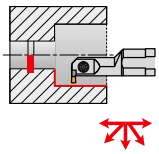
462, 463

456 – 458

# SPORSTIK – INDVENDIG



## GG.(RL) INT



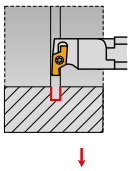
| LCMF, LCMR |
|---|
| 0313<br>0413 |

| ØDmin | |
|---|---|
| 16 – 32 | |

421

418 – 454

## P61 (RL) INT NEW



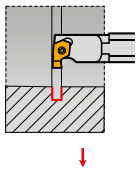
| X61 |
|---|
| |

| ØDmin | |
|---|---|
| 16 – 40 | |

471

468

## P61S(RL)-1 INT NEW



| X61-1 |
|---|
| |

| ØDmin | |
|---|---|
| 12.5 | |

474

472

| 1 | 2 | | 3 | 4 | 5 | 6 | 7 | | 8 |
|---|---|---|---|---|---|---|---|---|---|
| GL | 3 | – | D | 300 | G | 02 | L06 | – | PM |

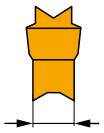


## 1 Tool group

GL

## 2 Pocket size

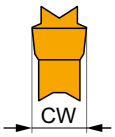
1, 2, 3, 4, 5, 6



## 3 Number of edges

| | |
|---|---|
| S | One edge |
| D | Two edges |

## 4 Cutting width – CW

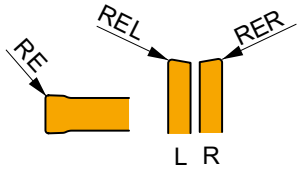


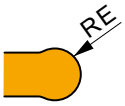

| | CW |
|---|---|
| 200 | 2.00 |
| 250 | 2.50 |
| 300 | 3.00 |
| 400 | 4.00 |
| 500 | 5.00 |
| 600 | 6.00 |

## 5 Edge design

| | |
|---|---|
| G | Ground |
| M | Direct pressed |

## 6 Nose radius



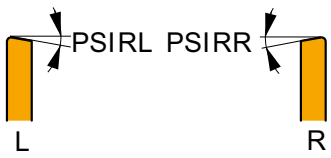




| | RE, RER, REL (mm) |
|---|---|
| 02 | 0.2 |
| 03 | 0.3 |
| 04 | 0.4 |
| 08 | 0.8 |

ROUND GEOMETRY

| | RE (mm) |
|---|---|
| M0 | RE = CW/2 |

## 7 Primary cutting edge angle

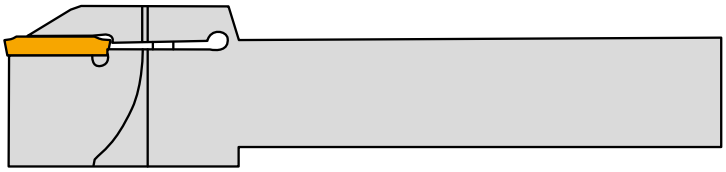



| | (°) |
|---|---|
| 06 | 6 |
| 12 | 12 |

## 8 Chipbreaker designation

PM
PR
GM
MM

| 1 | 2 | | 3 | 4 | 5 | 6 | 7 | | 8 | | 9 | 10 | 11 |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| GL | 3 | – | S | 2525 | M | F | L | – | 20 | – | R | 120 | 090 |

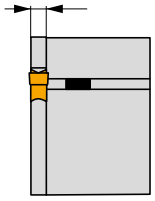


## 1

GL

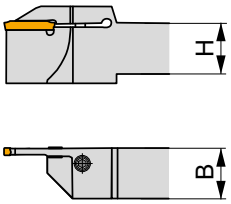
## 2

1, 2, 3, 4, 5, 6



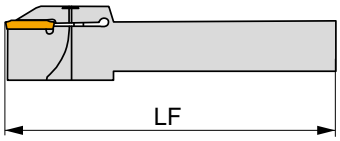
## 3

## 4



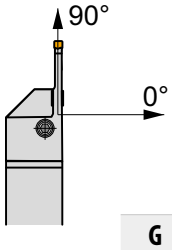

| | H/B (mm)/ (mm) |
|---|---|
| **1212** – | 12/12 |
| **1616** – | 16/16 |
| **2020** – | 20/20 |
| **2525** – | 25/25 |

## 5



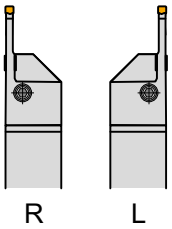

| | LF (mm) |
|---|---|
| **H** | 100 |
| **K** | 125 |
| **M** | 150 |
| **P** | 170 |

## 6

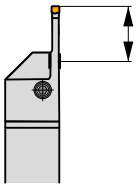



| | (°) |
|---|---|
| **G** | 0 |
| **F** | 90 |

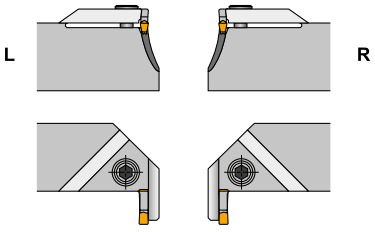
## 7



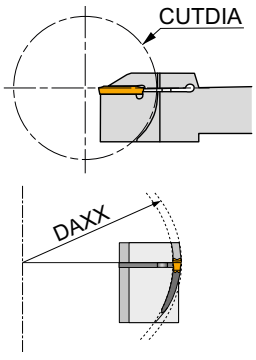

## 8



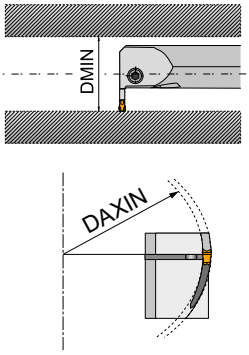
## 9




## 10




## 11

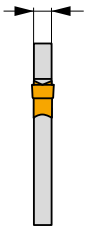


| 1 | 2 | | 3 | 4 | 5 | 6 |
|---|---|---|---|---|---|---|
| GL | 3 | – | S | 32 | M | B |



| 1 | 2 | 3 |
|---|---|---|
| | 1, 2, 3, 4, 5, 6 | |

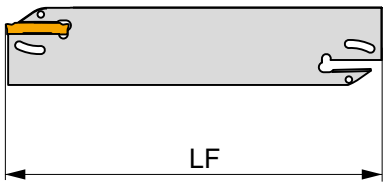
**GL**



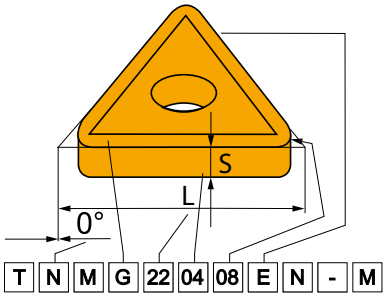
| 4 | 5 | 6 |
|---|---|---|




| | H (mm) |
|---|---|
| **26** | 26 |
| **32** | 32 |




| | LF (mm) | LF (") |
|---|---|---|
| **K** | 125 | 5.000" |
| **M** | 150 | 6.000" |




| | 1 | 2 | 3 | 4 |
|---|---|---|---|---|
| ISO | T | N | U | N |
| | T | N | M | G |
| ANSI | T | N | U | |
| | T | N | M | G |

## 1 Skærform

| | | | |
|---|---|---|---|
| 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 Frivinkel for skær

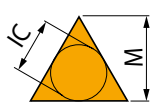
| | | | |
|---|---|---|---|
| A 3° | | B 5° | |
| C 7° | | D 15° | |
| E 20° | | F 25° | |
| G 30° | | N 0° | |
| P 11° | | O Speciel | |

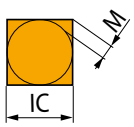
## 4 Skærtype

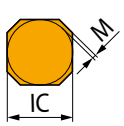
| | |
|---|---|
| N | |
| R | |
| F | |
| A | |
| M | |
| G | |
| W | 40° – 60° |
| T | |
| Q | |
| U | |
| B | 70° – 90° |
| H | |
| C | |
| J | |
| X | Speciel |

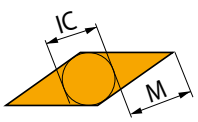
## 3 Tolerancer

| | (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" |



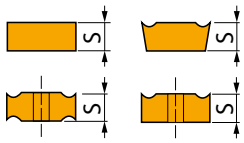



| 5 | 6 | 7 | 8 | 9 | | 10 |
|---|---|---|---|---|---|---|
| 22 | 04 | 08 | | | - | |
| 22 | 04 | 08 | E | N | | M |
| 5 | 6 | 7 | 8 | 9 | | 10 |
| 4 | 3 | 2 | | | - | |
| 4 | 3 | 2 | E | N | | M |

## 5 Skærlængde (skærstørrelse)

| d=IC (mm) | (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 Skærtykkelse



| | 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 Næseradius

| | 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" |



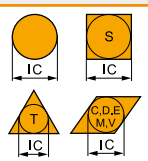
### Runde skær

| d = I.C. | |
|---|---|
| (") | 00 |
| (mm) | M0 |



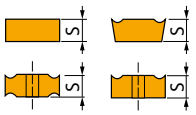
## ANSI

### 5 Indskrevet cirkel




| 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 Skærtykkelse



| 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 Næseradius for skær




| 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 Skærdesign

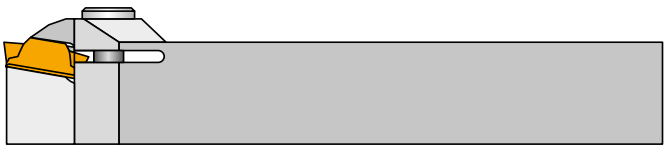
| | |
|---|---|
| F Skarpe skær | E Afrundede skær |
| T Skær med facet | S Afrundede skær med facet |
| K Skær med dobbelt facet | P Afrundede skær med dobbelt facet |

## 9 Tilspændingsretning

| | | | |
|---|---|---|---|
| R | Tilspænding ← | N | Tilspænding ← → Tilspænding |
| L | → Tilspænding | | |

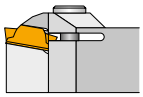
## 10 Spånbryderbetegnelse

| | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | 11 |
|---|---|---|---|---|---|---|---|---|---|---|---|
| ISO | G | F | I | L | 25 | 25 | M | 0316 | R | 030 | 017 |
| ANSI | 1 | 2 | 3 | 4 | 5 & 6 | | 7 | 8 | 9 | 10 | 11 |
| | G | F | I | L | 16 | | D | 0316 | R | 1.18 | .670 |

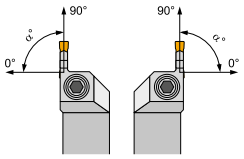


## 1 – Fastspændingsbetegnelse

G



## 2 – Holdertype – skærvinkel



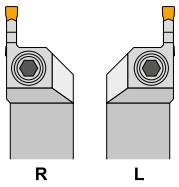

| α° | |
|---|---|
| G = 0° | K = 75° |
| R = 15° | F = 90° |
| T = 30° | B = 105° |
| S = 45° | E = 120° |
| W = 60° | D = 135° |

## 3 – Cutting depth maximum – CDX

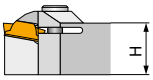



| | |
|---|---|
| G = 2.0 × CW | N = 5.5 × CW |
| H = 2.5 × CW | O = 6.0 × CW |
| I = 3.0 × CW | P = 6.5 × CW |
| J = 3.5 × CW | Q = 7.0 × CW |
| K = 4.0 × CW | R = 7.5 × CW |
| L = 4.5 × CW | S = 8.0 × CW |
| M = 5.0 × CW | T = 8.5 × CW |

## 4 – Version (højre/venstre) R/L

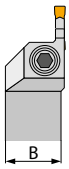



## 5 – Skafthøjde (mm)



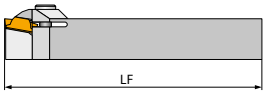

| |
|---|
| 12 = 12 mm |
| 16 = 16 mm |
| 20 = 20 mm |
| etc. |

## 6 – Skaftbredde (mm)




| |
|---|
| 12 = 12 mm |
| 16 = 16 mm |
| 20 = 20 mm |
| etc. |

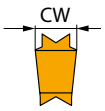
## 7 – Skaftbredde




| | 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 – Skærbredde



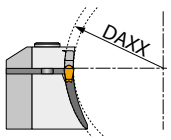

| | CW (mm) | CW (") |
|---|---|---|
| 02 | 2.0 | .079" |
| 03, 0313, 0316 | 3.0 | .118" |
| 04, 0413, 0416 | 4.0 | .157" |
| 05, 0516 | 5.0 | .197" |
| 06, 0616 | 6.0 | .236" |
| 08, 0830 | 8.0 | .315" |

## 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" |

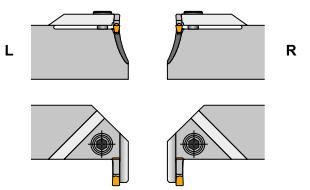
For firkantede skafter er dette antal sekstendedele af en tomme for bredde og højde. For rektangulære skafter er det første tal antallet af ottendedele af en tomme for bredden, og det andet tal er antal fjerdedele af en tomme for højden.

## 10 – Maks. diameter – planbearbejdning af spor



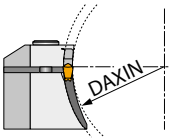

Yderligere oplysninger om aksial drejning

## 9 – Retning med rounding for blad




Yderligere oplysninger om aksial drejning

## 11 – Min. diameter – planbearbejdning af spor




Yderligere oplysninger om aksial drejning

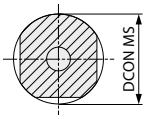
| | 1 | 2 | 3 | | 4 | 5 | 6 | 7 | 8 |
|---|---|---|---|---|---|---|---|---|---|
| ISO | A | 25 | S | – | G | G | H | L | 0313 |
| ANSI | A | 16 | S | – | G | G | H | L | 0313 |



## 1 Skaft

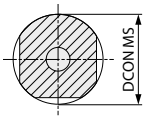
| | |
|---|---|
| S | Stålskaft |
| A | Stålskaft med kølemiddelhul |

## 2 Skaftdiameter



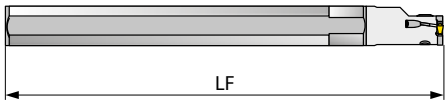

| | DCON MS (mm) |
|---|---|
| 12 | 12 |
| 16 | 16 |
| 20 | 20 |
| 25 | 25 |
| 32 | 32 |
| 40 | 40 |

## 2 Skaftdiameter




| | DCON MS (") |
|---|---|
| 08 | .500" |
| 10 | .625" |
| 12 | .750" |
| 16 | 1.000" |
| 20 | 1.250" |
| 24 | 1.500" |

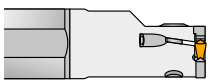
## 3 Holderens samlede længde



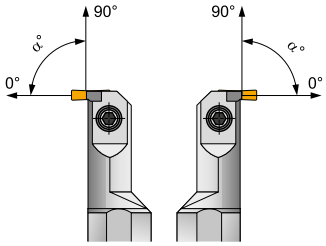

| | LF (mm) | LF (") | | LF (mm) | LF (") |
|---|---|---|---|---|---|
| M | 150 | 6.000" | S | 250 | 10.000" |
| P | 170 | 6.250" | T | 300 | 12.000" |
| Q | 180 | 7.250" | U | 350 | 14.000" |
| R | 200 | 8.000" | V | 400 | 15.750" |

## 4 Fastspændingsbetegnelse

G



## 5 Værktøjsstil – skærvinkel



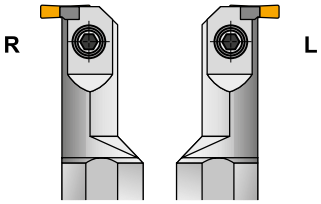

| α° | |
|---|---|
| G = 0° | K = 75° |
| R = 15° | F = 90° |
| T = 30° | B = 105° |
| S = 45° | E = 120° |
| W = 60° | D = 135° |

## 6 Cutting depth maximum – CDX

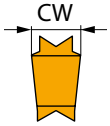



| | |
|---|---|
| E = 1.0 × CW | J = 3.5 × CW |
| F = 1.5 × CW | K = 4.0 × CW |
| G = 2.0 × CW | L = 4.5 × CW |
| H = 2.5 × CW | M = 5.0 × CW |
| I = 3.0 × CW | N = 5.5 × CW |
| X = Special | |

## 7 Version (højre/venstre) R/L




## 8 Skærbredde



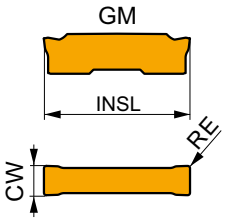

| | CW (mm) |
|---|---|
| 0313 | 3.0 |
| 0413 | 4.0 |

NEW

# 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 |




Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

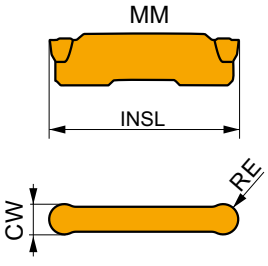
| Product | | RE | P | | | M | | | K | | | N | | | S | | | H | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | vc | f | ap | vc | f | ap | vc | f | ap | vc | f | ap | vc | f | ap | vc | f | ap |
| | | (mm) | (m/min) | (mm/rev) | (mm) | (m/min) | (mm/rev) | (mm) | (m/min) | (mm/rev) | (mm) | (m/min) | (mm/rev) | (mm) | (m/min) | (mm/rev) | (mm) | (m/min) | (mm/rev) | (mm) |
|  |  | | U E | | | | | | | | | | | | | | | | | |
| GM-geometri til spor og langsgående drejning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **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 | – | – | – |
| | **T7325** | 0.2 | 220 | 0.10 | 0.8 | 170 | 0.09 | 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 | – | – | – |
| | **T7325** | 0.2 | 175 | 0.20 | 1.0 | 135 | 0.18 | 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 | – | – | – |
| | **T7325** | 0.4 | 185 | 0.20 | 1.0 | 140 | 0.18 | 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 | – | – | – |
| | **T7325** | 0.4 | 170 | 0.25 | 1.2 | 130 | 0.23 | 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 | – | – | – |
| | **T7325** | 0.8 | 200 | 0.25 | 1.2 | 155 | 0.23 | 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 | – | – | – |
| | **T7325** | 0.8 | 190 | 0.30 | 1.2 | 145 | 0.27 | 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 | – | – | – |
| | **T7325** | 0.8 | 190 | 0.30 | 1.2 | 145 | 0.27 | 1.2 | – | – | – | – | – | – | 60 | 0.21 | 1.0 | – | – | – |

NEW

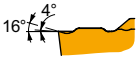
# GL. D - MM

PRAMET

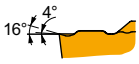
| | CW | CWTOLL | CWTOLU | INSL |
|---|---|---|---|---|
| | (mm) | (mm) | (mm) | (mm) |
| 200 | 2.00 | -0.05 | 0.05 | 25.0 |
| 300 | 3.00 | -0.05 | 0.05 | 25.0 |
| 400 | 4.00 | -0.05 | 0.05 | 25.0 |
| 500 | 5.00 | -0.05 | 0.05 | 26.0 |
| 600 | 6.00 | -0.05 | 0.05 | 26.0 |




Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |  | | U S | | | | | | | | | | | | | | | | | |
| MM-geometri med fuld radiusform til kopiprofilering og langsgående drejning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **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 | – | – | – |
| | **T7325** | 1.0 | 285 | 0.10 | 1.0 | 220 | 0.09 | 1.0 | – | – | – | – | – | – | 90 | 0.08 | 0.8 | – | – | – |

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

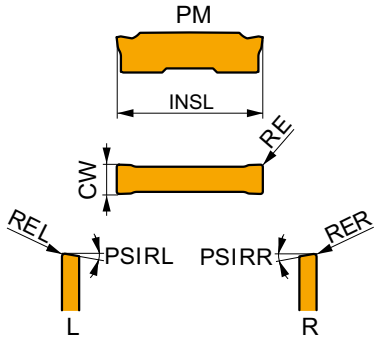
| Product | | RE | P | | | M | | | K | | | N | | | S | | | H | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | vc (m/min) | f (mm/rev) | ap (mm) | vc (m/min) | f (mm/rev) | ap (mm) | vc (m/min) | f (mm/rev) | ap (mm) | vc (m/min) | f (mm/rev) | ap (mm) | vc (m/min) | f (mm/rev) | ap (mm) | vc (m/min) | f (mm/rev) | ap (mm) |
| | | (mm) | | | | | | | | | | | | | | | | | | |
|  |  | | U S | | | | | | | | | | | | | | | | | |
| MM-geometri med fuld radiusform til kopiprofilering og langsgående drejning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **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 | – | – | – |
| | **T7325** | 1.5 | ◪ 240 | 0.20 | 1.2 | ■ 185 | 0.18 | 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 | – | – | – |
| | **T7325** | 2.0 | ◪ 250 | 0.20 | 1.2 | ■ 195 | 0.18 | 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 | – | – | – |
| | **T7325** | 2.5 | ◪ 235 | 0.25 | 1.2 | ■ 180 | 0.23 | 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 | – | – | – |
| | **T7325** | 3.0 | ◪ 220 | 0.30 | 1.2 | ■ 170 | 0.27 | 1.2 | – | – | – | – | – | – | ◪ 70 | 0.21 | 1.0 | – | – | – |

NEW

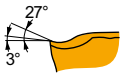
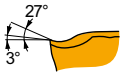
## GL. D - PM

PRAMET

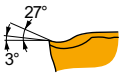
| | CW (mm) | CWTOLL (mm) | CWTOLU (mm) | INSL (mm) |
|---|---|---|---|---|
| 200 | 2.00 | -0.05 | 0.05 | 25.0 |
| 250 | 2.55 | -0.05 | 0.05 | 25.0 |
| 300 | 3.00 | -0.05 | 0.05 | 25.0 |
| 400 | 4.00 | -0.05 | 0.05 | 25.0 |
| 500 | 5.00 | -0.05 | 0.05 | 25.0 |
| 600 | 6.00 | -0.05 | 0.05 | 25.0 |




Egnethed og startværdier for skærehastighed (vc) og tilførsel (f). Se vores app til bearbejdning af yderligere beregninger.

| Product | | RE | P | | M | | K | | N | | S | | H | | PSIRR | PSIRL |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | vc (m/min) | f (mm/rev) | vc (m/min) | f (mm/rev) | vc (m/min) | f (mm/rev) | vc (m/min) | f (mm/rev) | vc (m/min) | f (mm/rev) | vc (m/min) | f (mm/rev) | (°) | (°) |
| | | (mm) | | | | | | | | | | | | | | |
|  |  | | 1 | | E | | | | | | | | | | | |
| PM-geometri, førstevalg til afstikning og sporstik og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | |
| **GL2-D200M02-PM** | **G8330** | 0.2 | ■ 130 | 0.08 | ■ 75 | 0.07 | ◪ 120 | 0.08 | – | – | ◪ 30 | 0.06 | – | – | – | – |
| | **T7325** | 0.2 | ◪ 150 | 0.08 | ■ 115 | 0.07 | – | – | – | – | ◪ 45 | 0.06 | – | – | – | – |
| **GL3-D250G02-PM** | **G8330** | 0.2 | ■ 130 | 0.10 | ■ 75 | 0.09 | ◪ 120 | 0.10 | – | – | ◪ 30 | 0.07 | – | – | – | – |
| **GL3-D300M02-PM** | **G8330** | 0.2 | ■ 130 | 0.10 | ■ 75 | 0.09 | ◪ 120 | 0.10 | – | – | ◪ 30 | 0.07 | – | – | – | – |
| | **T7325** | 0.2 | ◪ 150 | 0.10 | ■ 115 | 0.09 | – | – | – | – | ◪ 45 | 0.07 | – | – | – | – |
| **GL4-D400M02-PM** | **G8330** | 0.2 | ■ 130 | 0.12 | ■ 75 | 0.11 | ◪ 120 | 0.12 | – | – | ◪ 30 | 0.10 | – | – | – | – |
| | **T7325** | 0.2 | ◪ 150 | 0.12 | ■ 115 | 0.11 | – | – | – | – | ◪ 45 | 0.10 | – | – | – | – |
| **GL5-D500M03-PM** | **G8330** | 0.3 | ■ 130 | 0.15 | ■ 75 | 0.14 | ◪ 120 | 0.15 | – | – | ◪ 30 | 0.12 | – | – | – | – |
| **GL6-D600M03-PM** | **G8330** | 0.3 | ■ 130 | 0.15 | ■ 75 | 0.14 | ◪ 120 | 0.15 | – | – | ◪ 30 | 0.12 | – | – | – | – |
|  |  | | E | | | | | | | | | | | | | |
| R-PM højrehåndet geometri, førstevalg til afstik og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | |
| **GL2-D200G02R06-PM** | **G8330** | 0.2 | ■ 130 | 0.08 | ■ 75 | 0.07 | ◪ 120 | 0.08 | – | – | ◪ 30 | 0.06 | – | – | 6 | – |
| | **T7325** | 0.2 | ◪ 150 | 0.08 | ■ 115 | 0.07 | – | – | – | – | ◪ 45 | 0.06 | – | – | 6 | – |
| **GL2-D200G02R12-PM** | **G8330** | 0.2 | ■ 130 | 0.08 | ■ 75 | 0.07 | ◪ 120 | 0.08 | – | – | ◪ 30 | 0.06 | – | – | 12 | – |
| **GL3-D300G02R06-PM** | **G8330** | 0.2 | ■ 130 | 0.10 | ■ 75 | 0.09 | ◪ 120 | 0.10 | – | – | ◪ 30 | 0.07 | – | – | 6 | – |
| | **T7325** | 0.2 | ◪ 150 | 0.10 | ■ 115 | 0.09 | – | – | – | – | ◪ 45 | 0.07 | – | – | 6 | – |
| **GL3-D300G02R12-PM** | **G8330** | 0.2 | ■ 130 | 0.10 | ■ 75 | 0.09 | ◪ 120 | 0.10 | – | – | ◪ 30 | 0.07 | – | – | 12 | – |
| **GL4-D400G02R06-PM** | **G8330** | 0.2 | ■ 130 | 0.12 | ■ 75 | 0.11 | ◪ 120 | 0.12 | – | – | ◪ 30 | 0.10 | – | – | 6 | – |
| | **T7325** | 0.2 | ◪ 150 | 0.12 | ■ 115 | 0.11 | – | – | – | – | ◪ 45 | 0.10 | – | – | 6 | – |
| **GL4-D400G02R12-PM** | **G8330** | 0.2 | ■ 130 | 0.12 | ■ 75 | 0.11 | ◪ 120 | 0.12 | – | – | ◪ 30 | 0.10 | – | – | 12 | – |

Egnethed og startværdier for skærehastighed (vc) og tilførsel (f). Se vores app til bearbejdning af yderligere beregninger.

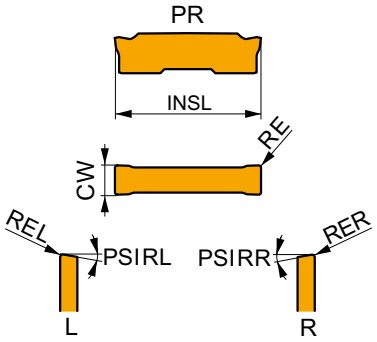
| Product | | RE | P | | | | M | | | | K | | | | N | | | | S | | | | H | | | | PSIRR | PSIRL |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | vc | | f | | vc | | f | | vc | | f | | vc | | f | | vc | | f | | vc | | f | | | |
| | | (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) | | (°) | (°) |
|  |  | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| L-PM venstrehåndsgeometri, førstevalg til afstikning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| GL2-D200G02L06-PM | G8330 | 0.2 | 130 | | 0.08 | | 75 | | 0.07 | | 120 | | 0.08 | | – | | – | | 30 | | 0.06 | | – | | – | | – | 6 |
| | T7325 | 0.2 | 150 | | 0.08 | | 115 | | 0.07 | | – | | – | | – | | – | | 45 | | 0.06 | | – | | – | | – | 6 |
| GL2-D200G02L12-PM | G8330 | 0.2 | 130 | | 0.08 | | 75 | | 0.07 | | 120 | | 0.08 | | – | | – | | 30 | | 0.06 | | – | | – | | – | 12 |
| GL3-D300G02L06-PM | G8330 | 0.2 | 130 | | 0.10 | | 75 | | 0.09 | | 120 | | 0.10 | | – | | – | | 30 | | 0.07 | | – | | – | | – | 6 |
| | T7325 | 0.2 | 150 | | 0.10 | | 115 | | 0.09 | | – | | – | | – | | – | | 45 | | 0.07 | | – | | – | | – | 6 |
| GL3-D300G02L12-PM | G8330 | 0.2 | 130 | | 0.10 | | 75 | | 0.09 | | 120 | | 0.10 | | – | | – | | 30 | | 0.07 | | – | | – | | – | 12 |
| GL4-D400G02L06-PM | G8330 | 0.2 | 130 | | 0.12 | | 75 | | 0.11 | | 120 | | 0.12 | | – | | – | | 30 | | 0.10 | | – | | – | | – | 6 |
| | T7325 | 0.2 | 150 | | 0.12 | | 115 | | 0.11 | | – | | – | | – | | – | | 45 | | 0.10 | | – | | – | | – | 6 |
| GL4-D400G02L12-PM | G8330 | 0.2 | 130 | | 0.12 | | 75 | | 0.11 | | 120 | | 0.12 | | – | | – | | 30 | | 0.10 | | – | | – | | – | 12 |

NEW

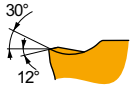
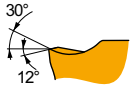
## GL. D - PR

PRAMET

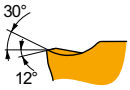
| | CW | CWTOLL | CWTOLU | INSL |
|---|---|---|---|---|
| | (mm) | (mm) | (mm) | (mm) |
| 200 | 2.00 | -0.05 | 0.05 | 25.0 |
| 300 | 3.00 | -0.05 | 0.05 | 25.0 |
| 400 | 4.00 | -0.05 | 0.05 | 25.0 |
| 500 | 5.00 | -0.05 | 0.05 | 25.0 |
| 600 | 6.00 | -0.05 | 0.05 | 25.0 |




Egnethed og startværdier for skærehastighed (vc) og tilførsel (f). Se vores app til bearbejdning af yderligere beregninger.

| 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, førstevalg til afstikning og notstik og kontinuerlige til afbrudte snit. | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| GL2-D200M02-PR | G8330 | 0.2 | 130 | | 0.10 | | 75 | | 0.09 | | 120 | | 0.10 | | – | | – | | – | | – | | – | | – | | – | – |
| | T7325 | 0.2 | 150 | | 0.10 | | 115 | | 0.09 | | – | | – | | – | | – | | – | | – | | – | | – | | – | – |
| GL3-D300M02-PR | G8330 | 0.2 | 130 | | 0.12 | | 75 | | 0.11 | | 120 | | 0.12 | | – | | – | | – | | – | | – | | – | | – | – |
| | T7325 | 0.2 | 150 | | 0.12 | | 115 | | 0.11 | | – | | – | | – | | – | | – | | – | | – | | – | | – | – |
| GL4-D400M02-PR | G8330 | 0.2 | 130 | | 0.15 | | 75 | | 0.14 | | 120 | | 0.15 | | – | | – | | – | | – | | – | | – | | – | – |
| | T7325 | 0.2 | 150 | | 0.15 | | 115 | | 0.14 | | – | | – | | – | | – | | – | | – | | – | | – | | – | – |
| 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 højrehåndet geometri, førstevalg til afstik og kontinuerlige til afbrudte snit. | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 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 | – |

Egnethed og startværdier for skærehastighed (vc) og tilførsel (f). Se vores app til bearbejdning af yderligere beregninger.

| Product | | RE | P | | M | | K | | N | | S | | H | | PSIRR | PSIRL |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | vc (m/min) | f (mm/rev) | vc (m/min) | f (mm/rev) | vc (m/min) | f (mm/rev) | vc (m/min) | f (mm/rev) | vc (m/min) | f (mm/rev) | vc (m/min) | f (mm/rev) | (°) | (°) |
|  |   | | | | | | | | | | | | | | | |
| | | | L-PR venstrehåndsgeometri, førstevalg til afstikning og kontinuerlige til afbrudte snit. | | | | | | | | | | | | | |
| **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 |

NEW

# GLSF(RL) EXT

P M K N S H

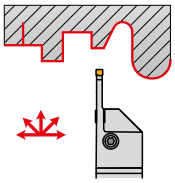
PRAMET

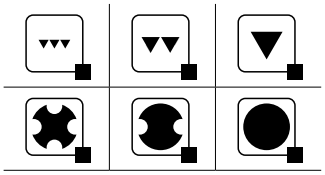
G

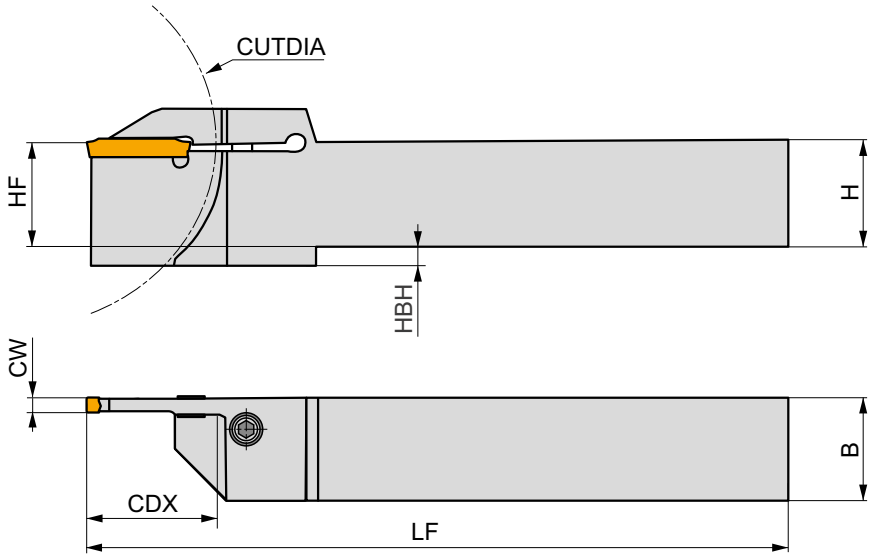


## Eksternt V-Groove Top Clamp-spor- og afstikningsværktøj til GL-skær

Ekstern højre / venstre hånd radial værktøjsholder til notning med dobbeltsidet GL 2, 3, 4, 5 eller 6 stilindsatser. Velegnet til radial not og afskæring, op til 32 mm maksimal skæredybde. Fås med skaftstørrelse 20x20 eller 25x25 mm. Forstærket kropsdesign for længere værktøjslevetid og lave vibrationer.










| | Product | HF (mm) | HBH (mm) | H (mm) | B (mm) | LF (mm) | CW (mm) | CDX (mm) | CUTDIA (mm) | kg | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| R | GL2-S2020KFR-20-80 | 20 | – | 20 | 20 | 125 | 2.00 | 20 | 80 | 0.38 | GI334 | GL11 |
| | GL2-S2020KFR-24-80 | 20 | 5 | 20 | 20 | 125 | 2.00 | 24 | 80 | 0.36 | GI334 | GL11 |
| | GL2-S2525MFR-20-80 | 25 | – | 25 | 25 | 150 | 2.00 | 20 | 80 | 0.68 | GI334 | GL11 |
| | GL2-S2525MFR-24-80 | 25 | – | 25 | 25 | 150 | 2.00 | 24 | 80 | 0.64 | GI334 | GL11 |
| | GL3-S2020KFR-20-80 | 20 | – | 20 | 20 | 125 | 3.00 | 20 | 80 | 0.38 | GI335 | GL11 |
| | GL3-S2020KFR-24-80 | 20 | 5 | 20 | 20 | 125 | 3.00 | 24 | 80 | 0.36 | GI335 | GL11 |
| | GL3-S2525MFR-20-80 | 25 | – | 25 | 25 | 150 | 3.00 | 20 | 80 | 0.68 | GI335 | GL11 |
| | GL3-S2525MFR-24-80 | 25 | – | 25 | 25 | 150 | 3.00 | 24 | 80 | 0.65 | GI335 | GL11 |
| | GL3-S2525PFR-32-80 | 25 | 5 | 25 | 25 | 170 | 3.00 | 32 | 80 | 0.72 | GI335 | GL11 |
| | GL4-S2020KFR-20-80 | 20 | – | 20 | 20 | 125 | 4.00 | 20 | 80 | 0.38 | GI336 | GL11 |
| | GL4-S2020KFR-24-80 | 20 | 5 | 20 | 20 | 125 | 4.00 | 24 | 80 | 0.37 | GI336 | GL11 |
| | GL4-S2525MFR-20-80 | 25 | – | 25 | 25 | 150 | 4.00 | 20 | 80 | 0.68 | GI336 | GL11 |
| | GL4-S2525MFR-24-80 | 25 | – | 25 | 25 | 150 | 4.00 | 24 | 80 | 0.65 | GI336 | GL11 |
| | GL4-S2525PFR-32-80 | 25 | 5 | 25 | 25 | 170 | 4.00 | 32 | 80 | 0.78 | GI336 | GL11 |
| | GL5-S2020KFR-20-80 | 20 | – | 20 | 20 | 125 | 5.00 | 20 | 80 | 0.38 | GI337 | GL11 |
| | GL5-S2525MFR-20-80 | 25 | – | 25 | 25 | 150 | 5.00 | 20 | 80 | 0.68 | GI337 | GL11 |
| | GL5-S2525PFR-32-100 | 25 | 5 | 25 | 25 | 170 | 5.00 | 32 | 100 | 0.75 | GI337 | GL11 |
| | GL6-S2020KFR-20-80 | 20 | – | 20 | 20 | 125 | 6.00 | 20 | 80 | 0.39 | GI338 | GL11 |
| | GL6-S2525MFR-20-80 | 25 | – | 25 | 25 | 150 | 6.00 | 20 | 80 | 0.68 | GI338 | GL11 |
| | GL6-S2525PFR-32-100 | 25 | 5 | 25 | 25 | 170 | 6.00 | 32 | 100 | 0.75 | GI338 | GL11 |
| L | GL2-S2020KFL-20-80 | 20 | – | 20 | 20 | 125 | 2.00 | 20 | 80 | 0.38 | GI334 | GL11 |
| | GL2-S2020KFL-24-80 | 20 | 5 | 20 | 20 | 125 | 2.00 | 24 | 80 | 0.36 | GI334 | GL11 |
| | GL2-S2525MFL-20-80 | 25 | – | 25 | 25 | 150 | 2.00 | 20 | 80 | 0.70 | GI334 | GL11 |
| | GL2-S2525MFL-24-80 | 25 | – | 25 | 25 | 150 | 2.00 | 24 | 80 | 0.64 | GI334 | GL11 |
| | GL3-S2020KFL-20-80 | 20 | – | 20 | 20 | 125 | 3.00 | 20 | 80 | 0.38 | GI335 | GL11 |
| | GL3-S2020KFL-24-80 | 20 | 5 | 20 | 20 | 125 | 3.00 | 24 | 80 | 0.36 | GI335 | GL11 |
| | GL3-S2525MFL-20-80 | 25 | – | 25 | 25 | 150 | 3.00 | 20 | 80 | 0.68 | GI335 | GL11 |

| | Product | HF (mm) | HBH (mm) | H (mm) | B (mm) | LF (mm) | CW (mm) | CDX (mm) | CUTDIA (mm) | kg | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| L | **GL3-S2525MFL-24-80** | 25 | – | 25 | 25 | 150 | 3.00 | 24 | 80 | 0.65 | GI335 | GL11 |
| | **GL3-S2525PFL-32-80** | 25 | 5 | 25 | 25 | 170 | 3.00 | 32 | 80 | 0.78 | GI335 | GL11 |
| | **GL4-S2020KFL-20-80** | 20 | – | 20 | 20 | 125 | 4.00 | 20 | 80 | 0.38 | GI336 | GL11 |
| | **GL4-S2020KFL-24-80** | 20 | 5 | 20 | 20 | 125 | 4.00 | 24 | 80 | 0.37 | GI336 | GL11 |
| | **GL4-S2525MFL-20-80** | 25 | – | 25 | 25 | 150 | 4.00 | 20 | 80 | 0.68 | GI336 | GL11 |
| | **GL4-S2525MFL-24-80** | 25 | – | 25 | 25 | 150 | 4.00 | 24 | 80 | 0.65 | GI336 | GL11 |
| | **GL4-S2525PFL-32-80** | 25 | 5 | 25 | 25 | 170 | 4.00 | 32 | 80 | 0.72 | GI336 | GL11 |
| | **GL5-S2020KFL-20-80** | 20 | – | 20 | 20 | 125 | 5.00 | 20 | 80 | 0.38 | GI337 | GL11 |
| | **GL5-S2525MFL-20-80** | 25 | – | 25 | 25 | 150 | 5.00 | 20 | 80 | 0.71 | GI337 | GL11 |
| | **GL5-S2525PFL-32-100** | 25 | 5 | 25 | 25 | 170 | 5.00 | 32 | 100 | 0.75 | GI337 | GL11 |
| | **GL6-S2020KFL-20-80** | 20 | – | 20 | 20 | 125 | 6.00 | 20 | 80 | 0.39 | GI338 | GL11 |
| | **GL6-S2525MFL-20-80** | 25 | – | 25 | 25 | 150 | 6.00 | 20 | 80 | 0.71 | GI338 | GL11 |
| | **GL6-S2525PFL-32-100** | 25 | 5 | 25 | 25 | 170 | 6.00 | 32 | 100 | 0.75 | GI338 | GL11 |

| | |
|---|---|
| GI334 | GL2.. |
| GI335 | GL3.. |
| GI336 | GL4.. |
| GI337 | GL5.. |
| GI338 | GL6.. |

| | | Nm | | | |
|---|---|---|---|---|---|
| GL11 | US 5018-T20P | 5.0 | M 5 | 18.2 | LK T20P |

Skæredybder på bearbejdet diameter på side xxx.

NEW

# GLSF(RL) EXT-G

P M K N S H

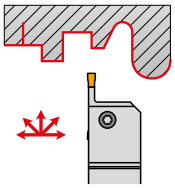
PRAMET

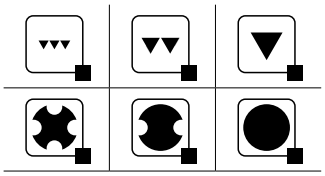
G

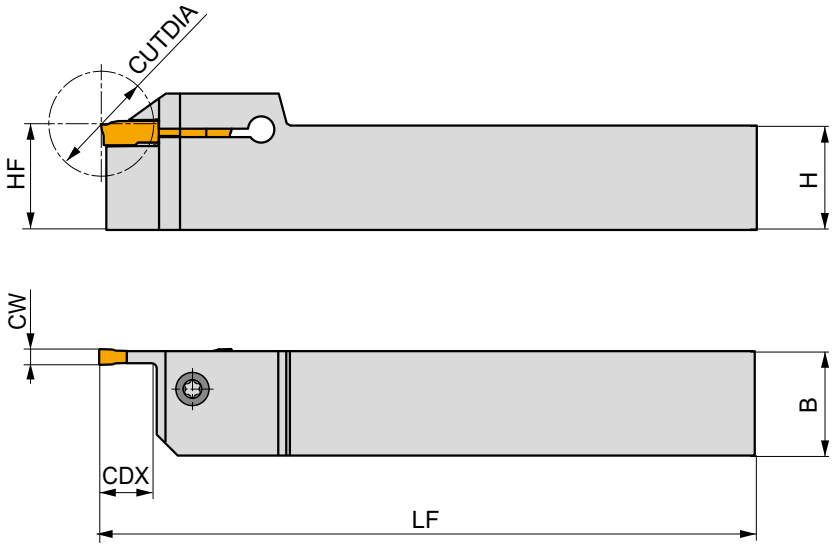


## Eksternt V-Groove Top Clamp-spor- og afstikningsværktøj til GL-skær

Ekstern højre / venstre hånd radial værktøjsholder til notning med dobbeltsidet GL 2, 3, 4, 5 eller 6 stilindsatser. Velegnet til radial notning, langsgående drejning og profilering, op til 12 mm maksimal skæredybde. Fås med skaftstørrelse 20x20 eller 25x25 mm. Krop behandlet for længere værktøjstid.










| | Product | HF (mm) | H (mm) | B (mm) | LF (mm) | CW (mm) | CDX (mm) | CUTDIA (mm) | kg | | |
|---|---|---|---|---|---|---|---|---|---|---|---|
| R | GL2-S2020KFR-10 | 20 | 20 | 20 | 125 | 2.00 | 10 | 20 | 0.38 | GI334 | GL11 |
| | GL2-S2525MFR-10 | 25 | 25 | 25 | 150 | 2.00 | 10 | 20 | 0.69 | GI334 | GL11 |
| | GL3-S2020KFR-10 | 20 | 20 | 20 | 125 | 3.00 | 10 | 20 | 0.36 | GI335 | GL11 |
| | GL3-S2525MFR-10 | 25 | 25 | 25 | 150 | 3.00 | 10 | 20 | 0.69 | GI335 | GL11 |
| | GL4-S2020KFR-12 | 20 | 20 | 20 | 125 | 4.00 | 12 | 24 | 0.37 | GI336 | GL11 |
| | GL4-S2525MFR-12 | 25 | 25 | 25 | 150 | 4.00 | 12 | 24 | 0.69 | GI336 | GL11 |
| | GL5-S2020KFR-12 | 20 | 20 | 20 | 125 | 5.00 | 12 | 24 | 0.36 | GI337 | GL11 |
| | GL5-S2525MFR-12 | 25 | 25 | 25 | 150 | 5.00 | 12 | 24 | 0.70 | GI337 | GL11 |
| | GL6-S2020KFR-12 | 20 | 20 | 20 | 125 | 6.00 | 12 | 24 | 0.36 | GI338 | GL11 |
| | GL6-S2525MFR-12 | 25 | 25 | 25 | 150 | 6.00 | 12 | 24 | 0.68 | GI338 | GL11 |
| L | GL2-S2020KFL-10 | 20 | 20 | 20 | 125 | 2.00 | 10 | 20 | 0.37 | GI334 | GL11 |
| | GL2-S2525MFL-10 | 25 | 25 | 25 | 150 | 2.00 | 10 | 20 | 0.70 | GI334 | GL11 |
| | GL3-S2020KFL-10 | 20 | 20 | 20 | 125 | 3.00 | 10 | 20 | 0.36 | GI335 | GL11 |
| | GL3-S2525MFL-10 | 25 | 25 | 25 | 150 | 3.00 | 10 | 20 | 0.70 | GI335 | GL11 |
| | GL4-S2020KFL-12 | 20 | 20 | 20 | 125 | 4.00 | 12 | 24 | 0.37 | GI336 | GL11 |
| | GL4-S2525MFL-12 | 25 | 25 | 25 | 150 | 4.00 | 12 | 24 | 0.69 | GI336 | GL11 |
| | GL5-S2020KFL-12 | 20 | 20 | 20 | 125 | 5.00 | 12 | 24 | 0.36 | GI337 | GL11 |
| | GL5-S2525MFL-12 | 25 | 25 | 25 | 150 | 5.00 | 12 | 24 | 0.69 | GI337 | GL11 |
| | GL6-S2020KFL-12 | 20 | 20 | 20 | 125 | 6.00 | 12 | 24 | 0.36 | GI338 | GL11 |
| | GL6-S2525MFL-12 | 25 | 25 | 25 | 150 | 6.00 | 12 | 24 | 0.68 | GI338 | GL11 |

| | |
|---|---|
| GI334 | GL2.. |
| GI335 | GL3.. |
| GI336 | GL4.. |
| GI337 | GL5.. |
| GI338 | GL6.. |

| | | Nm | | | |
|---|---|---|---|---|---|
| GL11 | US 5018-T20P | 5.0 | M 5 | 18.2 | LKT20P |

NEW

# GLSF(RL) EXT-S

P M K N S H

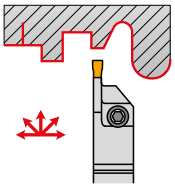
PRAMET

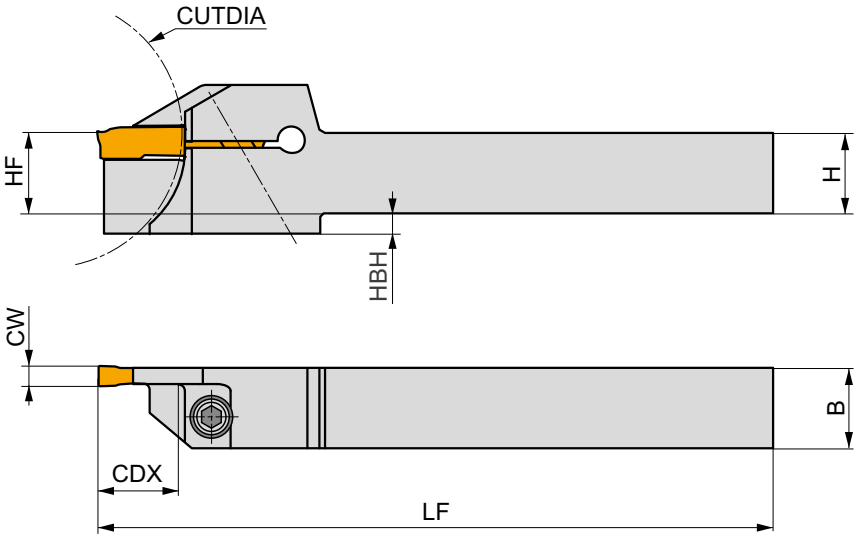
G

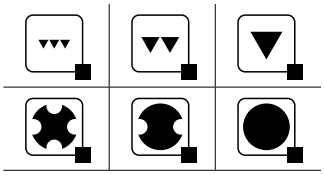


## Eksternt spor- og afstikningsværktøj, GL-skær til Sliding head maskiner

Ekstern højre / venstre radial værktøjsholder til maskiner GL 2, 3, 4 lommebredder. Til radial notning, profilering og afskæring på op til 16 mm maksimal skæredybde. Fås med skaftstørrelse 12x12 eller 16x16 mm. Forstærket kropsdesign for længere værktøjslevetid og lave vibrationer, nem adgang til fastspænding.







| | Product | HF (mm) | HBH (mm) | H (mm) | B (mm) | LF (mm) | CW (mm) | CDX (mm) | CUTDIA (mm) | kg | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| R | **GL2-S1212HFR-12-40** | 12 | 3 | 12 | 12 | 100 | 2.00 | 12 | 40 | 0.11 | GI334 | GL13 |
| | **GL2-S1616KFR-16-45** | 16 | 3 | 16 | 16 | 125 | 2.00 | 16 | 45 | 0.23 | GI334 | GL12 |
| | **GL3-S1212HFR-12-40** | 12 | 3 | 12 | 12 | 100 | 3.00 | 12 | 40 | 0.11 | GI335 | GL13 |
| | **GL3-S1616KFR-16-45** | 16 | 3 | 16 | 16 | 125 | 3.00 | 16 | 45 | 0.23 | GI335 | GL12 |
| | **GL4-S1616KFR-16-45** | 16 | 4 | 16 | 16 | 125 | 4.00 | 16 | 45 | 0.26 | GI336 | GL12 |
| L | **GL2-S1212HFL-12-40** | 12 | 3 | 12 | 12 | 100 | 2.00 | 12 | 40 | 0.11 | GI334 | GL13 |
| | **GL2-S1616KFL-16-45** | 16 | 3 | 16 | 16 | 125 | 2.00 | 16 | 45 | 0.23 | GI334 | GL12 |
| | **GL3-S1212HFL-12-40** | 12 | 3 | 12 | 12 | 100 | 3.00 | 12 | 40 | 0.11 | GI335 | GL13 |
| | **GL3-S1616KFL-16-45** | 16 | 3 | 16 | 16 | 125 | 3.00 | 16 | 45 | 0.23 | GI335 | GL12 |
| | **GL4-S1616KFL-16-45** | 16 | 4 | 16 | 16 | 125 | 4.00 | 16 | 45 | 0.24 | GI336 | GL12 |

| | |
|---|---|
| GI334 | GL2.. |
| GI335 | GL3.. |
| GI336 | GL4.. |

| | | Nm | | | |
|---|---|---|---|---|---|
| GL12 | HS 0516 | 5.0 | M 5 | 16 | HXK 4 |
| GL13 | HS 0412 | 5.0 | M 4 | 12 | HXK 3 |

Skæredybder på bearbejdet diameter på side xxx.

NEW

# GLS B

P M K N S H

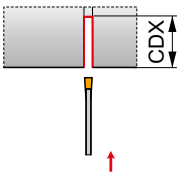
PRAMET

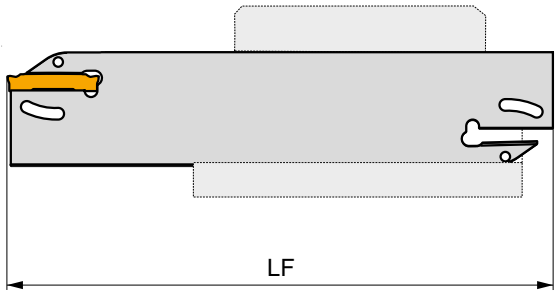
X

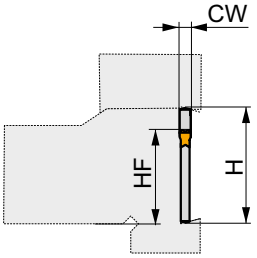


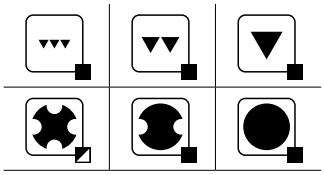
## Dobbeltsidet afskæringsblad til GL-skær

Blad til afskæringsopgaver op til 60 mm maksimal dybde eller Ø120 mm stangmateriale. Velegnet til dobbeltsidede skær GL-familien. Fås i højden 26 og 32 mm. Kan monteres i DU Pramet basisholdere. Blad behandlet for længere levetid på værktøjet.





| Product | HF (mm) | H (mm) | LF (mm) | CW (mm) | CDX (mm) | kg | | |
|---|---|---|---|---|---|---|---|---|
| **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 | 0.16 | GI335 | KV2 |
| **GL4-S32MB** | 25 | 32 | 150 | 4.00 | 50 | 0.16 | GI336 | KV2 |
| **GL5-S32MB** | 25 | 32 | 150 | 5.00 | 60 | 0.16 | GI337 | KV2 |
| **GL6-S32MB** | 25 | 32 | 150 | 6.00 | 60 | 0.16 | GI338 | KV2 |

| | |
|---|---|
| GI334 | GL2.. |
| GI335 | GL3.. |
| GI336 | GL4.. |
| GI337 | GL5.. |
| GI338 | GL6.. |

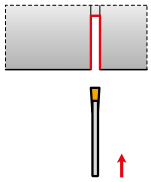
| | |
|---|---|
| KV2 | KV 15x150 |

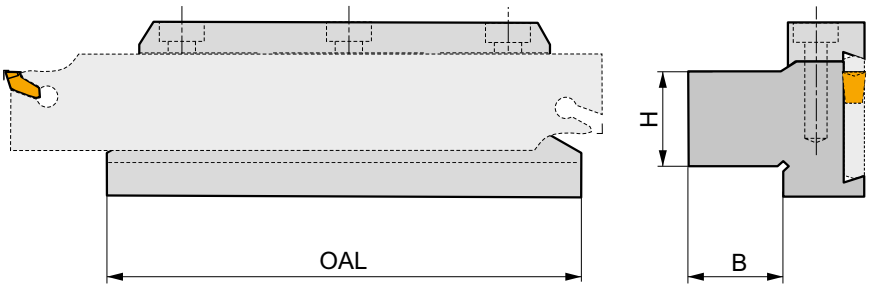
# DU, D

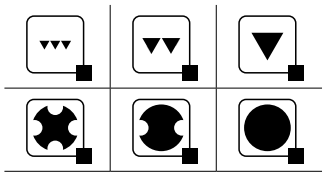


## Værktøjsholderblok til stikblade

Værktøjsholder, der passer til GL eller XLC. knive til afskæring. Fås med skaftstørrelse 20x20 op til 40x40 mm. Krop behandlet for længere levetid på værktøjet.





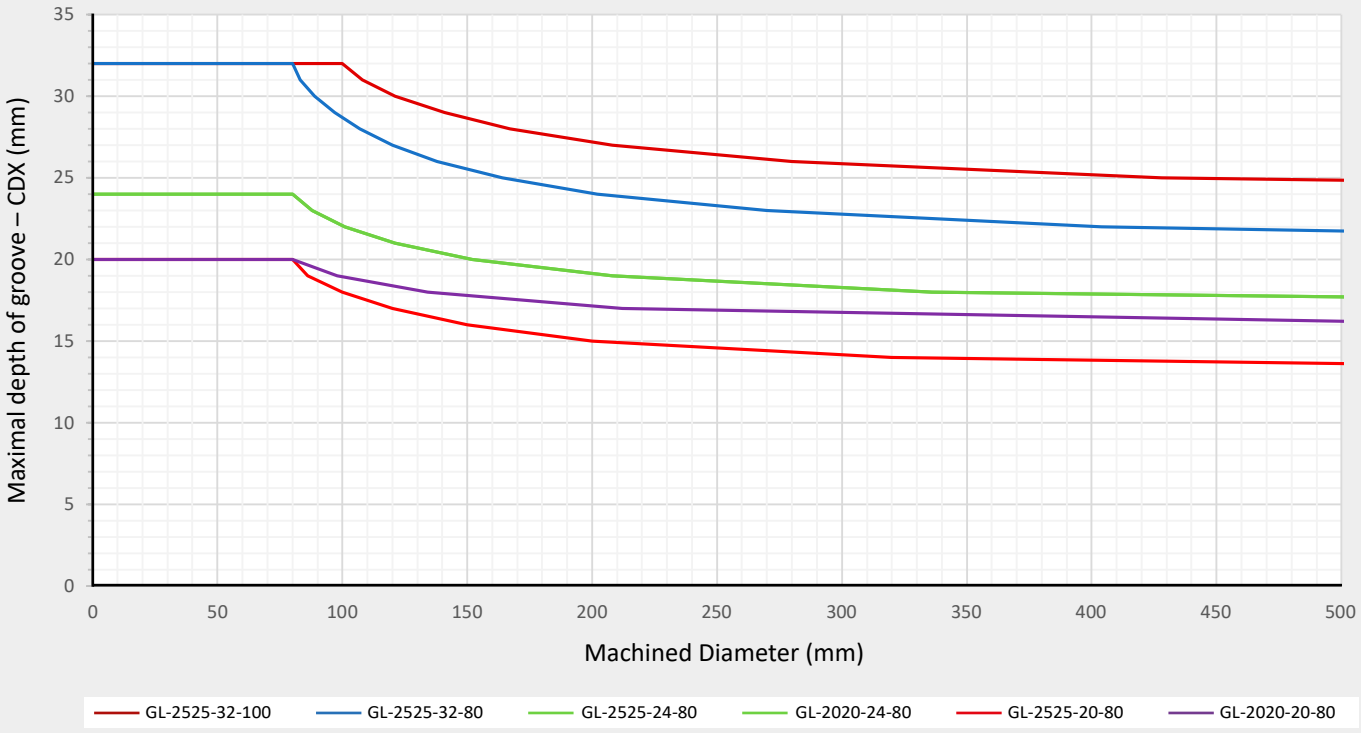
| Product | H (mm) | B (mm) | OAL (mm) | kg | | |
|---|---|---|---|---|---|---|
| **26-DU 2020** | 20 | 20 | 90 | 0.70 | GI007 | ND2 |
| **26-D 2020** | 20 | 20 | 100 | 0.82 | GI007 | ND2 |
| **32-DU 2523** | 25 | 23 | 110 | 1.02 | GI008 | ND2 |
| **32-DU 2532** | 25 | 32 | 110 | 1.10 | GI008 | ND2 |
| **32-DU 3229** | 32 | 29 | 110 | 1.25 | GI008 | ND2 |
| **32-D 2530** | 25 | 30 | 115 | 1.30 | 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 | 3.88 | GI091 | ND3 |

| | | |
|---|---|---|
| GI007 | XLC.N 26.. | GL.-S26.B |
| GI008 | XLC.N 32.. | GL.-S32.B |
| GI009 | XLC.N 45.. | – |
| GI091 | XLC.N 47.. | – |

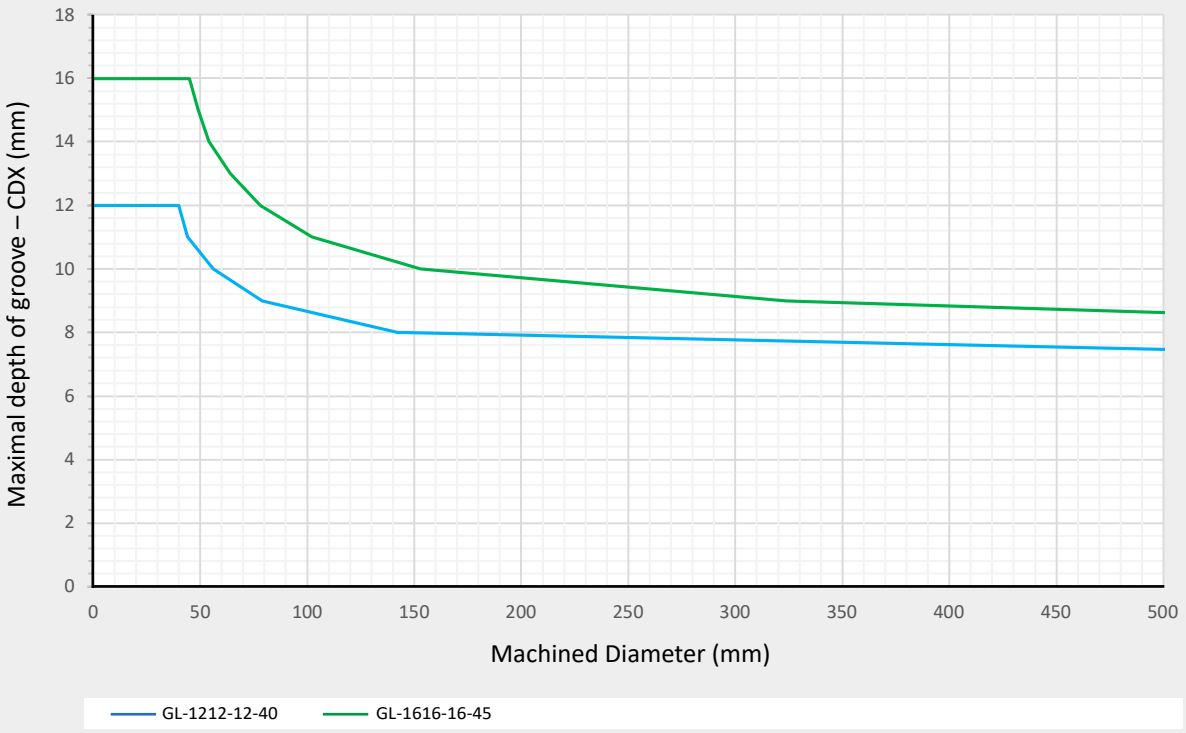
| | | Nm | | | |
|---|---|---|---|---|---|
| ND2 | HS 0625 | 6.0 | M 6 | 25 | HXK 5 |
| ND3 | HS 1030 | 8.0 | M 10 | 30 | HXK 8 |
| ND7 | HS 0630 | 6.0 | M 6 | 30 | HXK 5 |

## CUTTING DEPTHS DEPENDING ON MACHINED DIAMETER

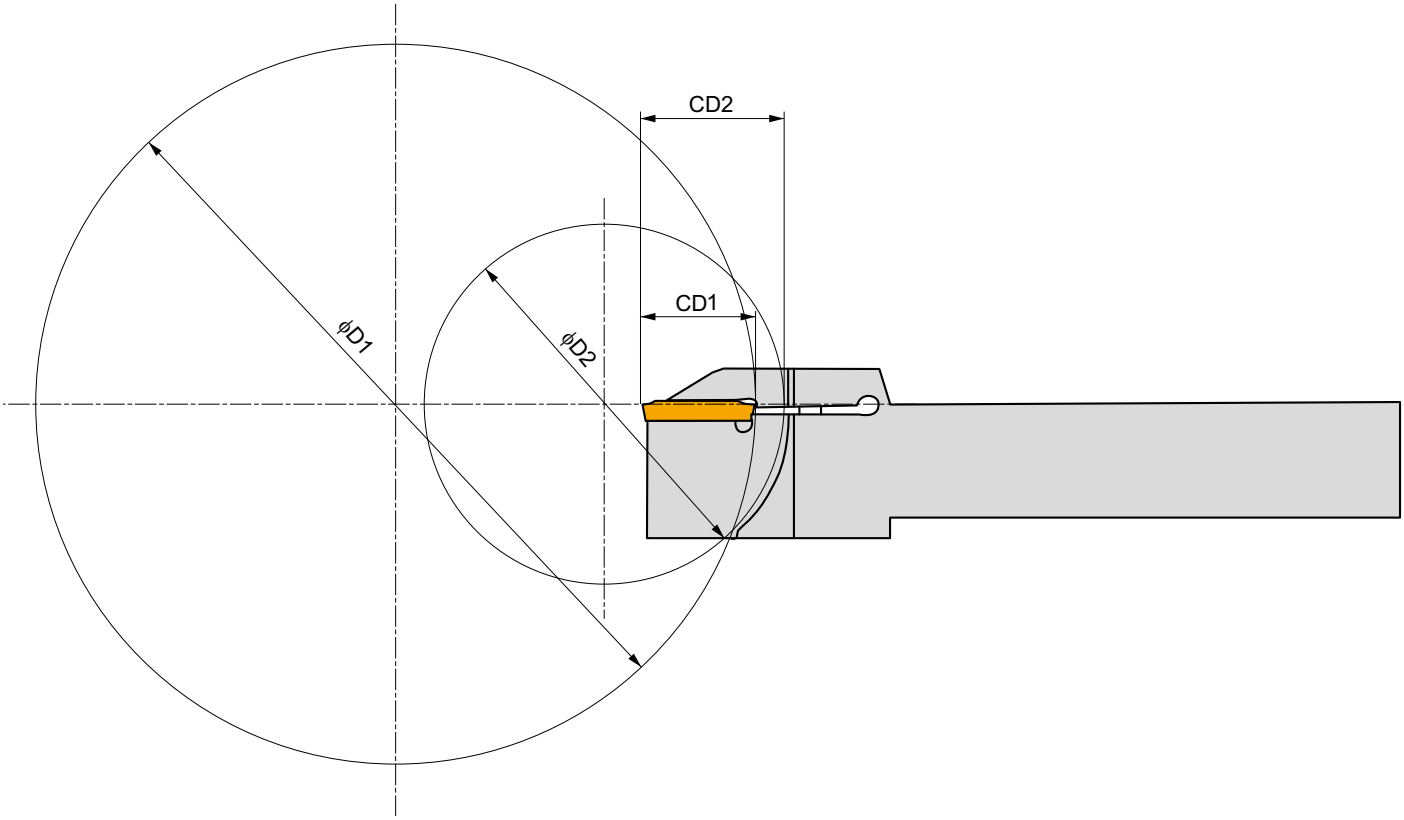
### GLSF (RL) EXT




### GLSF (RL) EXT-S



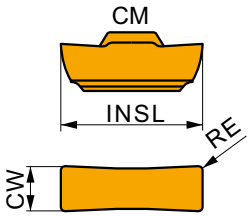
## CUTTING DEPTHS DEPENDING ON MACHINED DIAMETER



# 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 |




Egnethed og startværdier for skærehastighed (vc) og tilførsel (f). Se vores app til bearbejdning af yderligere beregninger.

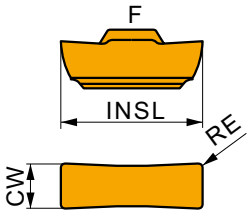
| Product | | RE | P | | M | | K | | N | | S | | H | | PSIRR | PSIRL |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | vc (m/min) | f (mm/rev) | vc (m/min) | f (mm/rev) | vc (m/min) | f (mm/rev) | vc (m/min) | f (mm/rev) | vc (m/min) | f (mm/rev) | vc (m/min) | f (mm/rev) | (°) | (°) |
| | | (mm) | | | | | | | | | | | | | | |
| | R20 5° 5° | | E | | | | | | | | | | | | | |
| | | | CM-geometri og førstevalg til sporstik. | | | | | | | | | | | | | |
| **LCMF 031304-CM** | **T8330** | 0.4 | 130 | 0.11 | 75 | 0.10 | 120 | 0.11 | – | – | – | – | – | – | – | – |
| **LCMF 031304-CM-04** | **T8330**[1)] | 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 | – | – | – | – | – | – | – | – |

[1)] Insert for internal holder A16Q-GGERIL0313-04, A20R-GGFRIL0313-04.

# 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 |



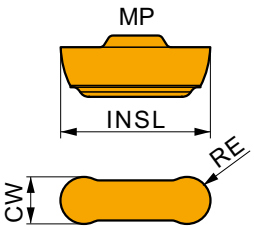

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) | | | | | | | | | | | | | | | | | | |
| | 0,1 0° 12° 0,1 0° 5° | | U | S | | | | | | | | | | | | | | | | |
| | | | F geometri og førstevalg til drejning. | | | | | | | | | | | | | | | | | |
| **LCMF 031302-F** | **T8330** | 0.2 | 195 | 0.10 | 0.3 | 115 | 0.09 | 0.3 | 185 | 0.10 | 0.3 | – | – | – | – | – | – | – | – | – |
| **LCMF 031302-F-04** | **T8330**[1)] | 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 031304-F-04** | **T8330**[1)] | 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 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 275 | 0.13 | 0.5 | 165 | 0.12 | 0.5 | 260 | 0.13 | 0.5 | – | – | – | – | – | – | – | – | – |

[1)] Insert for internal holder A16Q-GGERIL0313-04, A20R-GGFRIL0313-04.

# LCMF 13 - MP

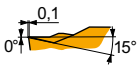
| | CW | CWTOLL | CWTOLU | INSL |
|---|---|---|---|---|
| | (mm) | (mm) | (mm) | (mm) |
| 0313 | 3.00 | -0.05 | 0.05 | 12.6 |
| 0413 | 4.00 | -0.05 | 0.05 | 12.6 |




Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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 0313MO-MP-04** | **T8330**[1)] | 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 | – | – | – | – | – | – | – | – | – |



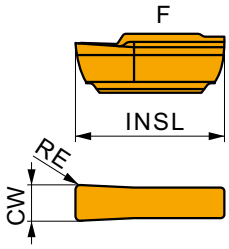



MP-geometri til langsgående drejning og kopiprofilering, fin- og finishbearbejdning og kontinuerlig til afbrudt snit.

[1)] Insert for internal holder A16Q-GGERIL0313-04, A20R-GGFRIL0313-04.

# LCMR 13 - F

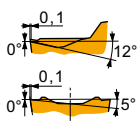
| | CW | CWTOLL | CWTOLU | INSL |
|---|---|---|---|---|
| | (mm) | (mm) | (mm) | (mm) |
| 0313 | 3.00 | -0.05 | 0.05 | 12.6 |
| 0413 | 4.00 | -0.05 | 0.05 | 12.6 |




Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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 031304-F** | **T8330** | 0.4 | 185 | 0.13 | 0.5 | 110 | 0.12 | 0.5 | 175 | 0.13 | 0.5 | – | – | – | – | – | – | – | – | – |
| **LCMR 041304-F** | **T8330** | 0.4 | 185 | 0.13 | 0.5 | 110 | 0.12 | 0.5 | 175 | 0.13 | 0.5 | – | – | – | – | – | – | – | – | – |



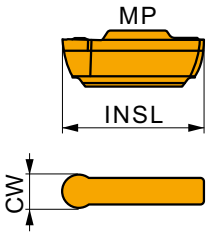



F-geometri til spor og drejning, fin- og finishbearbejdning og kontinuerlige til let afbrudte snit.

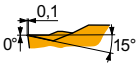
# LCMR 13 - MP

PRAMET

| | CW (mm) | CWTOLL (mm) | CWTOLU (mm) | INSL (mm) |
|---|---|---|---|---|
| 0313 | 3.00 | -0.05 | 0.05 | 12.6 |
| 0413 | 4.00 | -0.05 | 0.05 | 12.6 |




Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |   | | | | | | | | | | | | | | | | | | | |
| MP-geometri til langsgående drejning og kopiprofilering og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **LCMR 0313M0-MP** | **T8330** | 1.5 | ■ 190 | 0.30 | 0.8 | ◪ 110 | 0.27 | 0.8 | ■ 180 | 0.30 | 0.8 | – | – | – | – | – | – | – | – | – |
| **LCMR 0413M0-MP** | **T8330** | 2.0 | ■ 175 | 0.40 | 1.0 | ◪ 105 | 0.36 | 1.0 | ■ 165 | 0.40 | 1.0 | – | – | – | – | – | – | – | – | – |

# GG.(RL) INT

P M K N S H

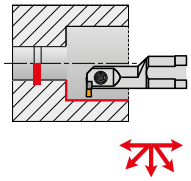
PRAMET

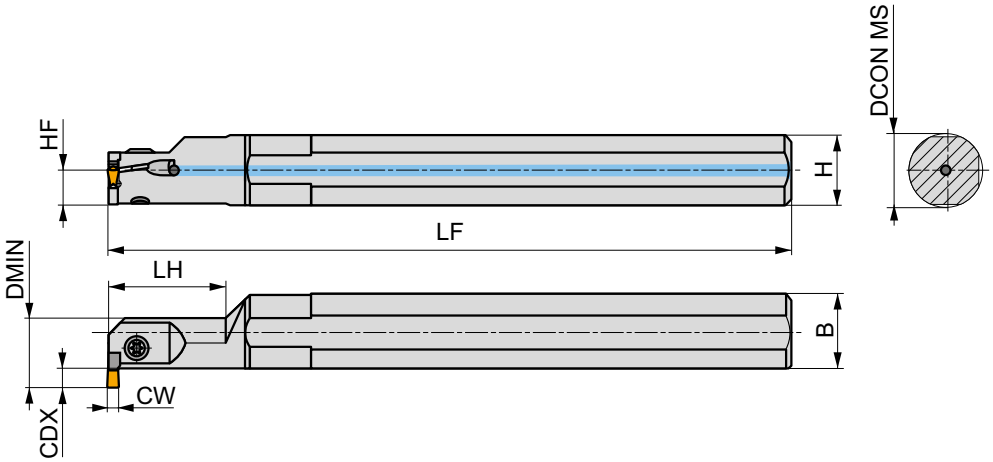
G

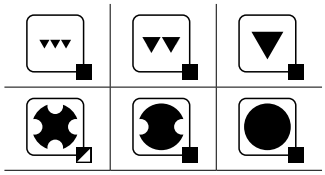


## Intern stik holder til LCM. skær

Indvendigt højre / venstre spor borestang til spor med LCM. 0313 og 0413 skær. Minimum indvendig sporiameter Ø16 mm. Velegnet til indvendig not og drejning i flere retninger. Fås med skaftstørrelse Ø16 op til Ø32 mm. Krop behandlet for længere levetid på værktøjet.





| | 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 | 3.00 | 3 | 16 | ✓ | 0.26 | GI143 | GL06 |
| | A16Q-GGER 0313-04 | 16 | 7.5 | 15 | 15.5 | 180 | 25 | 3.00 | 3 | 16 | ✓ | 0.26 | GI190 | GL06 |
| | A20R-GGFR 0313 | 20 | 9 | 18 | 19 | 200 | 30 | 3.00 | 4.5 | 20 | ✓ | 0.36 | GI143 | GL06 |
| | A20R-GGFR 0313-04 | 20 | 9 | 18 | 19 | 200 | 30 | 3.00 | 4.5 | 20 | ✓ | 0.39 | GI190 | GL06 |
| | A25S-GGHR 0313 | 25 | 11.5 | 23 | 24 | 250 | 40 | 3.00 | 6.5 | 25 | ✓ | 0.78 | GI143 | GL06 |
| | A25S-GGFR 0413 | 25 | 11.5 | 23 | 24 | 250 | 40 | 4.00 | 6.5 | 25 | ✓ | 0.73 | GI170 | GL06 |
| | A32T-GGHR 0413 | 32 | 15 | 30 | 31 | 300 | 50 | 4.00 | 9.5 | 32 | ✓ | 1.59 | GI170 | GL06 |
| L | A16Q-GGEL 0313 | 16 | 7.5 | 15 | 15.5 | 180 | 25 | 3.00 | 3 | 16 | ✓ | 0.29 | GI143 | GL06 |
| | A16Q-GGEL 0313-04 | 16 | 7.5 | 15 | 15.5 | 180 | 25 | 3.00 | 3 | 16 | ✓ | 0.28 | GI190 | GL06 |
| | A20R-GGFL 0313 | 20 | 9 | 18 | 19 | 200 | 30 | 3.00 | 4.5 | 20 | ✓ | 0.38 | GI143 | GL06 |
| | A20R-GGFL 0313-04 | 20 | 9 | 18 | 19 | 200 | 30 | 3.00 | 4.5 | 20 | ✓ | 0.38 | GI190 | GL06 |
| | A25S-GGHL 0313 | 25 | 11.5 | 23 | 24 | 250 | 40 | 3.00 | 6.5 | 25 | ✓ | 0.81 | GI143 | GL06 |
| | A25S-GGFL 0413 | 25 | 11.5 | 23 | 24 | 250 | 40 | 4.00 | 6.5 | 25 | ✓ | 0.82 | GI170 | GL06 |
| | A32T-GGHL 0413 | 32 | 15 | 30 | 31 | 300 | 50 | 4.00 | 9.5 | 32 | ✓ | 1.59 | GI170 | GL06 |

| | |
|---|---|
| GI143 | LCM. 0313.. |
| GI170 | LCM. 0413.. |
| GI190 | LCM. 0313.....-04 |

| | | Nm | | | |
|---|---|---|---|---|---|
| GL06 | SR 85011-T15P | 5.0 | M 5 | 9 | FLAG T15P |

# GFIL-L AXIAL

P M K N S H

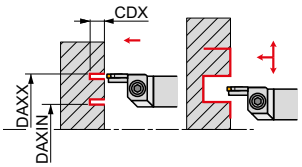
PRAMET

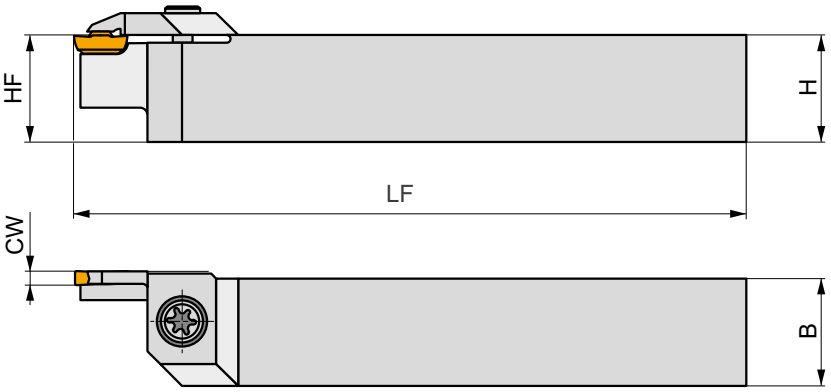
G

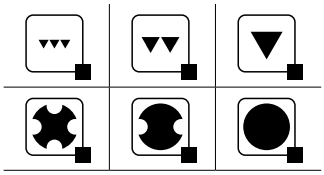


## Eksternt aksialt V-Groove Top Clamp Grooving Værktøj til LCM. 03 skær

Ekstern venstre aksial værktøjsholder til sporing med enkelt- eller dobbeltsidet LCM. 0313 eller 0316 skær. Velegnet til aksial notning, aksial profilering eller notudvidelse Ø17 op til Ø170 mm applikationer med maksimal skæredybde 9 mm. Fås med skaftstørrelse 25x25 mm. Krop behandlet for længere levetid





| | Product | HF (mm) | H (mm) | B (mm) | LF (mm) | CW (mm) | CDX (mm) | DAXIN (mm) | DAXX (mm) | kg | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| L | **GFIL 2525 M 0313L 030017** | 25 | 25 | 25 | 150 | 3.00 | 9 | 17 | 30 | 0.64 | GI143 | GL02 |
| | **GFIL 2525 M 0313L 039024** | 25 | 25 | 25 | 150 | 3.00 | 9 | 24 | 39 | 0.66 | GI143 | GL07 |
| | **GFIL 2525 M 0313L 050033** | 25 | 25 | 25 | 150 | 3.00 | 9 | 33 | 50 | 0.67 | GI143 | GL07 |
| | **GFIL 2525 M 0313L 060043** | 25 | 25 | 25 | 150 | 3.00 | 9 | 43 | 60 | 0.67 | GI143 | GL07 |
| | **GFIL 2525 M 0313L 076053** | 25 | 25 | 25 | 150 | 3.00 | 9 | 53 | 76 | 0.67 | GI143 | GL07 |
| | **GFIL 2525 M 0316L 100070** | 25 | 25 | 25 | 150 | 3.00 | 9 | 70 | 100 | 0.69 | GI136 | GL07 |
| | **GFIL 2525 M 0316L 130090** | 25 | 25 | 25 | 150 | 3.00 | 9 | 90 | 130 | 0.70 | GI136 | GL07 |
| | **GFIL 2525 M 0316L 170110** | 25 | 25 | 25 | 150 | 3.00 | 9 | 110 | 170 | 0.71 | GI136 | GL07 |

| | |
|---|---|
| GI136 | LCM. 0316.. |
| GI143 | LCM. 0313.. |

| | | Nm | | | |
|---|---|---|---|---|---|
| GL02 | US 5015-T20P | 5.0 | M 5 | 15 | FLAG T20P |
| GL07 | US 5018-T20P | 5.0 | M 5 | 18.2 | FLAG T20P |

# GFIL-R AXIAL

P M K N S H

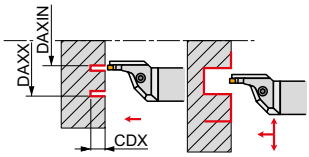
PRAMET

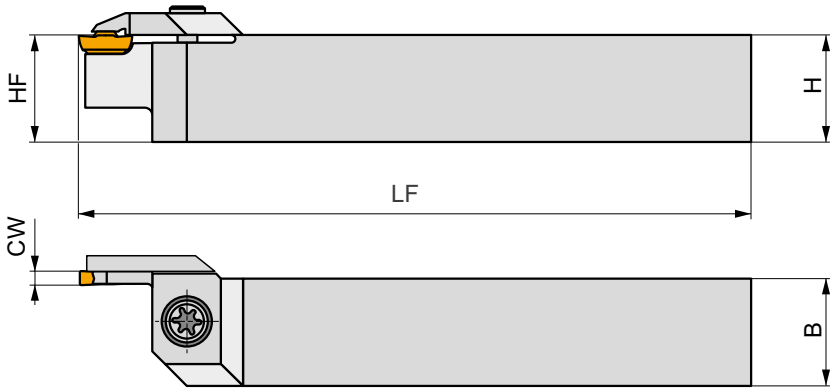
G

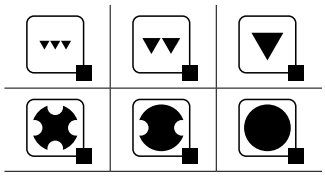


## Eksternt aksialt V-Groove Top Clamp Grooving Tool til LCM. 03 eller 04 skær

Ekstern venstre aksial værktøjsholder til sporing med enkelt- eller dobbeltsidet LCM. 0313, 0316, 0413 eller 0416 skær. Velegnet til aksial notning, aksial profilering eller notudvidelse Ø17 op til Ø230 mm applikationer med maksimal skæredybde 12 mm. Fås med skaftstørrelse 25x25. Krop behandlet for længere levetid





| | Product | HF (mm) | H (mm) | B (mm) | LF (mm) | CW (mm) | CDX (mm) | DAXIN (mm) | DAXX (mm) | kg | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| L | GFIL 2525 M 03R 030017-A | 25 | 25 | 25 | 150 | 3.00 | 9 | 17 | 30 | 0.69 | GI143 | GL07 |
| | GFIL 2525 M 03R 039024-A | 25 | 25 | 25 | 150 | 3.00 | 9 | 24 | 39 | 0.69 | GI143 | GL07 |
| | GFIL 2525 M 03R 050033-A | 25 | 25 | 25 | 150 | 3.00 | 9 | 33 | 50 | 0.72 | GI143 | GL07 |
| | GFIL 2525 M 03R 060043-A | 25 | 25 | 25 | 150 | 3.00 | 9 | 43 | 60 | 0.69 | GI143 | GL07 |
| | GFIL 2525 M 03R 076053-A | 25 | 25 | 25 | 150 | 3.00 | 9 | 53 | 76 | 0.68 | GI143 | GL07 |
| | GFIL 2525 M 03R 100070-A | 25 | 25 | 25 | 150 | 3.00 | 9 | 70 | 100 | 0.79 | GI136 | GL08 |
| | GFIL 2525 M 03R 130090-A | 25 | 25 | 25 | 150 | 3.00 | 9 | 90 | 130 | 0.73 | GI136 | GL08 |
| | GFIL 2525 M 03R 170110-A | 25 | 25 | 25 | 150 | 3.00 | 9 | 110 | 170 | 0.76 | GI136 | GL08 |
| | GFIL 2525 M 04R 030017-A | 25 | 25 | 25 | 150 | 3.00 | 9 | 17 | 30 | 0.71 | GI170 | GL07 |
| | GFIL 2525 M 04R 034021-A | 25 | 25 | 25 | 150 | 4.00 | 9 | 21 | 34 | 0.69 | GI170 | GL07 |
| | GFIL 2525 M 04R 040026-A | 25 | 25 | 25 | 150 | 4.00 | 11 | 26 | 40 | 0.00 | GI170 | GL07 |
| | GFIL 2525 M 04R 050032-A | 25 | 25 | 25 | 150 | 4.00 | 11 | 32 | 50 | 0.68 | GI170 | GL07 |
| | GFIL 2525 M 04R 060042-A | 25 | 25 | 25 | 150 | 4.00 | 11 | 42 | 60 | 0.66 | GI170 | GL07 |
| | GFIL 2525 M 04R 075052-A | 25 | 25 | 25 | 150 | 4.00 | 11 | 52 | 75 | 0.67 | GI170 | GL07 |
| | GFIL 2525 M 04R 100070-A | 25 | 25 | 25 | 150 | 4.00 | 12 | 70 | 100 | 0.75 | GI137 | GL08 |
| | GFIL 2525 M 04R 130090-A | 25 | 25 | 25 | 150 | 4.00 | 12 | 90 | 130 | 0.75 | GI137 | GL08 |
| | GFIL 2525 M 04R 170110-A | 25 | 25 | 25 | 150 | 4.00 | 12 | 110 | 170 | 0.75 | GI137 | GL08 |
| | GFIL 2525 M 04R 230140-A | 25 | 25 | 25 | 150 | 4.00 | 12 | 140 | 230 | 0.78 | GI137 | GL08 |

| | |
|---|---|
| GI136 | LCM. 0316.. |
| GI137 | LCM. 0416.. |
| GI143 | LCM. 0313.. |
| GI170 | LCM. 0413.. |

| | | Nm | | | | |
|---|---|---|---|---|---|---|
| GL07 | US 5018-T20P | 5.0 | M 5 | 18.2 | FLAG T20P | – |
| GL08 | US 6020-T25P | 6.0 | M 6 | 20.2 | – | SDR T25P |

# GFIR-L AXIAL

P M K N S H

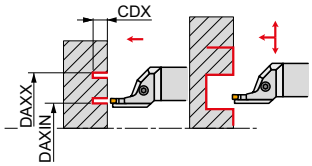
PRAMET

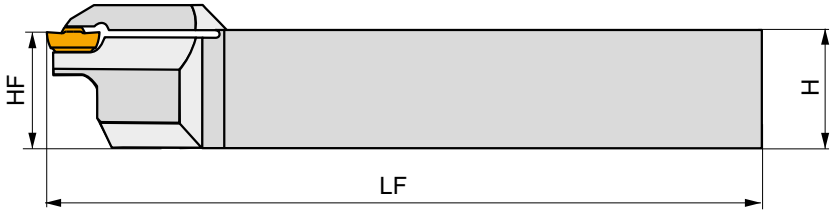
G



## Eksternt aksialt V-Groove Top Clamp Grooving Værktøj til LCM. 03 og 04 skær

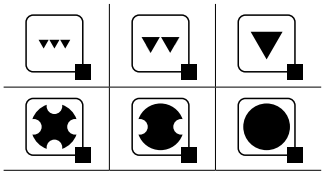
Ekstern højre aksial værktøjsholder til spor med enkelt- eller dobbeltsidet LCM. 0313, 0316, 0413 eller 0416 skær. Velegnet til aksial notstik, aksial profilering eller notudvidelse Ø17 op til Ø230 mm applikationer med maksimal skæredybde 12 mm. Fås med skaftstørrelse 25x25 mm. Krop behandlet for længere levetid på værktøjet.











| | Product | HF (mm) | H (mm) | B (mm) | LF (mm) | CW (mm) | CDX (mm) | DAXIN (mm) | DAXX (mm) | kg | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| R | GFIR 2525 M 03L 030017-A | 25 | 25 | 25 | 150 | 3.00 | 9 | 17 | 30 | 0.65 | GI143 | GL07 |
| | GFIR 2525 M 03L 039024-A | 25 | 25 | 25 | 150 | 3.00 | 9 | 24 | 39 | 0.68 | GI143 | GL07 |
| | GFIR 2525 M 03L 050033-A | 25 | 25 | 25 | 150 | 3.00 | 9 | 33 | 50 | 0.65 | GI143 | GL07 |
| | GFIR 2525 M 03L 060043-A | 25 | 25 | 25 | 150 | 3.00 | 9 | 43 | 60 | 0.68 | GI143 | GL07 |
| | GFIR 2525 M 03L 076053-A | 25 | 25 | 25 | 150 | 3.00 | 9 | 53 | 76 | 0.69 | GI143 | GL07 |
| | GFIR 2525 M 03L 100070-A | 25 | 25 | 25 | 150 | 3.00 | 9 | 70 | 100 | 0.75 | GI136 | GL08 |
| | GFIR 2525 M 03L 130090-A | 25 | 25 | 25 | 150 | 3.00 | 9 | 90 | 130 | 0.76 | GI136 | GL08 |
| | GFIR 2525 M 03L 170110-A | 25 | 25 | 25 | 150 | 3.00 | 9 | 110 | 170 | 0.68 | GI136 | GL08 |
| | GFIR 2525 M 04L 030017-A | 25 | 25 | 25 | 150 | 3.00 | 9 | 17 | 30 | 0.68 | GI170 | GL07 |
| | GFIR 2525 M 04L 034021-A | 25 | 25 | 25 | 150 | 4.00 | 9 | 21 | 34 | 0.68 | GI170 | GL07 |
| | GFIR 2525 M 04L 040026-A | 25 | 25 | 25 | 150 | 4.00 | 11 | 26 | 40 | 0.68 | GI170 | GL07 |
| | GFIR 2525 M 04L 050032-A | 25 | 25 | 25 | 150 | 4.00 | 11 | 32 | 50 | 0.66 | GI170 | GL07 |
| | GFIR 2525 M 04L 060042-A | 25 | 25 | 25 | 150 | 4.00 | 11 | 42 | 60 | 0.69 | GI170 | GL07 |
| | GFIR 2525 M 04L 075052-A | 25 | 25 | 25 | 150 | 4.00 | 11 | 52 | 75 | 0.67 | GI170 | GL07 |
| | GFIR 2525 M 04L 100070-A | 25 | 25 | 25 | 150 | 4.00 | 12 | 70 | 100 | 0.72 | GI137 | GL08 |
| | GFIR 2525 M 04L 130090-A | 25 | 25 | 25 | 150 | 4.00 | 12 | 90 | 130 | 0.75 | GI137 | GL08 |
| | GFIR 2525 M 04L 170110-A | 25 | 25 | 25 | 150 | 4.00 | 12 | 110 | 170 | 0.72 | GI137 | GL08 |
| | GFIR 2525 M 04L 230140-A | 25 | 25 | 25 | 150 | 4.00 | 12 | 140 | 230 | 0.79 | GI137 | GL08 |

| | |
|---|---|
| GI136 | LCM. 0316.. |
| GI137 | LCM. 0416.. |
| GI143 | LCM. 0313.. |
| GI170 | LCM. 0413.. |

| | | Nm | | | | |
|---|---|---|---|---|---|---|
| GL07 | US 5018-T20P | 5.0 | M 5 | 18.2 | FLAG T20P | – |
| GL08 | US 6020-T25P | 6.0 | M 6 | 20.2 | – | SDR T25P |

# GFIR-R AXIAL

P M K N S H

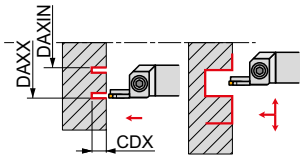
PRAMET

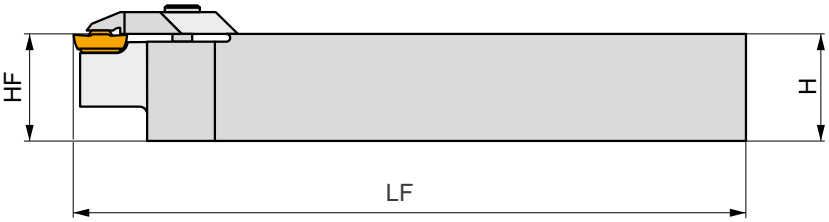
G



## Eksternt aksialt V-Groove Top Clamp Grooving Værktøj til LCM. 03 skær

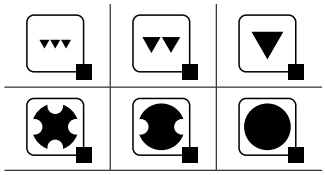
Ekstern højre aksial værktøjsholder til spor med enkelt- eller dobbeltsidet LCM. 0313 eller 0316 skær. Velegnet til aksial notstik, aksial profilering eller notudvidelse Ø17 op til Ø170 mm applikationer med maksimal skæredybde 9 mm. Fås med skaftstørrelse 25x25 mm. Krop behandlet for længere levetid på værktøjet.











| | Product | HF (mm) | H (mm) | B (mm) | LF (mm) | CW (mm) | CDX (mm) | DAXIN (mm) | DAXX (mm) | kg | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| R | **GFIR 2525 M 0313R 030017** | 25 | 25 | 25 | 150 | 3.00 | 9 | 17 | 30 | 0.65 | GI143 | GL02 |
| | **GFIR 2525 M 0313R 039024** | 25 | 25 | 25 | 150 | 3.00 | 9 | 24 | 39 | 0.66 | GI143 | GL07 |
| | **GFIR 2525 M 0313R 050033** | 25 | 25 | 25 | 150 | 3.00 | 9 | 33 | 50 | 0.68 | GI143 | GL07 |
| | **GFIR 2525 M 0313R 060043** | 25 | 25 | 25 | 150 | 3.00 | 9 | 43 | 60 | 0.68 | GI143 | GL07 |
| | **GFIR 2525 M 0313R 076053** | 25 | 25 | 25 | 150 | 3.00 | 9 | 53 | 76 | 0.68 | GI143 | GL07 |
| | **GFIR 2525 M 0316R 100070** | 25 | 25 | 25 | 150 | 3.00 | 9 | 70 | 100 | 0.69 | GI136 | GL07 |
| | **GFIR 2525 M 0316R 130090** | 25 | 25 | 25 | 150 | 3.00 | 9 | 90 | 130 | 0.70 | GI136 | GL07 |
| | **GFIR 2525 M 0316R 170110** | 25 | 25 | 25 | 150 | 3.00 | 9 | 110 | 170 | 0.70 | GI136 | GL07 |

| | |
|---|---|
| GI136 | LCM. 0316.. |
| GI143 | LCM. 0313.. |

| | | Nm | | | |
|---|---|---|---|---|---|
| GL02 | US 5015-T20P | 5.0 | M 5 | 15 | FLAG T20P |
| GL07 | US 5018-T20P | 5.0 | M 5 | 18.2 | FLAG T20P |

# GFML-L AXIAL

P M K N S H

PRAMET

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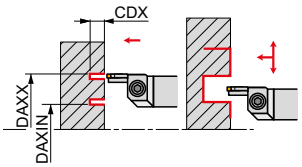
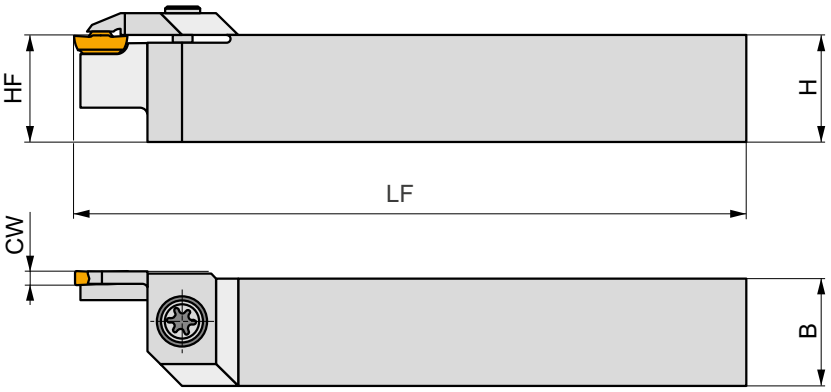
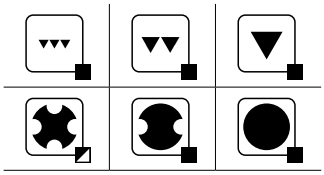
## Eksternt aksialt V-Groove Top Clamp Grooving Tool til LCM. 04 skær

Ekstern venstre aksial værktøjsholder til sporing med enkelt- eller dobbeltsidet LCM. 0413 eller 0416 skær. Velegnet til dyb aksial rille, aksial profilering eller rille udvidelse Ø17 op til Ø230 mm applikationer, med maksimal skæredybde 20 mm. Fås med skaftstørrelse 25x25 mm. Krop behandlet for længere levetid





| | Product | HF (mm) | H (mm) | B (mm) | LF (mm) | CW (mm) | CDX (mm) | DAXIN (mm) | DAXX (mm) | kg | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| L | **GFML 2525 M 0413L 030017** | 25 | 25 | 25 | 150 | 4.00 | 20 | 17 | 30 | 0.62 | GI170 | GL02 |
| | **GFML 2525 M 0413L 034021** | 25 | 25 | 25 | 150 | 4.00 | 20 | 21 | 34 | 0.63 | GI170 | GL07 |
| | **GFML 2525 M 0413L 040026** | 25 | 25 | 25 | 150 | 4.00 | 20 | 26 | 40 | 0.65 | GI170 | GL07 |
| | **GFML 2525 M 0413L 050032** | 25 | 25 | 25 | 150 | 4.00 | 20 | 32 | 50 | 0.64 | GI170 | GL07 |
| | **GFML 2525 M 0413L 060042** | 25 | 25 | 25 | 150 | 4.00 | 20 | 42 | 60 | 0.65 | GI170 | GL07 |
| | **GFML 2525 M 0413L 075052** | 25 | 25 | 25 | 150 | 4.00 | 20 | 52 | 75 | 0.66 | GI170 | GL07 |
| | **GFML 2525 M 0416L 100070** | 25 | 25 | 25 | 150 | 4.00 | 20 | 70 | 100 | 0.66 | GI137 | GL07 |
| | **GFML 2525 M 0416L 130090** | 25 | 25 | 25 | 150 | 4.00 | 20 | 90 | 130 | 0.67 | GI137 | GL07 |
| | **GFML 2525 M 0416L 170110** | 25 | 25 | 25 | 150 | 4.00 | 20 | 110 | 170 | 0.67 | GI137 | GL07 |
| | **GFML 2525 M 0416L 230140** | 25 | 25 | 25 | 150 | 4.00 | 20 | 140 | 230 | 0.67 | GI137 | GL07 |

| | |
|---|---|
| GI137 | LCM. 0416.. |
| GI170 | LCM. 0413.. |

| | | Nm | | | |
|---|---|---|---|---|---|
| GL02 | US 5015-T20P | 5.0 | M 5 | 15 | FLAG T20P |
| GL07 | US 5018-T20P | 5.0 | M 5 | 18.2 | FLAG T20P |

# GFML-R AXIAL

P M K N S H

PRAMET

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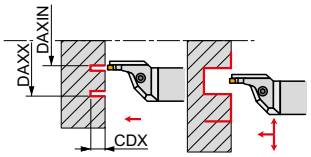
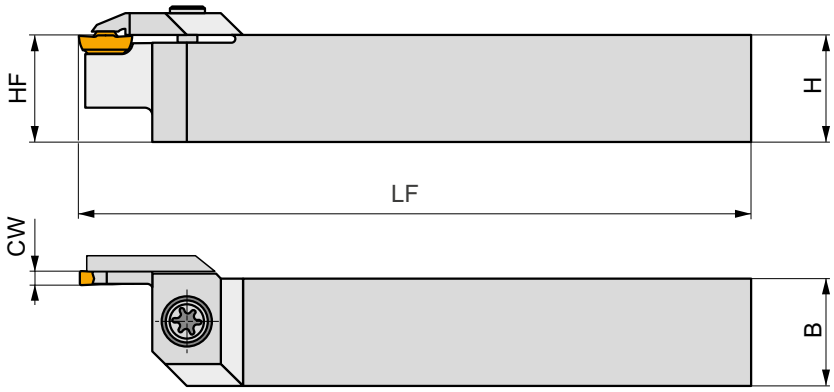
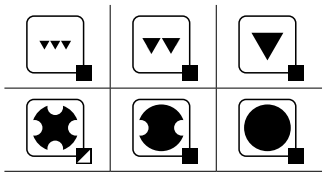
## Eksternt aksialt V-Groove Top Clamp Grooving Tool til LCM. 04 skær

Ekstern venstre aksial værktøjsholder til sporing med enkelt- eller dobbeltsidet LCM. 0413 eller 0416 skær. Velegnet til dyb aksial rille, aksial profilering eller rille udvidelse Ø17 op til Ø230 mm applikationer, med maksimal skæredybde 20 mm. Fås med skaftstørrelse 25x25 mm. Krop behandlet for længere levetid





| | Product | HF (mm) | H (mm) | B (mm) | LF (mm) | CW (mm) | CDX (mm) | DAXIN (mm) | DAXX (mm) | kg | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| L | **GFML 2525 M 0413R 030017** | 25 | 25 | 25 | 150 | 4.00 | 20 | 17 | 30 | 0.68 | GI170 | GL07 |
| | **GFML 2525 M 0413R 034021** | 25 | 25 | 25 | 150 | 4.00 | 20 | 21 | 34 | 0.69 | GI170 | GL07 |
| | **GFML 2525 M 0413R 040026** | 25 | 25 | 25 | 150 | 4.00 | 20 | 26 | 40 | 0.69 | GI170 | GL07 |
| | **GFML 2525 M 0413R 050032** | 25 | 25 | 25 | 150 | 4.00 | 20 | 32 | 50 | 0.68 | GI170 | GL07 |
| | **GFML 2525 M 0413R 060042** | 25 | 25 | 25 | 150 | 4.00 | 20 | 42 | 60 | 0.69 | GI170 | GL07 |
| | **GFML 2525 M 0413R 075052** | 25 | 25 | 25 | 150 | 4.00 | 20 | 52 | 75 | 0.69 | GI170 | GL07 |
| | **GFML 2525 M 0416R 100070** | 25 | 25 | 25 | 150 | 4.00 | 20 | 70 | 100 | 0.80 | GI137 | GL08 |
| | **GFML 2525 M 0416R 130090** | 25 | 25 | 25 | 150 | 4.00 | 20 | 90 | 130 | 0.78 | GI137 | GL08 |
| | **GFML 2525 M 0416R 170110** | 25 | 25 | 25 | 150 | 4.00 | 20 | 110 | 170 | 0.78 | GI137 | GL08 |
| | **GFML 2525 M 0416R 230140** | 25 | 25 | 25 | 150 | 4.00 | 20 | 140 | 230 | 0.78 | GI137 | GL08 |

| | |
|---|---|
| GI137 | LCM. 0416.. |
| GI170 | LCM. 0413.. |

| | | Nm | | | | |
|---|---|---|---|---|---|---|
| GL07 | US 5018-T20P | 5.0 | M 5 | 18.2 | FLAG T20P | – |
| GL08 | US 6020-T25P | 6.0 | M 6 | 20.2 | – | SDR T25P |

# GFMR-L AXIAL

P M K N S H

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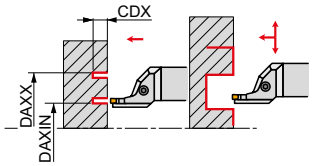
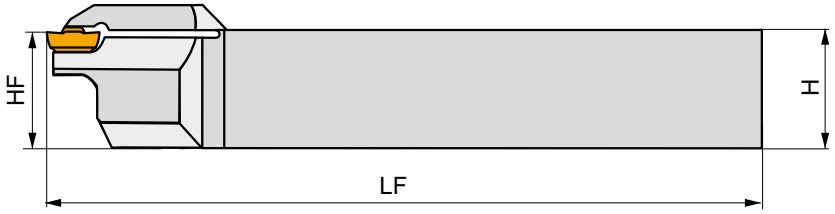
## Eksternt aksialt V-Groove Top Clamp Grooving Værktøj til LCM. 04 skær

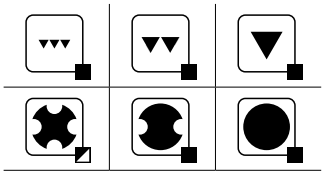
Ekstern højre aksial værktøjsholder til sporstik med enkelt- eller dobbeltsidet LCM. 0413 eller 0416 skær. Velegnet til dyb aksial spor, aksial profilering eller spor udvidelse Ø17 op til Ø230 mm applikationer med maksimal skæredybde 20 mm. Fås med skaftstørrelse 25x25 mm. Krop behandlet for længere levetid på værktøjet.











| | Product | HF (mm) | H (mm) | B (mm) | LF (mm) | CW (mm) | CDX (mm) | DAXIN (mm) | DAXX (mm) | kg | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| R | GFMR 2525 M 0413L 030017 | 25 | 25 | 25 | 150 | 4.00 | 20 | 17 | 30 | 0.70 | GI170 | GL07 |
| | GFMR 2525 M 0413L 034021 | 25 | 25 | 25 | 150 | 4.00 | 20 | 21 | 34 | 0.66 | GI170 | GL07 |
| | GFMR 2525 M 0413L 040026 | 25 | 25 | 25 | 150 | 4.00 | 20 | 26 | 40 | 0.66 | GI170 | GL07 |
| | GFMR 2525 M 0413L 050032 | 25 | 25 | 25 | 150 | 4.00 | 20 | 32 | 50 | 0.68 | GI170 | GL07 |
| | GFMR 2525 M 0413L 060042 | 25 | 25 | 25 | 150 | 4.00 | 20 | 42 | 60 | 0.66 | GI170 | GL07 |
| | GFMR 2525 M 0413L 075052 | 25 | 25 | 25 | 150 | 4.00 | 20 | 52 | 75 | 0.69 | GI170 | GL07 |
| | GFMR 2525 M 0416L 100070 | 25 | 25 | 25 | 150 | 4.00 | 20 | 70 | 100 | 0.88 | GI137 | GL08 |
| | GFMR 2525 M 0416L 130090 | 25 | 25 | 25 | 150 | 4.00 | 20 | 90 | 130 | 0.78 | GI137 | GL08 |
| | GFMR 2525 M 0416L 170110 | 25 | 25 | 25 | 150 | 4.00 | 20 | 110 | 170 | 0.81 | GI137 | GL08 |
| | GFMR 2525 M 0416L 230140 | 25 | 25 | 25 | 150 | 4.00 | 20 | 140 | 230 | 0.78 | GI137 | GL08 |

| | |
|---|---|
| GI137 | LCM. 0416.. |
| GI170 | LCM. 0413.. |

| | | Nm | | | | |
|---|---|---|---|---|---|---|
| GL07 | US 5018-T20P | 5.0 | M 5 | 18.2 | FLAG T20P | – |
| GL08 | US 6020-T25P | 6.0 | M 6 | 20.2 | – | SDR T25P |

# GFMR-R AXIAL

P M K N S H

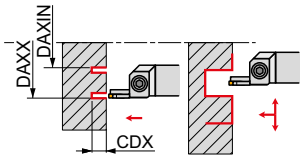
PRAMET

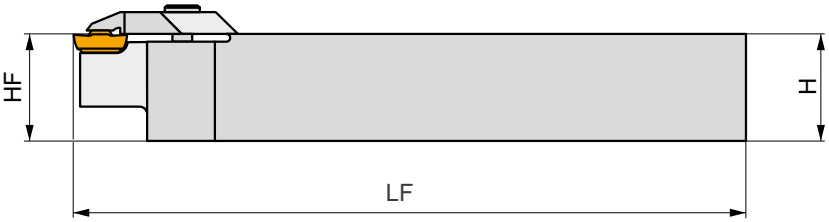
G



## Eksternt aksialt V-Groove Top Clamp Grooving Værktøj til LCM. 04 skær

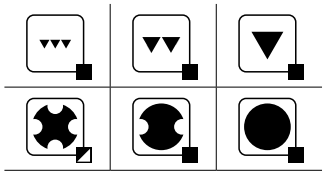
Ekstern højre aksial værktøjsholder til sporstik med enkelt- eller dobbeltsidet LCM. 0413 eller 0416 skær. Velegnet til dyb aksial spor, aksial profilering eller spor udvidelse Ø17 op til Ø230 mm applikationer med maksimal skæredybde 20 mm. Fås med skaftstørrelse 25x25 mm. Krop behandlet for længere levetid på værktøjet.











| | Product | HF (mm) | H (mm) | B (mm) | LF (mm) | CW (mm) | CDX (mm) | DAXIN (mm) | DAXX (mm) | kg | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| R | **GFMR 2525 M 0413R 030017** | 25 | 25 | 25 | 150 | 4.00 | 20 | 17 | 30 | 0.62 | GI170 | GL02 |
| | **GFMR 2525 M 0413R 034021** | 25 | 25 | 25 | 150 | 4.00 | 20 | 21 | 34 | 0.63 | GI170 | GL07 |
| | **GFMR 2525 M 0413R 040026** | 25 | 25 | 25 | 150 | 4.00 | 20 | 26 | 40 | 0.64 | GI170 | GL07 |
| | **GFMR 2525 M 0413R 050032** | 25 | 25 | 25 | 150 | 4.00 | 20 | 32 | 50 | 0.63 | GI170 | GL07 |
| | **GFMR 2525 M 0413R 060042** | 25 | 25 | 25 | 150 | 4.00 | 20 | 42 | 60 | 0.64 | GI170 | GL07 |
| | **GFMR 2525 M 0413R 075052** | 25 | 25 | 25 | 150 | 4.00 | 20 | 52 | 75 | 0.67 | GI170 | GL07 |
| | **GFMR 2525 M 0416R 100070** | 25 | 25 | 25 | 150 | 4.00 | 20 | 70 | 100 | 0.67 | GI137 | GL07 |
| | **GFMR 2525 M 0416R 130090** | 25 | 25 | 25 | 150 | 4.00 | 20 | 90 | 130 | 0.66 | GI137 | GL07 |
| | **GFMR 2525 M 0416R 170110** | 25 | 25 | 25 | 150 | 4.00 | 20 | 110 | 170 | 0.67 | GI137 | GL07 |
| | **GFMR 2525 M 0416R 230140** | 25 | 25 | 25 | 150 | 4.00 | 20 | 140 | 230 | 0.68 | GI137 | GL07 |

| | |
|---|---|
| GI137 | LCM. 0416.. |
| GI170 | LCM. 0413.. |

| | | Nm | | | |
|---|---|---|---|---|---|
| GL02 | US 5015-T20P | 5.0 | M 5 | 15 | FLAG T20P |
| GL07 | US 5018-T20P | 5.0 | M 5 | 18.2 | FLAG T20P |

# GGI(RL)-90 AXIAL

P M K N S H

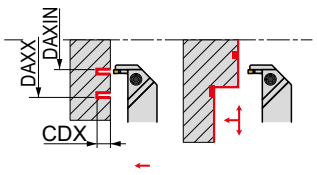
PRAMET

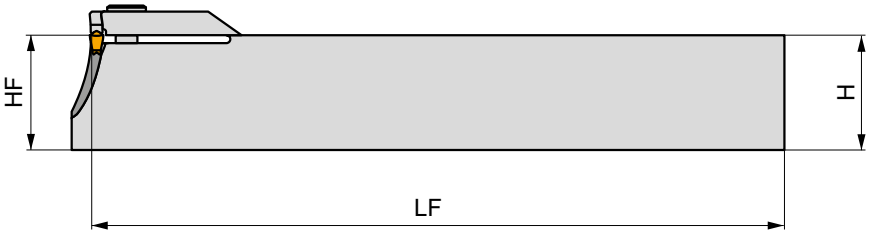
G

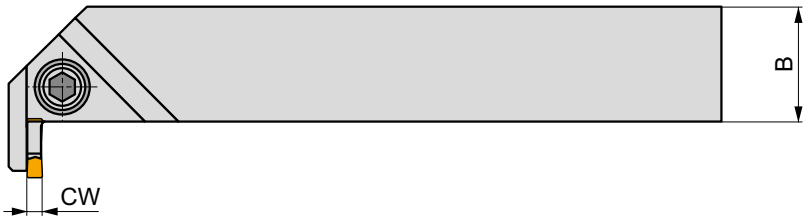


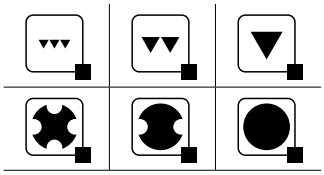
## Eksternt aksialt 90 ° V-rille Top Clamp Grooving Tool til LCM. 03 skær

Ekstern højre / venstre aksial 90° værktøjsholder til spor med enkel eller dobbeltsidet LCM. 0313 eller 0316 skær. Velegnet til aksial notning, aksial profilering eller notudvidelse Ø17 op til Ø170 mm applikationer med maksimal skæredybde 11 mm. Fås med skaftstørrelse 25x25 mm. Krop behandlet for længere levetid





| | Product | HF (mm) | H (mm) | B (mm) | LF (mm) | CW (mm) | CDX (mm) | DAXIN (mm) | DAXX (mm) | kg | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| R | GGIR 2525 M 03R 030017 | 25 | 25 | 25 | 150 | 3.00 | 9.5 | 17 | 30 | 0.75 | GI143 | GL01 |
| | GGIR 2525 M 03R 039024 | 25 | 25 | 25 | 150 | 3.00 | 9.5 | 24 | 39 | 0.78 | GI143 | GL01 |
| | GGIR 2525 M 03R 050033 | 25 | 25 | 25 | 150 | 3.00 | 11 | 33 | 50 | 0.75 | GI143 | GL01 |
| | GGIR 2525 M 03R 060043 | 25 | 25 | 25 | 150 | 3.00 | 11 | 43 | 60 | 0.78 | GI143 | GL01 |
| | GGIR 2525 M 03R 076053 | 25 | 25 | 25 | 150 | 3.00 | 11 | 53 | 76 | 0.75 | GI143 | GL01 |
| | GGIR 2525 M 03R 100070 | 25 | 25 | 25 | 150 | 3.00 | 9 | 70 | 100 | 0.78 | GI136 | GL04 |
| | GGIR 2525 M 03R 130090 | 25 | 25 | 25 | 150 | 3.00 | 9 | 90 | 130 | 0.73 | GI136 | GL04 |
| | GGIR 2525 M 03R 170110 | 25 | 25 | 25 | 150 | 3.00 | 9 | 110 | 170 | 0.76 | GI136 | GL04 |
| L | GGIL 2525 M 03L 030017 | 25 | 25 | 25 | 150 | 3.00 | 9.5 | 17 | 30 | 0.75 | GI143 | GL01 |
| | GGIL 2525 M 03L 039024 | 25 | 25 | 25 | 150 | 3.00 | 9.5 | 24 | 39 | 0.25 | GI143 | GL01 |
| | GGIL 2525 M 03L 050033 | 25 | 25 | 25 | 150 | 3.00 | 11 | 33 | 50 | 0.75 | GI143 | GL01 |
| | GGIL 2525 M 03L 060043 | 25 | 25 | 25 | 150 | 3.00 | 11 | 43 | 60 | 0.75 | GI143 | GL01 |
| | GGIL 2525 M 03L 076053 | 25 | 25 | 25 | 150 | 3.00 | 11 | 53 | 76 | 0.75 | GI143 | GL01 |
| | GGIL 2525 M 03L 100070 | 25 | 25 | 25 | 150 | 3.00 | 9 | 70 | 100 | 0.77 | GI136 | GL04 |
| | GGIL 2525 M 03L 130090 | 25 | 25 | 25 | 150 | 3.00 | 9 | 90 | 130 | 0.77 | GI136 | GL04 |
| | GGIL 2525 M 03L 170110 | 25 | 25 | 25 | 150 | 3.00 | 9 | 110 | 170 | 0.76 | GI136 | GL04 |

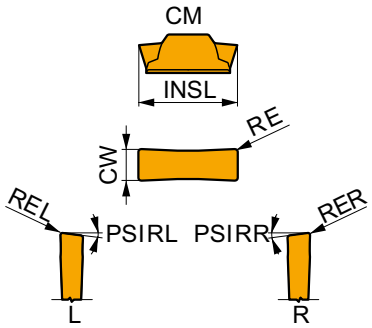
| | |
|---|---|
| GI136 | LCM. 0316.. |
| GI143 | LCM. 0313.. |

| | | Nm | | | |
|---|---|---|---|---|---|
| GL01 | HS 0520C | 5.0 | M 5 | 20 | HXK 4 |
| GL04 | HS 0620C | 6.0 | M 6 | 20 | HXK 5 |

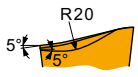
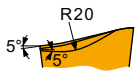
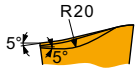
# LCMF 16 - CM

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 |
| 0516 | 5.00 | -0.05 | 0.05 | 16.4 |
| 0616 | 6.00 | -0.05 | 0.05 | 16.4 |




Egnethed og startværdier for skærehastighed (vc) og tilførsel (f). Se vores app til bearbejdning af yderligere beregninger.

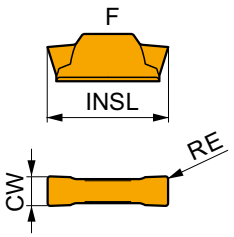
| Product | | RE | P | | M | | K | | N | | S | | H | | PSIRR | PSIRL |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | vc | f | vc | f | vc | f | vc | f | vc | f | vc | f | | |
| | | (mm) | (m/min) | (mm/rev) | (m/min) | (mm/rev) | (m/min) | (mm/rev) | (m/min) | (mm/rev) | (m/min) | (mm/rev) | (m/min) | (mm/rev) | (°) | (°) |
|  |  | | | | | | | | | | | | | | | |
| CM-geometri, førstevalg til afskæring og sporstik og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | |
| **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 geometri, højrehåndet design, førstevalg til afstik og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | |
| **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 geometri, venstrehåndet design, førstevalg til afstikning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | |
| **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.

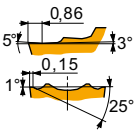
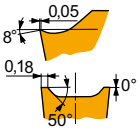
# LCMF 16, LCMF 30 - F

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 |
| 0830 | 8.00 | -0.05 | 0.05 | 30.0 |



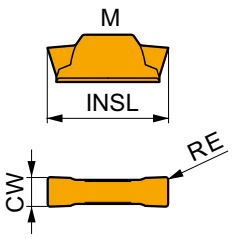

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |  | | F-geometri til afstikning, spor og aksial drejning, fin- og finishbearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | |
| **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 | – | – | – | – | – | – | – | – | – |
| | **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 | – | – | – | – | – | – | – | – | – |
| | **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 | – | – | – | – | – | – | – | – | – |
| | **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 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 270 | 0.17 | 1.0 | 160 | 0.15 | 1.0 | 255 | 0.17 | 1.0 | – | – | – | – | – | – | – | – | – |
|  |  | | F-geometri til afstikning, spor og aksial drejning, fin- og finishbearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | | |
| **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 | – | – | – | – | – | – | – | – | – |

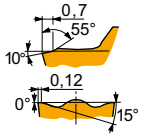
# LCMF 16 - M

PRAMET

| | CW (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 |



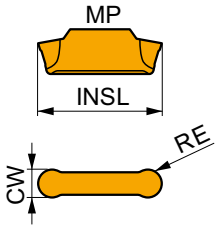

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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-geometri til spor og langsgående drejning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **LCMF 031602-M** | **T8330** | 0.2 | ■ 160 | 0.13 | 1.0 | ◪ 95 | 0.12 | 1.0 | ■ 150 | 0.13 | 1.0 | – | – | – | – | – | – | ◪ 30 | 0.15 | 1.0 |
| **LCMF 031604-M** | **T8330** | 0.4 | ■ 170 | 0.13 | 1.0 | ◪ 100 | 0.12 | 1.0 | ■ 160 | 0.13 | 1.0 | – | – | – | – | – | – | ◪ 30 | 0.15 | 1.0 |
| **LCMF 041604-M** | **T8330** | 0.4 | ■ 155 | 0.18 | 1.0 | ◪ 90 | 0.16 | 1.0 | ■ 145 | 0.18 | 1.0 | – | – | – | – | – | – | ◪ 30 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| | **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 | 0.15 | 1.0 |
| | **T9325** | 0.8 | ■ 230 | 0.25 | 1.0 | ◪ 135 | 0.23 | 1.0 | ◪ 215 | 0.25 | 1.0 | – | – | – | – | – | – | – | – | – |

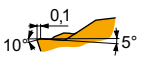
# LCMF 16, LCMF 30 - MP

PRAMET

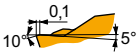
| | CW (mm) | CWTOLL (mm) | CWTOLU (mm) | INSL (mm) |
|---|---|---|---|---|
| 0316 | 3.00 | -0.05 | 0.05 | 17.5 |
| 0416 | 4.00 | -0.05 | 0.05 | 17.6 |
| 0516 | 5.00 | -0.05 | 0.05 | 18.3 |
| 0616 | 6.00 | -0.05 | 0.05 | 18.5 |
| 0830 | 8.00 | -0.05 | 0.05 | 30.9 |




Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | MP-geometri til langsgående drejning og kopiprofilering og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **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 | – | – | – | – | – | – | – | – | – |
| | **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 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 2.5 | ■ 205 | 0.45 | 1.0 | ◪ 120 | 0.41 | 1.0 | ◪ 190 | 0.45 | 1.0 | – | – | – | – | – | – | – | – | – |

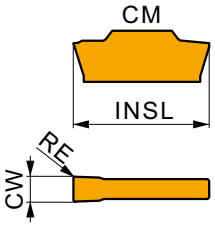
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) | | | | | | | | | | | | | | | | | | |
|  |  | | | | | | | | | | | | | | | | | | | |
| MP-geometri til langsgående drejning og kopiprofilering og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **LCMF 0616MO-MP** | **T8330** | 3.0 | 165 | 0.50 | 1.0 | 95 | 0.45 | 1.0 | 155 | 0.50 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **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 | – | – | – | – | – | – | – | – | – |

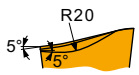
# LCMR 16 - CM

PRAMET

| | 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 |



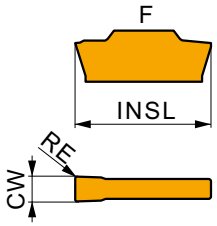

Egnethed og startværdier for skærehastighed (vc) og tilførsel (f). Se vores app til bearbejdning af yderligere beregninger.

| Product | | RE | P | | M | | K | | N | | S | | H | | PSIRR | PSIRL |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | vc (m/min) | f (mm/rev) | vc (m/min) | f (mm/rev) | vc (m/min) | f (mm/rev) | vc (m/min) | f (mm/rev) | vc (m/min) | f (mm/rev) | vc (m/min) | f (mm/rev) | (°) | (°) |
| | | (mm) | | | | | | | | | | | | | | |
|  |  | | | | | | | | | | | | | | | |
| CM-geometri, førstevalg til afskæring og sporstik og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | |
| **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 | – | – | – | – | – | – | – | – |

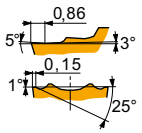
# LCMR 16, LCMR 30 - F

PRAMET

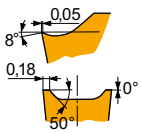
| | CW (mm) | CWTOLL (mm) | CWTOLU (mm) | INSL (mm) |
|---|---|---|---|---|
| 0316 | 3.00 | -0.05 | 0.05 | 16.4 |
| 0416 | 4.00 | -0.05 | 0.05 | 16.4 |
| 0516 | 5.00 | -0.05 | 0.05 | 16.4 |
| 0616 | 6.00 | -0.05 | 0.05 | 16.4 |
| 0830 | 8.00 | -0.05 | 0.05 | 30.0 |




Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | | | | | | | | | | | | | | | | | | |
| 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 til afstikning, spor og langsgående drejning, fin- og finishbearbejdning og kontinuerlige til let afbrudte snit.

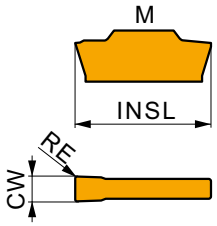
| | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| LCMR 083008-F | T8330 | 0.8 | 175 | 0.25 | 1.0 | 105 | 0.23 | 1.0 | 165 | 0.25 | 1.0 | – | – | – | – | – | – | – | – | – |

F-geometri til afstikning, spor og langsgående drejning, fin- og finishbearbejdning og kontinuerlige til let afbrudte snit.

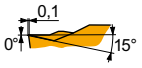
# LCMR 16 - M

PRAMET

| | 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 |




Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

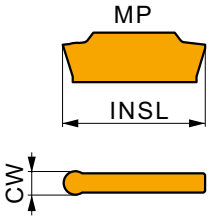
| Product | | RE (mm) | P vc (m/min) | P f (mm/rev) | P ap (mm) | M vc (m/min) | M f (mm/rev) | M ap (mm) | K vc (m/min) | K f (mm/rev) | K ap (mm) | N vc (m/min) | N f (mm/rev) | N ap (mm) | S vc (m/min) | S f (mm/rev) | S ap (mm) | H vc (m/min) | H f (mm/rev) | H ap (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | | | | | | | | | | | | | | | | | | |
| LCMR 031604-M | T8330 | 0.4 | 170 | 0.13 | 1.0 | 100 | 0.12 | 1.0 | 160 | 0.13 | 1.0 | – | – | – | – | – | – | 30 | 0.15 | 1.0 |
| LCMR 041604-M | T8330 | 0.4 | 155 | 0.18 | 1.0 | 90 | 0.16 | 1.0 | 145 | 0.18 | 1.0 | – | – | – | – | – | – | 30 | 0.15 | 1.0 |
| LCMR 051604-M | T8330 | 0.4 | 150 | 0.20 | 1.0 | 90 | 0.18 | 1.0 | 140 | 0.20 | 1.0 | – | – | – | – | – | – | 30 | 0.15 | 1.0 |
| LCMR 061608-M | T8330 | 0.8 | 175 | 0.25 | 1.0 | 105 | 0.23 | 1.0 | 165 | 0.25 | 1.0 | – | – | – | – | – | – | 35 | 0.15 | 1.0 |

M-geometri til spor og langsgående drejning og kontinuerlig til afbrudt snit.

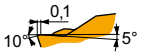
# LCMR 16 - MP

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 |




Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |  | | | | | | | | | | | | | | | | | | | |
| MP-geometri til langsgående drejning og kopiprofilering og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | | | | |
| **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 | – | – | – | – | – | – | – | – | – |

# GFI(RL) EXT

P M K N S H

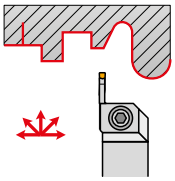
PRAMET

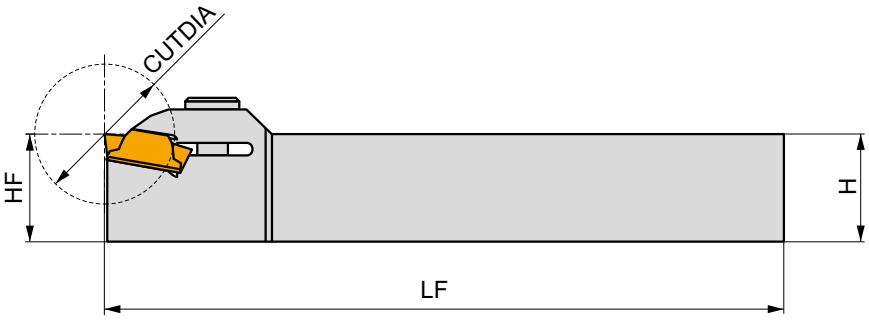
G

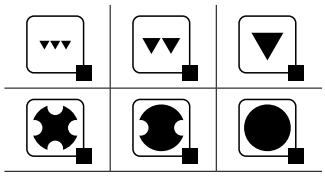


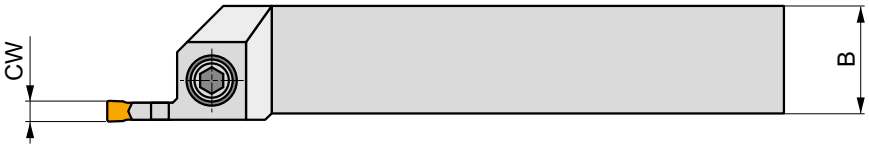
## Eksternt V-spor topspænde- og drejeværktøj til LCM. skær

Ekstern højre / venstre værktøjsholder til sporing med LCM. 0316, 0416, 0516, 0616 og 0830 skær. Velegnet til afstikning op til maksimalt Ø30 til Ø80 mm materiale i spor-, profilerings- og længdedrejningsapplikationer. Fås med skaftstørrelse 16x16 op til 32x25 mm. Krop behandlet for længere værktøjstid.










| | 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 | 0.22 | GI137 | GL03 |
| | **GFIR 2020 K 04** | 20 | 20 | 20 | 125 | 4.00 | 24 | 0.38 | GI137 | GL04 |
| | **GFIR 2525 M 04** | 25 | 25 | 25 | 150 | 4.00 | 24 | 0.67 | 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 | 1.03 | 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 | 0.69 | 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 | 0.75 | GI193 | GL09 |
| | **GFIL 3225 P 08** | 32 | 32 | 25 | 170 | 8.00 | 48 | 1.03 | 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

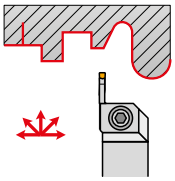
PRAMET

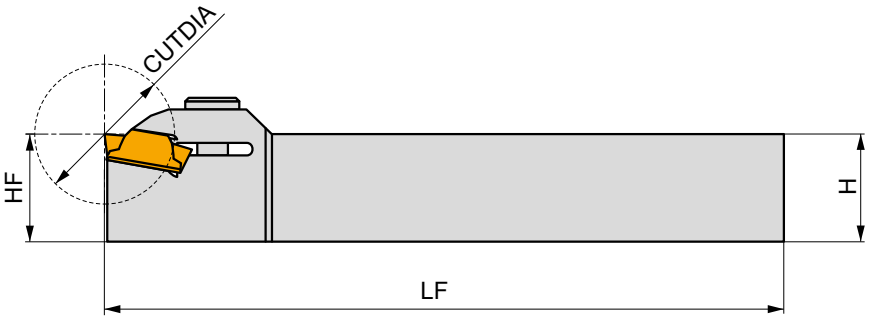
G

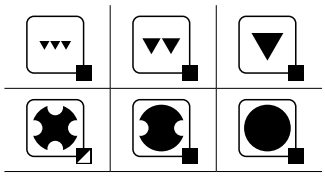


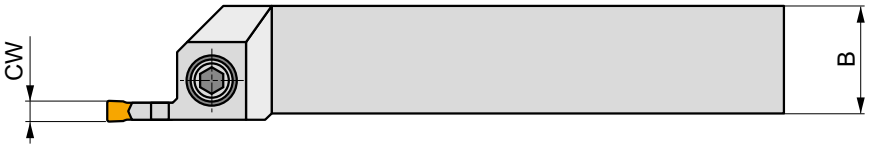
## Eksternt V-spor topspænde- og drejeværktøj til LCM. skær

Ekstern højre / venstre værktøjsholder til sporing med LCM. 0316, 0416, 0516, 0616 og 0830 skær. Velegnet til afstikning op til maksimalt Ø30 til Ø80 mm materiale i spor-, profilerings- og længdedrejningsapplikationer. Fås med skaftstørrelse 20x20 op til 32x25 mm. Krop behandlet for længere værktøjstid.










| | 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 | 0.38 | GI137 | GL04 |
| | **GFMR 2525 M 0416** | 25 | 25 | 25 | 150 | 4.00 | 40 | 0.68 | GI137 | GL04 |
| | **GFMR 2525 M 0516** | 25 | 25 | 25 | 150 | 5.00 | 50 | 0.67 | GI138 | GL04 |
| | **GFMR 3225 P 0516** | 32 | 32 | 25 | 170 | 5.00 | 50 | 0.97 | 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 | 0.97 | 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 | 0.24 | GI136 | GL04 |
| | **GFML 2525 M 0316** | 25 | 25 | 25 | 150 | 3.00 | 30 | 0.70 | 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 | 0.69 | GI137 | GL04 |
| | **GFML 2525 M 0516** | 25 | 25 | 25 | 150 | 5.00 | 50 | 0.64 | GI138 | GL04 |
| | **GFML 3225 P 0516** | 32 | 32 | 25 | 170 | 5.00 | 50 | 0.97 | 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 | 0.99 | 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 |

# XLCCN B

P M K N S H

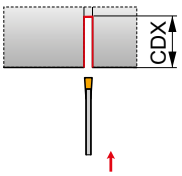
PRAMET

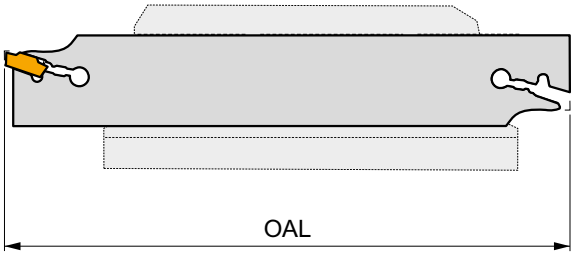
X

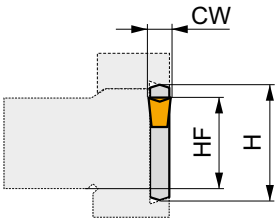


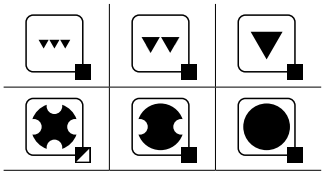
## Dobbeltsidet afskæringsblad til LCM-skær

Blad til afskæringsopgaver op til 60 mm maksimal dybde eller Ø120 mm stangmateriale. Velegnet til dobbeltsidede skær LCM-familien. Fås i højden 26 og 32 mm. Kan monteres i DU Pramet basisholdere. Blad behandlet for længere levetid på værktøjet.





| | Product | HF (mm) | H (mm) | LF (mm) | CW (mm) | CDX (mm) | kg | | |
|---|---|---|---|---|---|---|---|---|---|
| N | **XLCCN 2602 J 0316** | 21.4 | 26 | 110 | 3.00 | 35 | 0.09 | GI136 | KV1 |
| | **XLCCN 3202 M 0316** | 25 | 32 | 150 | 3.00 | 50 | 0.13 | GI136 | KV1 |
| | **XLCCN 3203 M 0416** | 25 | 32 | 150 | 4.00 | 50 | 0.15 | GI137 | KV1 |
| | **XLCCN 3204 M 0516** | 25 | 32 | 150 | 5.00 | 60 | 0.18 | GI138 | KV1 |
| | **XLCCN 3205 M 0616** | 25 | 32 | 150 | 6.00 | 60 | 0.17 | GI139 | KV1 |

| | |
|---|---|
| GI136 | LCM. 0316.. |
| GI137 | LCM. 0416.. |
| GI138 | LCM. 0516.. |
| GI139 | LCM. 0616.. |

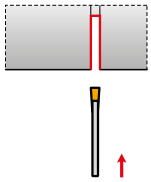
| | |
|---|---|
| KV1 | KV 5x100 |

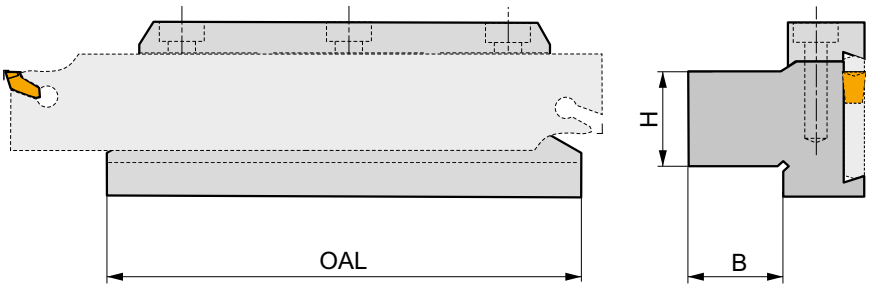
# DU, D

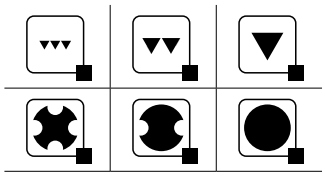


## Værktøjsholderblok til stikblade

Værktøjsholder, der passer til GL eller XLC. knive til afskæring. Fås med skaftstørrelse 20x20 op til 40x40 mm. Krop behandlet for længere levetid på værktøjet.





| Product | H (mm) | B (mm) | OAL (mm) | kg | | |
|---|---|---|---|---|---|---|
| **26-DU 2020** | 20 | 20 | 90 | 0.70 | GI007 | ND2 |
| **26-D 2020** | 20 | 20 | 100 | 0.82 | GI007 | ND2 |
| **32-DU 2523** | 25 | 23 | 110 | 1.02 | GI008 | ND2 |
| **32-DU 2532** | 25 | 32 | 110 | 1.10 | GI008 | ND2 |
| **32-DU 3229** | 32 | 29 | 110 | 1.25 | GI008 | ND2 |
| **32-D 2530** | 25 | 30 | 115 | 1.30 | 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 | 3.88 | 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 |

# XLCCN 25 BS

P M K N S H

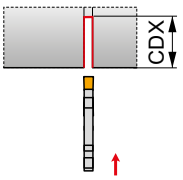
PRAMET

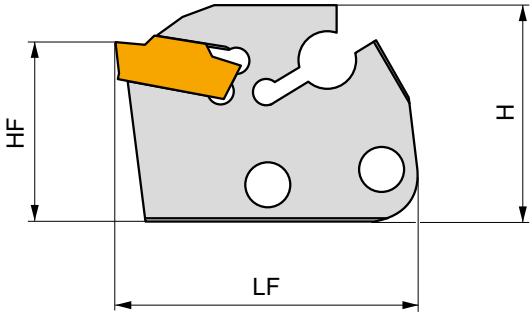
G

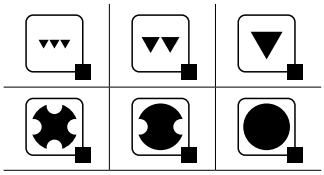


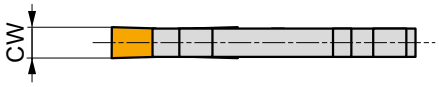
## Radial skærblad til modulært MS-EN værktøjsholder til LCM. skær

Modulært stikblad til spor med enkelt- eller dobbeltsidet LCM. 0316, 0416, 0516 eller 0616 skær. Velegnet til fræsning eller afskæring (maks. 25 mm skæredybde). Kan monteres på MS-EN værktøjsholder. Klinger behandlet for længere levetid på værktøjet.





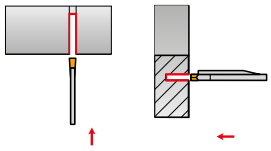


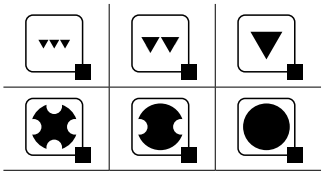

| | Product | HF (mm) | H (mm) | LF (mm) | CW (mm) | CDX (mm) | kg | | |
|---|---|---|---|---|---|---|---|---|---|
| N | **XLCCN 250215-0316** | 24 | 29 | 40 | 3.00 | 15 | 0.01 | GI136 | – |
| | **XLCCN 250225-0316** | 24 | 29 | 50 | 3.00 | 25 | 0.02 | GI136 | – |
| | **XLCCN 250315-0416** | 24 | 29 | 40 | 4.00 | 15 | 0.04 | GI137 | – |
| | **XLCCN 250325-0416** | 24 | 29 | 50 | 4.00 | 25 | 0.04 | GI137 | – |
| | **XLCCN 250425-0516** | 24 | 29 | 50 | 5.00 | 25 | 0.03 | GI138 | – |
| | **XLCCN 250525-0616** | 24 | 29 | 50 | 6.00 | 25 | 0.04 | GI139 | – |

| | |
|---|---|
| GI136 | LCM. 0316.. |
| GI137 | LCM. 0416.. |
| GI138 | LCM. 0516.. |
| GI139 | LCM. 0616.. |

# MS-EN

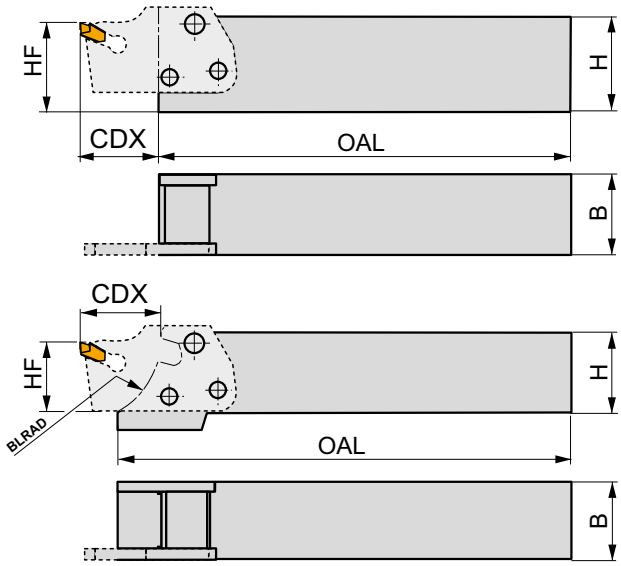






## Modulær værktøjsholder til XLCCN, XLCF (NRL) eller XLXFL stikblad

Værktøjsholder til montering af modulære stikskær fra XLC 25 BS, XLCF (NRL) BS, XLXFL BS aksial stikblad. Fås med skaftstørrelse 12x12 op til 32x25 mm. Krop behandlet for længere levetid på værktøjet.




| Product | HF (mm) | H (mm) | B (mm) | OAL (mm) | CDX (mm) | BLRAD (mm) | kg | | |
|---|---|---|---|---|---|---|---|---|---|
| **MS-EN-1212 F** | 12 | 12 | 12 | 75 | 15 | – | 0.13 | GI006 | ND4 |
| **MS-EN-1616 H** | 16 | 16 | 16 | 90 | 15 | – | 0.21 | GI006 | ND4 |
| **MS-EN-2020 K** | 20 | 20 | 20 | 115 | 15 | – | 0.23 | GI003 | ND5 |
| **MS-EN-2020 KS** | 20 | 20 | 20 | 129 | 15 | 25 | 0.42 | GI060 | ND5 |
| **MS-EN-2525 M** | 25 | 25 | 25 | 140 | 15 | – | 0.65 | GI003 | ND5 |
| **MS-EN-2525 MS** | 25 | 25 | 25 | 153 | 15 | 25 | 0.74 | GI060 | ND5 |
| **MS-EN-3225 P** | 32 | 32 | 25 | 160 | 15 | – | 0.95 | GI003 | ND5 |
| **MS-EN-3225 PS** | 32 | 32 | 25 | 174 | 15 | 25 | 1.00 | GI060 | ND5 |

| | | | |
|---|---|---|---|
| GI003 | XLC.. 25..15... | XLXFL 25… | XLC.. 25..25… |
| GI006 | XLCF. 16..15… | XLCF. 16..20… | – |
| GI060 | XLC.. 25..15… | XLC.. 25..25… | – |

| | | Nm | | | | Nm | | | |
|---|---|---|---|---|---|---|---|---|---|
| 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 T15P |

ND4 =3 x US 4011-T15P; ND5=2 x US 45013-T20P

# GFIL-L AXIAL

P M K N S H

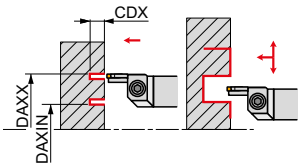
PRAMET

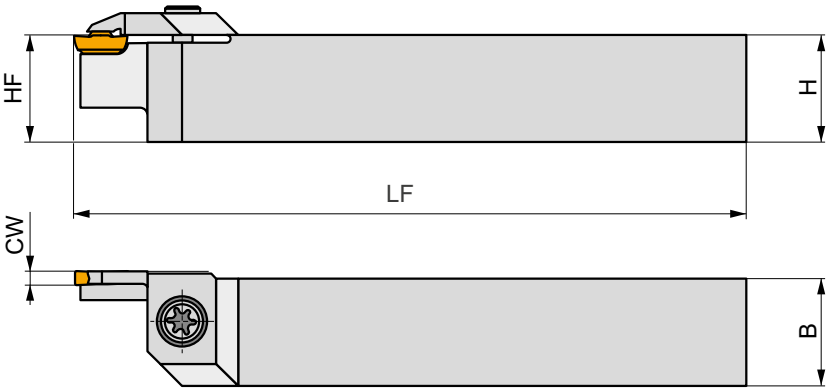
G

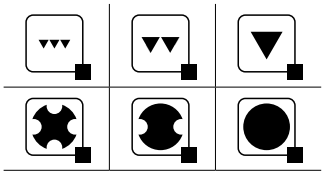


## Eksternt aksialt V-Groove Top Clamp Grooving Værktøj til LCM. 03 skær

Ekstern venstre aksial værktøjsholder til sporing med enkelt- eller dobbeltsidet LCM. 0313 eller 0316 skær. Velegnet til aksial notning, aksial profilering eller notudvidelse Ø17 op til Ø170 mm applikationer med maksimal skæredybde 9 mm. Fås med skaftstørrelse 25x25 mm. Krop behandlet for længere levetid





| | Product | HF (mm) | H (mm) | B (mm) | LF (mm) | CW (mm) | CDX (mm) | DAXIN | DAXX (mm) | kg | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| L | **GFIL 2525 M 0313L 030017** | 25 | 25 | 25 | 150 | 3.00 | 9 | 17 | 30 | 0.64 | GI143 | GL02 |
| | **GFIL 2525 M 0313L 039024** | 25 | 25 | 25 | 150 | 3.00 | 9 | 24 | 39 | 0.66 | GI143 | GL07 |
| | **GFIL 2525 M 0313L 050033** | 25 | 25 | 25 | 150 | 3.00 | 9 | 33 | 50 | 0.67 | GI143 | GL07 |
| | **GFIL 2525 M 0313L 060043** | 25 | 25 | 25 | 150 | 3.00 | 9 | 43 | 60 | 0.67 | GI143 | GL07 |
| | **GFIL 2525 M 0313L 076053** | 25 | 25 | 25 | 150 | 3.00 | 9 | 53 | 76 | 0.67 | GI143 | GL07 |
| | **GFIL 2525 M 0316L 100070** | 25 | 25 | 25 | 150 | 3.00 | 9 | 70 | 100 | 0.69 | GI136 | GL07 |
| | **GFIL 2525 M 0316L 130090** | 25 | 25 | 25 | 150 | 3.00 | 9 | 90 | 130 | 0.70 | GI136 | GL07 |
| | **GFIL 2525 M 0316L 170110** | 25 | 25 | 25 | 150 | 3.00 | 9 | 110 | 170 | 0.71 | GI136 | GL07 |

| | |
|---|---|
| GI136 | LCM. 0316.. |
| GI143 | LCM. 0313.. |

| | | Nm | | | |
|---|---|---|---|---|---|
| GL02 | US 5015-T20P | 5.0 | M 5 | 15 | FLAG T20P |
| GL07 | US 5018-T20P | 5.0 | M 5 | 18.2 | FLAG T20P |

# GFIL-R AXIAL

P M K N S H

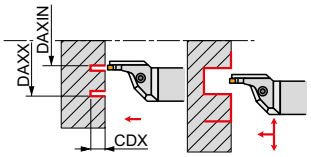
PRAMET

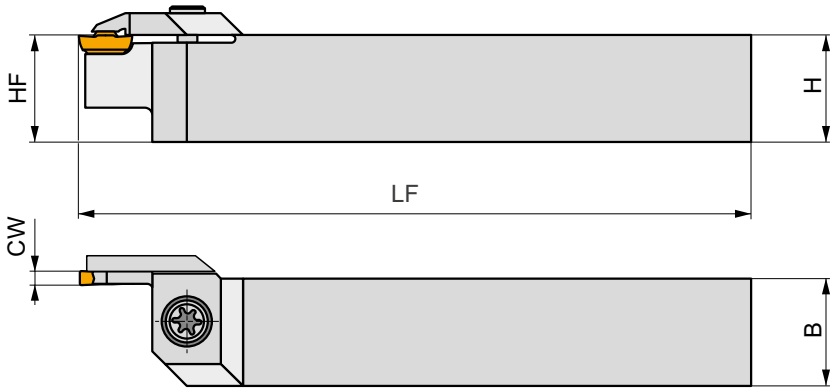
G

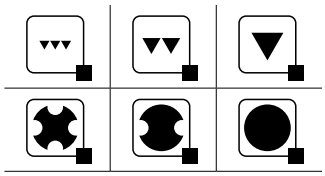


## Eksternt aksialt V-Groove Top Clamp Grooving Tool til LCM. 03 eller 04 skær

Ekstern venstre aksial værktøjsholder til sporing med enkelt- eller dobbeltsidet LCM. 0313, 0316, 0413 eller 0416 skær. Velegnet til aksial notning, aksial profilering eller notudvidelse Ø17 op til Ø230 mm applikationer med maksimal skæredybde 12 mm. Fås med skaftstørrelse 25x25. Krop behandlet for længere levetid





| | Product | HF (mm) | H (mm) | B (mm) | LF (mm) | CW (mm) | CDX (mm) | DAXIN | DAXX (mm) | kg | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| L | GFIL 2525 M 03R 030017-A | 25 | 25 | 25 | 150 | 3.00 | 9 | 17 | 30 | 0.69 | GI143 | GL07 |
| | GFIL 2525 M 03R 039024-A | 25 | 25 | 25 | 150 | 3.00 | 9 | 24 | 39 | 0.69 | GI143 | GL07 |
| | GFIL 2525 M 03R 050033-A | 25 | 25 | 25 | 150 | 3.00 | 9 | 33 | 50 | 0.72 | GI143 | GL07 |
| | GFIL 2525 M 03R 060043-A | 25 | 25 | 25 | 150 | 3.00 | 9 | 43 | 60 | 0.69 | GI143 | GL07 |
| | GFIL 2525 M 03R 076053-A | 25 | 25 | 25 | 150 | 3.00 | 9 | 53 | 76 | 0.68 | GI143 | GL07 |
| | GFIL 2525 M 03R 100070-A | 25 | 25 | 25 | 150 | 3.00 | 9 | 70 | 100 | 0.79 | GI136 | GL08 |
| | GFIL 2525 M 03R 130090-A | 25 | 25 | 25 | 150 | 3.00 | 9 | 90 | 130 | 0.73 | GI136 | GL08 |
| | GFIL 2525 M 03R 170110-A | 25 | 25 | 25 | 150 | 3.00 | 9 | 110 | 170 | 0.76 | GI136 | GL08 |
| | GFIL 2525 M 04R 030017-A | 25 | 25 | 25 | 150 | 3.00 | 9 | 17 | 30 | 0.71 | GI170 | GL07 |
| | GFIL 2525 M 04R 034021-A | 25 | 25 | 25 | 150 | 4.00 | 9 | 21 | 34 | 0.69 | GI170 | GL07 |
| | GFIL 2525 M 04R 040026-A | 25 | 25 | 25 | 150 | 4.00 | 11 | 26 | 40 | 0.00 | GI170 | GL07 |
| | GFIL 2525 M 04R 050032-A | 25 | 25 | 25 | 150 | 4.00 | 11 | 32 | 50 | 0.68 | GI170 | GL07 |
| | GFIL 2525 M 04R 060042-A | 25 | 25 | 25 | 150 | 4.00 | 11 | 42 | 60 | 0.66 | GI170 | GL07 |
| | GFIL 2525 M 04R 075052-A | 25 | 25 | 25 | 150 | 4.00 | 11 | 52 | 75 | 0.67 | GI170 | GL07 |
| | GFIL 2525 M 04R 100070-A | 25 | 25 | 25 | 150 | 4.00 | 12 | 70 | 100 | 0.75 | GI137 | GL08 |
| | GFIL 2525 M 04R 130090-A | 25 | 25 | 25 | 150 | 4.00 | 12 | 90 | 130 | 0.75 | GI137 | GL08 |
| | GFIL 2525 M 04R 170110-A | 25 | 25 | 25 | 150 | 4.00 | 12 | 110 | 170 | 0.75 | GI137 | GL08 |
| | GFIL 2525 M 04R 230140-A | 25 | 25 | 25 | 150 | 4.00 | 12 | 140 | 230 | 0.78 | GI137 | GL08 |

| | |
|---|---|
| GI136 | LCM. 0316.. |
| GI137 | LCM. 0416.. |
| GI143 | LCM. 0313.. |
| GI170 | LCM. 0413.. |

| | | Nm | | | | |
|---|---|---|---|---|---|---|
| GL07 | US 5018-T20P | 5.0 | M 5 | 18.2 | FLAG T20P | – |
| GL08 | US 6020-T25P | 6.0 | M 6 | 20.2 | – | SDR T25P |

# GFIR-L AXIAL

P M K N S H

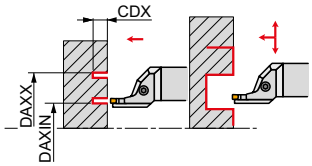
PRAMET

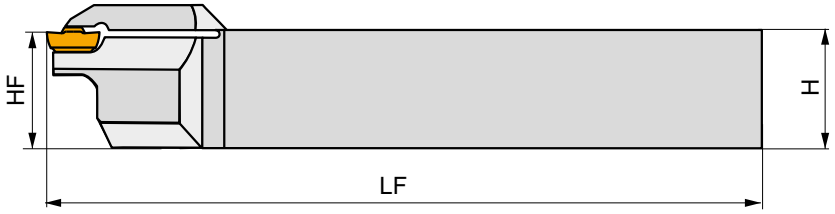
G



## Eksternt aksialt V-Groove Top Clamp Grooving Værktøj til LCM. 03 og 04 skær

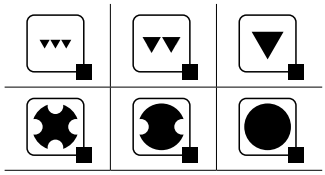
Ekstern højre aksial værktøjsholder til spor med enkelt- eller dobbeltsidet LCM. 0313, 0316, 0413 eller 0416 skær. Velegnet til aksial notstik, aksial profilering eller notudvidelse Ø17 op til Ø230 mm applikationer med maksimal skæredybde 12 mm. Fås med skaftstørrelse 25x25 mm. Krop behandlet for længere levetid på værktøjet.











| | Product | HF (mm) | H (mm) | B (mm) | LF (mm) | CW (mm) | CDX (mm) | DAXIN (mm) | DAXX (mm) | kg | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| R | GFIR 2525 M 03L 030017-A | 25 | 25 | 25 | 150 | 3.00 | 9 | 17 | 30 | 0.65 | GI143 | GL07 |
| | GFIR 2525 M 03L 039024-A | 25 | 25 | 25 | 150 | 3.00 | 9 | 24 | 39 | 0.68 | GI143 | GL07 |
| | GFIR 2525 M 03L 050033-A | 25 | 25 | 25 | 150 | 3.00 | 9 | 33 | 50 | 0.65 | GI143 | GL07 |
| | GFIR 2525 M 03L 060043-A | 25 | 25 | 25 | 150 | 3.00 | 9 | 43 | 60 | 0.68 | GI143 | GL07 |
| | GFIR 2525 M 03L 076053-A | 25 | 25 | 25 | 150 | 3.00 | 9 | 53 | 76 | 0.69 | GI143 | GL07 |
| | GFIR 2525 M 03L 100070-A | 25 | 25 | 25 | 150 | 3.00 | 9 | 70 | 100 | 0.75 | GI136 | GL08 |
| | GFIR 2525 M 03L 130090-A | 25 | 25 | 25 | 150 | 3.00 | 9 | 90 | 130 | 0.76 | GI136 | GL08 |
| | GFIR 2525 M 03L 170110-A | 25 | 25 | 25 | 150 | 3.00 | 9 | 110 | 170 | 0.68 | GI136 | GL08 |
| | GFIR 2525 M 04L 030017-A | 25 | 25 | 25 | 150 | 3.00 | 9 | 17 | 30 | 0.68 | GI170 | GL07 |
| | GFIR 2525 M 04L 034021-A | 25 | 25 | 25 | 150 | 4.00 | 9 | 21 | 34 | 0.68 | GI170 | GL07 |
| | GFIR 2525 M 04L 040026-A | 25 | 25 | 25 | 150 | 4.00 | 11 | 26 | 40 | 0.68 | GI170 | GL07 |
| | GFIR 2525 M 04L 050032-A | 25 | 25 | 25 | 150 | 4.00 | 11 | 32 | 50 | 0.66 | GI170 | GL07 |
| | GFIR 2525 M 04L 060042-A | 25 | 25 | 25 | 150 | 4.00 | 11 | 42 | 60 | 0.69 | GI170 | GL07 |
| | GFIR 2525 M 04L 075052-A | 25 | 25 | 25 | 150 | 4.00 | 11 | 52 | 75 | 0.67 | GI170 | GL07 |
| | GFIR 2525 M 04L 100070-A | 25 | 25 | 25 | 150 | 4.00 | 12 | 70 | 100 | 0.72 | GI137 | GL08 |
| | GFIR 2525 M 04L 130090-A | 25 | 25 | 25 | 150 | 4.00 | 12 | 90 | 130 | 0.75 | GI137 | GL08 |
| | GFIR 2525 M 04L 170110-A | 25 | 25 | 25 | 150 | 4.00 | 12 | 110 | 170 | 0.72 | GI137 | GL08 |
| | GFIR 2525 M 04L 230140-A | 25 | 25 | 25 | 150 | 4.00 | 12 | 140 | 230 | 0.79 | GI137 | GL08 |

| | |
|---|---|
| GI136 | LCM. 0316.. |
| GI137 | LCM. 0416.. |
| GI143 | LCM. 0313.. |
| GI170 | LCM. 0413.. |

| | | Nm | | | | |
|---|---|---|---|---|---|---|
| GL07 | US 5018-T20P | 5.0 | M 5 | 18.2 | FLAG T20P | – |
| GL08 | US 6020-T25P | 6.0 | M 6 | 20.2 | – | SDR T25P |

# GFIR-R AXIAL

P M K N S H

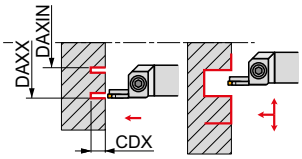
PRAMET

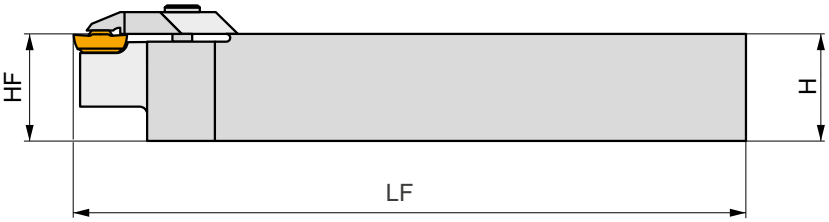
G



## Eksternt aksialt V-Groove Top Clamp Grooving Værktøj til LCM. 03 skær

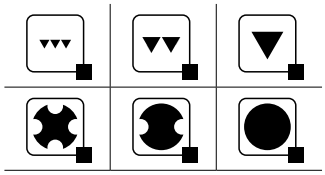
Ekstern højre aksial værktøjsholder til spor med enkelt- eller dobbeltsidet LCM. 0313 eller 0316 skær. Velegnet til aksial notstik, aksial profilering eller notudvidelse Ø17 op til Ø170 mm applikationer med maksimal skæredybde 9 mm. Fås med skaftstørrelse 25x25 mm. Krop behandlet for længere levetid på værktøjet.











| | Product | HF (mm) | H (mm) | B (mm) | LF (mm) | CW (mm) | CDX (mm) | DAXIN (mm) | DAXX (mm) | kg | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| R | **GFIR 2525 M 0313R 030017** | 25 | 25 | 25 | 150 | 3.00 | 9 | 17 | 30 | 0.65 | GI143 | GL02 |
| | **GFIR 2525 M 0313R 039024** | 25 | 25 | 25 | 150 | 3.00 | 9 | 24 | 39 | 0.66 | GI143 | GL07 |
| | **GFIR 2525 M 0313R 050033** | 25 | 25 | 25 | 150 | 3.00 | 9 | 33 | 50 | 0.68 | GI143 | GL07 |
| | **GFIR 2525 M 0313R 060043** | 25 | 25 | 25 | 150 | 3.00 | 9 | 43 | 60 | 0.68 | GI143 | GL07 |
| | **GFIR 2525 M 0313R 076053** | 25 | 25 | 25 | 150 | 3.00 | 9 | 53 | 76 | 0.68 | GI143 | GL07 |
| | **GFIR 2525 M 0316R 100070** | 25 | 25 | 25 | 150 | 3.00 | 9 | 70 | 100 | 0.69 | GI136 | GL07 |
| | **GFIR 2525 M 0316R 130090** | 25 | 25 | 25 | 150 | 3.00 | 9 | 90 | 130 | 0.70 | GI136 | GL07 |
| | **GFIR 2525 M 0316R 170110** | 25 | 25 | 25 | 150 | 3.00 | 9 | 110 | 170 | 0.70 | GI136 | GL07 |

| | |
|---|---|
| GI136 | LCM. 0316.. |
| GI143 | LCM. 0313.. |

| | | Nm | | | |
|---|---|---|---|---|---|
| GL02 | US 5015-T20P | 5.0 | M 5 | 15 | FLAG T20P |
| GL07 | US 5018-T20P | 5.0 | M 5 | 18.2 | FLAG T20P |

# GFML-L AXIAL

P M K N S H

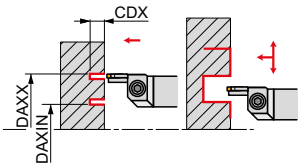
PRAMET

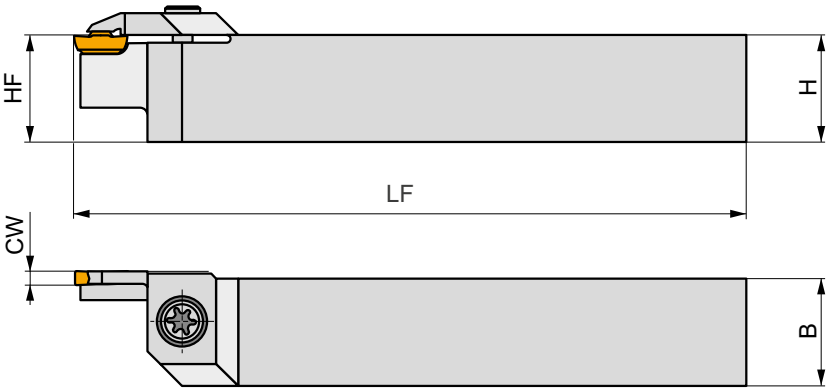
G

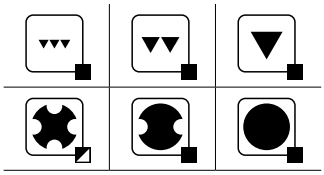


## Eksternt aksialt V-Groove Top Clamp Grooving Tool til LCM. 04 skær

Ekstern venstre aksial værktøjsholder til sporing med enkelt- eller dobbeltsidet LCM. 0413 eller 0416 skær. Velegnet til dyb aksial rille, aksial profilering eller rille udvidelse Ø17 op til Ø230 mm applikationer, med maksimal skæredybde 20 mm. Fås med skaftstørrelse 25x25 mm. Krop behandlet for længere levetid





| | Product | HF (mm) | H (mm) | B (mm) | LF (mm) | CW (mm) | CDX (mm) | DAXIN (mm) | DAXX (mm) | kg | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| L | **GFML 2525 M 0413L 030017** | 25 | 25 | 25 | 150 | 4.00 | 20 | 17 | 30 | 0.62 | GI170 | GL02 |
| | **GFML 2525 M 0413L 034021** | 25 | 25 | 25 | 150 | 4.00 | 20 | 21 | 34 | 0.63 | GI170 | GL07 |
| | **GFML 2525 M 0413L 040026** | 25 | 25 | 25 | 150 | 4.00 | 20 | 26 | 40 | 0.65 | GI170 | GL07 |
| | **GFML 2525 M 0413L 050032** | 25 | 25 | 25 | 150 | 4.00 | 20 | 32 | 50 | 0.64 | GI170 | GL07 |
| | **GFML 2525 M 0413L 060042** | 25 | 25 | 25 | 150 | 4.00 | 20 | 42 | 60 | 0.65 | GI170 | GL07 |
| | **GFML 2525 M 0413L 075052** | 25 | 25 | 25 | 150 | 4.00 | 20 | 52 | 75 | 0.66 | GI170 | GL07 |
| | **GFML 2525 M 0416L 100070** | 25 | 25 | 25 | 150 | 4.00 | 20 | 70 | 100 | 0.66 | GI137 | GL07 |
| | **GFML 2525 M 0416L 130090** | 25 | 25 | 25 | 150 | 4.00 | 20 | 90 | 130 | 0.67 | GI137 | GL07 |
| | **GFML 2525 M 0416L 170110** | 25 | 25 | 25 | 150 | 4.00 | 20 | 110 | 170 | 0.67 | GI137 | GL07 |
| | **GFML 2525 M 0416L 230140** | 25 | 25 | 25 | 150 | 4.00 | 20 | 140 | 230 | 0.67 | GI137 | GL07 |

| | |
|---|---|
| GI137 | LCM. 0416.. |
| GI170 | LCM. 0413.. |

| | | Nm | | | |
|---|---|---|---|---|---|
| GL02 | US 5015-T20P | 5.0 | M 5 | 15 | FLAG T20P |
| GL07 | US 5018-T20P | 5.0 | M 5 | 18.2 | FLAG T20P |

# GFML-R AXIAL

P M K N S H

PRAMET

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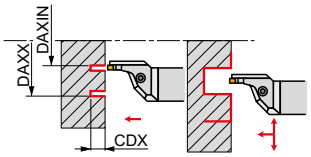
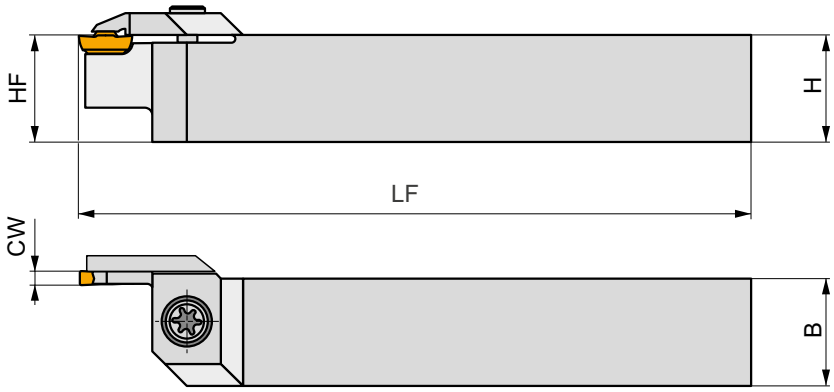
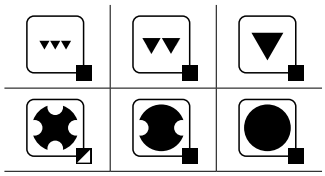
## Eksternt aksialt V-Groove Top Clamp Grooving Tool til LCM. 04 skær

Ekstern venstre aksial værktøjsholder til sporing med enkelt- eller dobbeltsidet LCM. 0413 eller 0416 skær. Velegnet til dyb aksial rille, aksial profilering eller rille udvidelse Ø17 op til Ø230 mm applikationer, med maksimal skæredybde 20 mm. Fås med skaftstørrelse 25x25 mm. Krop behandlet for længere levetid





| | Product | HF (mm) | H (mm) | B (mm) | LF (mm) | CW (mm) | CDX (mm) | DAXIN (mm) | DAXX (mm) | kg | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| L | **GFML 2525 M 0413R 030017** | 25 | 25 | 25 | 150 | 4.00 | 20 | 17 | 30 | 0.68 | GI170 | GL07 |
| | **GFML 2525 M 0413R 034021** | 25 | 25 | 25 | 150 | 4.00 | 20 | 21 | 34 | 0.69 | GI170 | GL07 |
| | **GFML 2525 M 0413R 040026** | 25 | 25 | 25 | 150 | 4.00 | 20 | 26 | 40 | 0.69 | GI170 | GL07 |
| | **GFML 2525 M 0413R 050032** | 25 | 25 | 25 | 150 | 4.00 | 20 | 32 | 50 | 0.68 | GI170 | GL07 |
| | **GFML 2525 M 0413R 060042** | 25 | 25 | 25 | 150 | 4.00 | 20 | 42 | 60 | 0.69 | GI170 | GL07 |
| | **GFML 2525 M 0413R 075052** | 25 | 25 | 25 | 150 | 4.00 | 20 | 52 | 75 | 0.69 | GI170 | GL07 |
| | **GFML 2525 M 0416R 100070** | 25 | 25 | 25 | 150 | 4.00 | 20 | 70 | 100 | 0.80 | GI137 | GL08 |
| | **GFML 2525 M 0416R 130090** | 25 | 25 | 25 | 150 | 4.00 | 20 | 90 | 130 | 0.78 | GI137 | GL08 |
| | **GFML 2525 M 0416R 170110** | 25 | 25 | 25 | 150 | 4.00 | 20 | 110 | 170 | 0.78 | GI137 | GL08 |
| | **GFML 2525 M 0416R 230140** | 25 | 25 | 25 | 150 | 4.00 | 20 | 140 | 230 | 0.78 | GI137 | GL08 |

| | |
|---|---|
| GI137 | LCM. 0416.. |
| GI170 | LCM. 0413.. |

| | | Nm | | | | |
|---|---|---|---|---|---|---|
| GL07 | US 5018-T20P | 5.0 | M 5 | 18.2 | FLAG T20P | – |
| GL08 | US 6020-T25P | 6.0 | M 6 | 20.2 | – | SDR T25P |

# GFMR-L AXIAL

P M K N S H

PRAMET

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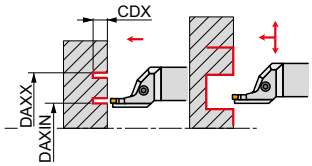
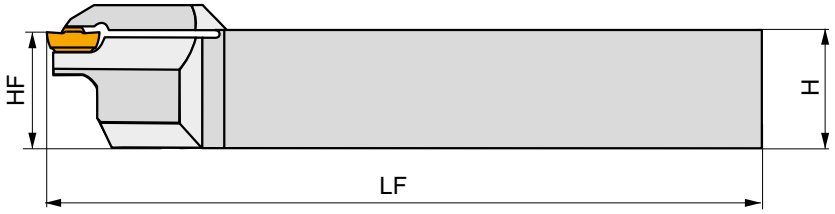
## Eksternt aksialt V-Groove Top Clamp Grooving Værktøj til LCM. 04 skær

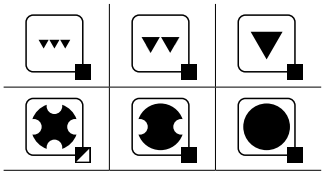
Ekstern højre aksial værktøjsholder til sporstik med enkelt- eller dobbeltsidet LCM. 0413 eller 0416 skær. Velegnet til dyb aksial spor, aksial profilering eller spor udvidelse Ø17 op til Ø230 mm applikationer med maksimal skæredybde 20 mm. Fås med skaftstørrelse 25x25 mm. Krop behandlet for længere levetid på værktøjet.











| | Product | HF (mm) | H (mm) | B (mm) | LF (mm) | CW (mm) | CDX (mm) | DAXIN (mm) | DAXX (mm) | kg | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| R | **GFMR 2525 M 0413L 030017** | 25 | 25 | 25 | 150 | 4.00 | 20 | 17 | 30 | 0.70 | GI170 | GL07 |
| | **GFMR 2525 M 0413L 034021** | 25 | 25 | 25 | 150 | 4.00 | 20 | 21 | 34 | 0.66 | GI170 | GL07 |
| | **GFMR 2525 M 0413L 040026** | 25 | 25 | 25 | 150 | 4.00 | 20 | 26 | 40 | 0.66 | GI170 | GL07 |
| | **GFMR 2525 M 0413L 050032** | 25 | 25 | 25 | 150 | 4.00 | 20 | 32 | 50 | 0.68 | GI170 | GL07 |
| | **GFMR 2525 M 0413L 060042** | 25 | 25 | 25 | 150 | 4.00 | 20 | 42 | 60 | 0.66 | GI170 | GL07 |
| | **GFMR 2525 M 0413L 075052** | 25 | 25 | 25 | 150 | 4.00 | 20 | 52 | 75 | 0.69 | GI170 | GL07 |
| | **GFMR 2525 M 0416L 100070** | 25 | 25 | 25 | 150 | 4.00 | 20 | 70 | 100 | 0.88 | GI137 | GL08 |
| | **GFMR 2525 M 0416L 130090** | 25 | 25 | 25 | 150 | 4.00 | 20 | 90 | 130 | 0.78 | GI137 | GL08 |
| | **GFMR 2525 M 0416L 170110** | 25 | 25 | 25 | 150 | 4.00 | 20 | 110 | 170 | 0.81 | GI137 | GL08 |
| | **GFMR 2525 M 0416L 230140** | 25 | 25 | 25 | 150 | 4.00 | 20 | 140 | 230 | 0.78 | GI137 | GL08 |

| | |
|---|---|
| GI137 | LCM. 0416.. |
| GI170 | LCM. 0413.. |

| | | Nm | | | | |
|---|---|---|---|---|---|---|
| GL07 | US 5018-T20P | 5.0 | M 5 | 18.2 | FLAG T20P | – |
| GL08 | US 6020-T25P | 6.0 | M 6 | 20.2 | – | SDR T25P |

# GFMR-R AXIAL

P M K N S H

PRAMET

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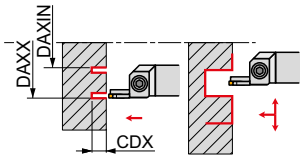
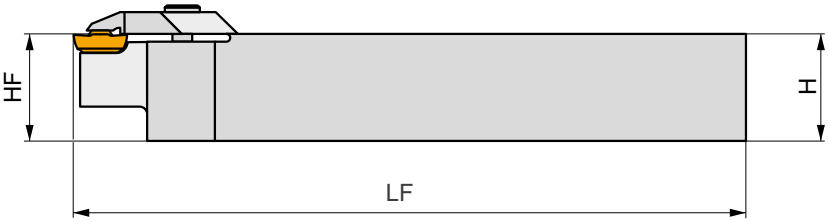
## Eksternt aksialt V-Groove Top Clamp Grooving Værktøj til LCM. 04 skær

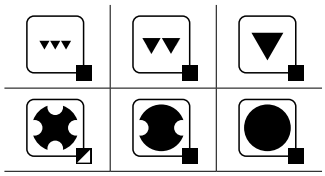
Ekstern højre aksial værktøjsholder til sporstik med enkelt- eller dobbeltsidet LCM. 0413 eller 0416 skær. Velegnet til dyb aksial spor, aksial profilering eller spor udvidelse Ø17 op til Ø230 mm applikationer med maksimal skæredybde 20 mm. Fås med skaftstørrelse 25x25 mm. Krop behandlet for længere levetid på værktøjet.











| | Product | HF (mm) | H (mm) | B (mm) | LF (mm) | CW (mm) | CDX (mm) | DAXIN (mm) | DAXX (mm) | kg | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| R | **GFMR 2525 M 0413R 030017** | 25 | 25 | 25 | 150 | 4.00 | 20 | 17 | 30 | 0.62 | GI170 | GL02 |
| | **GFMR 2525 M 0413R 034021** | 25 | 25 | 25 | 150 | 4.00 | 20 | 21 | 34 | 0.63 | GI170 | GL07 |
| | **GFMR 2525 M 0413R 040026** | 25 | 25 | 25 | 150 | 4.00 | 20 | 26 | 40 | 0.64 | GI170 | GL07 |
| | **GFMR 2525 M 0413R 050032** | 25 | 25 | 25 | 150 | 4.00 | 20 | 32 | 50 | 0.63 | GI170 | GL07 |
| | **GFMR 2525 M 0413R 060042** | 25 | 25 | 25 | 150 | 4.00 | 20 | 42 | 60 | 0.64 | GI170 | GL07 |
| | **GFMR 2525 M 0413R 075052** | 25 | 25 | 25 | 150 | 4.00 | 20 | 52 | 75 | 0.67 | GI170 | GL07 |
| | **GFMR 2525 M 0416R 100070** | 25 | 25 | 25 | 150 | 4.00 | 20 | 70 | 100 | 0.67 | GI137 | GL07 |
| | **GFMR 2525 M 0416R 130090** | 25 | 25 | 25 | 150 | 4.00 | 20 | 90 | 130 | 0.66 | GI137 | GL07 |
| | **GFMR 2525 M 0416R 170110** | 25 | 25 | 25 | 150 | 4.00 | 20 | 110 | 170 | 0.67 | GI137 | GL07 |
| | **GFMR 2525 M 0416R 230140** | 25 | 25 | 25 | 150 | 4.00 | 20 | 140 | 230 | 0.68 | GI137 | GL07 |

| | |
|---|---|
| GI137 | LCM. 0416.. |
| GI170 | LCM. 0413.. |

| | | Nm | | | |
|---|---|---|---|---|---|
| GL02 | US 5015-T20P | 5.0 | M 5 | 15 | FLAG T20P |
| GL07 | US 5018-T20P | 5.0 | M 5 | 18.2 | FLAG T20P |

# GGI(RL)-90 AXIAL

P M K N S H

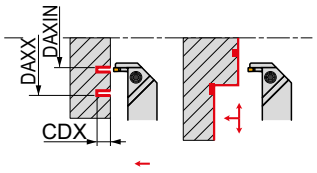
PRAMET

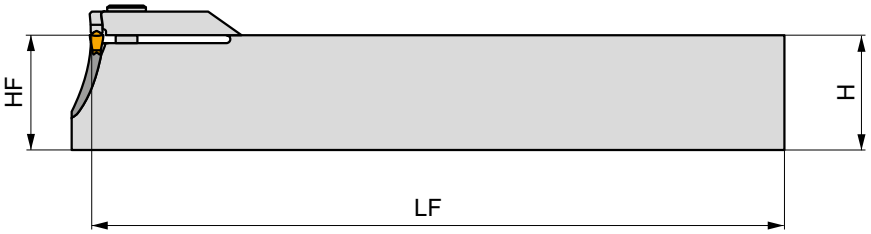
G

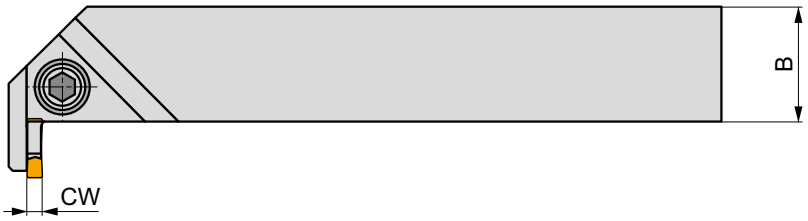


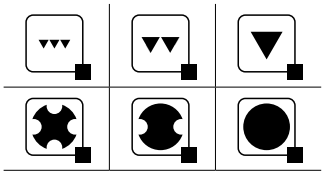
## Eksternt aksialt 90 ° V-rille Top Clamp Grooving Tool til LCM. 03 skær

Ekstern højre / venstre aksial 90° værktøjsholder til spor med enkel eller dobbeltsidet LCM. 0313 eller 0316 skær. Velegnet til aksial notning, aksial profilering eller notudvidelse Ø17 op til Ø170 mm applikationer med maksimal skæredybde 11 mm. Fås med skaftstørrelse 25x25 mm. Krop behandlet for længere levetid





| | Product | HF (mm) | H (mm) | B (mm) | LF (mm) | CW (mm) | CDX (mm) | DAXIN (mm) | DAXX (mm) | kg | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| R | GGIR 2525 M 03R 030017 | 25 | 25 | 25 | 150 | 3.00 | 9.5 | 17 | 30 | 0.75 | GI143 | GL01 |
| | GGIR 2525 M 03R 039024 | 25 | 25 | 25 | 150 | 3.00 | 9.5 | 24 | 39 | 0.78 | GI143 | GL01 |
| | GGIR 2525 M 03R 050033 | 25 | 25 | 25 | 150 | 3.00 | 11 | 33 | 50 | 0.75 | GI143 | GL01 |
| | GGIR 2525 M 03R 060043 | 25 | 25 | 25 | 150 | 3.00 | 11 | 43 | 60 | 0.78 | GI143 | GL01 |
| | GGIR 2525 M 03R 076053 | 25 | 25 | 25 | 150 | 3.00 | 11 | 53 | 76 | 0.75 | GI143 | GL01 |
| | GGIR 2525 M 03R 100070 | 25 | 25 | 25 | 150 | 3.00 | 9 | 70 | 100 | 0.78 | GI136 | GL04 |
| | GGIR 2525 M 03R 130090 | 25 | 25 | 25 | 150 | 3.00 | 9 | 90 | 130 | 0.73 | GI136 | GL04 |
| | GGIR 2525 M 03R 170110 | 25 | 25 | 25 | 150 | 3.00 | 9 | 110 | 170 | 0.76 | GI136 | GL04 |
| L | GGIL 2525 M 03L 030017 | 25 | 25 | 25 | 150 | 3.00 | 9.5 | 17 | 30 | 0.75 | GI143 | GL01 |
| | GGIL 2525 M 03L 039024 | 25 | 25 | 25 | 150 | 3.00 | 9.5 | 24 | 39 | 0.25 | GI143 | GL01 |
| | GGIL 2525 M 03L 050033 | 25 | 25 | 25 | 150 | 3.00 | 11 | 33 | 50 | 0.75 | GI143 | GL01 |
| | GGIL 2525 M 03L 060043 | 25 | 25 | 25 | 150 | 3.00 | 11 | 43 | 60 | 0.75 | GI143 | GL01 |
| | GGIL 2525 M 03L 076053 | 25 | 25 | 25 | 150 | 3.00 | 11 | 53 | 76 | 0.75 | GI143 | GL01 |
| | GGIL 2525 M 03L 100070 | 25 | 25 | 25 | 150 | 3.00 | 9 | 70 | 100 | 0.77 | GI136 | GL04 |
| | GGIL 2525 M 03L 130090 | 25 | 25 | 25 | 150 | 3.00 | 9 | 90 | 130 | 0.77 | GI136 | GL04 |
| | GGIL 2525 M 03L 170110 | 25 | 25 | 25 | 150 | 3.00 | 9 | 110 | 170 | 0.76 | GI136 | GL04 |

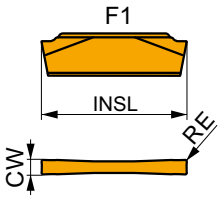
| | |
|---|---|
| GI136 | LCM. 0316.. |
| GI143 | LCM. 0313.. |

| | | | | | |
|---|---|---|---|---|---|
| GL01 | HS 0520C | 5.0 | M 5 | 20 | HXK 4 |
| GL04 | HS 0620C | 6.0 | M 6 | 20 | HXK 5 |

# LCMF 20 - F1

PRAMET

| | CW | CWTOLL | CWTOLU | INSL |
|---|---|---|---|---|
| | (mm) | (mm) | (mm) | (mm) |
| 0220 | 2.00 | -0.03 | 0.03 | 19.5 |



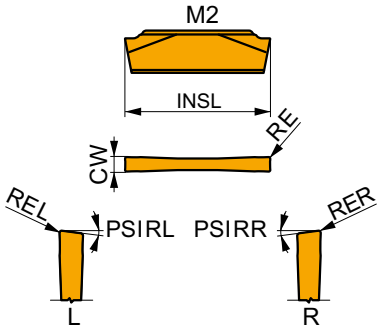

Egnethed og startværdier for skærehastighed (vc) og tilførsel (f). Se vores app til bearbejdning af yderligere beregninger.

| Product | | RE | P | | M | | K | | N | | S | | H | | PSIRR | PSIRL |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | vc (m/min) | f (mm/rev) | vc (m/min) | f (mm/rev) | vc (m/min) | f (mm/rev) | vc (m/min) | f (mm/rev) | vc (m/min) | f (mm/rev) | vc (m/min) | f (mm/rev) | (°) | (°) |
| | 0,1 0° 12° 0,1 0° 5° | | | | | | | | | | | | | | | |
| F1-geometri til afstikning og spordrejning, finbearbejdning og finishbearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | |
| **LCMF 022002-F1** | **T8330** | 0.2 | 205 | 0.09 | 120 | 0.08 | 190 | 0.09 | – | – | – | – | – | – | – | – |

# LCMF 20 - M2

PRAMET

| | CW | CWTOLL | CWTOLU | INSL |
|---|---|---|---|---|
| | (mm) | (mm) | (mm) | (mm) |
| 0220 | 2.00 | -0.03 | 0.03 | 19.5 |

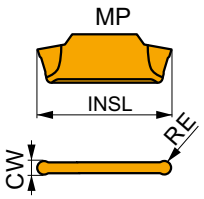



Egnethed og startværdier for skærehastighed (vc) og tilførsel (f). Se vores app til bearbejdning af yderligere beregninger.

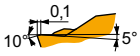
| Product | | RE | P | | M | | K | | N | | S | | H | | PSIRR | PSIRL |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | vc (m/min) | f (mm/rev) | vc (m/min) | f (mm/rev) | vc (m/min) | f (mm/rev) | vc (m/min) | f (mm/rev) | vc (m/min) | f (mm/rev) | vc (m/min) | f (mm/rev) | (°) | (°) |
| | 0,05 8° 0,18 50° 0° | | | | | | | | | | | | | | | |
| M2 geometri til afskæring og sporstik, fin- og finishbearbejdning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | |
| **LCMF 022002-M2** | **T8330** | 0.2 | 180 | 0.12 | 105 | 0.11 | 170 | 0.12 | – | – | – | – | – | – | – | – |
| | 0,05 8° 0,18 50° 0° | | | | | | | | | | | | | | | |
| R-M2 geometri med højrehåndet design til afstik og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | |
| **LCMF 022002R6-M2** | **T8330** | 0.2 | 130 | 0.12 | 75 | 0.11 | 120 | 0.12 | – | – | – | – | – | – | 6 | – |
| | 0,05 8° 0,18 50° 0° | | | | | | | | | | | | | | | |
| L-M2 geometri med venstrehåndet design til afstikning og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | |
| **LCMF 022002L6-M2** | **T8330** | 0.2 | 130 | 0.12 | 75 | 0.11 | 120 | 0.12 | – | – | – | – | – | – | – | 6 |

# LCMF 20 - MP

| | CW | CWTOLL | CWTOLU | INSL |
|---|---|---|---|---|
| | (mm) | (mm) | (mm) | (mm) |
| 0220 | 2.00 | -0.03 | 0.03 | 19.5 |




Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | MP-geometri til langsgående drejning og kopiprofilering, fin- og finishbearbejdning og kontinuerlig til afbrudt snit. | | | | | | | | | | | | | | | | | |
| **LCMF 0220MO-MP** | **T8330** | 1.0 | ■ 200 | 0.30 | 0.5 | ◪ 120 | 0.27 | 0.5 | ■ 190 | 0.30 | 0.5 | – | – | – | – | – | – | – | – | – |

# GFK(RL) EXT

P M K N S H

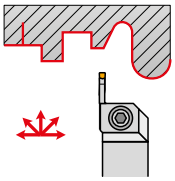
PRAMET

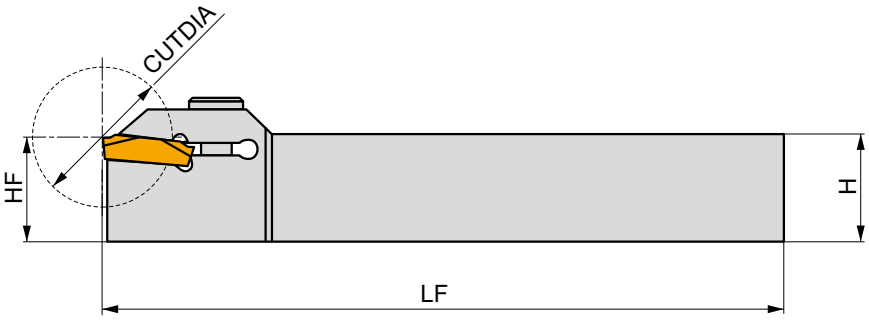
G

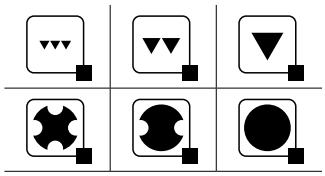


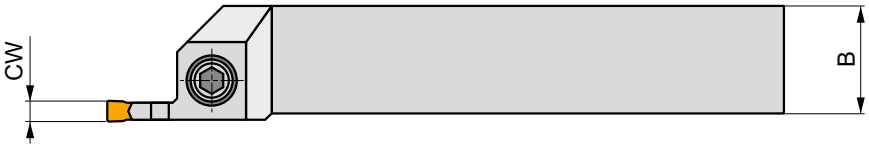
## Eksternt V-spor topspænde- og afskæringsværktøj, LCMF 0220 skær

Ekstern højre / venstre værktøjsholder til sporing med LCMF 0220 skær. Velegnet til afskærings-, spor- og profileringsopgaver op til 16 mm maksimal skæredybde. Fås med skaftstørrelse 16x16 op til 25x25 mm. Krop behandlet for længere værktøjstid.










| | Product | HF (mm) | H (mm) | B (mm) | LF (mm) | CW (mm) | CUTDIA (mm) | kg | | |
|---|---|---|---|---|---|---|---|---|---|---|
| R | **GFKR 1616 H 02** | 16 | 16 | 16 | 100 | 2.00 | 32 | 0.20 | GI168 | GL03 |
| | **GFKR 2020 K 02** | 20 | 20 | 20 | 125 | 2.00 | 32 | 0.38 | GI168 | GL04 |
| | **GFKR 2525 M 02** | 25 | 25 | 25 | 150 | 2.00 | 32 | 0.68 | GI168 | GL05 |
| L | **GFKL 1616 H 02** | 16 | 16 | 16 | 100 | 2.00 | 32 | 0.20 | GI168 | GL03 |
| | **GFKL 2020 K 02** | 20 | 20 | 20 | 125 | 2.00 | 32 | 0.38 | GI168 | GL04 |
| | **GFKL 2525 M 02** | 25 | 25 | 25 | 150 | 2.00 | 32 | 0.68 | GI168 | GL05 |

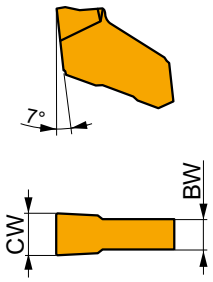
| | |
|---|---|
| GI168 | LCMF 0220.. |

| | | Nm | | | |
|---|---|---|---|---|---|
| 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 |

# 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 |



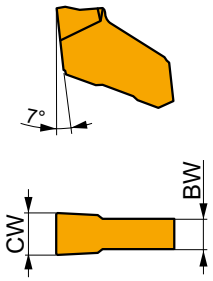

Egnethed og startværdier for skærehastighed (vc) og tilførsel (f). Se vores app til bearbejdning af yderligere beregninger.

| 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) | (°) | (°) |
|  |  | | E | | | | | | | | | | | | | |
| | | | EN-F1 geometri til afstikning og spordrejning og kontinuerlige snit. | | | | | | | | | | | | | |
| **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 | – | – | – | – | – | – | – | – |

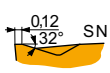
# LFMX - F2

PRAMET

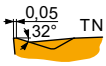
| | CW | CWTOLL | CWTOLU | BW |
|---|---|---|---|---|
| | (mm) | (mm) | (mm) | (mm) |
| 1.6 | 1.60 | -0.03 | 0.03 | 1.30 |
| 2.0 | 2.00 | -0.03 | 0.03 | 1.60 |
| 3.1 | 3.10 | -0.04 | 0.04 | 2.60 |
| 4.1 | 4.10 | -0.04 | 0.04 | 3.60 |
| 5.1 | 5.10 | -0.04 | 0.04 | 4.60 |
| 6.35 | 6.35 | -0.04 | 0.04 | 5.80 |




Egnethed og startværdier for skærehastighed (vc) og tilførsel (f). Se vores app til bearbejdning af yderligere beregninger.

| 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) | (°) | (°) |
|  |  | | U | S | | | | | | | | | | | | |
| | | | SN-F2 geometri til afskæring og sporstik og kontinuerlige snit. | | | | | | | | | | | | | |
| **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 | – | – | – | – | – | – | – | – |
| | **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 | – | – | – | – | – | – | – | – |
| | **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 | – | – | – | – | – | – | – | – |

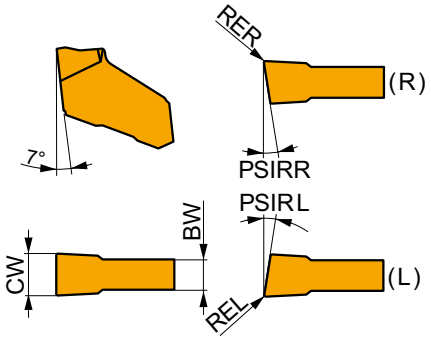
Egnethed og startværdier for skærehastighed (vc) og tilførsel (f). Se vores app til bearbejdning af yderligere beregninger.

| Product | | RE | P | | M | | K | | N | | S | | H | | PSIRR | PSIRL |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | vc (m/min) | f (mm/rev) | vc (m/min) | f (mm/rev) | vc (m/min) | f (mm/rev) | vc (m/min) | f (mm/rev) | vc (m/min) | f (mm/rev) | vc (m/min) | f (mm/rev) | (°) | (°) |
|  |  | | | | | | | | | | | | | | | |
| TN-F2 geometri til afstifning og sporstik og kontinuerlige snit. | | | | | | | | | | | | | | | | |
| **LFMX 3.1-.20TNF2** | **6640** | 0.2 | 150 | 0.10 | 90 | 0.09 | 140 | 0.10 | – | – | – | – | – | – | – | – |
| | **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 | – | – | – | – | – | – | – | – |

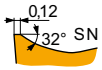
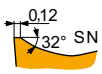
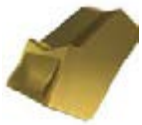
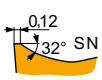
# LFMX - M2

PRAMET

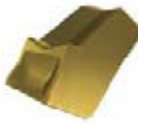
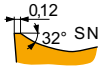
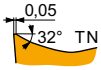
| | CW (mm) | CWTOLL (mm) | CWTOLU (mm) | BW (mm) |
|---|---|---|---|---|
| 2.0 | 2.00 | -0.03 | 0.03 | 1.60 |
| 2.2 | 2.20 | -0.03 | 0.03 | 1.60 |
| 3.1 | 3.10 | -0.04 | 0.04 | 2.60 |
| 4.1 | 4.10 | -0.04 | 0.04 | 3.60 |
| 5.1 | 5.10 | -0.04 | 0.04 | 4.60 |
| 6.35 | 6.35 | -0.04 | 0.04 | 5.80 |




Egnethed og startværdier for skærehastighed (vc) og tilførsel (f). Se vores app til bearbejdning af yderligere beregninger.

| Product | | RE | P | | M | | K | | N | | S | | H | | PSIRR | PSIRL |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | vc (m/min) | f (mm/rev) | vc (m/min) | f (mm/rev) | vc (m/min) | f (mm/rev) | vc (m/min) | f (mm/rev) | vc (m/min) | f (mm/rev) | vc (m/min) | f (mm/rev) | (°) | (°) |
|  |  | | | | | | | | | | | | | | | |
| SN-M2 geometri til afskæring og rsporstik og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | |
| **LFMX 2.0-.16SNM2** | **6640** | 0.2 | 150 | 0.11 | 90 | 0.10 | 140 | 0.11 | – | – | – | – | – | – | – | – |
| | **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 | – | – | – | – | – | – | – | – |
| | **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 | – | – | – | – | – | – | – | – |
| | **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 | – | – | – | – | – | – | – | – |
| | **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 | – | – | – | – | – | – | – | – |
| | **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 | – | – | – | – | – | – | – | – |
| | **T8330** | 0.2 | 130 | 0.20 | 75 | 0.18 | 120 | 0.20 | – | – | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | |
| SR-M2 geometri med højrehåndet design til afstik og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | |
| **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 | – |
|  |  | | | | | | | | | | | | | | | |
| SL-M2 geometri med venstrehåndet design til afstik og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | |
| **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 |

Egnethed og startværdier for skærehastighed (vc) og tilførsel (f). Se vores app til bearbejdning af yderligere beregninger.

| Product | | RE | P | | M | | K | | N | | S | | H | | PSIRR | PSIRL |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | vc (m/min) | f (mm/rev) | vc (m/min) | f (mm/rev) | vc (m/min) | f (mm/rev) | vc (m/min) | f (mm/rev) | vc (m/min) | f (mm/rev) | vc (m/min) | f (mm/rev) | (°) | (°) |
|  |   | |  | | | | | | | | | | | | | |
| SL-M2 geometri med venstrehåndet design til afstik og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | |
| **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 til afskæring og sporstikog kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | |
| **LFMX 3.1-.20TNM2** | **6640** | 0.2 | 150 | 0.15 | 90 | 0.14 | 140 | 0.15 | – | – | – | – | – | – | – | – |
| | **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 | – | – | – | – | – | – | – | – |
| | **T8330** | 0.2 | 130 | 0.15 | 75 | 0.14 | 120 | 0.15 | – | – | – | – | – | – | – | – |

# XLCFN B

P M K N S H

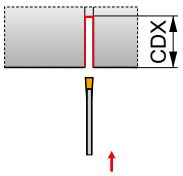
PRAMET

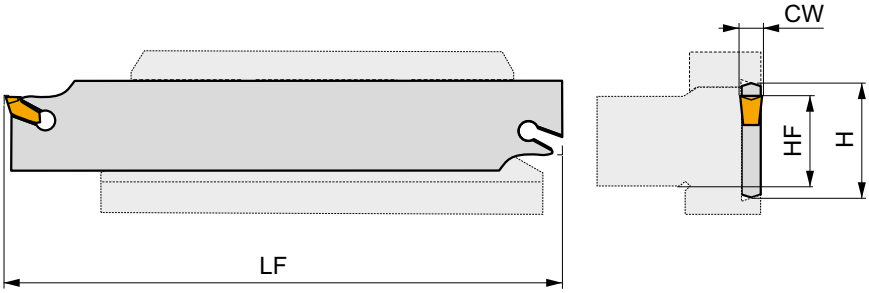
X

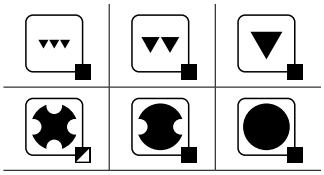


## Dobbeltsidet afskæringsblad til LFMX-skær

Blad til afstikningsapplikationer op til 80 mm maksimal dybde eller Ø160 mm stangmateriale. Velegnet til ensidige LFMX-skær. Fås i højder på 26, 32 eller 45 mm. Kan monteres i DU Pramet basisholdere. Blad behandlet for længere levetid på værktøjet.





| | 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 | 0.03 | GI132 | KV |
| | **XLCFN 2601 J 2.00** | 21.4 | 26 | 110 | 2.00 | 25 | 0.04 | GI061 | KV |
| | **XLCFN 2602 J 3.00** | 21.4 | 26 | 110 | 3.10 | 37.5 | 0.05 | GI001 | KV |
| | **XLCFN 2603 J 4.00** | 21.4 | 26 | 110 | 4.10 | 40 | 0.06 | GI002 | KV |
| | **XLCFN 3201 M 1.60** | 25 | 32 | 150 | 1.50 | 15 | 0.06 | 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 | 0.11 | GI002 | KV |
| | **XLCFN 3204 M 5.00** | 25 | 32 | 150 | 5.10 | 60 | 0.14 | GI004 | KV |
| | **XLCFN 3205 M 6.35** | 25 | 32 | 150 | 6.35 | 60 | 0.17 | GI005 | KV |
| | **XLCFN 4502 S 3.00** | 32 | 45 | 250 | 3.10 | 80 | 0.12 | GI001 | KV |
| | **XLCFN 4503 S 4.00** | 32 | 45 | 250 | 4.10 | 80 | 0.19 | GI002 | KV |
| | **XLCFN 4504 S 5.00** | 32 | 45 | 250 | 5.10 | 80 | 0.28 | GI004 | KV |
| | **XLCFN 4505 S 6.35** | 32 | 45 | 250 | 6.35 | 80 | 0.40 | 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 |

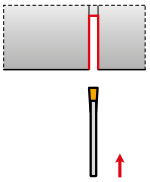
# DU, D

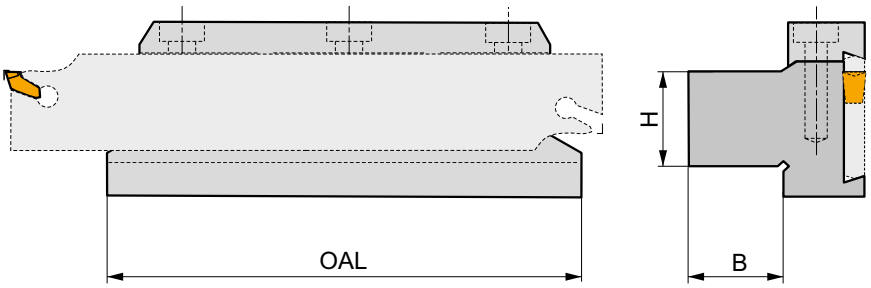
PRAMET

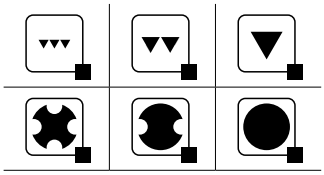


## Værktøjsholderblok til stikblade

Værktøjsholder, der passer til GL eller XLC. knive til afskæring. Fås med skaftstørrelse 20x20 op til 40x40 mm. Krop behandlet for længere levetid på værktøjet.





| | Product | H (mm) | B (mm) | OAL (mm) | kg | | |
|---|---|---|---|---|---|---|---|
| | **26-DU 2020** | 20 | 20 | 90 | 0.70 | GI007 | ND2 |
| | **26-D 2020** | 20 | 20 | 100 | 0.82 | GI007 | ND2 |
| | **32-DU 2523** | 25 | 23 | 110 | 1.02 | GI008 | ND2 |
| | **32-DU 2532** | 25 | 32 | 110 | 1.10 | GI008 | ND2 |
| | **32-DU 3229** | 32 | 29 | 110 | 1.25 | GI008 | ND2 |
| | **32-D 2530** | 25 | 30 | 115 | 1.30 | 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 | 3.88 | 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 |

# XLCF(NRL) BS

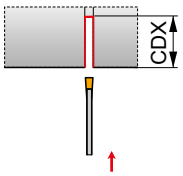
P M K N S H

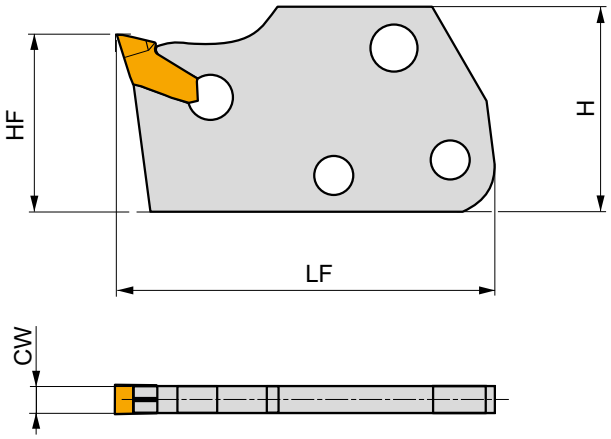
PRAMET X

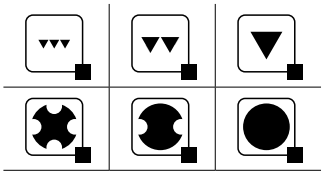


## Radial skærblad til modulært MS-EN værktøjsholder til LFMX-skær

Modulært stikblad til spor med ensidige LFMX-skær. Velegnet til fræsning eller afskæring (maks. 25 mm skæredybde). Klinger behandlet for længere levetid på værktøjet.





| | Product | HF (mm) | H (mm) | LF (mm) | CW (mm) | CDX (mm) | kg | | |
|---|---|---|---|---|---|---|---|---|---|
| R | XLCFR 160115-1.60 | 12 | 25 | 35 | 1.50 | 15 | 0.01 | 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 | 0.01 | 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 | 0.01 | 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 | 0.02 | GI001 | KV |
| | XLCFN 250215-3.00 | 24 | 29 | 40 | 3.10 | 15 | 0.02 | 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 | 0.02 | GI002 | KV |
| | XLCFN 250325-4.00 | 24 | 29 | 50 | 4.10 | 25 | 0.03 | 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 | 0.04 | 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 |

# XLXFL BS AXIAL

P M K N S H

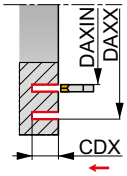
PRAMET

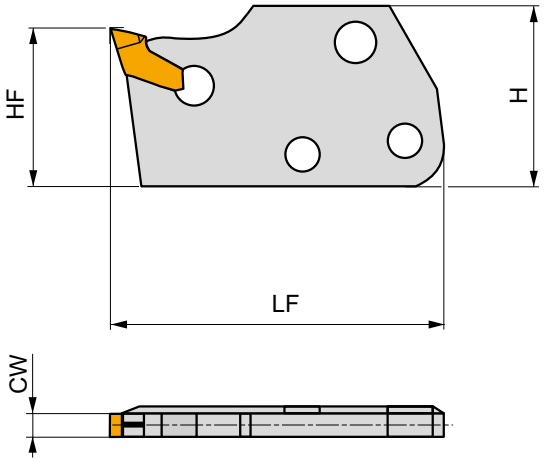
X

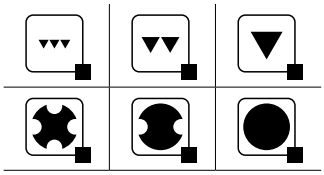


## Aksialt skærblad til modulært MS-EN værktøjsholder til LFMX-skær

Modulært stikblad til spor med ensidige LFMX 3.1 skær. Velegnet til aksial notning (maks. 20 mm skæredybde). Kan monteres på MS-EN værktøjsholder. Klinger behandlet for længere levetid på værktøjet.







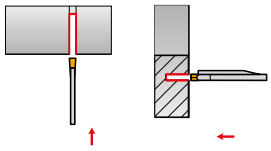
| | Product | H (mm) | HF (mm) | LF (mm) | CW (mm) | CDX (mm) | DAXIN (mm) | DAXX (mm) | kg | | |
|---|---|---|---|---|---|---|---|---|---|---|---|
| L | **XLXFL 250220-3.00-60** | 29 | 24 | 46 | 3.10 | 20 | 60 | 85 | 0.07 | GI001 | KV |
| | **XLXFL 250220-3.00-80** | 29 | 24 | 46 | 3.10 | 20 | 80 | 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 |

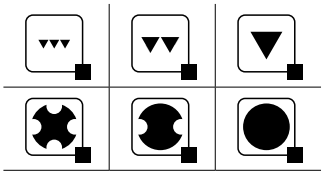
| | |
|---|---|
| GI001 | LFMX 3.1-. |

| | |
|---|---|
| KV | KV 5x70 |

# MS-EN

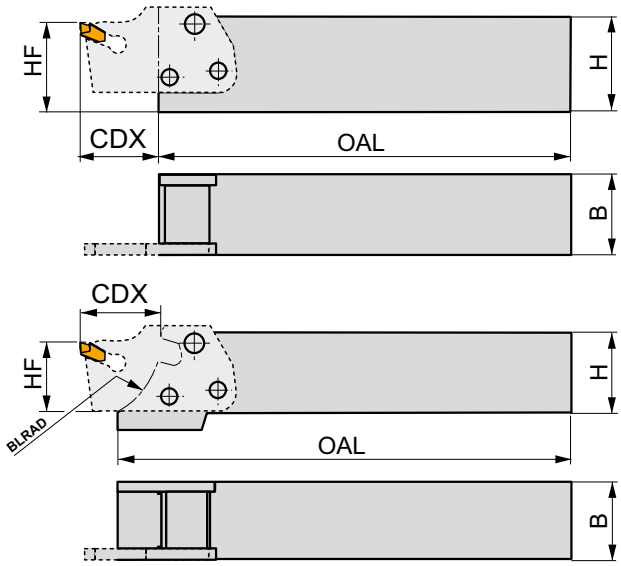






## Modulær værktøjsholder til XLCCN, XLCF (NRL) eller XLXFL stikblad

Værktøjsholder til montering af modulære stikskær fra XLC 25 BS, XLCF (NRL) BS, XLXFL BS aksial stikblad. Fås med skaftstørrelse 12x12 op til 32x25 mm. Krop behandlet for længere levetid på værktøjet.




| Product | HF (mm) | H (mm) | B (mm) | OAL (mm) | CDX (mm) | BLRAD (mm) | kg | | |
|---|---|---|---|---|---|---|---|---|---|
| **MS-EN-1212 F** | 12 | 12 | 12 | 75 | 15 | – | 0.13 | GI006 | ND4 |
| **MS-EN-1616 H** | 16 | 16 | 16 | 90 | 15 | – | 0.21 | GI006 | ND4 |
| **MS-EN-2020 K** | 20 | 20 | 20 | 115 | 15 | – | 0.23 | GI003 | ND5 |
| **MS-EN-2020 KS** | 20 | 20 | 20 | 129 | 15 | 25 | 0.42 | GI060 | ND5 |
| **MS-EN-2525 M** | 25 | 25 | 25 | 140 | 15 | – | 0.65 | GI003 | ND5 |
| **MS-EN-2525 MS** | 25 | 25 | 25 | 153 | 15 | 25 | 0.74 | GI060 | ND5 |
| **MS-EN-3225 P** | 32 | 32 | 25 | 160 | 15 | – | 0.95 | GI003 | ND5 |
| **MS-EN-3225 PS** | 32 | 32 | 25 | 174 | 15 | 25 | 1.00 | GI060 | ND5 |

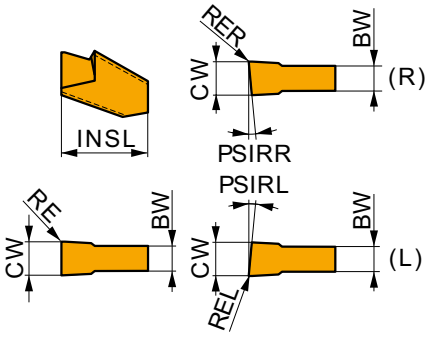
| | | | |
|---|---|---|---|
| GI003 | XLC.. 25..15... | XLXFL 25… | XLC.. 25..25… |
| GI006 | XLCF. 16..15… | XLCF. 16..20… | – |
| GI060 | XLC.. 25..15… | XLC.. 25..25… | – |

| | | Nm | | | | Nm | | | |
|---|---|---|---|---|---|---|---|---|---|
| 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 T15P |

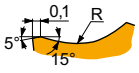
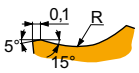
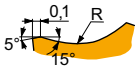
ND4 =3 x US 4011-T15P; ND5=2 x US 45013-T20P

# LFUX

| | CW (mm) | BW (mm) | INSL (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 |




Egnethed og startværdier for skærehastighed (vc) og tilførsel (f). Se vores app til bearbejdning af yderligere beregninger.

| 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 (°) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | | | | | | | | | | | | | | |
| TN-geometri til afskæring og sporing og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | |
| **LFUX 030802TN** | **6640** | 0.2 | 150 | 0.10 | – | – | 140 | 0.10 | – | – | – | – | – | – | – | – |
| | **T8330** | 0.2 | 130 | 0.10 | – | – | 120 | 0.10 | – | – | – | – | – | – | – | – |
| **LFUX 040802TN** | **6640** | 0.2 | 150 | 0.12 | – | – | 140 | 0.12 | – | – | – | – | – | – | – | – |
| | **T8330** | 0.2 | 130 | 0.12 | – | – | 120 | 0.12 | – | – | – | – | – | – | – | – |
| **LFUX 050802TN** | **6640** | 0.2 | 150 | 0.15 | – | – | 140 | 0.15 | – | – | – | – | – | – | – | – |
| | **T8330** | 0.2 | 130 | 0.15 | – | – | 120 | 0.15 | – | – | – | – | – | – | – | – |
| **LFUX 060802TN** | **6640** | 0.2 | 150 | 0.20 | – | – | 140 | 0.20 | – | – | – | – | – | – | – | – |
| | **T8330** | 0.2 | 130 | 0.20 | – | – | 120 | 0.20 | – | – | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | |
| TR-geometri, højrehåndet, til afstik og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | |
| **LFUX 030800TR** | **6640** | 0.2 | 150 | 0.10 | – | – | 140 | 0.10 | – | – | – | – | – | – | 5 | – |
| | **T8330** | 0.2 | 130 | 0.10 | – | – | 120 | 0.10 | – | – | – | – | – | – | 5 | – |
| **LFUX 040800TR** | **6640** | 0.2 | 150 | 0.12 | – | – | 140 | 0.12 | – | – | – | – | – | – | 5 | – |
| | **T8330** | 0.2 | 130 | 0.12 | – | – | 120 | 0.12 | – | – | – | – | – | – | 5 | – |
|  |  | | | | | | | | | | | | | | | |
| TL-geometri, venstrehåndet, til afstik og kontinuerlige til let afbrudte snit. | | | | | | | | | | | | | | | | |
| **LFUX 030800TL** | **6640** | 0.2 | 150 | 0.10 | – | – | 140 | 0.10 | – | – | – | – | – | – | – | 5 |
| | **T8330** | 0.2 | 130 | 0.10 | – | – | 120 | 0.10 | – | – | – | – | – | – | – | 5 |

# XLCF(RL)

P M K N S H

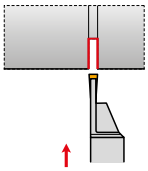
PRAMET

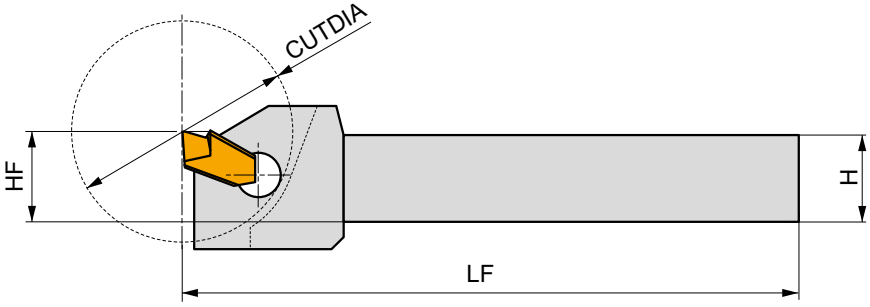
X

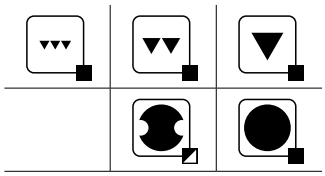


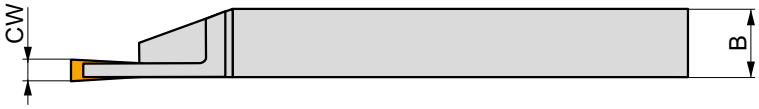
## Eksternt V-Groove Top Clamp-spor- og afstikningsværktøj til LFUX-skær

Ekstern højre / venstre radial værktøjsholder til sporing med ensidige LFUX 0308, 0408, 0508 eller 0608 skær. Velegnet til afstik op til maksimalt Ø65 mm. Fås med skaftstørrelse 16x12 op til 32x25 mm. Krop behandlet for længere værktøjstid.












| | Product | HF (mm) | H (mm) | B (mm) | LF (mm) | CW (mm) | CUTDIA (mm) | kg | | |
|---|---|---|---|---|---|---|---|---|---|---|
| R | **XLCFR 1612 H 03** | 16 | 16 | 12 | 100 | 3.00 | 40 | 0.14 | GI018 | KV |
| | **XLCFR 2016 K 03** | 20 | 20 | 16 | 130 | 3.00 | 50 | 0.30 | GI018 | KV |
| | **XLCFR 2520 K 03** | 25 | 25 | 20 | 130 | 3.00 | 50 | 0.44 | GI018 | KV |
| | **XLCFR 2016 K 04** | 20 | 20 | 16 | 130 | 4.00 | 50 | 0.30 | GI019 | KV |
| | **XLCFR 2520 K 04** | 25 | 25 | 20 | 130 | 4.00 | 50 | 0.43 | GI019 | KV |
| | **XLCFR 2520 K 05** | 25 | 25 | 20 | 130 | 5.00 | 50 | 0.45 | GI020 | KV |
| | **XLCFR 3225 P 05** | 32 | 32 | 25 | 170 | 5.00 | 65 | 0.90 | GI020 | KV |
| | **XLCFR 3225 P 06** | 32 | 32 | 25 | 170 | 6.00 | 65 | 0.91 | GI021 | KV |
| L | **XLCFL 1612 H 03** | 16 | 16 | 12 | 100 | 3.00 | 40 | 0.15 | GI018 | KV |
| | **XLCFL 2016 K 03** | 20 | 20 | 16 | 130 | 3.00 | 50 | 0.30 | GI018 | KV |
| | **XLCFL 2520 K 03** | 25 | 25 | 20 | 130 | 3.00 | 50 | 0.47 | GI018 | KV |
| | **XLCFL 2016 K 04** | 20 | 20 | 16 | 130 | 4.00 | 50 | 0.30 | GI019 | KV |
| | **XLCFL 2520 K 04** | 25 | 25 | 20 | 130 | 4.00 | 50 | 0.46 | GI019 | KV |
| | **XLCFL 2520 K 05** | 25 | 25 | 20 | 130 | 5.00 | 50 | 0.50 | GI020 | KV |
| | **XLCFL 3225 P 05** | 32 | 32 | 25 | 170 | 5.00 | 65 | 0.95 | GI020 | KV |
| | **XLCFL 3225 P 06** | 32 | 32 | 25 | 170 | 6.00 | 65 | 0.70 | GI021 | KV |

| | |
|---|---|
| GI018 | LFUX 0308.. |
| GI019 | LFUX 0408.. |
| GI020 | LFUX 0508.. |
| GI021 | LFUX 0608.. |

| | |
|---|---|
| KV | KV 5x70 |

# XLCFN B LFUX

P M K N S H

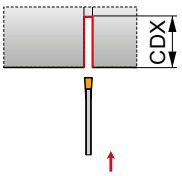
PRAMET

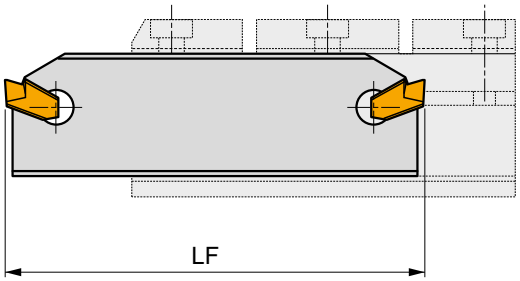
X

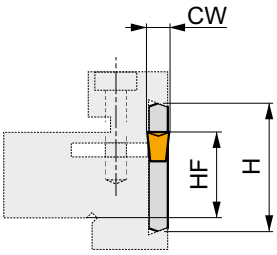


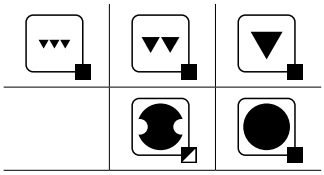
## Dobbeltsidet afskæringsblad til LFUX-skær

Blad til afstik applikationer op til 100 mm maksimal dybde eller Ø200 mm stangmateriale. Velegnet til ensidige LFUX-skær. Fås i højder på 26, 32 eller 47 mm. Kan monteres i DU, D Pramet basisholdere. Kniv behandlet for længere levetid på værktøjet.







| | 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 | 0.09 | GI018 | KV |
| | **XLCFN 3203 M 04** | 25 | 32 | 150 | 4.10 | 50 | 0.11 | GI019 | KV |
| | **XLCFN 3204 M 05** | 25 | 32 | 150 | 5.10 | 60 | 0.14 | GI020 | KV |
| | **XLCFN 4704 S 05** | 38 | 47 | 270 | 5.10 | 100 | 0.47 | 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.. |

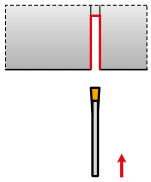
| | |
|---|---|
| KV | KV 5x70 |

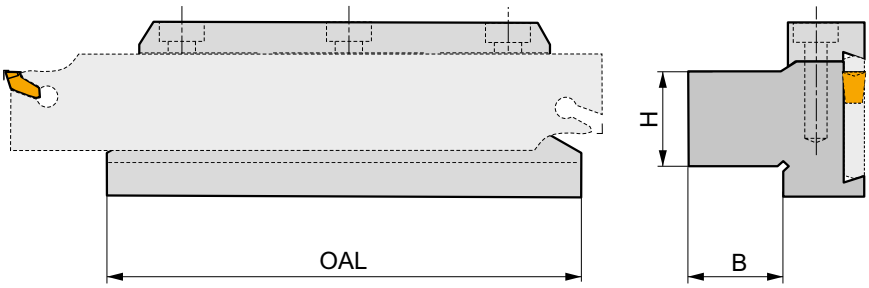
# DU, D

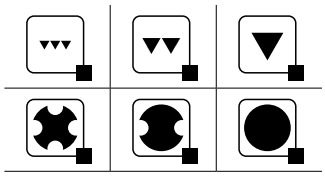


## Værktøjsholderblok til stikblade

Værktøjsholder, der passer til GL eller XLC. knive til afskæring. Fås med skaftstørrelse 20x20 op til 40x40 mm. Krop behandlet for længere levetid på værktøjet.





| Product | H (mm) | B (mm) | OAL (mm) | kg | | |
|---|---|---|---|---|---|---|
| **26-DU 2020** | 20 | 20 | 90 | 0.70 | GI007 | ND2 |
| **26-D 2020** | 20 | 20 | 100 | 0.82 | GI007 | ND2 |
| **32-DU 2523** | 25 | 23 | 110 | 1.02 | GI008 | ND2 |
| **32-DU 2532** | 25 | 32 | 110 | 1.10 | GI008 | ND2 |
| **32-DU 3229** | 32 | 29 | 110 | 1.25 | GI008 | ND2 |
| **32-D 2530** | 25 | 30 | 115 | 1.30 | 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 | 3.88 | GI091 | ND3 |

| | | |
|---|---|---|
| GI007 | XLC.N 26.. | GL.-S26.B |
| GI008 | XLC.N 32.. | GL.-S32.B |
| GI009 | XLC.N 45.. | – |
| GI091 | XLC.N 47.. | – |

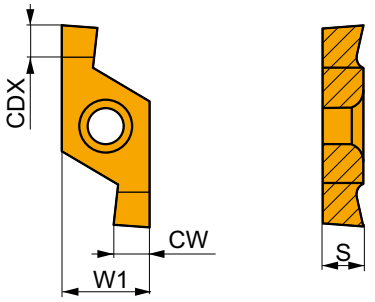
| | | Nm | | | |
|---|---|---|---|---|---|
| ND2 | HS 0625 | 6.0 | M 6 | 25 | HXK 5 |
| ND3 | HS 1030 | 8.0 | M 10 | 30 | HXK 8 |
| ND7 | HS 0630 | 6.0 | M 6 | 30 | HXK 5 |

NEW

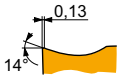
# X 61

PRAMET

| | W1 | CWTOLL | CWTOLU | S |
|---|---|---|---|---|
| | (mm) | (mm) | (mm) | (mm) |
| 0602 | 6.350 | -0.03 | 0.03 | 2.33 |

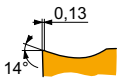



Egnethed og startværdier for skærehastighed (vc) og tilførsel (f). Se vores app til bearbejdning af yderligere beregninger.

| Product | | RE | 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | | | | | | | | | | | | | | |
| | | | | | | | | | | | | | | | | |

X 61-R udvendig og intern, højrehåndet geometri til bearbejdning af o-ring og låsespor med kontinuerlige snit.

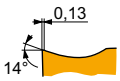
| | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **X61 0602-080 R** | **6640** | – | 195 | 0.06 | 115 | 0.05 | 185 | 0.06 | – | – | – | – | – | – | 0.85 | 0.8 |
| | **G8330** | – | 145 | 0.06 | 85 | 0.05 | 135 | 0.06 | – | – | – | – | – | – | 0.85 | 0.8 |
| **X61 0602-090 R** | **6640** | – | 195 | 0.06 | 115 | 0.05 | 185 | 0.06 | – | – | – | – | – | – | 0.95 | 0.8 |
| | **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 |
| | **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 |
| | **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 |
| | **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 |
| | **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 |
| | **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 |
| | **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 |
| | **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 |
| | **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 |
| | **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 |
| | **G8330** | – | 105 | 0.12 | 60 | 0.11 | 95 | 0.12 | – | – | – | – | – | – | 3.20 | 3 |

X 61-L udvendig og intern, venstrehåndet geometri, til bearbejdning af o-ring og låsering med kontinuerlige snit.

| | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **X61 0602-080 L** | **6640** | – | 195 | 0.06 | 115 | 0.05 | 185 | 0.06 | – | – | – | – | – | – | 0.85 | 0.8 |
| | **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 |
| | **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 |
| | **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 |
| | **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 |
| | **G8330** | – | 140 | 0.06 | 80 | 0.05 | 130 | 0.06 | – | – | – | – | – | – | 1.35 | 1.4 |

Egnethed og startværdier for skærehastighed (vc) og tilførsel (f). Se vores app til bearbejdning af yderligere beregninger.

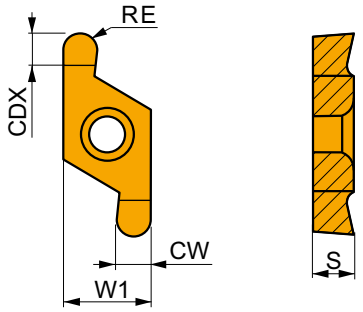
| Product | | RE | P vc (m/min) | P f (mm/rev) | M vc (m/min) | M f (mm/rev) | K vc (m/min) | K f (mm/rev) | N vc (m/min) | N f (mm/rev) | S vc (m/min) | S f (mm/rev) | H vc (m/min) | H f (mm/rev) | CW (mm) | CDX (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |   | | | | | | | | | | | | | | | |
| | | | U S | | | | | | | | | | | | | |
| | | | X 61-L udvendig og intern, venstrehåndet geometri, til bearbejdning af o-ring og låsering med kontinuerlige snit. | | | | | | | | | | | | | |
| **X61 0602-150 L** | **6640** | – | 180 | 0.06 | 105 | 0.05 | 170 | 0.06 | – | – | – | – | – | – | 1.55 | 1.6 |
| | **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 |
| | **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 |
| | **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 |
| | **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 |
| | **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 |
| | **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 |
| | **G8330** | – | 105 | 0.12 | 60 | 0.11 | 95 | 0.12 | – | – | – | – | – | – | 3.20 | 3 |

NEW

# X 61 R

PRAMET

| | W1 (mm) | CWTOLL (mm) | CWTOLU (mm) | S (mm) |
|---|---|---|---|---|
| 0602 | 6.350 | -0.03 | 0.03 | 2.33 |




Egnethed og startværdier for skærehastighed (vc) og tilførsel (f). Se vores app til bearbejdning af yderligere beregninger.

| Product | | RE | 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |   | | | | | | | | | | | | | | | |
| | | | U E | | | | | | | | | | | | | |
| | | | X 61 R-R ekstern og intern, højrehåndet geometri, til bearbejdning af o-ring og låsering med kontinuerlige snit. | | | | | | | | | | | | | |
| **X61 0602-R100 R** | **6640** | 1.0 | 170 | 0.06 | 100 | 0.05 | 160 | 0.06 | – | – | – | – | – | – | 2.09 | 3 |
| | **G8330** | 1.0 | 130 | 0.06 | 75 | 0.05 | 120 | 0.06 | – | – | – | – | – | – | 2.09 | 3 |
| **X61 0602-R150 R** | **6640** | 1.5 | 170 | 0.06 | 100 | 0.05 | 160 | 0.06 | – | – | – | – | – | – | 3.09 | 3 |
| | **G8330** | 1.5 | 130 | 0.06 | 75 | 0.05 | 120 | 0.06 | – | – | – | – | – | – | 3.09 | 3 |
|  |   | | | | | | | | | | | | | | | |
| | | | U E | | | | | | | | | | | | | |
| | | | X 61 R-L udvendig og intern, venstrehåndet geometri, til bearbejdning af o-ring og låsering med kontinuerlige snit. | | | | | | | | | | | | | |
| **X61 0602-R100 L** | **6640** | 1.0 | 170 | 0.06 | 100 | 0.05 | 160 | 0.06 | – | – | – | – | – | – | 2.09 | 3 |
| | **G8330** | 1.0 | 130 | 0.06 | 75 | 0.05 | 120 | 0.06 | – | – | – | – | – | – | 2.09 | 3 |
| **X61 0602-R150 L** | **6640** | 1.5 | 170 | 0.06 | 100 | 0.05 | 160 | 0.06 | – | – | – | – | – | – | 3.09 | 3 |
| | **G8330** | 1.5 | 130 | 0.06 | 75 | 0.05 | 120 | 0.06 | – | – | – | – | – | – | 3.09 | 3 |

NEW

# P61(RL) EXT

P M K N S

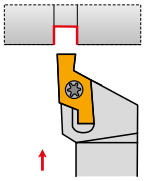
PRAMET

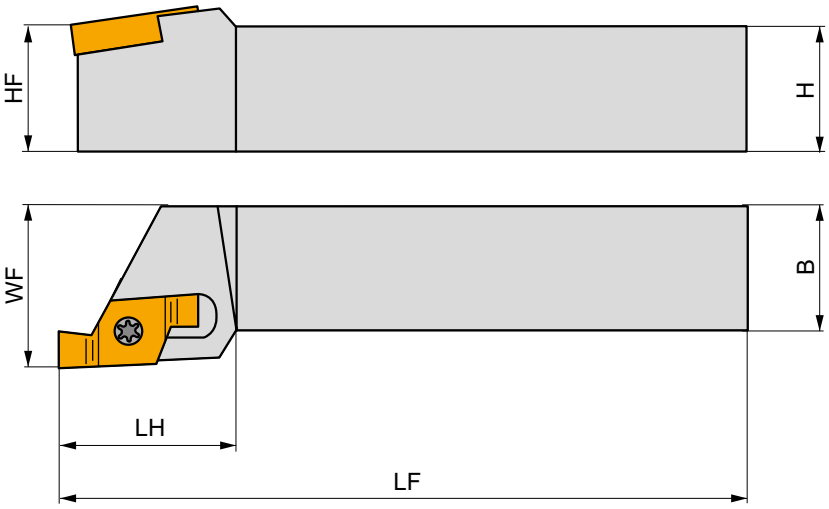
S

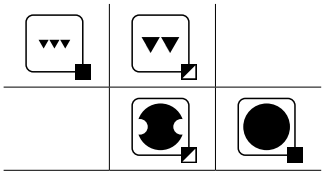


## Holder til eksternt sporværktøj til X61-låser og O-ringskær

Ekstern, højre / venstre hånd, radial værktøjsholder til sporing med X61 dobbeltsidet låsering eller O-ringskær. Giver glat skærevirkning for højt tolererede dimensioner. Fås med skaftstørrelse 16x16 op til 25x25 mm. Krop behandlet for længere værktøjstid.







| | 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 | 0.23 | GI332 | SV11 |
| | P61.SFR-2020K-06 | 20 | 20 | 20 | 25 | 125 | 25 | 0.40 | GI332 | SV11 |
| | P61.SFR-2525M-06 | 25 | 25 | 25 | 32 | 150 | 32 | 0.73 | GI332 | SV11 |
| L | P61.SFL-1616H-06 | 16 | 16 | 16 | 20 | 100 | 21 | 0.23 | GI332 | SV11 |
| | P61.SFL-2020K-06 | 20 | 20 | 20 | 25 | 125 | 25 | 0.42 | GI332 | SV11 |
| | P61.SFL-2525M-06 | 25 | 25 | 25 | 32 | 150 | 32 | 0.73 | GI332 | SV11 |

| | |
|---|---|
| GI332 | X61 0602.. |

| | | Nm | | | |
|---|---|---|---|---|---|
| SV11 | US 2003-T07P | 0.8 | M 2.5 | 6.5 | FLAG T07P |

NEW

# P61(RL) INT

P M K N S

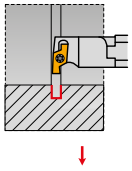
PRAMET

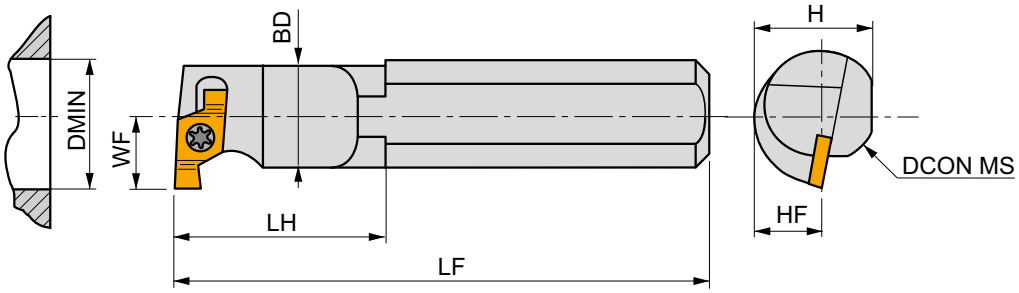
S

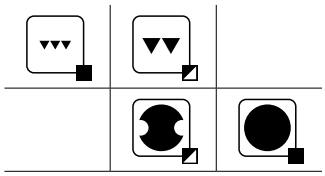


## Indvendig borestang til låsning til X61 skær

Indvendigt højre / venstre sporborestang til spor med X61 dobbeltsidede skær. Minimum indvendig spordiameter Ø16 mm. Velegnet til indvendig skæring af låsering af låsering eller O-ring. Fås med skaftstørrelse Ø12 op til Ø32 mm. Krop behandlet for længere levetid på værktøjet.









| | 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 | – | 0.17 | GI332 | SV11 |
| | **P61.SGR-A-0016M-06** | 16 | 20 | 15 | 11 | 15 | 150 | 29 | 0 | ✓ | 0.21 | GI332 | SV11 |
| | **P61.SGR-A-0020P-06** | 20 | 25 | 19 | 13 | 18 | 170 | 29 | 0 | ✓ | 0.38 | GI332 | SV11 |
| | **P61.SGR-A-0025R-06** | 25 | 32 | 24 | 17 | 23 | 200 | 31 | 0 | ✓ | 0.70 | GI332 | SV11 |
| | **P61.SGR-A-0032T-06** | 32 | 40 | 31 | 22 | 30 | 300 | 49 | 0 | ✓ | 1.72 | GI332 | SV11 |
| L | **P61.SGL-0012M-06** | 12 | 16 | 11.5 | 9 | 11 | 150 | 22 | 0 | – | 0.17 | GI332 | SV11 |
| | **P61.SGL-A-0016M-06** | 16 | 20 | 15 | 11 | 15 | 150 | 29 | 0 | ✓ | 0.24 | GI332 | SV11 |
| | **P61.SGL-A-0020P-06** | 20 | 25 | 19 | 13 | 18 | 170 | 29 | 0 | ✓ | 0.40 | GI332 | SV11 |
| | **P61.SGL-A-0025R-06** | 25 | 32 | 24 | 17 | 23 | 200 | 31 | 0 | ✓ | 0.72 | GI332 | SV11 |
| | **P61.SGL-A-0032T-06** | 32 | 40 | 31 | 22 | 30 | 300 | 49 | 0 | ✓ | 1.72 | GI332 | SV11 |

| | |
|---|---|
| GI332 | X61 0602.. |

| | | Nm | | | |
|---|---|---|---|---|---|
| SV11 | US 2003-T07P | 0.8 | M 2.5 | 6.5 | FLAG T07P |

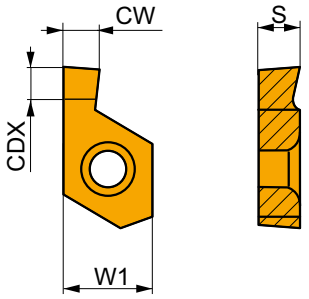
Venstre skærholder til højre borestang.

NEW

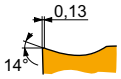
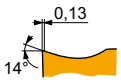
# X 61-1

PRAMET

| | W1 | CWTOLL | CWTOLU | S |
|---|---|---|---|---|
| | (mm) | (mm) | (mm) | (mm) |
| 0602 | 6.350 | -0.03 | 0.03 | 2.33 |




Egnethed og startværdier for skærehastighed (vc) og tilførsel (f). Se vores app til bearbejdning af yderligere beregninger.

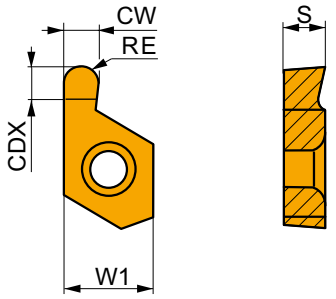
| Product | | RE | P | | M | | K | | N | | S | | H | | CW | CDX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | vc (m/min) | f (mm/rev) | vc (m/min) | f (mm/rev) | vc (m/min) | f (mm/rev) | vc (m/min) | f (mm/rev) | vc (m/min) | f (mm/rev) | vc (m/min) | f (mm/rev) | (mm) | (mm) |
|  |  | | | | | | | | | | | | | | | |
| X 61-1-R internt, højrehåndet design med en skærekant til bearbejdning af O-ring og låsering med kontinuerlige snit. | | | | | | | | | | | | | | | | |
| **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 |
|  |  | | | | | | | | | | | | | | | |
| X 61-1-L indvendigt, venstrehåndet design med en skærekant til bearbejdning af O-ring og låsering med kontinuerlige snit. | | | | | | | | | | | | | | | | |
| **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 |

NEW

# X 61 R-1

PRAMET

| | W1 | CWTOLL | CWTOLU | S |
|---|---|---|---|---|
| | (mm) | (mm) | (mm) | (mm) |
| 0602 | 6.350 | -0.03 | 0.03 | 2.33 |




Egnethed og startværdier for skærehastighed (vc) og tilførsel (f). Se vores app til bearbejdning af yderligere beregninger.

| Product | | RE | P | | M | | K | | N | | S | | H | | CW | CDX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | vc (m/min) | f (mm/rev) | vc (m/min) | f (mm/rev) | vc (m/min) | f (mm/rev) | vc (m/min) | f (mm/rev) | vc (m/min) | f (mm/rev) | vc (m/min) | f (mm/rev) | (mm) | (mm) |
|  |  | | | | | | | | | | | | | | | |
| | | | U E | | | | | | | | | | | | | |
| X 61 R-1-R internt, højrehåndet design, med en skærekant til bearbejdning af o-ring og låsering med kontinuerlige snit. | | | | | | | | | | | | | | | | |
| **X61 0602-R050 R1** | **6640** | 0.5 | ■ 185 | 0.06 | ◪ 110 | 0.05 | ◪ 175 | 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 |
|  |  | | | | | | | | | | | | | | | |
| | | | U E | | | | | | | | | | | | | |
| X 61 R-1-L indvendigt, venstrehåndet design, med en skærekant til bearbejdning af o-ring og låsering med kontinuerlige snit. | | | | | | | | | | | | | | | | |
| **X61 0602-R050 L1** | **6640** | 0.5 | ■ 185 | 0.06 | ◪ 110 | 0.05 | ◪ 175 | 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 |

NEW

# P61S(RL)-1 INT

P M K N S

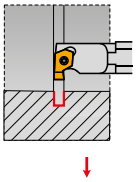
PRAMET

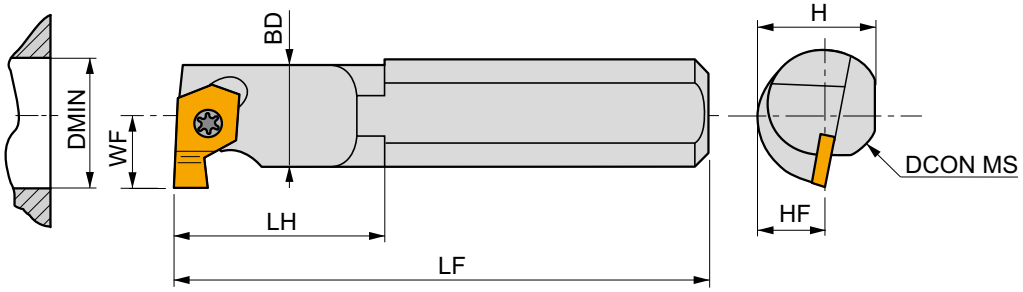
S

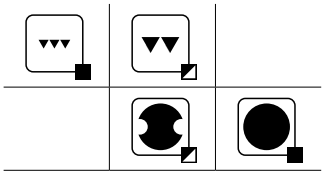


## Indvendig borestang til låsning til X61-1-skær

Indvendigt højre / venstre sporborestang til spor med ensidige X61-1-skær. Minimum indvendig spordiameter Ø12,5 mm. Velegnet til indvendig skæring af låsering af låsering eller O-ring. Fås med skaftstørrelse Ø10 og Ø12 mm. Krop behandlet for længere levetid på værktøjet.







| | 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 | 0.24 | GI333 | SV11 |
| | P61.SGR-0012M-06/1 | 12 | 12.5 | 10 | 7.5 | 11 | 150 | 19 | 0 | 0.17 | GI333 | SV11 |
| L | P61.SGL-0010M-06/1 | 10 | 12.5 | 10 | 7.5 | 9 | 150 | 19 | 0 | 0.13 | GI333 | SV11 |
| | P61.SGL-0012M-06/1 | 12 | 12.5 | 10 | 7.5 | 11 | 150 | 19 | 0 | 0.17 | GI333 | SV11 |

| | |
|---|---|
| GI333 | X61 0602..-1 |

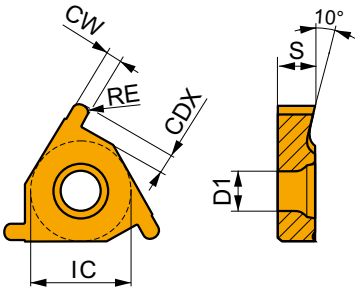
| | | Nm | | | |
|---|---|---|---|---|---|
| SV11 | US 2003-T07P | 0.8 | M 2.5 | 6.5 | FLAG T07P |

Venstre skærholder til højre borestang.

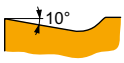
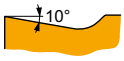
# TN R EXT

PRAMET

| | IC (mm) | D1 (mm) | S (mm) | CWTOLL (mm) | CWTOLU (mm) |
|---|---|---|---|---|---|
| 16 | 9.525 | 3.90 | 3.58 | 0.00 | 0.05 |
| 22 | 12.700 | 4.90 | 4.70 | 0.00 | 0.05 |



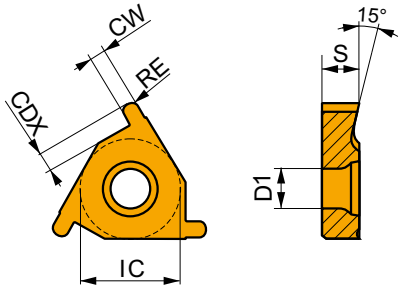

Egnethed og startværdier for skærehastighed (vc) og tilførsel (f). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | U E | | | | | | | | | | | | | |
| | | | TN ER-R ekstern, højrehåndet geometri, til bearbejdning af o-ring og låsespor med kontinuerlige snit. | | | | | | | | | | | | | |
| **TN 16ER-R050** | **T8330** | 0.5 | 130 | 0.06 | 75 | 0.05 | 120 | 0.06 | – | – | – | – | – | – | 1.00 | 1.3 |
| **TN 16ER-R100** | **T8330** | 1.0 | 130 | 0.06 | 75 | 0.05 | 120 | 0.06 | – | – | – | – | – | – | 2.00 | 1.85 |
| **TN 22ER-R150** | **T8330** | 1.5 | 130 | 0.06 | 75 | 0.05 | 120 | 0.06 | – | – | – | – | – | – | 3.00 | 2.2 |
|  |  | | U E | | | | | | | | | | | | | |
| | | | TN EL-R ekstern, venstrehånds geometri, til bearbejdning af O-ring og låsespor med kontinuerlige snit. | | | | | | | | | | | | | |
| **TN 16EL-R050** | **T8330** | 0.5 | 130 | 0.06 | 75 | 0.05 | 120 | 0.06 | – | – | – | – | – | – | 1.00 | 1.3 |
| **TN 16EL-R100** | **T8330** | 1.0 | 130 | 0.06 | 75 | 0.05 | 120 | 0.06 | – | – | – | – | – | – | 2.00 | 1.85 |
| **TN 22EL-R150** | **T8330** | 1.5 | 130 | 0.06 | 75 | 0.05 | 120 | 0.06 | – | – | – | – | – | – | 3.00 | 2.2 |

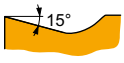
# TN R INT

PRAMET

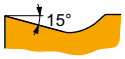
| | IC (mm) | D1 (mm) | S (mm) | CWTOLL (mm) | CWTOLU (mm) |
|---|---|---|---|---|---|
| 11 | 6.350 | 2.80 | 3.10 | 0.00 | 0.05 |
| 16 | 9.525 | 3.90 | 3.58 | 0.00 | 0.05 |
| 22 | 12.700 | 4.90 | 4.70 | 0.00 | 0.05 |




Egnethed og startværdier for skærehastighed (vc) og tilførsel (f). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | U E | | | | | | | | | | | | | |
| | | | TN NR-R intern, højrehåndet geometri til bearbejdning af o-ring og låsespor med kontinuerlige snit. | | | | | | | | | | | | | |
| **TN 11NR-R050** | **T8330** | 0.5 | 130 | 0.06 | 75 | 0.05 | 120 | 0.06 | – | – | – | – | – | – | 1.00 | 1.3 |
| **TN 16NR-R100** | **T8330** | 1.0 | 130 | 0.06 | 75 | 0.05 | 120 | 0.06 | – | – | – | – | – | – | 2.00 | 1.85 |
| **TN 22NR-R150** | **T8330** | 1.5 | 130 | 0.06 | 75 | 0.05 | 120 | 0.06 | – | – | – | – | – | – | 3.00 | 2.2 |

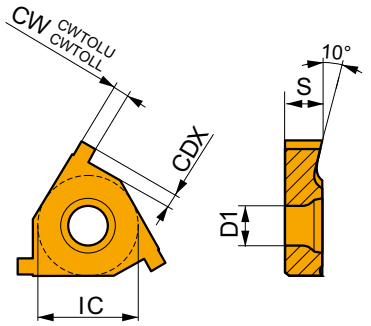
Egnethed og startværdier for skærehastighed (vc) og tilførsel (f). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|  |  | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| TN NL-R intern, venstrehåndet geometri, til bearbejdning af O-ring og låsespor med kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| **TN 11NL-R050** | **T8330** | 0.5 | ■ | 130 | 0.06 | ◪ | 75 | 0.05 | ◪ | 120 | 0.06 | | – | – | | – | – | | – | – | | – | – | | 1.00 | 1.3 |
| **TN 16NL-R100** | **T8330** | 1.0 | ■ | 130 | 0.06 | ◪ | 75 | 0.05 | ◪ | 120 | 0.06 | | – | – | | – | – | | – | – | | – | – | | 2.00 | 1.85 |
| **TN 22NL-R150** | **T8330** | 1.5 | ■ | 130 | 0.06 | ◪ | 75 | 0.05 | ◪ | 120 | 0.06 | | – | – | | – | – | | – | – | | – | – | | 3.00 | 2.2 |

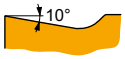
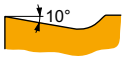
# TN ZZ EXT

PRAMET

| | IC | D1 | S |
|---|---|---|---|
| | (mm) | (mm) | (mm) |
| 16 | 9.525 | 3.90 | 3.40 |
| 22 | 12.700 | 4.90 | 4.70 |



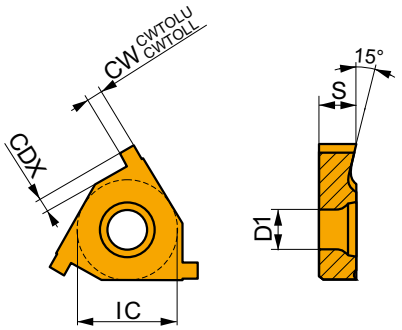

Egnethed og startværdier for skærehastighed (vc) og tilførsel (f). Se vores app til bearbejdning af yderligere beregninger.

| Product | | RE | P | | | | M | | | | K | | | | N | | | | S | | | | H | | | | CW | CWTOLL | CWTOLU | 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) | (mm) | (mm) |
|  |  | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| TN ER-ZZ ekstern, højrehåndet geometri til bearbejdning af O-ring og låsespor med kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| **TN 16ER090ZZ** | **T8330** | – | ■ | 130 | 0.09 | ◪ | 75 | 0.08 | ◪ | 120 | 0.09 | | – | – | | – | – | | – | – | | – | – | | 0.90 | 0.05 | 0.10 | 0.9 |
| **TN 16ER110ZZ** | **T8330** | – | ■ | 130 | 0.09 | ◪ | 75 | 0.08 | ◪ | 120 | 0.09 | | – | – | | – | – | | – | – | | – | – | | 1.10 | 0.05 | 0.10 | 1.3 |
| **TN 16ER130ZZ** | **T8330** | – | ■ | 130 | 0.09 | ◪ | 75 | 0.08 | ◪ | 120 | 0.09 | | – | – | | – | – | | – | – | | – | – | | 1.30 | 0.05 | 0.10 | 1.6 |
| **TN 16ER160ZZ** | **T8330** | – | ■ | 130 | 0.09 | ◪ | 75 | 0.08 | ◪ | 120 | 0.09 | | – | – | | – | – | | – | – | | – | – | | 1.60 | 0.05 | 0.10 | 1.85 |
| **TN 16ER185ZZ** | **T8330** | – | ■ | 130 | 0.09 | ◪ | 75 | 0.08 | ◪ | 120 | 0.09 | | – | – | | – | – | | – | – | | – | – | | 1.85 | 0.05 | 0.10 | 1.85 |
| **TN 16ER215ZZ** | **T8330** | – | ■ | 130 | 0.09 | ◪ | 75 | 0.08 | ◪ | 120 | 0.09 | | – | – | | – | – | | – | – | | – | – | | 2.15 | 0.05 | 0.10 | 1.85 |
| **TN 16ER265ZZ** | **T8330** | – | ■ | 130 | 0.12 | ◪ | 75 | 0.11 | ◪ | 120 | 0.12 | | – | – | | – | – | | – | – | | – | – | | 2.65 | 0.05 | 0.10 | 2.05 |
| **TN 22ER265ZZ** | **T8330** | – | ■ | 130 | 0.12 | ◪ | 75 | 0.11 | ◪ | 120 | 0.12 | | – | – | | – | – | | – | – | | – | – | | 2.65 | 0.08 | 0.13 | 2.2 |
| **TN 22ER315ZZ** | **T8330** | – | ■ | 130 | 0.12 | ◪ | 75 | 0.11 | ◪ | 120 | 0.12 | | – | – | | – | – | | – | – | | – | – | | 3.15 | 0.08 | 0.13 | 2.2 |
| **TN 22ER415ZZ** | **T8330** | – | ■ | 130 | 0.12 | ◪ | 75 | 0.11 | ◪ | 120 | 0.12 | | – | – | | – | – | | – | – | | – | – | | 4.15 | 0.08 | 0.13 | 2.4 |
|  |  | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| TN EL-ZZ ekstern, venstrehåndet geometri, til bearbejdning af o-ring og låsespor med kontinuerlige snit. | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| **TN 16EL090ZZ** | **T8330** | – | ■ | 130 | 0.06 | ◪ | 75 | 0.05 | ◪ | 120 | 0.06 | | – | – | | – | – | | – | – | | – | – | | 0.90 | 0.05 | 0.10 | 0.9 |
| **TN 16EL110ZZ** | **T8330** | – | ■ | 130 | 0.06 | ◪ | 75 | 0.05 | ◪ | 120 | 0.06 | | – | – | | – | – | | – | – | | – | – | | 1.10 | 0.05 | 0.10 | 1.3 |
| **TN 16EL130ZZ** | **T8330** | – | ■ | 130 | 0.06 | ◪ | 75 | 0.05 | ◪ | 120 | 0.06 | | – | – | | – | – | | – | – | | – | – | | 1.30 | 0.05 | 0.10 | 1.6 |
| **TN 16EL160ZZ** | **T8330** | – | ■ | 130 | 0.06 | ◪ | 75 | 0.05 | ◪ | 120 | 0.06 | | – | – | | – | – | | – | – | | – | – | | 1.60 | 0.05 | 0.10 | 1.85 |
| **TN 16EL185ZZ** | **T8330** | – | ■ | 130 | 0.06 | ◪ | 75 | 0.05 | ◪ | 120 | 0.06 | | – | – | | – | – | | – | – | | – | – | | 1.85 | 0.05 | 0.10 | 1.85 |
| **TN 16EL215ZZ** | **T8330** | – | ■ | 130 | 0.09 | ◪ | 75 | 0.08 | ◪ | 120 | 0.09 | | – | – | | – | – | | – | – | | – | – | | 2.15 | 0.05 | 0.10 | 1.85 |
| **TN 16EL265ZZ** | **T8330** | – | ■ | 130 | 0.09 | ◪ | 75 | 0.08 | ◪ | 120 | 0.09 | | – | – | | – | – | | – | – | | – | – | | 2.65 | 0.05 | 0.10 | 2.05 |
| **TN 22EL265ZZ** | **T8330** | – | ■ | 130 | 0.12 | ◪ | 75 | 0.11 | ◪ | 120 | 0.12 | | – | – | | – | – | | – | – | | – | – | | 2.65 | 0.08 | 0.13 | 2.2 |
| **TN 22EL315ZZ** | **T8330** | – | ■ | 130 | 0.12 | ◪ | 75 | 0.11 | ◪ | 120 | 0.12 | | – | – | | – | – | | – | – | | – | – | | 3.15 | 0.08 | 0.13 | 2.2 |
| **TN 22EL415ZZ** | **T8330** | – | ■ | 130 | 0.12 | ◪ | 75 | 0.11 | ◪ | 120 | 0.12 | | – | – | | – | – | | – | – | | – | – | | 4.15 | 0.08 | 0.13 | 2.4 |

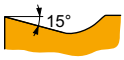
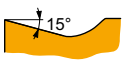
# TN ZZ INT

PRAMET

| | IC (mm) | D1 (mm) | S (mm) |
|---|---|---|---|
| 11 | 6.350 | 2.80 | 3.00 |
| 16 | 9.525 | 3.90 | 3.40 |
| 22 | 12.700 | 4.90 | 4.70 |




Egnethed og startværdier for skærehastighed (vc) og tilførsel (f). Se vores app til bearbejdning af yderligere beregninger.

| 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) | CWTOLL (mm) | CWTOLU (mm) | CDX (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | | | | | | | | | | | | | | | | |
| TN NR-ZZ intern, højrehåndet geometri til bearbejdning af o-ring og låsespor med kontinuerlige snit. | | | | | | | | | | | | | | | | | | |
| **TN 11NR090ZZ** | **T8330** | – | 130 | 0.06 | 75 | 0.05 | 120 | 0.06 | – | – | – | – | – | – | 0.90 | 0.05 | 0.10 | 0.9 |
| **TN 11NR110ZZ** | **T8330** | – | 130 | 0.06 | 75 | 0.05 | 120 | 0.06 | – | – | – | – | – | – | 1.10 | 0.05 | 0.10 | 1.3 |
| **TN 16NR090ZZ** | **T8330** | – | 130 | 0.06 | 75 | 0.05 | 120 | 0.06 | – | – | – | – | – | – | 0.90 | 0.05 | 0.10 | 0.9 |
| **TN 16NR110ZZ** | **T8330** | – | 130 | 0.06 | 75 | 0.05 | 120 | 0.06 | – | – | – | – | – | – | 1.10 | 0.05 | 0.10 | 1.3 |
| **TN 16NR130ZZ** | **T8330** | – | 130 | 0.06 | 75 | 0.05 | 120 | 0.06 | – | – | – | – | – | – | 1.30 | 0.05 | 0.10 | 1.6 |
| **TN 16NR160ZZ** | **T8330** | – | 130 | 0.06 | 75 | 0.05 | 120 | 0.06 | – | – | – | – | – | – | 1.60 | 0.05 | 0.10 | 1.85 |
| **TN 16NR185ZZ** | **T8330** | – | 130 | 0.06 | 75 | 0.05 | 120 | 0.06 | – | – | – | – | – | – | 1.85 | 0.05 | 0.10 | 1.85 |
| **TN 16NR215ZZ** | **T8330** | – | 130 | 0.09 | 75 | 0.08 | 120 | 0.09 | – | – | – | – | – | – | 2.15 | 0.05 | 0.10 | 1.85 |
| **TN 16NR265ZZ** | **T8330** | – | 130 | 0.12 | 75 | 0.11 | 120 | 0.12 | – | – | – | – | – | – | 2.65 | 0.05 | 0.10 | 2.05 |
| **TN 22NR265ZZ** | **T8330** | – | 130 | 0.12 | 75 | 0.11 | 120 | 0.12 | – | – | – | – | – | – | 2.65 | 0.08 | 0.13 | 2.2 |
| **TN 22NR315ZZ** | **T8330** | – | 130 | 0.12 | 75 | 0.11 | 120 | 0.12 | – | – | – | – | – | – | 3.15 | 0.08 | 0.13 | 2.2 |
| **TN 22NR415ZZ** | **T8330** | – | 130 | 0.12 | 75 | 0.11 | 120 | 0.12 | – | – | – | – | – | – | 4.15 | 0.08 | 0.13 | 2.4 |
|  |  | | | | | | | | | | | | | | | | | |
| TN NL-ZZ intern, venstrehånds geometri, til bearbejdning af o-ring og låsering med kontinuerlige snit. | | | | | | | | | | | | | | | | | | |
| **TN 11NL090ZZ** | **T8330** | – | 130 | 0.06 | 75 | 0.05 | 120 | 0.06 | – | – | – | – | – | – | 0.90 | 0.05 | 0.10 | 0.9 |
| **TN 11NL110ZZ** | **T8330** | – | 130 | 0.06 | 75 | 0.05 | 120 | 0.06 | – | – | – | – | – | – | 1.10 | 0.05 | 0.10 | 1.3 |
| **TN 16NL090ZZ** | **T8330** | – | 130 | 0.06 | 75 | 0.05 | 120 | 0.06 | – | – | – | – | – | – | 0.90 | 0.05 | 0.10 | 0.9 |
| **TN 16NL110ZZ** | **T8330** | – | 130 | 0.06 | 75 | 0.05 | 120 | 0.06 | – | – | – | – | – | – | 1.10 | 0.05 | 0.10 | 1.3 |
| **TN 16NL130ZZ** | **T8330** | – | 130 | 0.06 | 75 | 0.05 | 120 | 0.06 | – | – | – | – | – | – | 1.30 | 0.05 | 0.10 | 1.6 |
| **TN 16NL160ZZ** | **T8330** | – | 130 | 0.06 | 75 | 0.05 | 120 | 0.06 | – | – | – | – | – | – | 1.60 | 0.05 | 0.10 | 1.85 |
| **TN 16NL185ZZ** | **T8330** | – | 130 | 0.06 | 75 | 0.05 | 120 | 0.06 | – | – | – | – | – | – | 1.85 | 0.05 | 0.10 | 1.85 |
| **TN 16NL215ZZ** | **T8330** | – | 130 | 0.09 | 75 | 0.08 | 120 | 0.09 | – | – | – | – | – | – | 2.15 | 0.05 | 0.10 | 1.85 |
| **TN 16NL265ZZ** | **T8330** | – | 130 | 0.09 | 75 | 0.08 | 120 | 0.09 | – | – | – | – | – | – | 2.65 | 0.05 | 0.10 | 2.05 |
| **TN 22NL265ZZ** | **T8330** | – | 130 | 0.12 | 75 | 0.11 | 120 | 0.12 | – | – | – | – | – | – | 2.65 | 0.08 | 0.13 | 2.2 |
| **TN 22NL315ZZ** | **T8330** | – | 130 | 0.12 | 75 | 0.11 | 120 | 0.12 | – | – | – | – | – | – | 3.15 | 0.08 | 0.13 | 2.2 |
| **TN 22NL415ZZ** | **T8330** | – | 130 | 0.12 | 75 | 0.11 | 120 | 0.12 | – | – | – | – | – | – | 4.15 | 0.08 | 0.13 | 2.4 |

# SE(RL)

P M K N S H

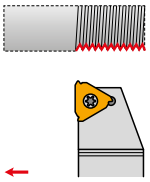
PRAMET

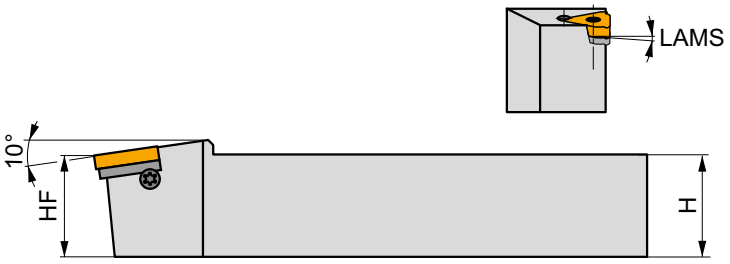
S

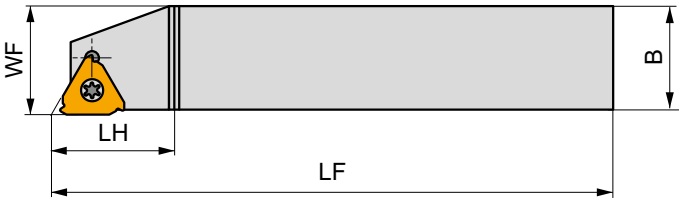


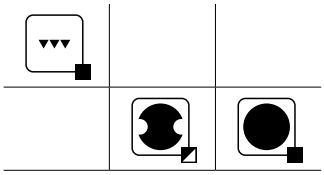
## Ekstern skrue fastspændt gevindholder til TN 16 og 22 neutral skær

Højre / venstre skruelåsværktøjsholder til udvendigt gevind med TN16 eller 22 ER / EL-skær. Velegnet til gevindskæring i metrisk eller tomme profil. Også velegnet til lav rille. Krop behandlet for længere levetid på værktøjet.







| | 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 | – | 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 | – | GI068 | Z12 |
| | **SEL 3225 P 16** | 32 | 32 | 25 | 25 | 170 | 24.5 | – | GI068 | Z12 |
| | **SEL 2525 M 22-A** | 25 | 25 | 25 | 25 | 150 | 25.5 | – | GI071 | Z13 |
| | **SEL 3225 P 22-A** | 32 | 32 | 25 | 25 | 170 | 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 | 481 |
| Z13 | US 4514A-T20 | 5.0 | M 4.5 | 14 | SP 0405 | – | FLAG T20 | – | 481 |

# SI(RL)

P M K N S H

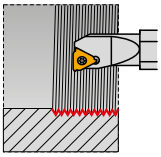
PRAMET

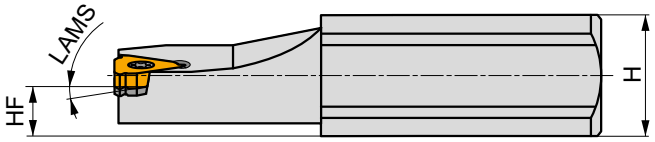
S

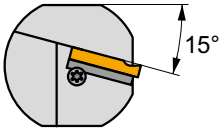


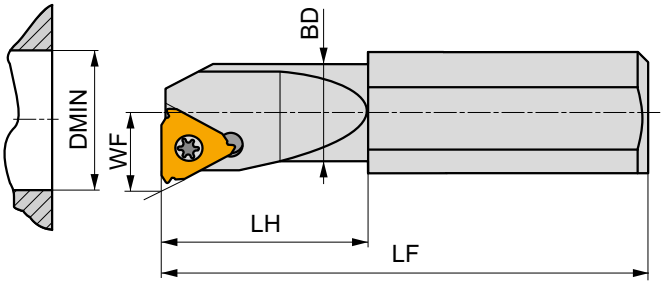
## Intern skrue fastspændt gevindholder til TN 11,16 og 22 neutral skær

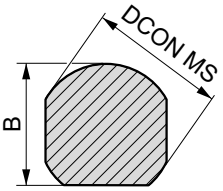
Højre / venstre skruelåsborestang til indvendigt gevind med TN11, 16 eller 22 ER / EL-skær. Velegnet til gevindskæring i metrisk eller tomme profil. Mindste indvendige diameter Ø13 mm. Også velegnet til lav rille. Fås med skaftstørrelse Ø16 op til Ø40 mm. Krop behandlet for længere levetid på værktøjet.

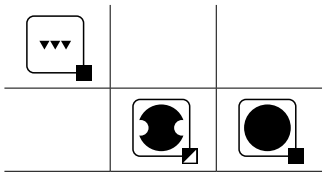






| | Product | B (mm) | DCON MS (mm) | DMIN (mm) | BD (mm) | WF (mm) | H (mm) | HF (mm) | LF (mm) | LH (mm) | LAMS (°) | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| R | SIR 0010 K 11-0 | 14.5 | 16 | 13 | 10 | 7.45 | 14 | 7 | 125 | 25 | 0 | – | GI085 | Z11 |
| | SIR 0010 K 11-1 | 14.5 | 16 | 13 | 10 | 7.45 | 14 | 7 | 125 | 25 | 1 | – | GI085 | Z11 |
| | SIR 0013 M 11-0 | 14.5 | 16 | 16 | 13 | 9 | 14 | 7 | 150 | 32 | 0 | – | GI085 | Z11 |
| | SIR 0013 M 11-1 | 14.5 | 16 | 16 | 13 | 9 | 14 | 7 | 150 | 32 | 1 | – | GI085 | Z11 |
| | SIR 1416 N 16-0 | 14 | 16 | 22 | 17 | 11.4 | 14.5 | 7.5 | 160 | – | 0 | – | GI022 | Z9 |
| | SIR 1416 N 16-1 | 14 | 16 | 22 | 17 | 11.4 | 14.5 | 7.5 | 160 | – | 1 | – | GI022 | Z9 |
| | SIR 1416 N 16-2 | 14 | 16 | 16.5 | 15.5 | 10.6 | 14.5 | 7.5 | 160 | 40 | 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 | 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 | – | GI085 | Z11 |
| | SIL 0010 K 11-1 | 14.5 | 16 | 13 | 10 | 7.55 | 14 | 7 | 125 | 25 | 1 | – | GI085 | Z11 |
| | SIL 0013 M 11-0 | 14.5 | 16 | 16 | 13 | 9 | 14 | 7 | 150 | 32 | 0 | – | GI085 | Z11 |
| | SIL 0013 M 11-1 | 14.5 | 16 | 16 | 13 | 9 | 14 | 7 | 150 | 32 | 1 | – | GI085 | Z11 |
| | SIL 1416 N 16-0 | 14 | 16 | 22 | 17 | 11.4 | 14.5 | 7.5 | 160 | – | 0 | – | GI022 | Z9 |
| | SIL 1416 N 16-1 | 14 | 16 | 22 | 17 | 11.4 | 14.5 | 7.5 | 160 | – | 1 | – | GI022 | Z9 |
| | SIL 1416 N 16-2 | 14 | 16 | 16.5 | 15.5 | 10.6 | 14.5 | 7.5 | 160 | 40 | 2 | ✓ | GI022 | Z10 |
| | SIL 1820 P 16 | 18.5 | 20 | 27 | 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 | 2 | ✓ | GI076 | Z14 |
| | SIL 2532 S 22-A | 30 | 32 | 36 | 32 | 21.65 | 25 | 12.5 | 250 | – | – | – | GI076 | Z13 |
| | SIL 3240 T 22-A | 38 | 40 | 48 | 40 | 25.85 | 32 | 16 | 300 | – | – | – | GI076 | Z13 |

| | | |
|---|---|---|
| GI022 | TN 16NR.. | TN 16NL.. |
| GI076 | TN 22NR.. | TN 22NL.. |
| GI085 | TN 11NR.. | TN 11NL.. |

| | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| 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 | 481 |
| Z13 | US 4514A-T20 | 5.0 | M 4.5 | 14 | SP 0405 | – | FLAG T20 | – | 481 |
| 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 |

Choice of shim

| Helix angle λ | Positive | | | | | Negative | | for grooving inserts TN16.. ... ZZ, TN22.. ... ZZ |
|---|---|---|---|---|---|---|---|---|
| | 4.5° | 3.5° | 2.5° | 1.5° | 0.5° | -0.5° | -1.5° | |
| **Tool holder** | **Anvil specification** | | | | | | | |
| **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 | PE16ZZ |
| **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 | PI16ZZ |
| **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 | PE22ZZ |
| **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 | PI22ZZ |
| **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 | - |

Tool holders are usually supplied with a helix angle λ = 1.5°. A different helix angle can be selected by changing the anvil.
Shims for holders SER-S .... ..., SIR-S .... ... are marked with „***S***“

# THREAD TURNING



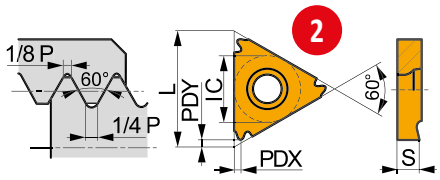
| | | |
|---|---|---|
| 📖 6 | | WMG & ISO 13399 |
| 📖 10 | ISO TURNING | INSTRUCTIONS |
| 📖 18 | | NAVIGATORS |
| 📖 57 | | POSITIVE INSERTS |
| 📖 219 | | NEGATIVE INSERTS |
| 📖 386 | | PARTING-OFF & GROOVING |
| 📖 **482** | | **THREAD TURNING** |
| 📖 528 | | BROACHING |
| 📖 536 | | GENERAL TECHNICAL INFORMATION |

# 1 TN M INT

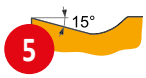
PRAMET

| | 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 |

3




Suitability and starting values for cutting speed (vc). Refer to our Machining Calculator app for further calculations.

| 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] |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 4  | 5  | | 1 U E 6 | | | | | | | | | |
| | | | 10 TN M NR internal, right-handed design, for machining ISO Metric threads, and continuous cuts. | | | | | | | | | |
| TN 11NR050M | T8010 | – | 175 | 105 | 165 | – | 40 | – | 0.50 | – | 0.8 | 0.8 |
| | T8030 | – | 160 | 95 | 150 | 11 | 40 | – | 0.50 | – | 0.8 | 0.8 |
| TN 1 7 75M | 8 | 9 | 175 | 105 | 165 | | 40 | – | 0.75 | – | 0.8 | 0.8 |
| | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | 0.75 | – | 0.8 | 0.8 |
| TN 11NR100M | T8010 | – | 175 | 105 | 165 | – | 40 | – | 1.00 | – | 0.8 | 0.8 |
| | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | 1.00 | – | 0.8 | 0.8 |
| TN 11NR125M | T8010 | – | 175 | 105 | 165 | – | 40 | – | 1.25 | – | 0.8 | 0.8 |
| | 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 |
| | 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 |
| | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | 2.00 | – | 0.9 | 0.8 |
| TN 16NR050M | T8010 | – | 175 | 105 | 165 | – | 40 | – | 0.50 | – | 0.8 | 0.8 |
| | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | 0.50 | – | 0.8 | 0.8 |
| TN 16NR075M | T8010 | – | 175 | 105 | 165 | – | 40 | – | 0.75 | – | 0.8 | 0.8 |
| | 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 |
| | T8030 | – | 160 | 95 | 150 | 480 | 40 | – | 1.00 | – | 0.8 | 0.8 |
| TN 16NR125M | T8010 | – | 175 | 105 | 165 | – | 40 | – | 1.25 | – | 0.8 | 0.8 |

**TN 16NR075M:T8010** Use full insert specification code when ordering!

Grade

Include colon

ISO insert code

Typical page with inserts displayed – specific page details will differ.

| Pos. | Description |
|---|---|
| 1 | Designation of insert |
| 2 | Schematic drawing of insert |
| 3 | Table with insert sizes (mm) |
| 4 | Picture of representative insert |
| 5 | Profile of main cutting edge |
| 6 | Icons – specific features and cutting edge type |

| Pos. | Description |
|---|---|
| 7 | ISO insert code |
| 8 | Grade |
| 9 | Insert radii (mm) |
| 10 | Geometry description |
| 11 | Application area of insert |

1 **SI(RL)**

P M K N S H 2

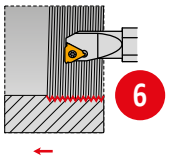
PRAMET 3 S

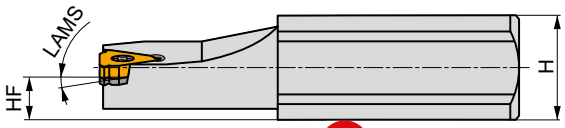

4

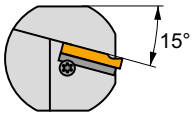
**Internal Screw Clamped Threading Holder for TN 11, 16 or 22 Insert**

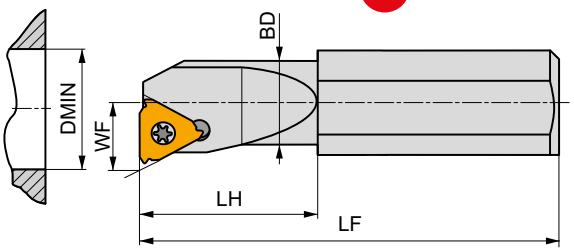
Right/Left hand screw lock boring bar for internal threading with TN11, 16 or 22 ER/EL inserts. Suited for threading in metric or inch profile. Minimum internal diameter Ø13 mm. Also suited for shallow grooving. Available with shank size Ø16 up to Ø40 mm. Body treated for longer tool life.

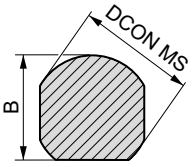
5

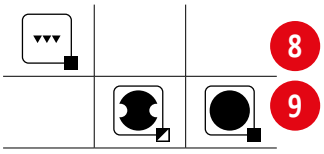

6





8 9


10

| | Product | B [mm] | DCON MS [mm] | DMIN [mm] | BD [mm] | WF [mm] | H [mm] | HF [mm] | LF [mm] | LH [mm] | LAMS [°] | 14 | 15 | 16 |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 11 | **SIR 0010 K 11-0** | 14.5 | 16 | 13 | 10 | 7.45 | 14 | 7 | 125 | 25 | 0 | – | GI085 | Z11 |
| | **SIR 0010 K 11-1** | 14.5 | 16 | 13 | 10 | 7.45 | 14 | 7 | 125 | 25 | 1 | – | GI085 | Z11 |
| | **SIR 0013 M 11-0** | 14.5 | 16 | 16 | 13 | 9 | 14 | 7 | 150 | 32 | 0 | | | |
| | **SIR 0013** 12 | 14.5 | 16 | 16 | 13 | 9 | 14 | 7 | 150 | 32 | 1 | | | |
| | **SIR 1416 N 16-0** | 14 | 16 | 22 | 17 | 11.4 | 14.5 | 7.5 | 160 | – | 0 | – | GI022 | Z9 |
| R | **SIR 1416 N 16-1** | 14 | 16 | 22 | 17 | 11.4 | 14.5 | 7.5 | 160 | – | 1 | – | GI022 | Z9 |
| | **SIR 1416 N 16-2** | 14 | 16 | 16.5 | 15.5 | 10.6 | 14.5 | 7.5 | 160 | 40 | 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 | 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 |

| | 17 | |
|---|---|---|
| GI022 | TN 16NR.. | TN 16NL.. |
| GI076 | TN 22NR.. | TN 22NL.. |
| GI085 | TN 11NR.. | TN 11NL.. |

| | | Nm | | | 18 | | | | |
|---|---|---|---|---|---|---|---|---|---|
| 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 |

Typical page with turning holders displayed – specific page details will differ.

## THREAD TURNING HOLDERS – PAGE OVERVIEW

| Pos. | Description |
|---|---|
| 1 | Designation of thread turning holder |
| 2 | Material group recommendations |
| 3 | Clamping system of insert |
| 4 | Illustrative picture [1] |
| 5 | Tool description |
| 6 | Workpiece profile |
| 7 | Schematic drawing of tool |
| 8 | Achievable quality of surface |
| 9 | Character of cut/working conditions |

| Pos. | Description |
|---|---|
| 10 | Product applications |
| 11 | Tool design |
| 12 | ISO code of holder |
| 13 | Dimensions (mm) and angles [2] (°) of holder |
| 14 | Internal coolant supply |
| 15 | Group of compatible inserts [3] |
| 16 | Group of spare parts [3], [4] |
| 17 | Compatible inserts |
| 18 | Spare parts |

[1] Drejeholderen vises primært med højreopsætning (R)

[2] GAMO = retvinklet hældningsvinkel (se den tekniske del)
LAMS = stigningsvinkel for hovedskær (se den tekniske del)

[3] Gruppekoden for kompatible vendeskær, reservedele og specialtilbehør bruges kun til dette katalog. Den kan ikke bruges til ordrer.

[4] Reservedels- og specialtilbehørsikoner er designet skematisk, så de er nemme at forstå. De er ikke inkluderet på listen over ikoner. Skruer er i visse tilfælde forsynet med oplysninger om tilspændingsmoment i Nm, skruelængde og gevindstørrelse.

# THREAD TURNING – ICONS OVERVIEW

## GENERAL ICONS

- Primary use
- Possible use
- Finishing – very good surface quality
- Medium machining – good surface quality
- Roughing – unlimited surface roughness
- Suitable for stable working conditions
- Suitable for unstable working conditions
- Suitable for very unstable working conditions

## FEATURES


Thread turning – external


Thread turning – internal

## COATING



First choice


For tough materials (long chipping)



Universal wide range option



Rounded edge



Sharp edge

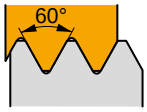
## OTHER



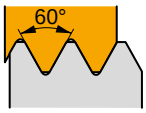
Clamping torque of screw (Nm)


Internal supply of coolant

## M
Fuld profil

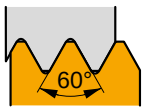
### TN M EXT NEW


495

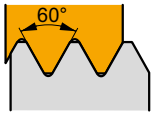
### TN M INT NEW


497

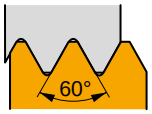
## M
Delprofil

### TN 60° PP EXT


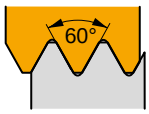
499

### TN 60° PP INT


500

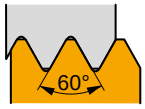
### TN 60°-S PP EXT


501

### TN 60°-S PP INT


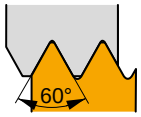
501

## MJ
Fuld profil

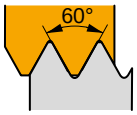
### TN MJ EXT NEW


499

## UN
Fuld profil

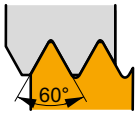
### TN UN EXT


502

### TN UN INT


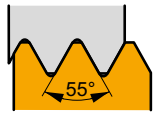
503

## UNJ
Fuld profil

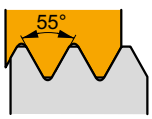
### TN UNJ EXT NEW


504

## W
Fuld profil

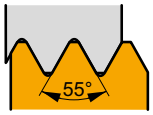
### TN W EXT


505

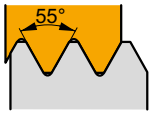
### TN W INT


506

## W
Delprofil

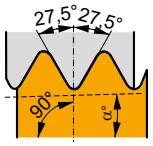
### TN 55° PP EXT


508

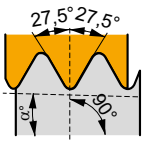
### TN 55° PP INT


509

## BSPT
Fuld profil

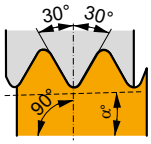
### TN BSPT EXT


510

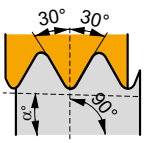
### TN BSPT INT


510

## NPT
Fuld profil

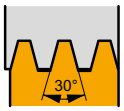
### TN NPT EXT


511

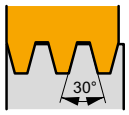
### TN NPT INT


512

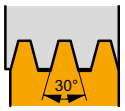
## TR
Fuld profil

### TN TR EXT


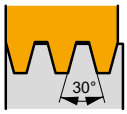
512

### TN TR INT


513

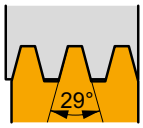
### TN TR-S EXT


514

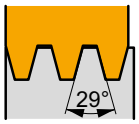
### TN TR-S INT


514

## ACME
Fuld profil

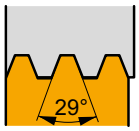
### TN ACME EXT


515

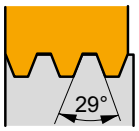
### TN ACME INT


516

## STACME
Fuld profil

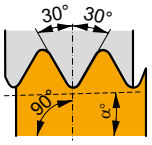
### TN STACME EXT NEW


517

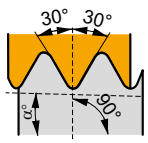
### TN STACME INT NEW


518

## API RD
Fuld profil

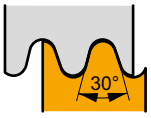
### TN API RD EXT


519

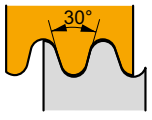
### TN API RD INT


519

## RD
Fuld profil

### TN RD EXT


520

### TN RD INT


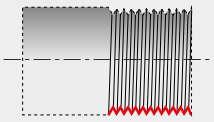
520

| Grade Identification | Area of Application | Application | Feed | Cutting speed | Resistance to adverse Working Conditions | Coating | Colour | Substrate | Coolant benefit | Grade description |
|---|---|---|---|---|---|---|---|---|---|---|
| **T8010** | P05 - P15<br>M05 - M15<br>K10 - K20<br>S10 - S15 | ■<br>■<br>■<br>◪ |  |  |  | PVD | | submicron H | + + + | This grade is suitable for continuous high precision thread turning of steels, stainless steel, cast iron and super alloys. Offering excellent wear resistance while ensuring operational reliability |
| **T8030** | P25 - P40<br>M20 - M35<br>K20 - K40<br>N15 - N30<br>S15 - S25<br>H15 - H25 | ■<br>■<br>■<br>◪<br>◪<br>◪ |  |  |  | PVD | | submicron H | + + + | Undoubtedly the most versatile grade it is suitable for machining all types of materials and can be applied in almost all turning operations. It's main benefits are high operational reliability and excellent frictional properties; it is therefore suited to applications at medium to low cutting speeds. |
| **HF7** | M10 - M20<br>K10 - K25<br>N10 - N25 | ◪<br>■<br>■ |  |  |  | × | | submicron H | + + | Uncoated grade which is primarily designed for machining non-ferrous metals; but can also be used for other machined materials (except steel). This material can be used in turning, milling, and even boring. |

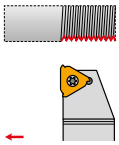
| Substrat | |
|---|---|
| **submicron H** | WC-Co based substrate fine grained (< 1 µm) |

| Coating | |
|---|---|
| **PVD** | Low-temperature physical method of coating |

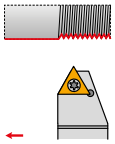
## ISO THREAD TURNING – EXTERNAL



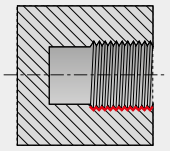
### SE(RL)

| | TN.. |
|---|---|
|  | 16<br>22 |
| 20×20<br>32×25 | |
| 522 | 459 – 521 |

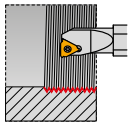
### SE(RL)-S

| | TN.. |
|---|---|
|  | 22 |
| 25×25<br>32×25 | |
| 523 | 459 – 521 |

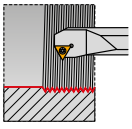
## ISO THREAD TURNING – INTERNAL



### SI(RL)

| | TN.. |
|---|---|
|  | 11<br>16<br>22 |
| 13<br>48 | |
| 524 | 459 – 521 |

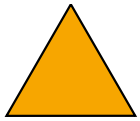
### SI(RL)-S

| | TN.. |
|---|---|
|  | 22 |
| 39<br>48 | |
| 526 | 459 – 521 |

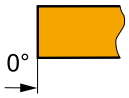
# INDEXABLE CUTTING INSERTS FOR THREADING ISO – CODE DESIGNATION

| | 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 |

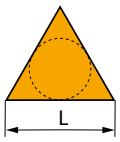
## 1 Skærform

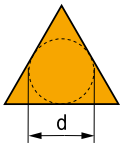
| | |
|---|---|
| T |  |

## 2 Frivinkel for skær

| | |
|---|---|
| N |   |

## 3 Skærkantslængde (skærstørrelse)




| L | | d = IC | |
|---|---|---|---|
| (mm) | (") | (mm) | (") |
| **11** | .433" | **6,350** | 1/4" |
| **16** | .650" | **9,525** | 3/8" |
| **22** | .866" | **12,7** | 1/2" |

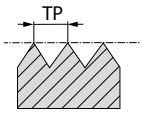
## 4 Udvendig - Indvendig

| | |
|---|---|
| E | Udvendig |
| N | Indvendig |

## 5 Skæreretning

| | |
|---|---|
| R | Højre |
| L | Venstre |
| N | Neutral |

## 6 Gevindstigning




s × 100

Gevindstigning mm × 100

## 6 Antal gevind

No. gevind pr. tomme × 10

## 7 Gevindprofil

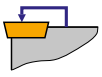
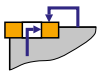
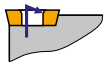
| | | | |
|---|---|---|---|
| **M** | Metrisk 60° | **TR** | TR 30°<br>ISO 2901/3–1977 |
| **MJ** | SEA MA1370 | **UN** | Americana UN 60°<br>ISO 5864–1978 |
| **W** | Whitworth 55°<br>ISO 228–1982 | **UNJ** | SEA AS8879 |
| **RD** | Rund 30° | **ACME** | ACME 29°<br>ANSI B1.5–1988 |
| **BSPT** | ISO 228/1<br>35 21 1959<br>ISO 7/1 | **STACME** | ASME/ANSI B1.8-1988 |
| **NPT** | ANSI B1.1–1983 | **API RD** | API |

## 8 Spånbryder

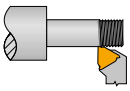
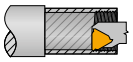
| | |
|---|---|
| P1 | Presset |
| AL | For nonferous |

| | 1 | 2 | 3 | | 4 | 5 | 6 | 7 | | 8 |
|---|---|---|---|---|---|---|---|---|---|---|
| ISO | S | E | R | – | S | 2525 | M | 16 | – | |
| ANSI | 1 | 2 | 3 | | 4 | 5 | 6 | 7 | | 8 |
| | S | E | R | – | S | 16 | D | 16 | – | |

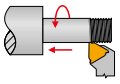
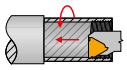
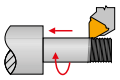
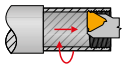
## 1 Fastspændingsbetegnelse

| | |
|---|---|
| C |  |
| P |  |
| M |  |
| S |  |

## 2 Maskinbearbejdningsmetode

| | | |
|---|---|---|
| E | Udvendig |  |
| I | Indvendig |  |

## 3 Skæreretning

| | | | |
|---|---|---|---|
| R | Højre | Udvendig |  |
| | | Indvendig |  |
| L | Venstre | Udvendig |  |
| | | Indvendig |  |

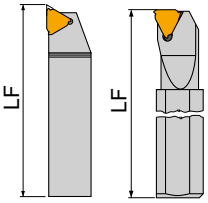
## 4 Konstruktionstype

| | |
|---|---|
| – | Normal |
| S | Speciel |

## 5 Holder dimensions (mm)

| | | |
|---|---|---|
| Udvendig drejning | **2525** | 25 × 25 mm |
| Indvendig drejning | **1416** | Skaft – 14 mm<br>Skafthøjde Ø – 16 mm |

## 6 Holderens samlede længde (mm)



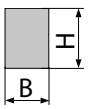

| | LF (mm) |
|---|---|
| K | 125 |
| L | 140 |
| M | 150 |
| N | 160 |
| P | 170 |
| Q | 180 |
| R | 200 |
| S | 250 |
| T | 300 |

## 7 Skærlængde (skærstørrelse)

| d = IC (mm) | d = IC (") | T |
|---|---|---|
| 6.350 | 1/4" | 11 |
| 9.525 | 3/8" | 16 |
| 12.700 | 1/2" | 22 |



## 5 Værktøjsmål (")



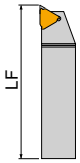

| | B (") | H (") |
|---|---|---|
| 10 | 5/8" | 5/8" |
| 12 | 3/4" | 3/4" |
| 16 | 1" | 1" |
| 85 | 1" | 1 1/4" |
| 86 | 1" | 1 1/2" |
| 20 | 1 1/4" | 1 1/4" |

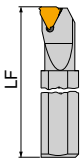



| | DCON (") |
|---|---|
| 08 | .500" |
| 10 | .625" |
| 12 | .750" |
| 16 | 1.000" |
| 20 | 1.250" |
| 24 | 1.500" |

For firkantede skafter er dette antal sekstendedele af en tomme for bredde og højde. For rektangulære skafter er det første tal antallet af ottendedele af en tomme for bredden, og det andet tal er antal fjerdedele af en tomme for højden.

## 6 Holderens samlede længde (")




| | 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 Skruevinkel λ

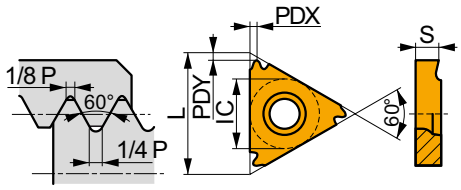
| | |
|---|---|
| 0 | Skruevinkel λ = 0° |
| 1 | Skruevinkel λ = 1° |
| 2 | Skruevinkel λ = 2° |

NEW

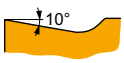
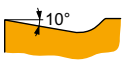
# TN M EXT

PRAMET

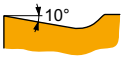
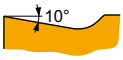
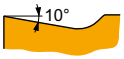
| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 16 | 9.525 | 16.50 | 3.47 |
| 22 | 12.700 | 22.00 | 4.71 |




Egnethed og startværdier for skærehastighed (vc). Se vores app til bearbejdning af yderligere beregninger.

| 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 ER eksternt, højrehåndet design til bearbejdning af ISO-metriske gevind og kontinuerlige snit. | | | | | | | | | | | | |
| **TN 16ER050M** | **T8010** | – | 175 | 105 | 165 | – | 40 | – | 0.50 | – | 0.8 | 0.8 |
| | **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 |
| | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | 0.75 | – | 0.8 | 0.8 |
| **TN 16ER080M** | **T8010** | – | 175 | 105 | 165 | – | 40 | – | 0.80 | – | 0.6 | 0.8 |
| | **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 |
| | **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 |
| | **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 |
| | **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 |
| | **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 |
| | **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 |
| | **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 |
| | **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** | **T8010** | – | 175 | 105 | 165 | – | 40 | – | 3.50 | – | 2.5 | 1.8 |
| | **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 |
| | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | 4.00 | – | 2.5 | 1.8 |
| **TN 22ER450M** | **T8010** | – | 175 | 105 | 165 | – | 40 | – | 4.50 | – | 2.5 | 1.8 |
| | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | 4.50 | – | 2.5 | 1.8 |
| **TN 22ER500M** | **T8010** | – | 175 | 105 | 165 | – | 40 | – | 5.00 | – | 2.5 | 1.8 |
| | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | 5.00 | – | 2.5 | 1.8 |
|  |  | | | | | | | | | | | |
| TN M EL eksternt, venstrehåndet design til bearbejdning af ISO-metriske gevind og kontinuerlige snit. | | | | | | | | | | | | |
| **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 |
| | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | 1.00 | – | 0.8 | 0.8 |
| **TN 16EL125M** | **T8010** | – | 175 | 105 | 165 | – | 40 | – | 1.25 | – | 0.8 | 0.8 |
| | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | 1.25 | – | 0.8 | 0.8 |

Egnethed og startværdier for skærehastighed (vc). Se vores app til bearbejdning af yderligere beregninger.

| 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 EL eksternt, venstrehåndet design til bearbejdning af ISO-metriske gevind og kontinuerlige snit. | | | | | | | | | | | | | | | | | | |
| **TN 16EL150M** | **T8010** | – | ■ | 175 | ◪ | 105 | ■ | 165 | | – | ◪ | 40 | | – | 1.50 | – | 0.8 | 0.8 |
| | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | 1.50 | – | 0.8 | 0.8 |
| **TN 16EL175M** | **T8010** | – | ■ | 175 | ◪ | 105 | ■ | 165 | | – | ◪ | 40 | | – | 1.75 | – | 1.5 | 1.2 |
| | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | 1.75 | – | 1.5 | 1.2 |
| **TN 16EL200M** | **T8010** | – | ■ | 175 | ◪ | 105 | ■ | 165 | | – | ◪ | 40 | | – | 2.00 | – | 1.5 | 1.2 |
| | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | 2.00 | – | 1.5 | 1.2 |
| **TN 16EL250M** | **T8010** | – | ■ | 175 | ◪ | 105 | ■ | 165 | | – | ◪ | 40 | | – | 2.50 | – | 1.5 | 1.2 |
| | **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 |
| | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | 3.00 | – | 1.5 | 1.2 |
| **TN 16EL350M** | **T8030**[1)] | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | 3.50 | – | 1.7 | 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 |
| **TN 22EL500M** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | 5.00 | – | 2.5 | 1.8 |
|  |  | |  | | | | | | | | | | | | | | | |
| TN M-P1 ER presset eksternt, højrehåndet design til bearbejdning af ISO-metriske gevind og kontinuerlige snit. | | | | | | | | | | | | | | | | | | |
| **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-AL ER eksternt, højrehåndet design til bearbejdning af ISO-metriske gevind og kontinuerlige snit. | | | | | | | | | | | | | | | | | | |
| **TN 16ER050M-AL** | **HF7** | – | | – | ◪ | 95 | | – | ■ | 480 | | – | | – | 0.50 | – | 0.8 | 0.8 |
| **TN 16ER075M-AL** | **HF7** | – | | – | ◪ | 95 | | – | ■ | 480 | | – | | – | 0.75 | – | 0.8 | 0.8 |
| **TN 16ER080M-AL** | **HF7** | – | | – | ◪ | 95 | | – | ■ | 480 | | – | | – | 0.80 | – | 0.6 | 0.8 |
| **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 16ER175M-AL** | **HF7** | – | | – | ◪ | 95 | | – | ■ | 480 | | – | | – | 1.75 | – | 1.5 | 1.2 |
| **TN 16ER200M-AL** | **HF7** | – | | – | ◪ | 95 | | – | ■ | 480 | | – | | – | 2.00 | – | 1.5 | 1.2 |
| **TN 16ER250M-AL** | **HF7** | – | | – | ◪ | 95 | | – | ■ | 480 | | – | | – | 2.50 | – | 1.5 | 1.2 |
| **TN 16ER300M-AL** | **HF7** | – | | – | ◪ | 95 | | – | ■ | 480 | | – | | – | 3.00 | – | 1.5 | 1.2 |

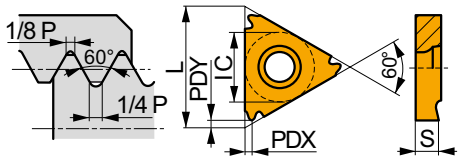
[1)] Toolholders have to be modified.

NEW

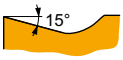
# TN M INT

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 |



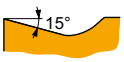

Egnethed og startværdier for skærehastighed (vc). Se vores app til bearbejdning af yderligere beregninger.

| 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 internt, højrehåndet design til bearbejdning af ISO-metriske gevind og kontinuerlige snit.

| | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **TN 11NR050M** | **T8010** | – | ■ | 175 | ◪ | 105 | ■ | 165 | | – | ◪ | 40 | | – | 0.50 | – | 0.8 | 0.8 |
| | **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 |
| | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | 0.75 | – | 0.8 | 0.8 |
| **TN 11NR100M** | **T8010** | – | ■ | 175 | ◪ | 105 | ■ | 165 | | – | ◪ | 40 | | – | 1.00 | – | 0.8 | 0.8 |
| | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | 1.00 | – | 0.8 | 0.8 |
| **TN 11NR125M** | **T8010** | – | ■ | 175 | ◪ | 105 | ■ | 165 | | – | ◪ | 40 | | – | 1.25 | – | 0.8 | 0.8 |
| | **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 |
| | **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 |
| | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | 2.00 | – | 0.9 | 0.8 |
| **TN 16NR050M** | **T8010** | – | ■ | 175 | ◪ | 105 | ■ | 165 | | – | ◪ | 40 | | – | 0.50 | – | 0.8 | 0.8 |
| | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | 0.50 | – | 0.8 | 0.8 |
| **TN 16NR075M** | **T8010** | – | ■ | 175 | ◪ | 105 | ■ | 165 | | – | ◪ | 40 | | – | 0.75 | – | 0.8 | 0.8 |
| | **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 |
| | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | 1.00 | – | 0.8 | 0.8 |
| **TN 16NR125M** | **T8010** | – | ■ | 175 | ◪ | 105 | ■ | 165 | | – | ◪ | 40 | | – | 1.25 | – | 0.8 | 0.8 |
| | **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 |
| | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | 1.50 | – | 0.8 | 0.8 |
| **TN 16NR175M** | **T8010** | – | ■ | 175 | ◪ | 105 | ■ | 165 | | – | ◪ | 40 | | – | 1.75 | – | 1.5 | 1.2 |
| | **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 |
| | **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 |
| | **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 |
| | **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** | **T8010** | – | ■ | 175 | ◪ | 105 | ■ | 165 | | – | ◪ | 40 | | – | 3.50 | – | 2.5 | 1.8 |
| | **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 |
| | **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 |
| | **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 |
| | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | 5.00 | – | 2.5 | 1.8 |

Egnethed og startværdier for skærehastighed (vc). Se vores app til bearbejdning af yderligere beregninger.

| 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 NL internt, venstrehåndet design til bearbejdning af ISO-metriske gevind og kontinuerlige snit. | | | | | | | | | | | | | | | | | | |
| **TN 11NL050M** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | 0.50 | – | 0.8 | 0.8 |
| **TN 11NL075M** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | 0.75 | – | 0.8 | 0.8 |
| **TN 11NL100M** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | 1.00 | – | 0.8 | 0.8 |
| **TN 11NL125M** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | 1.25 | – | 0.8 | 0.8 |
| **TN 11NL150M** | **T8010** | – | ■ | 175 | ◪ | 105 | ■ | 165 | | – | ◪ | 40 | | – | 1.50 | – | 0.8 | 0.8 |
| | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | 1.50 | – | 0.8 | 0.8 |
| **TN 11NL200M** | **T8010** | – | ■ | 175 | ◪ | 105 | ■ | 165 | | – | ◪ | 40 | | – | 2.00 | – | 0.9 | 0.8 |
| | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | 2.00 | – | 0.9 | 0.8 |
| **TN 16NL050M** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | 0.50 | – | 0.8 | 0.8 |
| **TN 16NL075M** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | 0.75 | – | 0.8 | 0.8 |
| **TN 16NL100M** | **T8010** | – | ■ | 175 | ◪ | 105 | ■ | 165 | | – | ◪ | 40 | | – | 1.00 | – | 0.8 | 0.8 |
| | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | 1.00 | – | 0.8 | 0.8 |
| **TN 16NL125M** | **T8010** | – | ■ | 175 | ◪ | 105 | ■ | 165 | | – | ◪ | 40 | | – | 1.25 | – | 0.8 | 0.8 |
| | **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 |
| | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | 1.50 | – | 0.8 | 0.8 |
| **TN 16NL175M** | **T8010** | – | ■ | 175 | ◪ | 105 | ■ | 165 | | – | ◪ | 40 | | – | 1.75 | – | 1.5 | 1.2 |
| | **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 |
| | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | 2.00 | – | 1.5 | 1.2 |
| **TN 16NL250M** | **T8010** | – | ■ | 175 | ◪ | 105 | ■ | 165 | | – | ◪ | 40 | | – | 2.50 | – | 1.5 | 1.2 |
| | **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 |
| | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | 3.00 | – | 1.5 | 1.2 |
| **TN 16NL350M** | **T8030**[1)] | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | 3.50 | – | 1.6 | 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 |
| **TN 22NL500M** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | 5.00 | – | 2.5 | 1.8 |
|  |  | |  | | | | | | | | | | | | | | | |
| TN M-P1 NR pressede internt, højrehåndet design til bearbejdning af ISO-metriske gevind og kontinuerlige snit. | | | | | | | | | | | | | | | | | | |
| **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 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 M-AL NR internt, højrehåndet design til bearbejdning af ISO-metriske gevind og kontinuerlige snit. | | | | | | | | | | | | | | | | | | |
| **TN 16NR050M-AL** | **HF7** | – | | – | ◪ | 95 | | – | ■ | 480 | | – | | – | 0.50 | – | 0.8 | 0.8 |
| **TN 16NR075M-AL** | **HF7** | – | | – | ◪ | 95 | | – | ■ | 480 | | – | | – | 0.75 | – | 0.8 | 0.8 |
| **TN 16NR100M-AL** | **HF7** | – | | – | ◪ | 95 | | – | ■ | 480 | | – | | – | 1.00 | – | 0.8 | 0.8 |
| **TN 16NR125M-AL** | **HF7** | – | | – | ◪ | 95 | | – | ■ | 480 | | – | | – | 1.25 | – | 0.8 | 0.8 |
| **TN 16NR150M-AL** | **HF7** | – | | – | ◪ | 95 | | – | ■ | 480 | | – | | – | 1.50 | – | 0.8 | 0.8 |
| **TN 16NR175M-AL** | **HF7** | – | | – | ◪ | 95 | | – | ■ | 480 | | – | | – | 1.75 | – | 1.5 | 1.2 |
| **TN 16NR200M-AL** | **HF7** | – | | – | ◪ | 95 | | – | ■ | 480 | | – | | – | 2.00 | – | 1.5 | 1.2 |
| **TN 16NR250M-AL** | **HF7** | – | | – | ◪ | 95 | | – | ■ | 480 | | – | | – | 2.50 | – | 1.5 | 1.2 |
| **TN 16NR300M-AL** | **HF7** | – | | – | ◪ | 95 | | – | ■ | 480 | | – | | – | 3.00 | – | 1.5 | 1.2 |

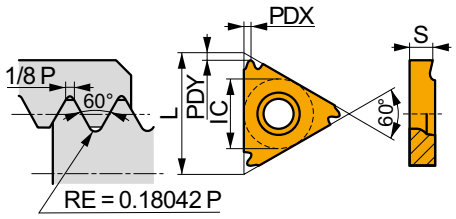
[1)] Toolholders have to be modified.

NEW

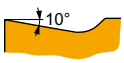
# TN MJ EXT

PRAMET

| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 16 | 9.525 | 16.50 | 3.47 |



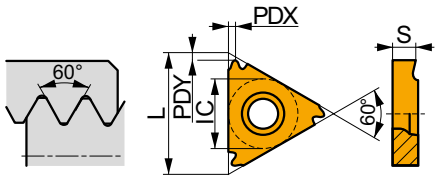

Egnethed og startværdier for skærehastighed (vc). Se vores app til bearbejdning af yderligere beregninger.

| 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 MJ ER eksternt, højrehåndet design til bearbejdning af metriske "J-form" -tråde og kontinuerlige snit. | | | | | | | | | |
| **TN 16ER100MJ** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 1.00 | – | 0.8 | 0.8 |
| **TN 16ER150MJ** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 1.50 | – | 0.8 | 0.8 |

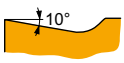
# TN 60° PP EXT

PRAMET

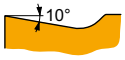
| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 16 | 9.525 | 16.50 | 3.47 |
| 22 | 12.700 | 22.00 | 4.71 |




Egnethed og startværdier for skærehastighed (vc). Se vores app til bearbejdning af yderligere beregninger.

| 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 ER eksternt, højrehåndet design til bearbejdning af metriske og ensartede gevind og kontinuerlige snit. | | | | | | | | | | | |
| **TN 16ERA60** | **T8010** | – | ■ 175 | ◪ 105 | ■ 165 | – | ◪ 40 | – | 0.50 | 1.50 | 16 | 48 | 0.8 | 0.6 |
| | **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 |
| | **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 |
| | **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 |
| | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 3.50 | 5.00 | 5 | 7 | 2.5 | 1.8 |

Egnethed og startværdier for skærehastighed (vc). Se vores app til bearbejdning af yderligere beregninger.

| 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 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 |
| | 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 |

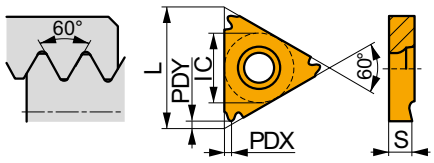


TN M60 PP EL eksternt, venstrehåndet design til bearbejdning af metriske og ensartede gevind og kontinuerlige snit.

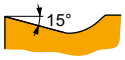
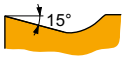
## TN 60° PP INT

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 |




Egnethed og startværdier for skærehastighed (vc). Se vores app til bearbejdning af yderligere beregninger.

| 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 11NRA60 | T8010 | – | ■ | 175 | ◪ | 105 | ■ | 165 | | – | ◪ | 40 | | – | 0.50 | 1.50 | 16 | 48 | 0.8 | 0.7 |
| | T8030 | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | 0.50 | 1.50 | 16 | 48 | 0.8 | 0.7 |
| TN 16NRA60 | T8010 | – | ■ | 175 | ◪ | 105 | ■ | 165 | | – | ◪ | 40 | | – | 0.50 | 1.50 | 16 | 48 | 0.8 | 0.7 |
| | 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 |
| | T8030 | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | 0.50 | 3.00 | 8 | 48 | 1.5 | 1.1 |
| TN 16NRG60 | T8010 | – | ■ | 175 | ◪ | 105 | ■ | 165 | | – | ◪ | 40 | | – | 1.75 | 3.00 | 8 | 14 | 1.5 | 1.1 |
| | 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 |
| | T8030 | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | 3.50 | 5.00 | 5 | 7 | 2.5 | 1.8 |
|  |  | | | | | | | | | | | | | | | | | | | |
| TN 11NLA60 | T8030 | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | 0.50 | 1.50 | 16 | 48 | 0.8 | 0.7 |
| TN 16NLA60 | T8030 | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | 0.50 | 1.50 | 16 | 48 | 0.8 | 0.7 |
| TN 16NLAG60 | T8010 | – | ■ | 175 | ◪ | 105 | ■ | 165 | | – | ◪ | 40 | | – | 0.50 | 3.00 | 8 | 48 | 1.5 | 1.1 |
| | T8030 | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | 0.50 | 3.00 | 8 | 48 | 1.5 | 1.1 |
| TN 16NLG60 | T8030 | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | 1.75 | 3.00 | 8 | 14 | 1.5 | 1.1 |
| TN 22NLN60 | T8030 | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | 3.50 | 5.00 | 5 | 7 | 2.5 | 1.8 |



TN M60 PP NR internt, højrehåndet design til bearbejdning af metriske og ensartede gevind og kontinuerlige snit.

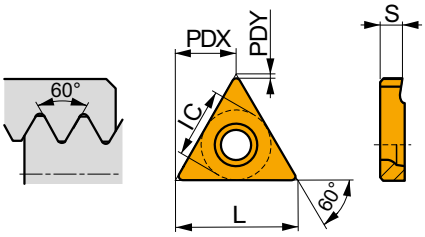


TN M60 PP NL internt, venstrehåndet design til bearbejdning af metriske og ensartede gevind og kontinuerlige snit.

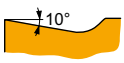
# TN 60°-S PP EXT

PRAMET

| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 22 | 12.700 | 22.00 | 4.60 |



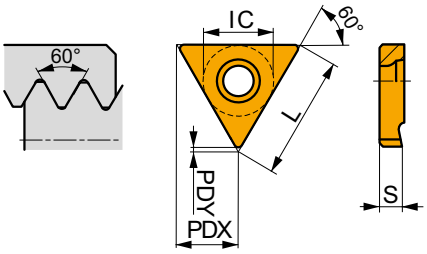

Egnethed og startværdier for skærehastighed (vc). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | 1 U E | | | | | | | | | | | |
| TN M60-S PP EN eksternt, venstre- og højrehåndet design til bearbejdning af metriske og ensartede gevind og kontinuerlige snit. | | | | | | | | | | | | | | |
| **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 |

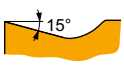
# TN 60°-S PP INT

PRAMET

| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 22 | 12.700 | 22.00 | 4.60 |

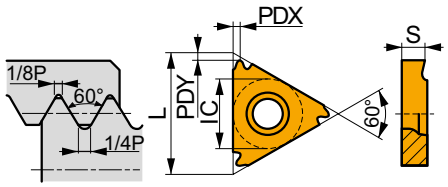



Egnethed og startværdier for skærehastighed (vc). Se vores app til bearbejdning af yderligere beregninger.

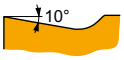
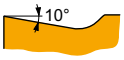
| Product | | RE (mm) | P vc (m/min) | M vc (m/min) | K vc (m/min) | N vc (m/min) | S vc (m/min) | H vc (m/min) | TPN (mm) | TPX (mm) | TPIN | TPIX | PDX (mm) | PDY (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | 1 U E | | | | | | | | | | | |
| TN M60-S PP NN internt, venstre- og højrehåndet design til bearbejdning af metriske og ensartede gevind og kontinuerlige snit. | | | | | | | | | | | | | | |
| **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 UN EXT

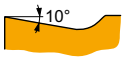
| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 16 | 9.525 | 16.50 | 3.47 |
| 22 | 12.700 | 22.00 | 4.71 |




Egnethed og startværdier for skærehastighed (vc). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | 1 U E | | | | | | | | | |
| TN UN ER eksternt, højrehåndet design til bearbejdning af ensartede gevind og kontinuerlige snit. | | | | | | | | | | | | |
| **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 |
| | **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 16ER115UN** | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | – | 11.5 | 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 |
| **TN 22ER050UN** | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | – | 5.0 | 2.5 | 1.8 |
|  |  | | 1 U E | | | | | | | | | |
| TN UN EL eksternt, venstrehåndet design til bearbejdning af ensartede gevind og kontinuerlige snit. | | | | | | | | | | | | |
| **TN 16EL320UN** | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | – | 32.0 | 0.8 | 0.8 |
| **TN 16EL280UN** | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | – | 28.0 | 0.8 | 0.8 |
| **TN 16EL240UN** | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | – | 24.0 | 0.8 | 0.8 |
| **TN 16EL200UN** | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | – | 20.0 | 0.8 | 0.8 |
| **TN 16EL180UN** | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | – | 18.0 | 0.8 | 0.8 |
| **TN 16EL160UN** | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | – | 16.0 | 0.8 | 0.8 |
| **TN 16EL140UN** | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | – | 14.0 | 1.5 | 1.2 |
| **TN 16EL120UN** | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | – | 12.0 | 1.5 | 1.2 |
| **TN 16EL110UN** | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | – | 11.0 | 1.5 | 1.2 |
| **TN 16EL100UN** | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | – | 10.0 | 1.5 | 1.2 |
| **TN 16EL090UN** | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | – | 9.0 | 1.5 | 1.2 |
| **TN 16EL080UN** | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | – | 8.0 | 1.5 | 1.2 |
| **TN 22EL070UN** | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | – | 7.0 | 2.5 | 1.8 |
| **TN 22EL060UN** | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | – | 6.0 | 2.5 | 1.8 |
| **TN 22EL050UN** | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | – | 5.0 | 2.5 | 1.8 |

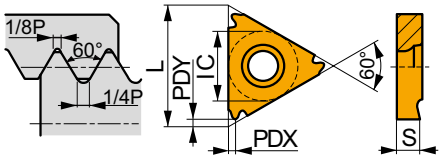
Egnethed og startværdier for skærehastighed (vc). Se vores app til bearbejdning af yderligere beregninger.

| 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 presset eksternt, højrehåndet design til bearbejdning af ensartede gevind og kontinuerlige snit. | | | | | | | | | | | | | | | | | | |
| **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 16ER080UN-P1** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | – | 8.0 | 1.5 | 1.2 |

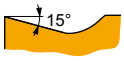
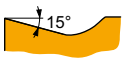
## TN UN INT

PRAMET

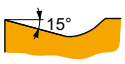
| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 16 | 9.525 | 16.50 | 3.47 |
| 22 | 12.700 | 22.00 | 4.71 |




Egnethed og startværdier for skærehastighed (vc). Se vores app til bearbejdning af yderligere beregninger.

| 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 internt, højrehåndet design til bearbejdning af ensartede gevind og kontinuerlige snit. | | | | | | | | | | | | | | | | | | |
| **TN 16NR320UN** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | – | 32.0 | 0.8 | 0.8 |
| **TN 16NR280UN** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | – | 28.0 | 0.8 | 0.8 |
| **TN 16NR240UN** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | – | 24.0 | 0.8 | 0.8 |
| **TN 16NR200UN** | **T8010** | – | ■ | 175 | ◪ | 105 | ■ | 165 | | – | ◪ | 40 | | – | – | 20.0 | 0.8 | 0.8 |
| | **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 16NR130UN** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | – | 13.0 | 1.5 | 1.2 |
| **TN 16NR120UN** | **T8010** | – | ■ | 175 | ◪ | 105 | ■ | 165 | | – | ◪ | 40 | | – | – | 12.0 | 1.5 | 1.2 |
| | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | – | 12.0 | 1.5 | 1.2 |
| **TN 16NR115UN** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | – | 11.5 | 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** | **T8010** | – | ■ | 175 | ◪ | 105 | ■ | 165 | | – | ◪ | 40 | | – | – | 8.0 | 1.5 | 1.2 |
| | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | – | 8.0 | 1.5 | 1.2 |
| **TN 22NR070UN** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | – | 7.0 | 2.5 | 1.8 |
| **TN 22NR060UN** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | – | 6.0 | 2.5 | 1.8 |
| **TN 22NR050UN** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | – | 5.0 | 2.5 | 1.8 |
|  |  | |  | | | | | | | | | | | | | | | |
| TN UN NL internt, venstrehåndet design til bearbejdning af ensartede gevind og kontinuerlige snit. | | | | | | | | | | | | | | | | | | |
| **TN 16NL320UN** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | – | 32.0 | 0.8 | 0.8 |

Egnethed og startværdier for skærehastighed (vc). Se vores app til bearbejdning af yderligere beregninger.

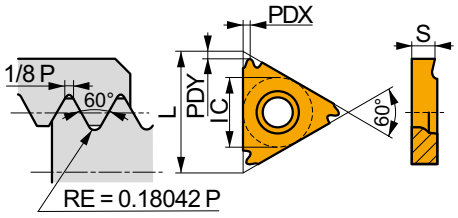
| Product | | RE (mm) | P vc (m/min) | | M vc (m/min) | | K vc (m/min) | | N vc (m/min) | | S vc (m/min) | | H vc (m/min) | | TP (mm) | TPI | PDX (mm) | PDY (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | |  | | | | | | | | | | | | | | | |
| TN UN NL internt, venstrehåndet design til bearbejdning af ensartede gevind og kontinuerlige snit. | | | | | | | | | | | | | | | | | | |
| TN 16NL280UN | T8030 | – | 160 | | 95 | | 150 | | 480 | | 40 | | – | | – | 28.0 | 0.8 | 0.8 |
| TN 16NL240UN | T8030 | – | 160 | | 95 | | 150 | | 480 | | 40 | | – | | – | 24.0 | 0.8 | 0.8 |
| TN 16NL200UN | T8030 | – | 160 | | 95 | | 150 | | 480 | | 40 | | – | | – | 20.0 | 0.8 | 0.8 |
| TN 16NL180UN | T8030 | – | 160 | | 95 | | 150 | | 480 | | 40 | | – | | – | 18.0 | 0.8 | 0.8 |
| TN 16NL160UN | T8030 | – | 160 | | 95 | | 150 | | 480 | | 40 | | – | | – | 16.0 | 0.8 | 0.8 |
| TN 16NL140UN | T8030 | – | 160 | | 95 | | 150 | | 480 | | 40 | | – | | – | 14.0 | 1.5 | 1.2 |
| TN 16NL120UN | T8030 | – | 160 | | 95 | | 150 | | 480 | | 40 | | – | | – | 12.0 | 1.5 | 1.2 |
| TN 16NL110UN | T8030 | – | 160 | | 95 | | 150 | | 480 | | 40 | | – | | – | 11.0 | 1.5 | 1.2 |
| TN 16NL100UN | T8030 | – | 160 | | 95 | | 150 | | 480 | | 40 | | – | | – | 10.0 | 1.5 | 1.2 |
| TN 16NL080UN | T8030 | – | 160 | | 95 | | 150 | | 480 | | 40 | | – | | – | 8.0 | 1.5 | 1.2 |
| TN 22NL070UN | T8030 | – | 160 | | 95 | | 150 | | 480 | | 40 | | – | | – | 7.0 | 2.5 | 1.8 |
| TN 22NL060UN | T8030 | – | 160 | | 95 | | 150 | | 480 | | 40 | | – | | – | 6.0 | 2.5 | 1.8 |
|  |  | |  | | | | | | | | | | | | | | | |
| TN UN-P1 NR pressede internt, højrehåndet design til bearbejdning af ensartede gevind og kontinuerlige snit. | | | | | | | | | | | | | | | | | | |
| 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 16NR080UN-P1 | T8030 | – | 160 | | 95 | | 150 | | 480 | | 40 | | – | | – | 8.0 | 1.5 | 1.2 |

NEW

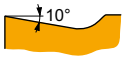
## TN UNJ EXT

PRAMET

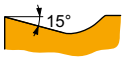
| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 16 | 9.525 | 16.50 | 3.47 |




Egnethed og startværdier for skærehastighed (vc). Se vores app til bearbejdning af yderligere beregninger.

| 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 UNJ ER eksternt, højrehåndet design til bearbejdning af ensartede "J-form" -tråde og kontinuerlige snit. | | | | | | | | | | | | | | | | | | |
| TN 16ER320UNJ | T8030 | – | 160 | | 95 | | 150 | | 480 | | 40 | | – | | – | 32.0 | 0.8 | 0.8 |
| TN 16ER280UNJ | T8030 | – | 160 | | 95 | | 150 | | 480 | | 40 | | – | | – | 28.0 | 0.8 | 0.8 |
| TN 16ER240UNJ | T8030 | – | 160 | | 95 | | 150 | | 480 | | 40 | | – | | – | 24.0 | 0.8 | 0.8 |
| TN 16ER200UNJ | T8030 | – | 160 | | 95 | | 150 | | 480 | | 40 | | – | | – | 20.0 | 0.8 | 0.8 |
| TN 16ER180UNJ | T8030 | – | 160 | | 95 | | 150 | | 480 | | 40 | | – | | – | 18.0 | 0.8 | 0.8 |
| TN 16ER160UNJ | T8030 | – | 160 | | 95 | | 150 | | 480 | | 40 | | – | | – | 16.0 | 1.5 | 1.2 |
| TN 16ER120UNJ | T8030 | – | 160 | | 95 | | 150 | | 480 | | 40 | | – | | – | 12.0 | 1.5 | 1.2 |

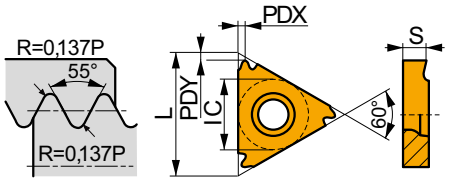
Egnethed og startværdier for skærehastighed (vc). Se vores app til bearbejdning af yderligere beregninger.

| 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 UNJ EL eksternt, venstrehåndet design til bearbejdning af ensartede "J-form" -tråde og kontinuerlige snit. | | | | | | | | | | | | | | | |
| **TN 16EL320UNJ** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | – | 32.0 | 0.8 | 0.8 |
| **TN 16EL280UNJ** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | – | 28.0 | 0.8 | 0.8 |
| **TN 16EL240UNJ** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | – | 24.0 | 0.8 | 0.8 |
| **TN 16EL200UNJ** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | – | 20.0 | 0.8 | 0.8 |
| **TN 16EL180UNJ** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | – | 18.0 | 0.8 | 0.8 |
| **TN 16EL160UNJ** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | – | 16.0 | 1.5 | 1.2 |
| **TN 16EL120UNJ** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | – | 12.0 | 1.5 | 1.2 |

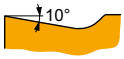
## TN W EXT

PRAMET

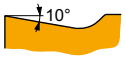
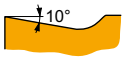
| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 16 | 9.525 | 16.50 | 3.47 |
| 22 | 12.700 | 22.00 | 4.71 |




Egnethed og startværdier for skærehastighed (vc). Se vores app til bearbejdning af yderligere beregninger.

| 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 eksternt, højrehåndet design til bearbejdning af Whitworth-formgevind og kontinuerlige snit. | | | | | | | | | | | | | | | |
| **TN 16ER280W** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | – | 28.0 | 0.8 | 0.8 |
| **TN 16ER260W** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | – | 26.0 | 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 |
| | **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** | **T8010** | – | ■ | 175 | ◪ | 105 | ■ | 165 | | – | ◪ | 40 | | – | – | 14.0 | 1.5 | 1.2 |
| | **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 |
| | **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 16ER090W** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | – | 9.0 | 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 |

Egnethed og startværdier for skærehastighed (vc). Se vores app til bearbejdning af yderligere beregninger.

| 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 16EL280W** | **T8030** | – | | 160 | | 95 | | 150 | | 480 | | 40 | | – | – | 28.0 | 0.8 | 0.8 |
| **TN 16EL260W** | **T8030** | – | | 160 | | 95 | | 150 | | 480 | | 40 | | – | – | 26.0 | 0.8 | 0.8 |
| **TN 16EL240W** | **T8030** | – | | 160 | | 95 | | 150 | | 480 | | 40 | | – | – | 24.0 | 0.8 | 0.8 |
| **TN 16EL200W** | **T8030** | – | | 160 | | 95 | | 150 | | 480 | | 40 | | – | – | 20.0 | 0.8 | 0.8 |
| **TN 16EL190W** | **T8030** | – | | 160 | | 95 | | 150 | | 480 | | 40 | | – | – | 19.0 | 0.8 | 0.8 |
| **TN 16EL160W** | **T8030** | – | | 160 | | 95 | | 150 | | 480 | | 40 | | – | – | 16.0 | 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 16EL090W** | **T8030** | – | | 160 | | 95 | | 150 | | 480 | | 40 | | – | – | 9.0 | 1.5 | 1.2 |
| **TN 16EL080W** | **T8030** | – | | 160 | | 95 | | 150 | | 480 | | 40 | | – | – | 8.0 | 1.5 | 1.2 |
| **TN 22EL070W** | **T8030** | – | | 160 | | 95 | | 150 | | 480 | | 40 | | – | – | 7.0 | 2.5 | 1.8 |
| **TN 22EL060W** | **T8030** | – | | 160 | | 95 | | 150 | | 480 | | 40 | | – | – | 6.0 | 2.5 | 1.8 |
| **TN 22EL050W** | **T8030** | – | | 160 | | 95 | | 150 | | 480 | | 40 | | – | – | 5.0 | 2.5 | 1.7 |
|  |  | | | | | | | | | | | | | | | | | |
| **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 |

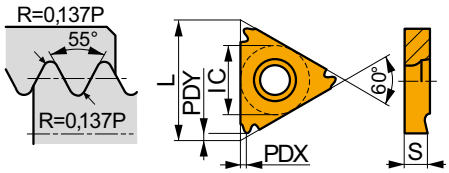
TN W EL eksternt, venstrehåndet design til bearbejdning af Whitworth-formgevind og kontinuerlige snit.

TN W-P1 ER presset eksternt, højrehåndet design til bearbejdning af Whitworth-formgevind og kontinuerlige snit.

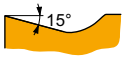
## TN W INT

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 |

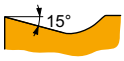
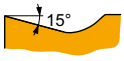
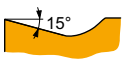



Egnethed og startværdier for skærehastighed (vc). Se vores app til bearbejdning af yderligere beregninger.

| 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 11NR190W** | **T8010** | – | | 175 | | 105 | | 165 | | – | | 40 | | – | – | 19.0 | 0.8 | 0.8 |
| | **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 |
| | **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 16NR260W** | **T8030** | – | | 160 | | 95 | | 150 | | 480 | | 40 | | – | – | 26.0 | 0.8 | 0.8 |
| **TN 16NR240W** | **T8030** | – | | 160 | | 95 | | 150 | | 480 | | 40 | | – | – | 24.0 | 0.8 | 0.8 |
| **TN 16NR200W** | **T8030** | – | | 160 | | 95 | | 150 | | 480 | | 40 | | – | – | 20.0 | 0.8 | 0.8 |

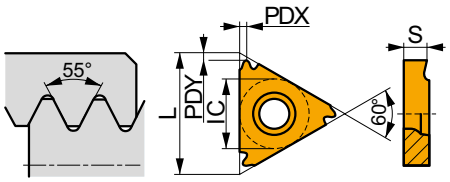
TN W NR internt, højrehåndet design til bearbejdning af Whitworth-formgevind og kontinuerlige snit.

Egnethed og startværdier for skærehastighed (vc). Se vores app til bearbejdning af yderligere beregninger.

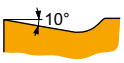
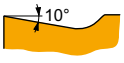
| Product | | RE (mm) | P vc (m/min) | | M vc (m/min) | | K vc (m/min) | | N vc (m/min) | | S vc (m/min) | | H vc (m/min) | | TP (mm) | TPI | PDX (mm) | PDY (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | | | | | | | | | | | | | | | | |
| | | | TN W NR internt, højrehåndet design til bearbejdning af Whitworth-formgevind og kontinuerlige snit. | | | | | | | | | | | | | | | |
| **TN 16NR190W** | **T8010** | – | ■ | 175 | ◪ | 105 | ■ | 165 | | – | ◪ | 40 | | – | – | 19.0 | 0.8 | 0.8 |
| | **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 |
| | **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 |
| | **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 22NR070W** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | – | 7.0 | 2.5 | 1.8 |
| **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 internt, venstrehåndet design til bearbejdning af Whitworth-formgevind og kontinuerlige snit. | | | | | | | | | | | | | | | |
| **TN 11NL190W** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | – | 19.0 | 0.8 | 0.8 |
| **TN 11NL140W** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | – | 14.0 | 0.9 | 0.7 |
| **TN 16NL280W** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | – | 28.0 | 0.8 | 0.8 |
| **TN 16NL260W** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | – | 26.0 | 0.8 | 0.8 |
| **TN 16NL240W** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | – | 24.0 | 0.8 | 0.8 |
| **TN 16NL200W** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | – | 20.0 | 0.8 | 0.8 |
| **TN 16NL190W** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | – | 19.0 | 0.8 | 0.8 |
| **TN 16NL160W** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | – | 16.0 | 0.8 | 0.8 |
| **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 16NL090W** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | – | 9.0 | 1.5 | 1.2 |
| **TN 16NL080W** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | – | 8.0 | 1.5 | 1.2 |
| **TN 22NL070W** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | – | 7.0 | 2.5 | 1.8 |
| **TN 22NL060W** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | – | 6.0 | 2.5 | 1.8 |
| **TN 22NL050W** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | – | 5.0 | 2.5 | 1.7 |
|  |  | | | | | | | | | | | | | | | | | |
| | | | TN W-P1 NR pressede internt, højrehåndet design til bearbejdning af Whitworth-gevind og kontinuerlige snit. | | | | | | | | | | | | | | | |
| **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

| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 16 | 9.525 | 16.50 | 3.47 |
| 22 | 12.700 | 22.00 | 4.71 |

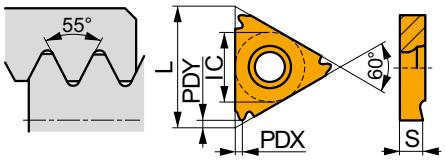



Egnethed og startværdier for skærehastighed (vc). Se vores app til bearbejdning af yderligere beregninger.

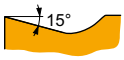
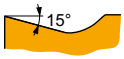
| Product | | RE (mm) | P vc (m/min) | M vc (m/min) | K vc (m/min) | N vc (m/min) | S vc (m/min) | H vc (m/min) | TPN (mm) | TPX (mm) | TPIN | TPIX | PDX (mm) | PDY (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | |  | | | | | | | | | | | |
| | | | TN W55 PP ER eksternt, højrehåndet design til bearbejdning af Whitworth-gevind og kontinuerlige snit. | | | | | | | | | | | |
| **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 |
| | **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 |
| | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 3.50 | 5.00 | 5 | 7 | 2.5 | 1.8 |
|  |  | |  | | | | | | | | | | | |
| | | | TN W55 PP EL eksternt, venstrehåndet design til bearbejdning af Whitworth-gevind og kontinuerlige snit. | | | | | | | | | | | |
| **TN 16ELA55** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 0.50 | 1.50 | 16 | 48 | 0.8 | 0.6 |
| **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

| | 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 |



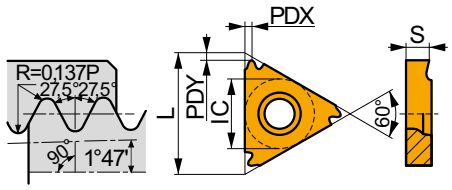

Egnethed og startværdier for skærehastighed (vc). Se vores app til bearbejdning af yderligere beregninger.

| 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 W55 PP NR internt, højrehåndet design til bearbejdning af Whitworth-gevind og kontinuerlige snit. | | | | | | | | | | | |
| **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 |
| | **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 |
|  |  | | | | | | | | | | | | | |
| | | | TN W55 PP NL internt, venstrehåndet design til bearbejdning af Whitworth-gevind og kontinuerlige snit. | | | | | | | | | | | |
| **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 22NLN55** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | 3.50 | 5.00 | 5 | 7 | 2.5 | 1.8 |

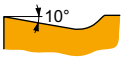
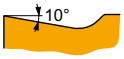
# TN BSPT EXT

PRAMET

| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 16 | 9.525 | 16.50 | 3.47 |



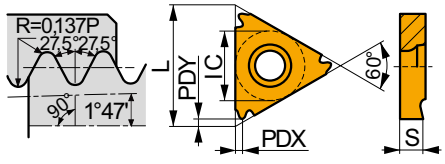

Egnethed og startværdier for skærehastighed (vc). Se vores app til bearbejdning af yderligere beregninger.

| 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 BSPT ER eksternt, højrehåndet design til bearbejdning af BSPT-gevind og kontinuerlige snit. | | | | | | | | | |
| **TN 16ER280BSPT** | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | – | 28.0 | 0.8 | 0.8 |
| **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 EL eksternt, venstrehåndet design til bearbejdning af BSPT-gevind og kontinuerlige snit. | | | | | | | | | |
| **TN 16EL280BSPT** | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | – | 28.0 | 0.8 | 0.8 |
| **TN 16EL190BSPT** | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | – | 19.0 | 1.5 | 1.2 |
| **TN 16EL140BSPT** | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | – | 14.0 | 1.5 | 1.2 |
| **TN 16EL110BSPT** | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | – | 11.0 | 1.5 | 1.2 |

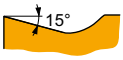
# TN BSPT INT

PRAMET

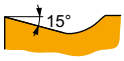
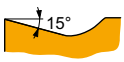
| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 16 | 9.525 | 16.50 | 3.47 |




Egnethed og startværdier for skærehastighed (vc). Se vores app til bearbejdning af yderligere beregninger.

| 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 BSPT NR internt, højrehåndet design til bearbejdning af BSPT-gevind og kontinuerlige snit. | | | | | | | | | |
| **TN 16NR280BSPT** | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | – | 28.0 | 0.8 | 0.8 |
| **TN 16NR190BSPT** | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | – | 19.0 | 1.5 | 1.2 |

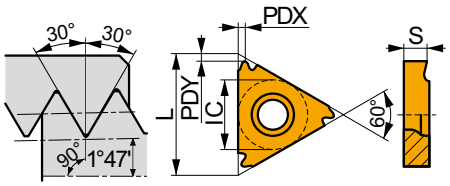
Egnethed og startværdier for skærehastighed (vc). Se vores app til bearbejdning af yderligere beregninger.

| 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 BSPT NR internt, højrehåndet design til bearbejdning af BSPT-gevind og kontinuerlige snit. | | | | | | | | | | | | | | | | | | |
| **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 NL internt, venstrehåndet design til bearbejdning af BSPT-gevind og kontinuerlige snit. | | | | | | | | | | | | | | | | | | |
| **TN 16NL280BSPT** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | – | 28.0 | 0.8 | 0.8 |
| **TN 16NL190BSPT** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | – | 19.0 | 1.5 | 1.2 |
| **TN 16NL140BSPT** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | – | 14.0 | 1.5 | 1.2 |
| **TN 16NL110BSPT** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | – | 11.0 | 1.5 | 1.2 |

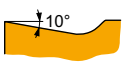
## TN NPT EXT

PRAMET

| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 16 | 9.525 | 16.50 | 3.47 |



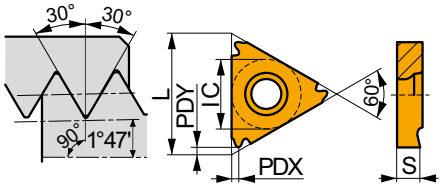

Egnethed og startværdier for skærehastighed (vc). Se vores app til bearbejdning af yderligere beregninger.

| 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 ER eksternt, højrehåndet design til bearbejdning af NPT-gevind og kontinuerlige snit. | | | | | | | | | | | | | | | | | | |
| **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** | **T8010** | – | ■ | 175 | ◪ | 105 | ■ | 165 | | – | ◪ | 40 | | – | – | 14.0 | 1.5 | 1.1 |
| | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | – | 14.0 | 1.5 | 1.1 |
| **TN 16ER115NPT** | **T8010** | – | ■ | 175 | ◪ | 105 | ■ | 165 | | – | ◪ | 40 | | – | – | 11.5 | 1.5 | 1.1 |
| | **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 |

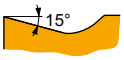
# TN NPT INT

PRAMET

| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 11 | 6.350 | 11.00 | 3.00 |
| 16 | 9.525 | 16.50 | 3.47 |



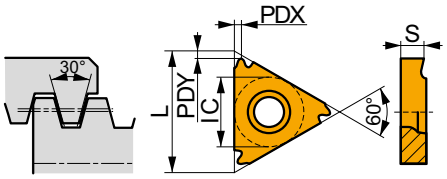

Egnethed og startværdier for skærehastighed (vc). Se vores app til bearbejdning af yderligere beregninger.

| 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 internt, højrehåndet design til bearbejdning af NPT-gevind og kontinuerlige snit. | | | | | | | | | | | | |
| **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 |
| | **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 |
| | **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 |

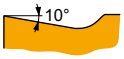
# TN TR EXT

PRAMET

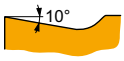
| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 16 | 9.525 | 16.50 | 3.47 |
| 22 | 12.700 | 22.00 | 4.71 |




Egnethed og startværdier for skærehastighed (vc). Se vores app til bearbejdning af yderligere beregninger.

| 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 eksternt, højrehåndet design til bearbejdning af trapezformede gevind og kontinuerlige snit. | | | | | | | | | | | | |
| **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 |

Egnethed og startværdier for skærehastighed (vc). Se vores app til bearbejdning af yderligere beregninger.

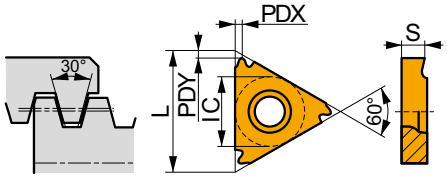
| Product | | RE (mm) | P vc (m/min) | | M vc (m/min) | | K vc (m/min) | | N vc (m/min) | | S vc (m/min) | | H vc (m/min) | | TP (mm) | TPI | PDX (mm) | PDY (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | | | | | | | | | | | | | | | | |
| | | | | | | | | | | | | | | | | | | |
| **TN 16EL150TR** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | 1.50 | – | 0.8 | 0.9 |
| **TN 16EL200TR** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | 2.00 | – | 1.5 | 1.3 |
| **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 EL udvendigt, venstrehåndet design til bearbejdning af trapezformede gevind og kontinuerlige snit.

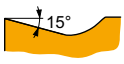
## TN TR INT

PRAMET

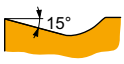
| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 16 | 9.525 | 16.50 | 3.47 |
| 22 | 12.700 | 22.00 | 4.71 |




Egnethed og startværdier for skærehastighed (vc). Se vores app til bearbejdning af yderligere beregninger.

| 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 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 NR internt, højrehåndet design til bearbejdning af trapesformede tråde og kontinuerlige snit.

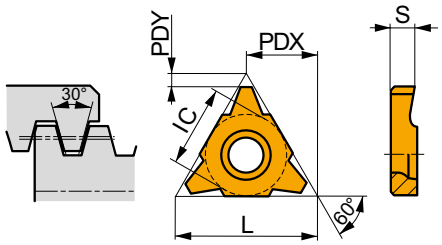
| | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **TN 16NL150TR** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | 1.50 | – | 0.8 | 0.9 |
| **TN 16NL200TR** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | 2.00 | – | 1.5 | 1.3 |
| **TN 16NL300TR** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | 3.00 | – | 1.6 | 1.3 |
| **TN 22NL400TR** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | 4.00 | – | 2.2 | 1.8 |
| **TN 22NL500TR** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◪ | 480 | ◪ | 40 | | – | 5.00 | – | 2.2 | 1.8 |

TN TR NL internt, venstrehåndet design til bearbejdning af trapesformede tråde og kontinuerlige snit.

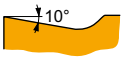
# TN TR-S EXT

PRAMET

| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 22 | 12.700 | 22.00 | 4.60 |



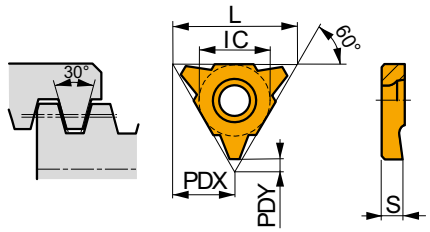

Egnethed og startværdier for skærehastighed (vc). Se vores app til bearbejdning af yderligere beregninger.

| 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 EN udvendigt, venstre- og højrehåndet design til bearbejdning af trapesformede gevind og kontinuerlige snit. | | | | | | | | | |
| **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 |

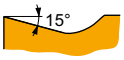
# TN TR-S INT

PRAMET

| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 22 | 12.700 | 22.00 | 4.60 |

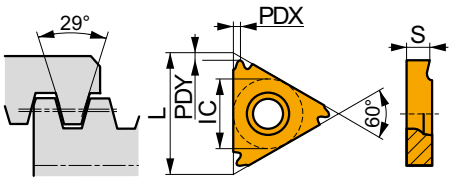



Egnethed og startværdier for skærehastighed (vc). Se vores app til bearbejdning af yderligere beregninger.

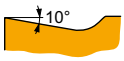
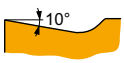
| Product | | RE (mm) | P vc (m/min) | M vc (m/min) | K vc (m/min) | N vc (m/min) | S vc (m/min) | H vc (m/min) | TP (mm) | TPI | PDX (mm) | PDY (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | |  TN M60-S PP NN internt, venstre- og højrehåndet design til bearbejdning af metriske og ensartede gevind og kontinuerlige snit. | | | | | | | | | |
| **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 | 2.3 |

# TN ACME EXT

| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 16 | 9.525 | 16.50 | 3.47 |
| 22 | 12.700 | 22.00 | 4.71 |

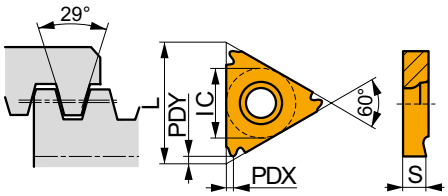



Egnethed og startværdier for skærehastighed (vc). Se vores app til bearbejdning af yderligere beregninger.

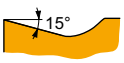
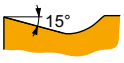
| Product | | RE (mm) | P vc (m/min) | M vc (m/min) | K vc (m/min) | N vc (m/min) | S vc (m/min) | H vc (m/min) | TP (mm) | TPI | PDX (mm) | PDY (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | | | | | | | | | | |
| TN ACME ER eksternt, højrehåndet design til bearbejdning af ACME-gevind og kontinuerlige snit. | | | | | | | | | | | | |
| **TN 16ER120ACME** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 12.0 | 1.5 | 1.3 |
| **TN 16ER100ACME** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 10.0 | 1.5 | 1.3 |
| **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 EL eksternt, venstrehåndet design til bearbejdning af ACME-gevind og kontinuerlige snit. | | | | | | | | | | | | |
| **TN 16EL120ACME** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 12.0 | 1.5 | 1.3 |
| **TN 16EL100ACME** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 10.0 | 1.5 | 1.3 |
| **TN 16EL080ACME** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 8.0 | 1.5 | 1.3 |
| **TN 22EL060ACME** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 6.0 | 2.5 | 2.0 |
| **TN 22EL050ACME** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 5.0 | 2.3 | 2.0 |

# TN ACME INT

| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 16 | 9.525 | 16.50 | 3.47 |
| 22 | 12.700 | 22.00 | 4.71 |




Egnethed og startværdier for skærehastighed (vc). Se vores app til bearbejdning af yderligere beregninger.

| 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 NR internt, højrehåndet design til bearbejdning af ACME-gevind og kontinuerlige snit. | | | | | | | | | |
| **TN 16NR120ACME** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 12.0 | 1.5 | 1.3 |
| **TN 16NR100ACME** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 10.0 | 1.5 | 1.3 |
| **TN 16NR080ACME** | **T8030**[1)] | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 8.0 | 1.5 | 1.3 |
| **TN 22NR060ACME** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 6.0 | 2.5 | 2.0 |
| **TN 22NR050ACME** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 5.0 | 2.3 | 2.0 |
|  |  | | | | | | | | | | | |
| | | | TN ACME NL internt, venstrehåndet design til bearbejdning af ACME-gevind og kontinuerlige snit. | | | | | | | | | |
| **TN 16NL120ACME** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 12.0 | 1.5 | 1.3 |
| **TN 16NL100ACME** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 10.0 | 1.5 | 1.3 |
| **TN 16NL080ACME** | **T8030**[1)] | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 8.0 | 1.5 | 1.3 |
| **TN 22NL060ACME** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 6.0 | 2.5 | 2.0 |
| **TN 22NL050ACME** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 5.0 | 2.3 | 2.0 |

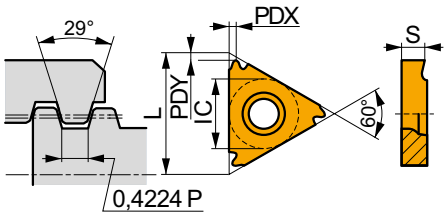
[1)] Toolholders have to be modified.

NEW

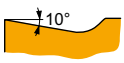
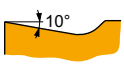
# TN STACME EXT

PRAMET

| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 16 | 9.525 | 16.50 | 3.47 |




Egnethed og startværdier for skærehastighed (vc). Se vores app til bearbejdning af yderligere beregninger.

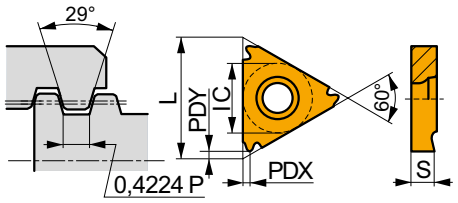
| Product | | RE (mm) | P vc (m/min) | M vc (m/min) | K vc (m/min) | N vc (m/min) | S vc (m/min) | H vc (m/min) | TP (mm) | TPI | PDX (mm) | PDY (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | | | | | | | | | | |
| | | | TN STACME ER eksternt, højrehåndet design til bearbejdning af ACME-tråde og kontinuerlige snit. | | | | | | | | | |
| **TN 16ER160STACME** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 16.0 | 0.8 | 0.8 |
| **TN 16ER120STACME** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 12.0 | 0.8 | 0.8 |
| **TN 16ER100STACME** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 10.0 | 1.5 | 1.3 |
| **TN 16ER080STACME** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 8.0 | 1.5 | 1.3 |
| **TN 16ER060STACME** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 6.0 | 1.4 | 1.3 |
|  |  | | | | | | | | | | | |
| | | | TN STACME EL eksternt, venstrehåndet design til bearbejdning af ACME-tråde og kontinuerlige snit. | | | | | | | | | |
| **TN 16EL160STACME** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 16.0 | 0.8 | 0.8 |
| **TN 16EL120STACME** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 12.0 | 0.8 | 0.8 |
| **TN 16EL100STACME** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 10.0 | 1.5 | 1.3 |
| **TN 16EL080STACME** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 8.0 | 1.5 | 1.3 |
| **TN 16EL060STACME** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 6.0 | 1.4 | 1.3 |

NEW

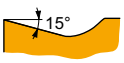
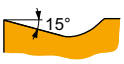
# TN STACME INT

PRAMET

| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 16 | 9.525 | 16.50 | 3.47 |




Egnethed og startværdier for skærehastighed (vc). Se vores app til bearbejdning af yderligere beregninger.

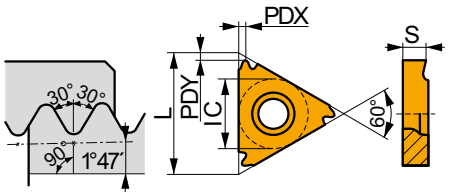
| Product | | RE (mm) | P vc (m/min) | M vc (m/min) | K vc (m/min) | N vc (m/min) | S vc (m/min) | H vc (m/min) | TP (mm) | TPI | PDX (mm) | PDY (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | | | | | | | | | | |
| | | | 1 U E | | | | | | | | | |
| TN STACME NR intern, højrehåndet, design til bearbejdning af Stub ACME-gevind og kontinuerlige snit. | | | | | | | | | | | | |
| **TN 16NR160STACME** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 16.0 | 0.8 | 0.8 |
| **TN 16NR120STACME** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 12.0 | 0.8 | 0.8 |
| **TN 16NR100STACME** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 10.0 | 1.5 | 1.3 |
| **TN 16NR080STACME** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 8.0 | 1.5 | 1.3 |
| **TN 16NR060STACME** | **T8030**[1)] | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 6.0 | 1.3 | 1.3 |
|  |  | | | | | | | | | | | |
| | | | 1 U E | | | | | | | | | |
| TN STACME NL internt, venstrehåndet design til bearbejdning af Stub ACME-gevind og kontinuerlige snit. | | | | | | | | | | | | |
| **TN 16NL160STACME** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 16.0 | 0.8 | 0.8 |
| **TN 16NL120STACME** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 12.0 | 0.8 | 0.8 |
| **TN 16NL100STACME** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 10.0 | 1.5 | 1.3 |
| **TN 16NL080STACME** | **T8030** | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 8.0 | 1.5 | 1.3 |
| **TN 16NL060STACME** | **T8030**[1)] | – | ■ 160 | ■ 95 | ■ 150 | ◪ 480 | ◪ 40 | – | – | 6.0 | 1.3 | 1.3 |

[1)] Toolholders have to be modified.

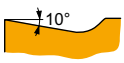
# TN API RD EXT

PRAMET

| | IC | L | S |
|---|---|---|---|
| | (mm) | (mm) | (mm) |
| 16 | 9.525 | 16.50 | 3.47 |



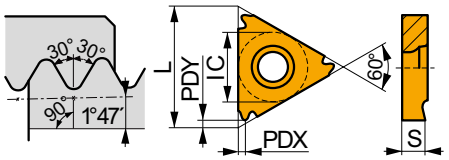

Egnethed og startværdier for skærehastighed (vc). Se vores app til bearbejdning af yderligere beregninger.

| 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 API ER eksternt, højrehåndet design til bearbejdning af API-tråde og kontinuerlige skæringer. | | | | | | | | | |
| **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 |

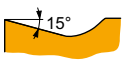
# TN API RD INT

PRAMET

| | IC | L | S |
|---|---|---|---|
| | (mm) | (mm) | (mm) |
| 16 | 9.525 | 16.50 | 3.47 |



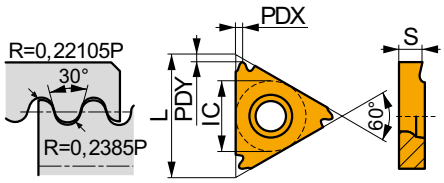

Egnethed og startværdier for skærehastighed (vc). Se vores app til bearbejdning af yderligere beregninger.

| 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 API NR internt, højrehåndet design til bearbejdning af API-tråde og kontinuerlige skæringer. | | | | | | | | | |
| **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 |

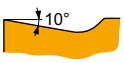
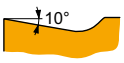
# TN RD EXT

PRAMET

| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 16 | 9.525 | 16.50 | 3.47 |
| 22 | 12.700 | 22.00 | 4.71 |




Egnethed og startværdier for skærehastighed (vc). Se vores app til bearbejdning af yderligere beregninger.

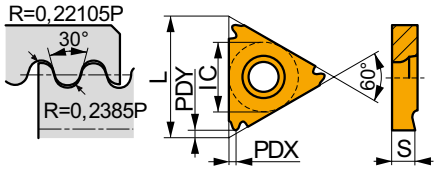
| Product | | RE (mm) | P vc (m/min) | M vc (m/min) | K vc (m/min) | N vc (m/min) | S vc (m/min) | H vc (m/min) | TP (mm) | TPI | PDX (mm) | PDY (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | | | | | | | | | | |
| | | | 1 U E | | | | | | | | | |
| | | | TN RD ER eksternt, højrehåndet design til bearbejdning af metriske gevind og kontinuerlige snit. | | | | | | | | | |
| **TN 16ER100RD** | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | – | 10.0 | 1.5 | 1.2 |
| **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 |
|  |  | | | | | | | | | | | |
| | | | 1 U E | | | | | | | | | |
| | | | TN RD EL eksternt, venstrehåndet design til bearbejdning af metriske gevind og kontinuerlige snit. | | | | | | | | | |
| **TN 16EL100RD** | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | – | 10.0 | 1.5 | 1.2 |
| **TN 16EL080RD** | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | – | 8.0 | 1.5 | 1.2 |
| **TN 16EL060RD** | **T8030**[1)] | – | 160 | 95 | 150 | 480 | 40 | – | – | 6.0 | 1.5 | 1.2 |
| **TN 22EL060RD** | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | – | 6.0 | 2.5 | 1.8 |

[1)] Toolholders have to be modified.

# TN RD INT

PRAMET

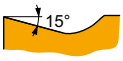
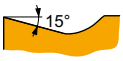
| | IC (mm) | L (mm) | S (mm) |
|---|---|---|---|
| 16 | 9.525 | 16.50 | 3.47 |
| 22 | 12.700 | 22.00 | 4.71 |




Egnethed og startværdier for skærehastighed (vc). Se vores app til bearbejdning af yderligere beregninger.

| 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) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | | | | | | | | | | |
| | | | 1 U E | | | | | | | | | |
| | | | TN RD NR internt, højrehåndet design til bearbejdning af metriske gevind og kontinuerlige snit. | | | | | | | | | |
| **TN 16NR100RD** | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | – | 10.0 | 1.5 | 1.2 |
| **TN 16NR080RD** | **T8030** | – | 160 | 95 | 150 | 480 | 40 | – | – | 8.0 | 1.5 | 1.2 |

Egnethed og startværdier for skærehastighed (vc). Se vores app til bearbejdning af yderligere beregninger.

| 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 RD NR internt, højrehåndet design til bearbejdning af metriske gevind og kontinuerlige snit. | | | | | | | | | | | | | | | | | | |
| **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 NL internt, venstrehåndet design til bearbejdning af metriske runde gevind og kontinuerlige snit. | | | | | | | | | | | | | | | | | | |
| **TN 16NL100RD** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◩ | 480 | ◩ | 40 | | – | – | 10.0 | 1.5 | 1.2 |
| **TN 16NL080RD** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◩ | 480 | ◩ | 40 | | – | – | 8.0 | 1.5 | 1.2 |
| **TN 16NL060RD** | **T8030**[1)] | – | ■ | 160 | ■ | 95 | ■ | 150 | ◩ | 480 | ◩ | 40 | | – | – | 6.0 | 1.5 | 1.2 |
| **TN 22NL060RD** | **T8030** | – | ■ | 160 | ■ | 95 | ■ | 150 | ◩ | 480 | ◩ | 40 | | – | – | 6.0 | 2.5 | 1.8 |

[1)] Toolholders have to be modified.

# SE(RL)

P M K N S H

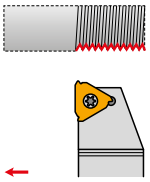
PRAMET

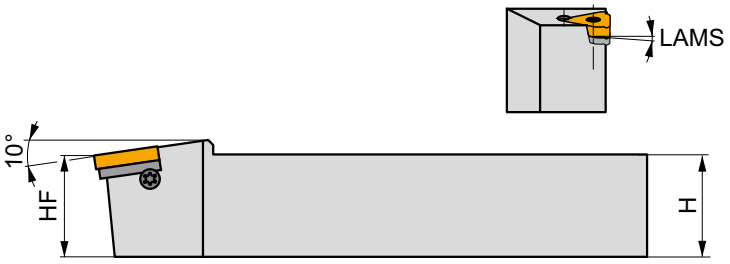
S

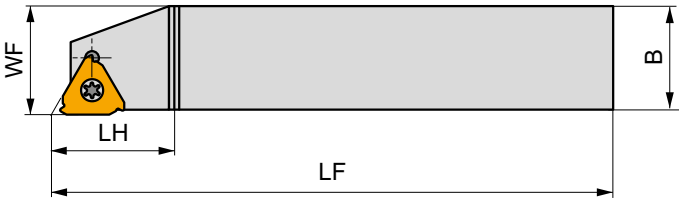


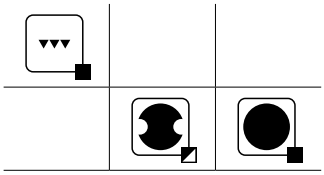
## Ekstern skrue fastspændt gevindholder til TN 16 og 22 neutral skær

Højre / venstre skruelåsværktøjsholder til udvendigt gevind med TN16 eller 22 ER / EL-skær. Velegnet til gevindskæring i metrisk eller tomme profil. Også velegnet til lav rille. Krop behandlet for længere levetid på værktøjet.







| | 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 | – | 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 | – | GI068 | Z12 |
| | **SEL 3225 P 16** | 32 | 32 | 25 | 25 | 170 | 24.5 | – | GI068 | Z12 |
| | **SEL 2525 M 22-A** | 25 | 25 | 25 | 25 | 150 | 25.5 | – | GI071 | Z13 |
| | **SEL 3225 P 22-A** | 32 | 32 | 25 | 25 | 170 | 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 | 604 |
| Z13 | US 4514A-T20 | 5.0 | M 4.5 | 14 | SP 0405 | – | FLAG T20 | – | 604 |

# SE(RL)-S

P M K N S H

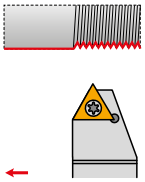
PRAMET

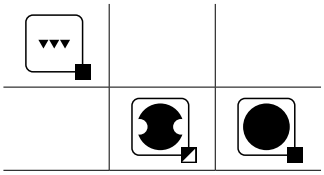
S

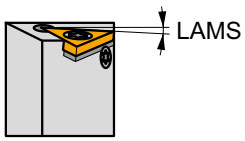


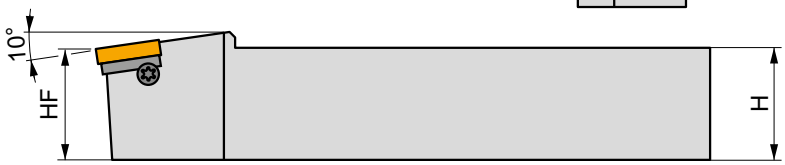
## Ekstern skrue fastspændt gevindholder til TN 22 neutral skær

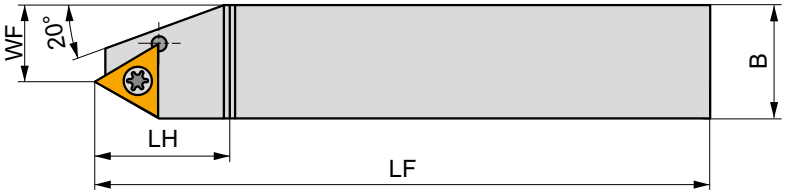
Højre / venstre skruelåsværktøjsholder til udvendigt stort gevind med TN22 EN-skær. Velegnet til gevindskæring i metrisk eller tomme profil. Krop behandlet for længere levetid på værktøjet.










| | Product | H (mm) | HF (mm) | B (mm) | WF (mm) | LF (mm) | LH (mm) | LAMS (°) | | |
|---|---|---|---|---|---|---|---|---|---|---|
| R | **SER-S 2525 M 22-A** | 25 | 25 | 25 | 14 | 150 | 30 | – | GI086 | Z15 |
| | **SER-S 3225 P 22-A** | 32 | 32 | 25 | 14 | 170 | 30 | – | GI086 | Z15 |
| L | **SEL-S 2525 M 22-A** | 25 | 25 | 25 | 14 | 150 | 30 | – | GI086 | Z15 |
| | **SEL-S 3225 P 22-A** | 32 | 32 | 25 | 14 | 170 | 30 | – | GI086 | Z15 |

| | |
|---|---|
| GI086 | TN 22EN.. |

| | | | | | | | |
|---|---|---|---|---|---|---|---|
| Z15 | US 4514A-T20 | 5.0 Nm | M 4.5 | 14 | SP 0405 | FLAG T20 | 604 |

# SI(RL)

P M K N S H

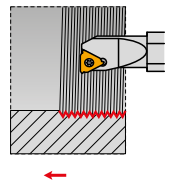
PRAMET

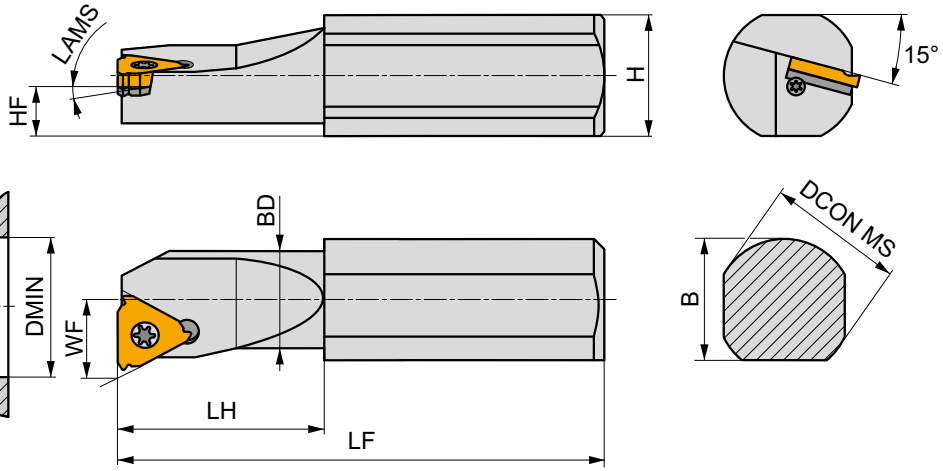
S

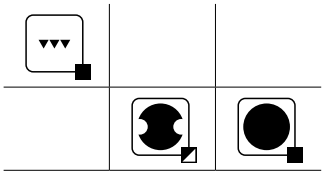


## Intern skrue fastspændt gevindholder til TN 11,16 og 22 neutral skær

Højre / venstre skruelåsborestang til indvendigt gevind med TN11, 16 eller 22 ER / EL-skær. Velegnet til gevindskæring i metrisk eller tomme profil. Mindste indvendige diameter Ø13 mm. Også velegnet til lav rille. Fås med skaftstørrelse Ø16 op til Ø40 mm. Krop behandlet for længere levetid på værktøjet.







| | Product | B (mm) | DCON MS (mm) | DMIN (mm) | BD (mm) | WF (mm) | H (mm) | HF (mm) | LF (mm) | LH (mm) | LAMS (°) | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| R | SIR 0010 K 11-0 | 14.5 | 16 | 13 | 10 | 7.45 | 14 | 7 | 125 | 25 | 0 | – | GI085 | Z11 |
| | SIR 0010 K 11-1 | 14.5 | 16 | 13 | 10 | 7.45 | 14 | 7 | 125 | 25 | 1 | – | GI085 | Z11 |
| | SIR 0013 M 11-0 | 14.5 | 16 | 16 | 13 | 9 | 14 | 7 | 150 | 32 | 0 | – | GI085 | Z11 |
| | SIR 0013 M 11-1 | 14.5 | 16 | 16 | 13 | 9 | 14 | 7 | 150 | 32 | 1 | – | GI085 | Z11 |
| | SIR 1416 N 16-0 | 14 | 16 | 22 | 17 | 11.4 | 14.5 | 7.5 | 160 | – | 0 | – | GI022 | Z9 |
| | SIR 1416 N 16-1 | 14 | 16 | 22 | 17 | 11.4 | 14.5 | 7.5 | 160 | – | 1 | – | GI022 | Z9 |
| | SIR 1416 N 16-2 | 14 | 16 | 16.5 | 15.5 | 10.6 | 14.5 | 7.5 | 160 | 40 | 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 | 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 | – | GI085 | Z11 |
| | SIL 0010 K 11-1 | 14.5 | 16 | 13 | 10 | 7.55 | 14 | 7 | 125 | 25 | 1 | – | GI085 | Z11 |
| | SIL 0013 M 11-0 | 14.5 | 16 | 16 | 13 | 9 | 14 | 7 | 150 | 32 | 0 | – | GI085 | Z11 |
| | SIL 0013 M 11-1 | 14.5 | 16 | 16 | 13 | 9 | 14 | 7 | 150 | 32 | 1 | – | GI085 | Z11 |
| | SIL 1416 N 16-0 | 14 | 16 | 22 | 17 | 11.4 | 14.5 | 7.5 | 160 | – | 0 | – | GI022 | Z9 |
| | SIL 1416 N 16-1 | 14 | 16 | 22 | 17 | 11.4 | 14.5 | 7.5 | 160 | – | 1 | – | GI022 | Z9 |
| | SIL 1416 N 16-2 | 14 | 16 | 16.5 | 15.5 | 10.6 | 14.5 | 7.5 | 160 | 40 | 2 | ✓ | GI022 | Z10 |
| | SIL 1820 P 16 | 18.5 | 20 | 27 | 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 | 2 | ✓ | GI076 | Z14 |
| | SIL 2532 S 22-A | 30 | 32 | 36 | 32 | 21.65 | 25 | 12.5 | 250 | – | – | – | GI076 | Z13 |
| | SIL 3240 T 22-A | 38 | 40 | 48 | 40 | 25.85 | 32 | 16 | 300 | – | – | – | GI076 | Z13 |

| | | |
|---|---|---|
| GI022 | TN 16NR.. | TN 16NL.. |
| GI076 | TN 22NR.. | TN 22NL.. |
| GI085 | TN 11NR.. | TN 11NL.. |

| | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| 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 | 📖 604 |
| Z13 | US 4514A-T20 | 5.0 | M 4.5 | 14 | SP 0405 | – | FLAG T20 | – | 📖 604 |
| 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

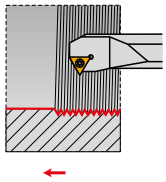
PRAMET

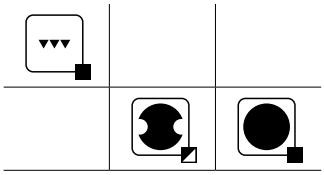
S

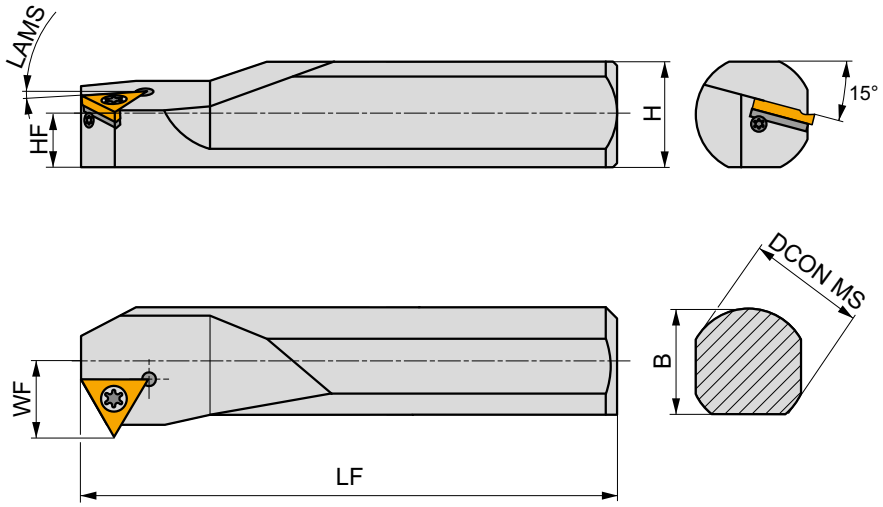


## Intern skrue fastspændt gevindholder til TN 22 neutral skær

Højre / venstre  borestang til intern stor gevindskæring med TN22 EN-skær. Velegnet til gevindskæring i metrisk eller tomme profil. Mindste indvendige Ø39 mm. Fås med skaftstørrelse Ø32 op til Ø40 mm. Krop behandlet for længere levetid på værktøjet.








| | Product | B (mm) | DCON MS (mm) | DMIN (mm) | WF (mm) | H (mm) | HF (mm) | LF (mm) | LAMS (°) | | |
|---|---|---|---|---|---|---|---|---|---|---|---|
| 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 |
| L | **SIL-S 2532 S 22-A** | 30 | 32 | 39 | 22.3 | 25 | 12.5 | 250 | – | GI107 | Z15 |
| | **SIL-S 3240 T 22-A** | 38 | 40 | 48 | 27 | 32 | 16 | 300 | – | GI107 | Z15 |

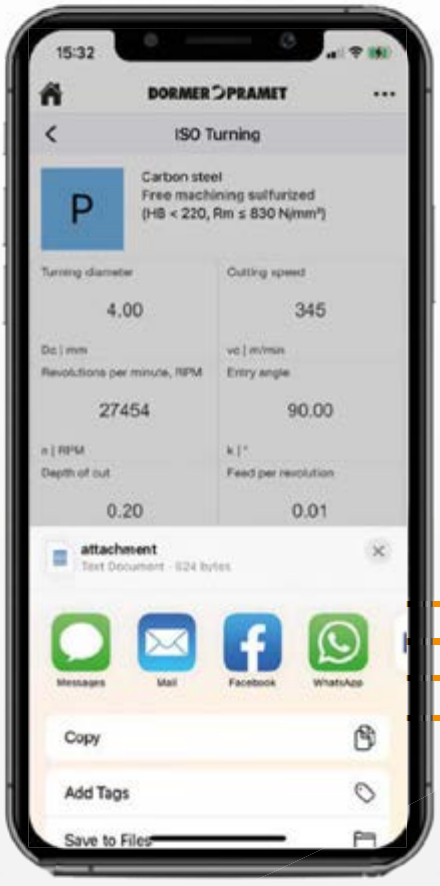
| | |
|---|---|
| GI107 | TN 22NN.. |

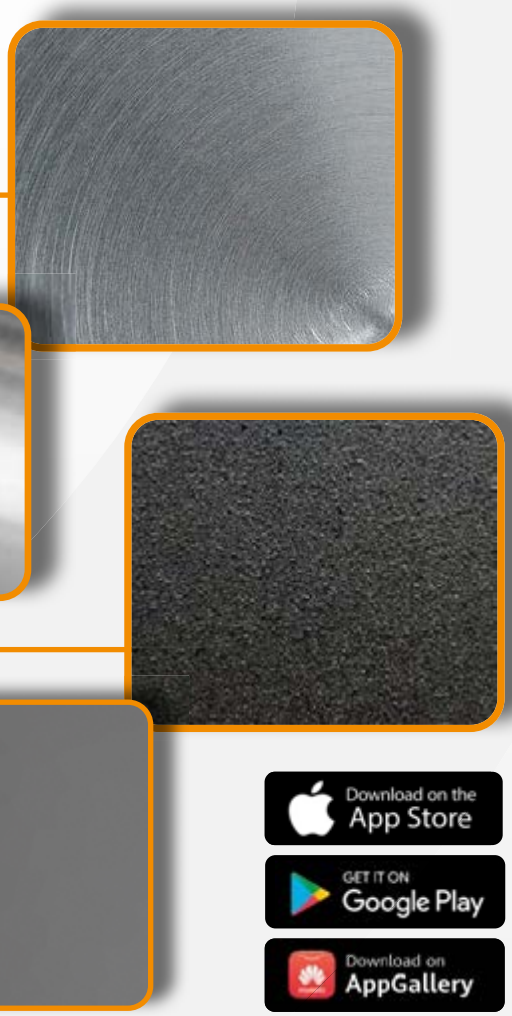
| | | | | | | | |
|---|---|---|---|---|---|---|---|
| Z15 | US 4514A-T20 | 5.0 Nm | M 4.5 | 14 | SP 0405 | FLAG T20 | 604 |

DORMER PRAMET

# EVERY MATERIAL

Machining steel, stainless steel, cast iron, super-alloys or non-ferrous materials, all are covered within our calculator app. Download it from your app store today.
**Simply Reliable.**



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# BROACHING



| | | |
|---|---|---|
| 📖 6 | | WMG & ISO 13399 |
| 📖 10 | ISO TURNING | INSTRUCTIONS |
| 📖 18 | | NAVIGATORS |
| 📖 57 | | POSITIVE INSERTS |
| 📖 219 | | NEGATIVE INSERTS |
| 📖 386 | | PARTING-OFF & GROOVING |
| 📖 482 | | THREAD TURNING |
| 📖 **528** | | **BROACHING** |
| 📖 536 | | GENERAL TECHNICAL INFORMATION |

# BROACHING – ICONS OVERVIEW

## GENERAL ICONS

| | |
|---|---|
| ■ | Primary use |
| ◪ | Possible use |

| | |
|---|---|
| ▼▼▼ | Finishing – very good surface quality |
| ▼▼ | Medium machining – good surface quality |
| ▼ | Roughing – unlimited surface roughness |

| | |
|---|---|
| ● | Suitable for stable working conditions |
| ● | Suitable for unstable working conditions |
| ● | Suitable for very unstable working conditions |

## FEATURES

| | |
|---|---|
| | Internal shaping |
| U | Universal wide range option |
| F | Sharp edge |

## OTHER

| | |
|---|---|
| Nm | Clamping torque of screw (Nm) |
| | Internal supply of coolant |

# BROACHING INSERTS – NAVIGATOR

**HZ**



531

**HZ-2**



532

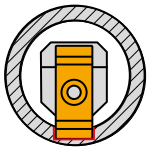
# BROACHING HOLDERS – NAVIGATOR

**PHZ**



| | HZ |
|---|---|
| | 03<br>04<br>05<br>06<br>08<br>10<br>12 |
| Ø 9,5<br>Ø 24,7 | |
| 533 | 531 |

**PHZ-2**

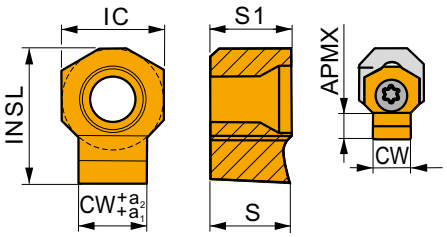


| | HZ/2.. |
|---|---|
| | 14<br>16<br>18<br>20 |
| Ø 44<br>Ø 58 | |
| 534 | 532 |

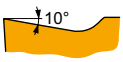
# HZ

PRAMET

| | IC | INSL | APMX | S | S1 | CW |
|---|---|---|---|---|---|---|
| | (mm) | (mm) | (mm) | (mm) | (mm) | (mm) |
| 0604-30 | 6.000 | 7.5 | 1.60 | 4.66 | 4.76 | 3.00 |
| 0604-40 | 6.000 | 8.0 | 2.50 | 4.66 | 4.76 | 4.00 |
| 0604-50 | 6.000 | 8.0 | 3.00 | 4.66 | 4.76 | 5.00 |
| 1006-60 | 10.000 | 13.5 | 4.20 | 6.25 | 6.35 | 6.00 |
| 1006-80 | 10.000 | 13.5 | 5.20 | 6.25 | 6.35 | 8.00 |
| 1309-100 | 13.000 | 18.5 | 6.20 | 9.40 | 9.53 | 10.00 |
| 1309-120 | 13.000 | 18.5 | 7.20 | 9.40 | 9.53 | 12.00 |



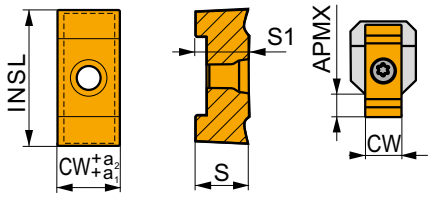

Egnethed og startværdier for skærehastighed (vc) og tilførsel (fz). Se vores app til bearbejdning af yderligere beregninger.

| Product | | RE | P | | M | | K | | N | | S | | H | | CW | CWTOLL | CWTOLU |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | vc | fz | vc | fz | vc | fz | vc | fz | vc | fz | vc | fz | | | |
| | | (mm) | (m/min) | (mm/tooth) | (m/min) | (mm/tooth) | (m/min) | (mm/tooth) | (m/min) | (mm/tooth) | (m/min) | (mm/tooth) | (m/min) | (mm/tooth) | (mm) | (mm) | (mm) |
|  |  | | U F | | | | | | | | | | | | | | |
| | | | Positiv geometri til not (et skær). | | | | | | | | | | | | | | |
| **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 | 0.02 |
| **HZ 1006-80 P9** | **333TN** | – | 50 | 0.10 | 30 | 0.09 | 45 | 0.10 | – | – | – | – | – | – | 8.00 | -0.05 | -0.02 |
| **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 | 0.02 |
| **HZ 1309-100 P9** | **333TN** | – | 50 | 0.10 | 30 | 0.09 | 45 | 0.10 | – | – | – | – | – | – | 10.00 | -0.05 | -0.02 |
| **HZ 1309-120 C11** | **333TN** | – | 50 | 0.10 | 30 | 0.09 | 45 | 0.10 | – | – | – | – | – | – | 12.00 | 0.10 | 0.21 |
| **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 |

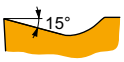
# HZ-2

PRAMET

| | INSL (mm) | APMX (mm) | S (mm) | S1 (mm) | CW (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 |




Egnethed og startværdier for skærehastighed (vc) og tilførsel (fz). Se vores app til bearbejdning af yderligere beregninger.

| Product | | RE (mm) | P vc (m/min) | P fz (mm/tooth) | M vc (m/min) | M fz (mm/tooth) | K vc (m/min) | K fz (mm/tooth) | N vc (m/min) | N fz (mm/tooth) | S vc (m/min) | S fz (mm/tooth) | H vc (m/min) | H fz (mm/tooth) | CW (mm) | CWTOLL (mm) | CWTOLU (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |  | | | | | | | | | | | | | | | | |
| | | | Positiv geometri til not (2 skær). | | | | | | | | | | | | | | |
| **HZ/2 14-14 C11** | **333TN** | – | 50 | 0.10 | 30 | 0.09 | 45 | 0.10 | – | – | – | – | – | – | 14.00 | 0.10 | 0.21 |
| **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 | 0.21 |
| **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 | 0.21 |
| **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 |

# PHZ

P M K N S H

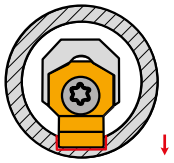
PRAMET

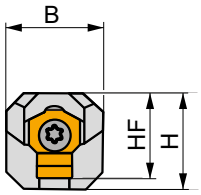
S

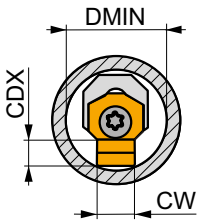


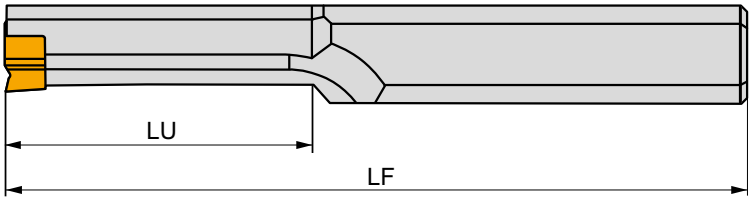
## Int. Holder til notværktøj til små diametre med ensidige HZ-skær

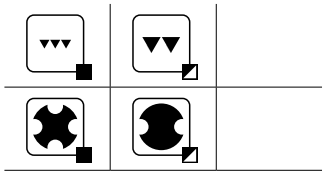
Intern værktøjsholder til opskæring op til 12 mm bredde. Mindste indvendige diameter Ø9,5 mm. Krop behandlet for længere levetid på værktøjet.







| | 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 | 0.17 | 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 | – | – | – | 0.19 | GI240 | SH21 |
| | **PHZ 1512-10** | 15.5 | 16.2 | – | 220 | – | – | – | – | 0.40 | GI224 | SH22 |
| | **PHZ 2014-13** | 20.6 | 21.5 | – | 250 | – | – | – | – | 0.65 | 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

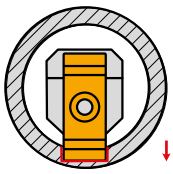
PRAMET

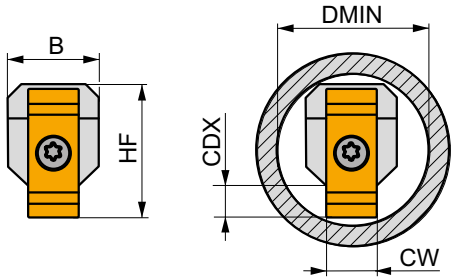
S

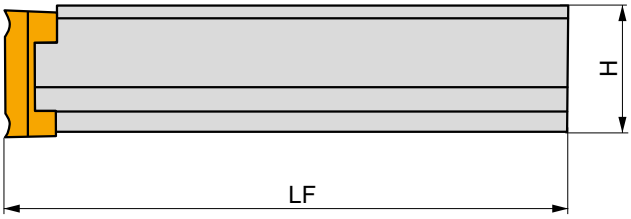


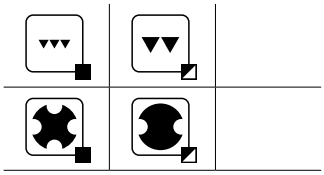
## Int. Holder til notværktøj til store diametre med ensidige HZ-skær

Intern værktøjsholder til opskæring op til 20 mm bredde Mindste indvendige diameter Ø44 mm. Krop behandlet for længere levetid på værktøjet.







| | 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 | – | 1.86 | 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 |

DORMER PRAMET

# HELP IS AT HAND

Our techincal support team are always at hand to help with any technical questions or queries you have about our technical apps. Use the contact us details to reach out to your local Dormer Pramet sales office.
**Simply Reliable.**



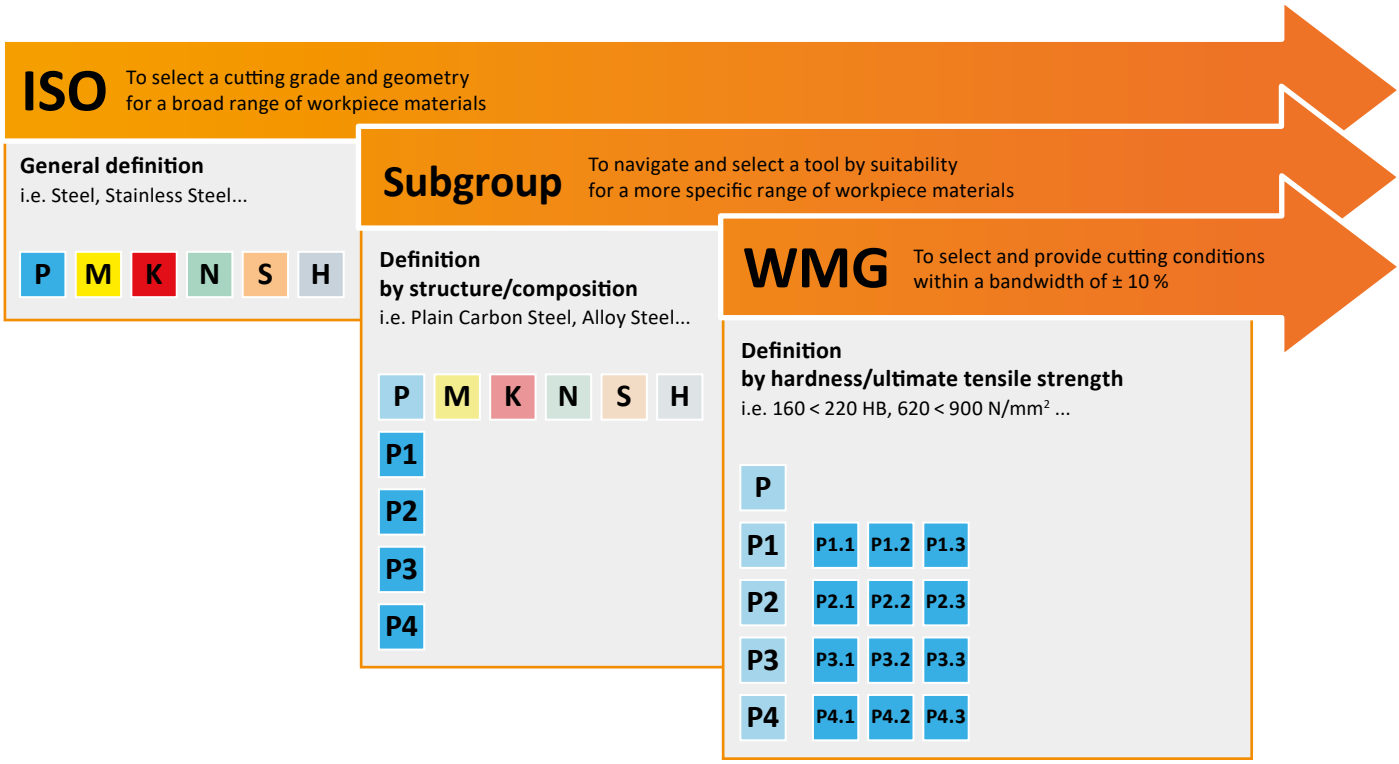
# GENERAL
# TECHNICAL INFORMATION



## TURNING – GENERAL CONTENT


| | | |
|---|---|---|
| 📖 6 | | WMG & ISO 13399 |
| 📖 10 | ISO TURNING | INSTRUCTIONS |
| 📖 18 | | NAVIGATORS |
| 📖 57 | | POSITIVE INSERTS |
| 📖 219 | | NEGATIVE INSERTS |
| 📖 386 | | PARTING-OFF & GROOVING |
| 📖 482 | | THREAD TURNING |
| 📖 528 | | BROACHING |
| 📖 536 | | GENERAL TECHNICAL INFORMATION |

## WORKPIECE MATERIAL GROUP (WMG)




## ABOUT DORMER PRAMET'S WORKPIECE MATERIAL CLASSIFICATION

**W**orkpiece **M**aterial **G**roups (**WMG**) are used to support easy and reliable selection of the right cutting tool and starting values for machining conditions in particular applications.
Dormer Pramet classifies workpiece materials into six different coloured groups;

- **Blue**: Steel and cast steel (P-group)
- **Yellow**: Stainless steel (M-group)
- **Red**: Cast iron (K-group)
- **Green**: Non-ferrous metals (N-group)
- **Brown**: High-temperature alloys (S-group)
- **Grey**: Hardened materials (H-group)

Each of these are divided into subgroups on the basis of their structure and/or composition. For example, P-group steel and cast steel is split into four subgroups, namely;

- **P1** – Free machining steel
- **P2** – Plain carbon steel
- **P3** – Alloy steel
- **P4** – Tool steel

A final division includes material properties, such as hardness and ultimate tensile strength. This is to provide our customers with a complete tool recommendation, including starting values for cutting speed and feed.
The table on the next page includes a description of each workpiece material group, as well as examples of commonly used designations.

| ISO group | | Subgroup | | WMG (Work Material Group) | | $k_{vg}$ | Examples of material (AISI, EN, DIN, ČSN, GB, SS, STN, BS, UNE, AFNOR, ASTM, GOST, UNS, UNI, ...) |
|---|---|---|---|---|---|---|---|
| P | **Steel and cast steel** (steels with alloy content ≤ 10 % and a hardness of < 45 HRC) | P1 | Free machining steel (carbon steels with increased machinability) | P1.1 | Free machining sulfurized carbon steel with a hardness of < 240 HB | 1.33 | AISI **1108,** EN **15S22,** DIN **1.0723,** SS **1922,** ČSN **11120,** BS **210A15,** UNE **F.210F,** GB **Y15,** AFNOR **10F1,** GOST **A30,** UNI **CF10S20** |
| | | | | P1.2 | Free machining sulfurized and phosphorized carbon steel with a hardness of < 180 HB | 1.49 | AISI **1211,** EN **11SMn30,** DIN **1.0715,** SS **1912,** ČSN **11109,** BS **230M7,** UNE **F.2111,** GB **Y15,** AFNOR **S250,** GOST **A40G,** UNI **CF9SMn28** |
| | | | | P1.3 | Free machining sulfurized/phosphorized and leaded carbon steel with a hardness of < 180 HB | 1.53 | AISI **12L13,** EN **11SMnPb30,** DIN **1.0718,** SS **1914,** ČSN **12110,** BS **210M16,** UNE **F.2114,** GB **Y15Pb,** AFNOR **S250Pb,** GOST **AS35G2,** UNI **CF10SPb20** |
| | | P2 | Plain carbon steel (steels comprised of mainly iron and carbon) | P2.1 | Plain low carbon steel containing < 0.25 % C with a hardness of < 180 HB | 1.14 | AISI **1015,** EN **C15,** DIN **1.0401,** SS **1350,** ČSN **11301 ,** BS **080A15,** UNE **F.111,** GB **15,** AFNOR **C18RR,** GOST **St2ps,** UNI **Fe360** |
| | | | | P2.2 | Plain medium carbon steel containing < 0.55 %C with a hardness of < 240 HB | 1.00 | AISI **1030,** EN **C30,** DIN **1.0528,** SS **1550,** ČSN **12031,** BS **080M32,** UNE **F.1130,** GB **30,** AFNOR **AF50C30,** GOST **30G,** UNI **Fe590** |
| | | | | P2.3 | Plain high carbon steel containing > 0.55 % C, with a hardness of < 300 HB | 0.89 | AISI **1060,** EN **C60,** DIN **1.0601,** SS **1655,** ČSN **12061,** BS **080A62,** UNE **F513,** GB **60,** AFNOR **1C60,** GOST **60G,** UNI **C60** |
| | | P3 | Alloy steel (carbon steels with an alloying content ≤ 10 %) | P3.1 | Alloy steel with a hardness of < 180 HB | 0.92 | AISI **5015,** EN **16Mo3,** DIN **1.5415,** SS **2912,** ČSN **15020,** BS **1501-240,** UNE **F.2601,** GB **16Mo,** AFNOR **15D3,** GOST **15M,** UNI **16Mo3KW** |
| | | | | P3.2 | Alloy steel with a hardness of 180 – 260 HB | 0.74 | AISI **4140,** EN **42CrMo4,** DIN **1.7225,** SS **2244,** ČSN **15142,** BS **708M40,** UNE **F.8232,** GB **42CrMo,** AFNOR **42CD4,** GOST **40ChFA,** UNI **42CrMo4** |
| | | | | P3.3 | Alloy steel with a hardness of 260 – 360 HB | 0.63 | AISI **4140,** EN **42CrMo4,** DIN **1.7225,** SS **2244,** ČSN **15142,** BS **708M40,** UNE **F.8232,** GB **42CrMo,** AFNOR **42CD4,** GOST **40ChFA,** UNI **42CrMo4** |
| | | P4 | Tool steel (special alloy steel for tools, dies and molds) | P4.1 | Tool steel with a hardness of < 26 HRC | 0.55 | AISI **D2,** EN **X155CrVMo12-1,** DIN **1.2370,** SS **2736,** ČSN **19573,** BS **BD2,** UNE **F.520A,** GB **Cr12Mo1V1,** AFNOR **Z160CDV12,** GOST **Ch12MF,** UNI **X155CrVMo121KU** |
| | | | | P4.2 | Tool steel with a hardness of 26 – 39 HRC | 0.47 | AISI **D2,** EN **X155CrVMo12-1,** DIN **1.2370,** SS **2736,** ČSN **19573,** BS **BD2,** UNE **F.520A,** GB **Cr12Mo1V1,** AFNOR **Z160CDV12,** GOST **Ch12MF,** UNI **X155CrVMo121KU** |
| | | | | P4.3 | Tool steel with a hardness of 39 – 45 HRC | 0.38 | AISI **D2,** EN **X155CrVMo12-1,** DIN **1.2370,** SS **2736,** ČSN **19573,** BS **BD2,** UNE **F.520A,** GB **Cr12Mo1V1,** AFNOR **Z160CDV12,** GOST **Ch12MF,** UNI **X155CrVMo121KU** |

| ISO group | | Subgroup | | WMG (Work Material Group) | | $k_{vG}$ | Examples of material (AISI, EN, DIN, ČSN, GB, SS, STN, BS, UNE, AFNOR, ASTM, GOST, UNS, UNI, ...) |
|---|---|---|---|---|---|---|---|
| **M** | **Stainless steel** (corrosion resistant steels with ≥ 11 % chromium content) | **M1** | Ferritic stainless steel (straight chromium non-hardenable alloys) | **M1.1** | Stainless steel, ferritic with a hardness of < 160 HB | **1.22** | AISI **S429,** EN **X7Cr14,** DIN **1.4001,** SS **2326,** BS **434S17,** UNE **F.3401,** AFNOR **Z8C12,** GOST **08Ch13,** UNI **X6CrTi12** |
| | | | | **M1.2** | Stainless steel, ferritic with a hardness of 160 – 220 HB | **1.03** | AISI **446,** EN **X10CrAl24,** DIN **1.4762,** SS **2322,** ČSN **17113,** BS **430S17,** UNE **F.3154,** GB **10Cr17,** AFNOR **Z10CAS24,** GOST **12Ch17,** UNI **X16Cr26** |
| | | **M2** | Martensitic stainless steel (straight chromium hardenable alloys) | **M2.1** | Stainless steel, martensitic with a hardness of < 200 HB | **1.08** | AISI **430F,** EN **X14CrMoS17,** DIN **1.4104,** SS **2383,** ČSN **17140,** BS **410S21,** UNE **F.3117,** AFNOR **Z10CF17,** UNI **X10CrS17** |
| | | | | **M2.2** | Stainless steel, martensitic with a hardness of 200 – 280 HB | **0.89** | AISI **440C,** EN **X105CrMo17,** DIN **1.4125,** SS **2385,** ČSN **17023,** BS **425C11,** UNE **F.3402,** GB **102Cr17Mo,** AFNOR **Z100CD17,** GOST **95Ch18,** UNI **GX6CrNi 13 04** |
| | | | | **M2.3** | Stainless steel, martensitic with a hardness of 280 – 380 HB | **0.75** | AISI **420,** EN **X45Cr13,** DIN **1.4034,** ČSN **17029,** BS **425C11,** UNE **F.3405,** AFNOR **Z44C14,** GOST **20X17H12,** UNI **X30Cr13** |
| | | **M3** | Austenitic stainless steel (chromium-nickel and chromium-nickel-manganese alloys) | **M3.1** | Stainless steel, austenitic with a hardness of < 200 HB | **1.00** | AISI **304,** EN **X5CrNi18-12,** DIN **1.4303,** SS **2352,** ČSN **17249,** BS **305S17,** UNE **F.3513,** GB **10Cr18Ni12,** AFNOR **Z8CN18.12,** UNI **X7CrNi18 10** |
| | | | | **M3.2** | Stainless steel, austenitic with a hardness of 200 – 260 HB | **0.86** | AISI **309,** EN **X15CrNiSi20-12,** DIN **1.4828,** ČSN **17251,** BS **309S24,** UNE **F.3312,** GB **1Cr23Ni13,** AFNOR **Z15CNS20.12,** GOST **20Ch20N14S2,** UNI **16CrNi23 14** |
| | | | | **M3.3** | Stainless steel, austenitic with a hardness of 260 – 300 HB | **0.77** | AISI **5848,** EN **X45CrNiW18-9,** DIN **1.4873,** BS **331S40,** UNE **F.3211,** AFNOR **Z35CNWS14-4,** UNI **X45CrNiW 18 9** |
| | | **M4** | Super-austenitic, Duplex or Precipitation Hardening stainless steel (austenitic alloys with > 20 % Ni, austenitic-ferritic microstructure or precipitation hardened) | **M4.1** | Stainless steel, austenitic-ferritic or super-austenitic with a hardness of < 300 HB | **0.75** | AISI **329,** EN **X1-NiCrMoCU25-20-5,** DIN **1.4539,** SS **2562,** ČSN **17265,** BS **318S13,** UNE **F.3552,** GB **022Cr25NiMo2N,** AFNOR **Z1NCDU25.20** |
| | | | | **M4.2** | Stainless steel, precipitation hardening austenitic with a hardness of 300 – 380 HB | **0.64** | AISI **631 (17-7PH),** EN **X7CrNiAL17-7,** DIN **1.4568,** SS **2388,** ČSN **17465 ,** BS **301S13,** UNE **F.3217,** GB **07Cr17Ni7Al,** AFNOR **29CNA17-07,** GOST **09Ch17N7Ju1,** UNI **X53CrMnNiN21 9** |

| ISO group | | Subgroup | | WMG (Work Material Group) | | $k_{vG}$ | Examples of material (AISI, EN, DIN, ČSN, GB, SS, STN, BS, UNE, AFNOR, ASTM, GOST, UNS, UNI, ...) |
|---|---|---|---|---|---|---|---|
| **K** | **Cast Iron** (castings of iron and carbon alloys with > 2 % carbon content) | **K1** | Gray iron (GG) (iron-carbon castings with a lamellar graphite microstructure) | **K1.1** | Gray iron, ferritic or ferritic-pearlitic with a hardness of < 180 HB | **1.35** | ASTM **A48 Grade 20 (F11401),** EN-**JL-100,** DIN **GG-10 (0.6010),** SS **0110,** STN **422410,** BS **Grade 150,** UNE **FG10,** GB **HAT 100,** AFNOR **Ft10D,** GOST **SC 10,** UNI **G10** |
| | | | | **K1.2** | Gray iron, ferritic-pearlitic or pearlitic with a hardness of 180 – 240 HB | **1.00** | ASTM **A48 Grade 30 (F12101),** EN-**JL-1030,** DIN **GG-20 (0.6020),** SS **0120,** STN **422420,** BS **Grade 220,** UNE **FG20,** GB **HT200,** AFNOR **Ft20D,** GOST **СЧ20,** UNI **G20** |
| | | | | **K1.3** | Gray iron, pearlitic with a hardness of 240 – 280 HB | **0.75** | ASTM **A48 Grade 50 (F13501),** EN-**JL-1060,** DIN **GG-35 (0.6035),** SS **0135,** STN **422435,** BS **Grade 350,** UNE **FG35,** GB **HAT300,** AFNOR **Ft35D,** GOST **SC35,** UNI **G35** |
| | | **K2** | Malleable iron (GTS/GTW) (heat-treated iron-carbon castings with a graphite-free microstructure) | **K2.1** | Malleable iron, ferritic with a hardness of < 160 HB | **1.39** | ASTM **A602 Grade M3210 (F20000),** EN-**JM-1130,** DIN **GTS-35 (0.8135),** SS **0815,** BS **B340/12,** UNE **Type A,** AFNOR **MN 35-10,** GOST **КЧ35-10** |
| | | | | **K2.2** | Malleable iron, ferritic or pearlitic with a hardness of 160 – 200 HB | **1.13** | ASTM **A602 Grade M4504 (F20001),** EN-**JM-1040,** DIN **GTS-50-05 (0.8045),** BS **P50-05,** AFNOR **MB 45-7** |
| | | | | **K2.3** | Malleable iron, pearlitic with a hardness of 200 – 240 HB | **0.90** | ASTM **A602 Grade M7002 (F20004),** EN-**JM-1140,** DIN **GTS-45 (0.8145),** SS **0854,** STN **422540,** BS **P 45-06,** UNE **Typ B,** AFNOR **MP 50-5,** GOST **КЧ45-7,** UNI **GMN 45** |
| | | **K3** | Ductile iron (GGG) (iron-carbon castings with a nodular graphite microsturcture) | **K3.1** | Ductile (nodular/spheriodal) iron, ferritic with a hardness of < 180 HB | **1.23** | ASTM **A536 Grade 60-40-18 (F32800),** EN-**JS-1030,** DIN **GGG-40 (0.7040),** SS **0717,** STN **422304,** BS **420/12,** UNE **FGE 42-12,** GB **QT 400,** AFNOR **FGS 400-12,** GOST **ВЧ40** |
| | | | | **K3.2** | Ductile (nodular/spheriodal) iron, ferritic or pearlitic with a hardness of 180 – 220 HB | **0.94** | ASTM **A536 Grade 80-55-06 (F33800),** EN-**JS-1050,** DIN **GGG-50 (0.7050),** SS **0727,** STN **422305,** BS **500/7,** UNE **FGE 50-7,** GB **QT 500-7,** AFNOR **FGS 500-7,** GOST **ВЧ50** |
| | | | | **K3.3** | Ductile (nodular/spheriodal) iron, pearlitic with a hardness of 220 – 260 HB | **0.76** | ASTM **A536 Grade 100-70-03 (F34800),** EN-**JS-1060,** DIN **GGG-60 (0.7060),** SS **0732,** STN **422306,** BS **600/3,** UNE **FG70-2,** GB **QT 600-3,** AFNOR **FGS 600-3,** GOST **ВЧ60** |
| | | **K4** | Austenitic or austempered ductile iron (Ni-Resist/ADI) (iron-carbon alloy castings with an austenitic or ausferrite microstructure) | **K4.1** | Austenitic cast iron with a hardness of < 180 HB | **1.14** | ASTM **A436 Type 1 (L-NiCuCr 15 6 2, F41000),** EN-**JL-3011,** DIN **GGL-NiMn 13 7 (0.6652),** SS **0523,** BS **Grade F1,** AFNOR **FGL-Ni13Mn7,** GOST **S-NiMn 13 7** |
| | | | | **K4.2** | Austenitic cast iron with a hardness of 180 – 240 HB | **0.86** | ASTM **A439 Type D-2B (S-NiCr 20 3, F43001),** EN-**JS-3021,** DIN **GGG-NiMn 23 4,** SS **0776,** BS **Grade S2M,** AFNOR **FGS Ni23 Mn4,** GOST **ЧН19Х3Ш** |
| | | | | **K4.3** | Austempered ductile iron with a hardness of 240 – 280 HB | **0.63** | ASTM **A897 Grade 110-70-11** |
| | | | | **K4.4** | Austempered ductile iron with a hardness of 280 – 320 HB | **0.54** | ASTM **A897 Grade 125-80-10,** EN-**JS-1100,** DIN **GGG-90 (5.3400)** |
| | | | | **K4.5** | Austempered ductile iron with a hardness of 320 – 360 HB | **0.45** | ASTM **A897 Grade 2 (150-110-07),** EN-**JS-1110,** DIN **GGG-100 (5.3403)** |
| | | **K5** | Compacted graphite iron (CGI) (iron-carbon castings with a vermicular graphite structure) | **K5.1** | Vermicular, compacted graphite iron with a hardness of < 180 HB | **1.29** | ASTM **A842 Grade 300,** EN-**GJV-300,** DIN **GGV 30,** GOST **ЧВГ30,** |
| | | | | **K5.2** | Vermicular, compacted graphite iron with a hardness of 180 – 220 HB | **0.97** | ASTM **A842 Grade 350,** EN-**GJV-350,** DIN **GGV 35 (5.2200),** GOST **ЧВГ30,** |
| | | | | **K5.3** | Vermicular, compacted graphite iron with a hardness of 220 – 260 HB | **0.75** | ASTM **A842 Grade 450,** EN-**GJV-450,** DIN **GGV 45,** GOST **ЧВГ45,** |

| ISO group | | Subgroup | | WMG (Work Material Group) | | $k_{vG}$ | Examples of material (AISI, EN, DIN, ČSN, GB, SS, STN, BS, UNE, AFNOR, ASTM, GOST, UNS, UNI, ...) |
|---|---|---|---|---|---|---|---|
| N | Non-ferrous metals (metals including alloys without an appreciable amount of iron) | N1 | Wrought aluminium | N1.1 | Pure aluminium and wrought aluminium alloys with a hardness of < 60 HB | 1.33 | UNS **A91200,** EN **AL99.6,** DIN **3.0205,** SS **4010,** STN **424009,** BS **1C,** UNE **L-3001,** GB **L5,** AFNOR **A4,** GOST **АДС,** UNI **3567** |
| | | | | N1.2 | Wrought aluminium alloys with a hardness of 60 – 100 HB | 1.00 | UNS **A93004,** EN **AlMn0.5Mg0.5,** DIN **3.0505,** SS **4054,** STN **424432,** BS **N31,** UNE **L-3831,** GB **LF2,** AFNOR **A-M1,** GOST **АМц,** UNI **3568** |
| | | | | N1.3 | Wrought aluminium alloys with a hardness of 100 – 150 HB | 0.67 | UNS **A95083,** EN **AlMg4.5Mn0.7,** DIN **3.3547,** SS **4140,** STN **424415,** BS **N8,** UNE **L-3321,** GB **AlMg4.5Mn,** AFNOR **A-G4.5Mn,** GOST **Amg 4.5,** UNI **P-AlMg4.4** |
| | | N2 | Cast aluminium | N2.1 | Cast aluminium alloys with a hardness of < 75 HB | 0.67 | UNS **A02080,** EN **AlCu4S,** BS **LM11,** STN **424331,** UNE **Al Si1Cu,** GOST **АМg5К,** UNI **G-AlSi7Mg** |
| | | | | N2.2 | Cast aluminium alloys with a hardness of 75 – 90 HB | 0.60 | UNS **A02420,** EN **AlCu4Ni2Mg2,** SS **AlSi7MgFe,** BS **LM6,** STN **424519,** UNE **Al-7SiMg,** AFNOR **A-S7G,** GOST **АК7,** UNI **G-AlSi7Mg** |
| | | | | N2.3 | Cast aluminium alloys with a hardness of 90 < 140 HB | 0.43 | UNS **A03360,** EN **G-ALCu4NiMg2,** SS **ALSi10Mg,** STN **424336,** BS **LM 30,** AFNOR **A-S10G,** UNI **G-AlSi9Mg** |
| | | N3 | Copper or copper alloys | N3.1 | Free-cutting copper-alloys materials with excellent machining properties | 0.70 | UNS **C14700,** EN **CuPb1P,** DIN **2.1498,** STN **423214,** BS **C111,** AFNOR **CuZn35Pb2,** GOST **L63-3,** UNI **CuS(P0.01)** |
| | | | | N3.2 | Short-chip copper-alloys with good to moderate machining properties | 0.41 | UNS **C81540,** EN **CuNi2SiCr,** DIN **2.0857,** STN **423220,** BS **NS113,** UNE **CuSn12,** AFNOR **CuZn40,** GOST **L60,** UNI **P-CuZn-40** |
| | | | | N3.3 | Electrolytic copper and long-chip copper-alloys with moderate to poor machining properties | 0.21 | UNS **C10100,** EN **CuAg0.1,** DIN **2.1203,** SS **5010,** UNE **CUSi3Mn1,** AFNOR **Cu-C2,** GOST **М1f,** UNI **Cu-OF** |
| | | N4 | Polymers (synthetic or semi-synthetic materials) | N4.1 | Thermoplastic polymers | 0.70 | ABS, Acryl, Duraplast, Elastomer, EP, Epoxid, FEP, Fluor, Gummi, Kautschuk, Latex, MF, MPF, PA, PAI, PC, PE, PEEK, PEI, PES, PET, PF, Phenolharze, PI, PMMA, Polyamide, Polyester, Polyolefine, Polysulfon, POM, PP, PPE, PPS, PS, PSU, PTFE, PU, PUR, PVDF, SAN, SI, Styrol, UF, Ureol |
| | | | | N4.2 | Thermosetting polymers | 0.27 | Aramid, Epoxy, Fluoropolymer, Mehacrylate, Melamine, Phenolic, Polyester, Polyimide, Polymethacrylimide, Polyurethane |
| | | | | N4.3 | Reinforced polymers or composites | 0.29 | CFK, GFK, GMT, Honeycomb, Kevlar, LFT, Organo, SMC |
| | | N5 | Graphite | N5.1 | | 1.0 | CGM-1, CM-00, GM-10, GM-11, GR030, GR030PI, GR060, GR060PI, GR125, MC-01, MC-01RO, MC-03, MC-03M, IG11, IG-15, IG-32, IG-43, IG-45, IG-70, ISEM-1, ISEM-2, ISEM-3, R8340, R8500X, Technograph 15, Technograph 30, ISO-63, EDM C-3, EDM1, EDM3, ISO-90, ISO-93, ISO-95, R8510, R8650, |

| ISO group | | Subgroup | | WMG (Work Material Group) | | $k_{vG}$ | Examples of material (AISI, EN, DIN, ČSN, GB, SS, STN, BS, UNE, AFNOR, ASTM, GOST, UNS, UNI, ...) |
|---|---|---|---|---|---|---|---|
| S | **High-temperature alloys** (superalloys with high temperature stength and corrosion resistant surpassing that of stainless steel) | **S1** | Titanium or titanium alloys | **S1.1** | Titanium or titanium alloys, with a hardness of <200 HB | 1.94 | UNS **R50250 (Grade 1),** EN **Ti 99.6,** DIN **3.7035,** BS **TA.2,** UNE **Ti-Po2,** AFNOR **T-40,** GOST **BT1-00,** AISI **R50250, 3.7025, T35, 2TA1, R50400, 3.7035, 2TA2,** |
| | | | | **S1.2** | Titanium alloys, with a hardness of 200 – 280 HB | 1.72 | UNS **R56404 (Grade 29),** EN **Ti2Cu,** DIN **3.7124,** BS **TA.21,** UNE **Ti-P11,** AFNOR **T-U2 ,** AISI **TA6V, Ti-6Al-4V, Ti 10.2.3, Ti5553** |
| | | | | **S1.3** | Titanium alloys, a hardness of 280 – 360 HB | 1.44 | UNS **R54250 (Grade 38),** EN **TiAl6V4,** DIN **3.7165,** ČSN **TiAl6VELI,** BS **TA. 13,** UNE **Ti-P63,** AFNOR **T-A6V,** GOST **BT6,** AISI **TA6V, Ti-6Al-4V, Ti 10.2.3, Ti5553** |
| | | **S2** | Fe-based high-temperature alloys | **S2.1** | High-temperature Fe-based alloys with a hardness of <200 HB | 1.33 | UNS **N08801 (Incoloy 801),** EN **X8 NiCrAlTi31-21,** DIN **1.4959,** BS **NA 15,** AFNOR **Z8NC33-21,** AISI **A-286, Discaloy, Haynes 556, Iconel 909, Greek Ascolloy** |
| | | | | **S2.2** | High-temperature Fe-based alloys with a hardness of 200 – 280 HB | 1.17 | UNS **N19907,** EN **X6NiCrTiMoVB25-15-2,** DIN **1.4980,** SS **2570,** BS **HR52,** AFNOR **Z6NCTDV25.15B,** GOST **36HXTЮ,** AISI **A-286, Discaloy, Haynes 556, Iconel 909, Greek Ascolloy** |
| | | **S3** | Ni-based high-temperature alloys | **S3.1** | High-temperature Ni-based alloys with a hardness of <280 HB | 1.00 | UNS **A09706 (Inconel 706),** EN **NiCr25FeAl,** DIN **2.4856,** BS **HR 6,** ČSN **Inconel 625,** UNE **F.3313,** GB **1Cr16Ni35,** AFNOR **NC22FeDNB,** GOST **XH38BT,** AISI **Inconel 718, 706 Waspalloy, Udimet 720, Inconel 625** |
| | | | | **S3.2** | High-temperature Ni-based alloys with a hardness of 280 – 360 HB | 0.83 | UNS **N07001,** EN **NiCr20Co13Mo4Ti3Al,** DIN **2.4654,** BS **HR 2,** ČSN **Waspaloy,** AFNOR **NCKD 20ATV,** GOST **XH80TБЮ,** AISI **Inconel 718, 706 Waspalloy, Udimet 720, Inconel 625** |
| | | **S4** | Co-based high-temperature alloys | **S4.1** | High-temperature Co-based alloys with a hardness of <240 HB | 0.78 | UNS **R30016 (Stellite 6b),** EN **CoCr20W15Ni,** DIN **2.4964,** AFNOR **KC 20 WN,** GOST **ЛК52,** AISI **Haynes 25, Stellite 21, 31** |
| | | | | **S4.2** | High-temperature Co-based alloys with a hardness of 240 – 320 HB | 0.67 | UNS **R30016 (Stellite 6b),** EN **CoCr20W15Ni,** DIN **2.4964,** AFNOR **KC 20 WN,** GOST **ЛК52,** AISI **Haynes 25, Stellite 21, 31** |

| ISO group | | Subgroup | | WMG (Work Material Group) | | $k_{vG}$ | Examples of material (AISI, EN, DIN, ČSN, GB, SS, STN, BS, UNE, AFNOR, ASTM, GOST, UNS, UNI, ...) |
|---|---|---|---|---|---|---|---|
| **H** | **Hardened materials** (any engineering metal with a hardness > 45 HRC) | **H1** | Chilled cast iron | **H1.1** | Chilled cast iron with a hardness of < 440 HB | **1.52** | UNS **F45001,** EN-**GJS-1050-6,** DIN **5.3406,** SS **0512,** BS **Grade 2A** |
| | | **H2** | Hardened cast iron | **H2.1** | Hardened cast iron with a hardness < 55 HRC | **0.90** | UNS **F45003,** EN-**GJS-1400-1,** DIN **5.3405,** SS **0457,** BS **Grade 3D** |
| | | | | **H2.2** | Hardened cast iron with a hardness > 55 HRC | **0.77** | UNS **F45003,** EN **G-X260NiCr4-2,** DIN **0.9620,** SS **0466,** BS **Grade S** |
| | | **H3** | Hardened steel < 55 HRC | **H3.1** | Hardened steel with a hardness of < 51 HRC | **1.00** | AISI **4135,** EN **34CrMo4,** DIN **1.7220,** SS **2234,** STN **415131,** BS **198,** UNE **F.1250,** GB **35CrMo,** AFNOR **35CD4,** GOST **АС38ХГМ,** UNI **35CrMo4KB** |
| | | | | **H3.2** | Hardened steel with a hardness of 51 – 55 HRC | **0.82** | AISI **4135,** EN **34CrMo4,** DIN **1.7220,** SS **2234,** STN **415131,** BS **198,** UNE **F.1250,** GB **35CrMo,** AFNOR **35CD4,** GOST **АС38ХГМ,** UNI **35CrMo4KB** |
| | | **H4** | Hardened steel > 55 HRC | **H4.1** | Hardened steel with a hardness of 55 – 59 HRC | **0.64** | UNS **T31501,** EN **100MnCrW4,** DIN **1.2510,** SS **2140,** STN **419413,** BS **BO1,** UNE **F.5220,** GB **9CrWMn,** AFNOR **90MWCrV5,** GOST **9ХВГ,** UNI **95MNWCr5KU** |
| | | | | **H4.2** | Hardened steel with a hardness of > 59 HRC | **0.54** | UNS **T31501,** EN **100MnCrW4,** DIN **1.2510,** SS **2140,** STN **419413,** BS **BO1,** UNE **F.5220,** GB **9CrWMn,** AFNOR **90MWCrV5,** GOST **9ХВГ,** UNI **95MNWCr5KU** |

### Correction factors for specific type of operation $C_{VcO}$

| X.V | FF | | | F | | | M | | | R | | | HR | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $a_p$ | 0.5 | | | 1.5 | | | 2.5 | | | 5.0 | | | 12.0 | | |
| | I | II | III | I | II | III | I | II | III | I | II | III | I | II | III |
| f ⇨ | 0.05 | 0.08 | 0.10 | 0.10 | 0.15 | 0.20 | 0.20 | 0.30 | 0.40 | 0.40 | 0.60 | 0.80 | 0.80 | 1.00 | 1.30 |
| **Chip-breakers for fine finishing** (FF, FF2…) | 1.15 | 1.00 | 0.95 | 0.85 | 0.80 | – | – | – | – | – | – | – | – | – | – |
| **Chip-breakers for finishing** (NF, SF..) | – | – | 1.20 | 1.05 | 1.00 | 1.05 | 1.00 | 0.90 | – | – | – | – | – | – | – |
| **Chip-breakers for medium machining** (FM, M, NM, NMR, SM…) | – | – | – | – | – | 1.15 | 1.10 | 1.00 | 0.95 | 0.85 | – | – | – | – | – |
| **Chip-breakers for roughing** (RM, NRM, NR, R…) | – | – | – | – | – | – | – | – | 1.25 | 1.10 | 1.00 | 0.95 | 0.65 | – | – |
| **Chip-breakers for heavy roughing** (HR, HR2, NR2, OR…) for 45 min durability | – | – | – | – | – | – | – | – | – | 1.25 | 1.20 | 1.15 | 1.05 | 1.00 | 0.95 |

### Correction factors for required durability $C_{VcT}$

| minutes | 10 | 15 | 20 | 30 | 45 | 60 |
|---|---|---|---|---|---|---|
| **General machining operations** (fine finishing up to roughing) | 1.13 | 1.00 | 0.93 | 0.84 | 0.76 | 0.71 |
| **Heavy machining operations** (heavy roughing) | – | – | – | 1.10 | 1.00 | 0.93 |

### Additional correction factors $C_{VcA}$

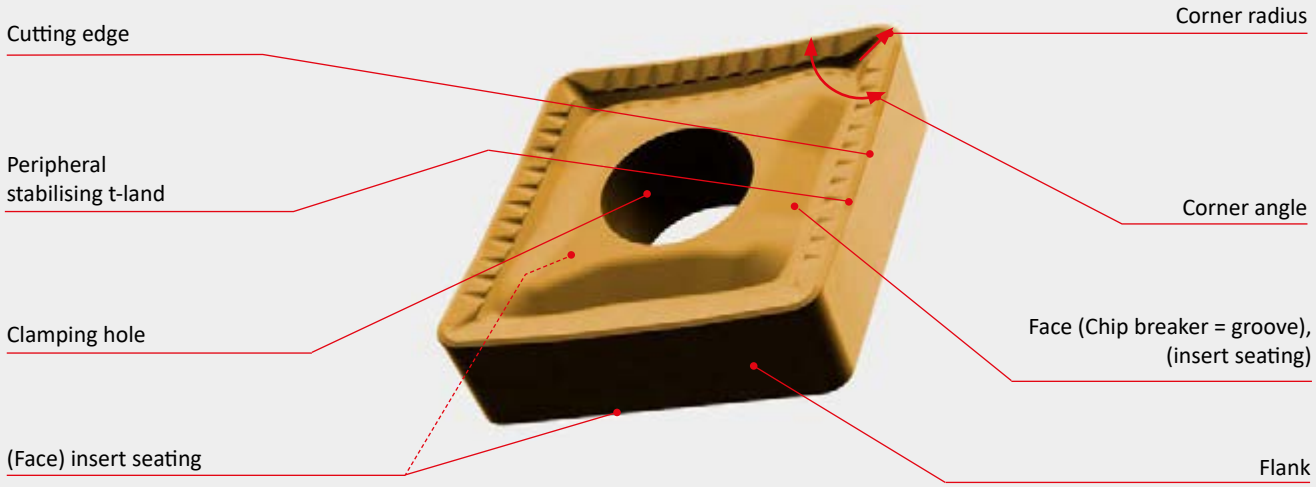
| Machining environment | $C_{VcA}$ |
|---|---|
| **Condition of the work-material** (hard skin due to forging or casting) | 0.70 |
| **Internal turning** | 0.75 |
| **Parting and grooving (radial)** | 0.88 |
| **Face grooving** | 0.80 |
| **Interrupted cut** | 0.80 |
| **Unstable machining conditions** | 0.85 |
| **Common machining conditions** | 1.00 |
| **Stable machining conditions** | 1.20 |

### Resulting corrected cutting speed $v_{cC}$

$$v_{cC} = v_c \cdot k_{vG} \cdot C_{VcO} \cdot C_{VcT} \cdot C_{VcA}$$

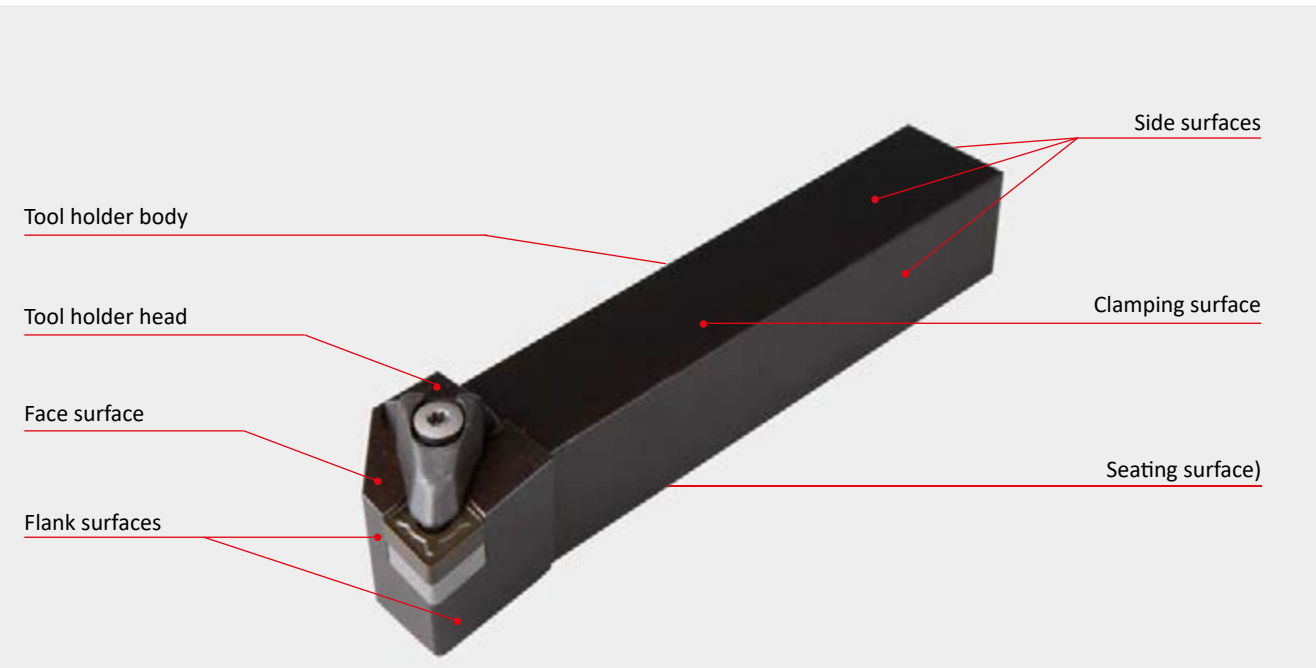
$k_{vG}$ – coefficient of used material
$v_c$ – starting speed from catalogue page

**Insert parts**




**Corner radius** – determines in most cases the recommended minimum depth of cut and, together with the feed, also determines the achieved roughness.
The **Cutting edge** is the intersection of face and flank surfaces. Its longitudinal roughness is one of the first evaluation criteria when assessing an insert.
The **insert corner angle** is very important with regard to the usable cutting edge length, resistance in the interrupted cut, heat dissipation from the cutting point, etc.
The **peripheral stabilising t-land** is an area located after the cutting edge. Its width is very often variable and its angle also changes regularly. In most cases, the width of the t-land, together with the adjustment angle at which the insert works, is a limiting factor for specifying the minimum feed.
The **chip breaker** – together with the t-land determines the application area (narrow grooves – finishing and materials with short chip, wide grooves – mostly roughing operations and tough materials).
The **clamping hole** – if there is no hole, the insert will definitely be designed for the ISO C clamping system. If the hole is cylindrical, the insert is designed for the ISO P, M, D + clamping systems (in nearly all cases the flank angle is 0°. If the hole is trumpet-shaped and the flank angle is positive, the insert is single-sided and is designed for the ISO S clamping system. If the hole is conical and is the same on both sides of the insert, then it is most likely a tangential insert (double-sided).
The **insert seating** – if it is formed by the same relief as the face surface, the insert is double-sided, if it is different, the insert is single-sided. It must be assessed with regard to the planned load or the type of cut. (the size and distance of the radius and the cutting edges).

**Tool holder parts**



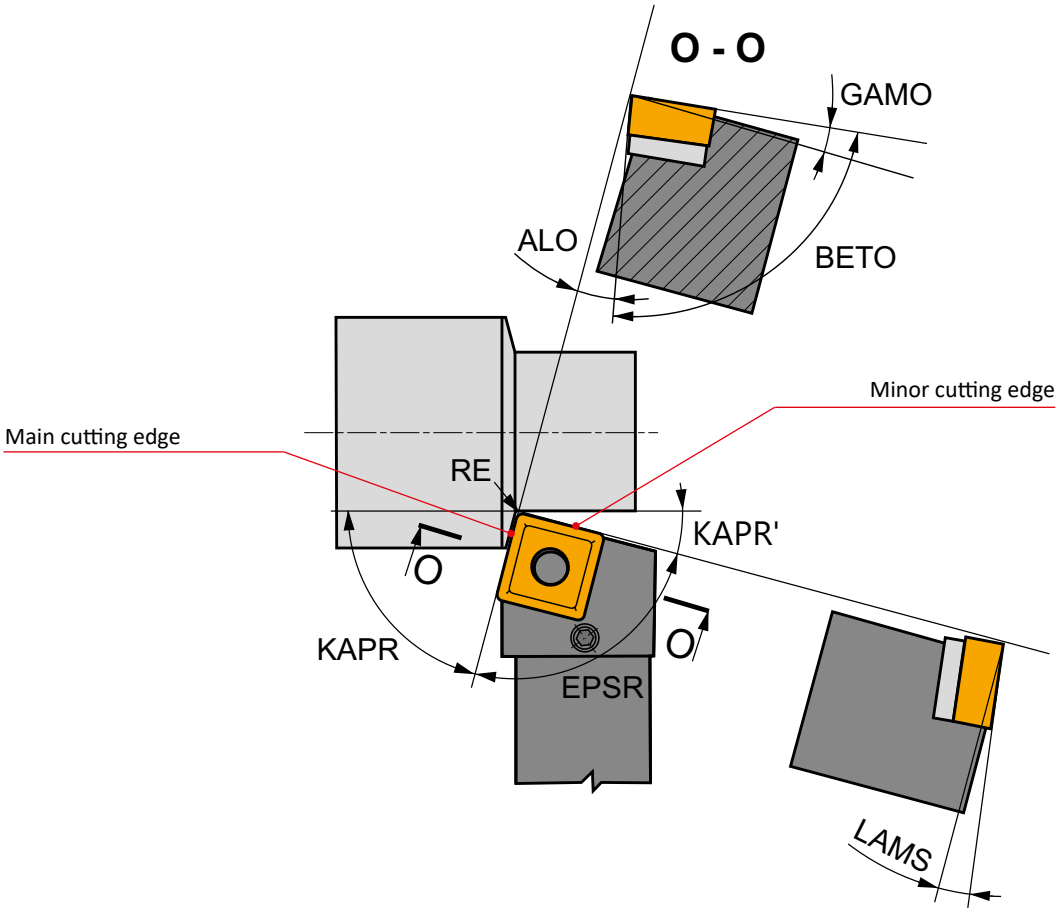
The turning tool consists of two basic parts:
**1) the body consisting of:**
seating surface
clamping surface
side surfaces (which can further be provided with adjusting screws)
**Note:** For external turning, the tool holder body is usually a square cross section (square or rectangle). For internal turning, the cross section of the holder body is circular and, for larger cross sections, it is provided with adjusting surfaces. But the holder body can also be formed by a special type of shank, such as CAPTO (PSC) or HSK

**2) the head with:**
face
flank surfaces
The tool holder head also includes a clamping system into which the inserts are inserted
From the face side (for radial inserts) or from the flank surface side (for tangential inserts)
**Note: the types of heads are:**
straight – allows turning in both directions
side – distinguish between right and left design
bent – distinguish between right and left design (allows better access when turning more complex surfaces)

**Working and construction angles of turning tools**

The position and orientation of the cutting edge in relation to the workpiece and its geometric shape determine the cutting angle characteristics.
The angles on the cutting edge are determined by a two coordinate system:
a) design
b) working

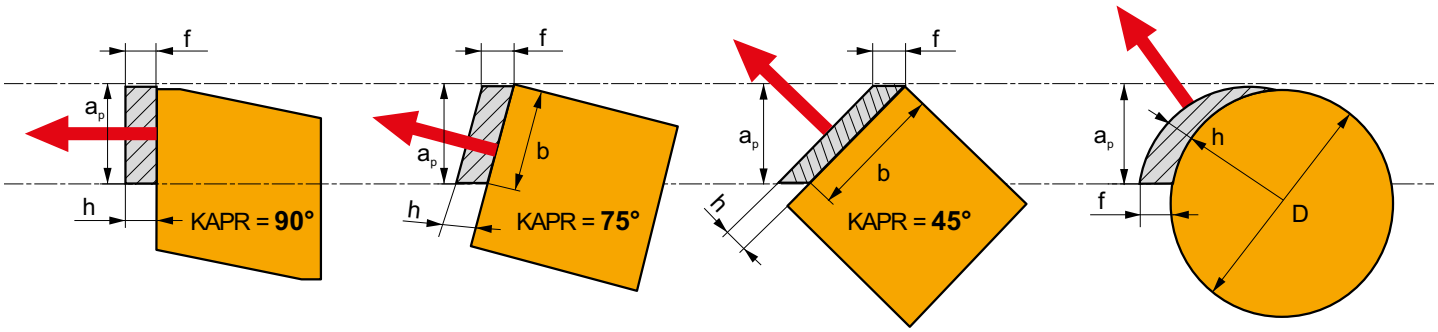
**a) tool coordinate system** (stationary), which is used to determine the cutting edge geometry during design, production and checking. All angles defined in this system are called tool cutting angles. All angles defined by ISO standards according to the insert shape belong in this group.



**b) working coordinate system,** used to determine the cutting edge geometry during the machining process. These angles are called working angles and they depend on the position of the insert clamped into the tool holder. For example, the cutting insert SNUN ..... has a tool clearance angle ***AN*** = 0° and a rake angle ***GAMP*** = 0°, however the insert is clamped in the tool holder to give a working clearance angle ***ALO*** = 6° and a working rake angle ***GAMO*** = -6°. The working angles affect the tool angles with pre-formed chip breakers. However the most important are the working angles for the cutting process.

The basic tool angles are indicated in the picture in the basic tool plane (interlaid by the bearing surface of the tool holder) and in the normal tool plane (interlaid across to cutting edge – cut O-O).
We are concerned with the following angles:
**The rake angle** ***GAMO*** – substantially affects the cutting process. Its size determines the progress and the intensity of plastic deformation during chip forming; it also determines the value of the cutting forces and the thermal stress on the cutting edge. The range of rake angles is wide, from ***GAMO*** = +25° to -15° for cutting tools with indexable cutting inserts for milling and turning. A positive rake angle improves the chip forming conditions, reduces the cutting forces and reduces the cutting temperature level. A negative rake angle improves the strength of the cutting edge, however it increases plastic deformation during chip forming and thereby also the cutting forces and temperatures.

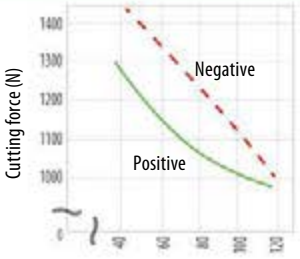
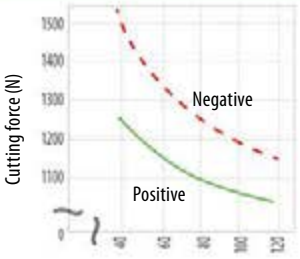
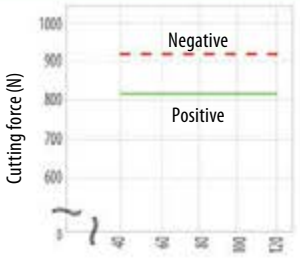
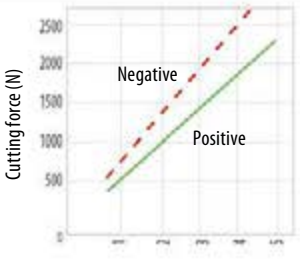
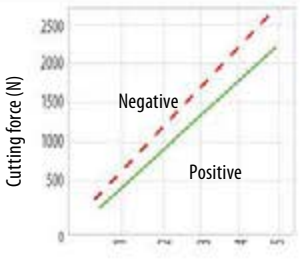
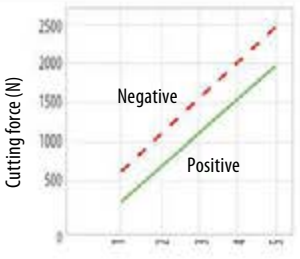
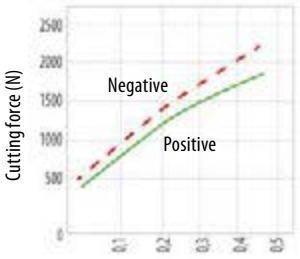
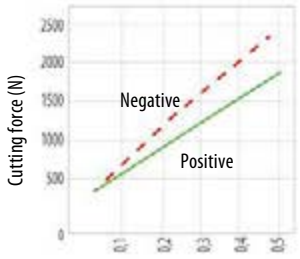
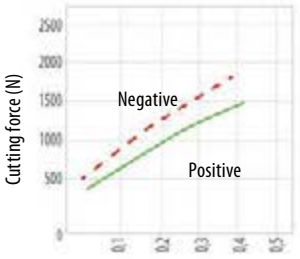
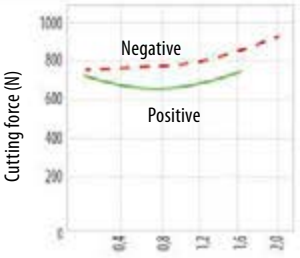
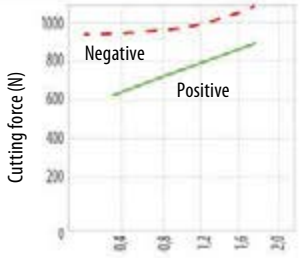
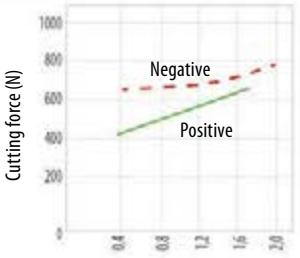
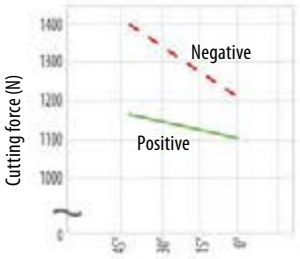
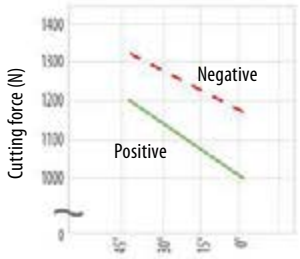
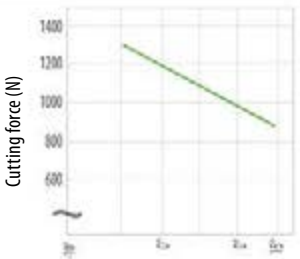
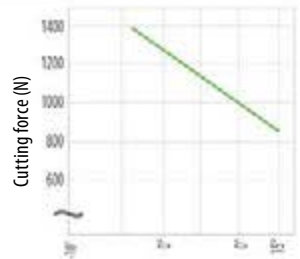
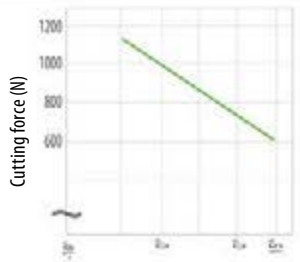
**Clearance angle** ***ALO*** affects the value of friction between the flank and the machined surface. Increasing the clearance angle ***ALO*** reduces this friction and thereby flank wear as well.
**Wedge angle** ***BETO*** is the angle of the cutting insert's wedge. Increasing angle ***BETO*** increases the strength of the cutting edge (resistance against shock), however it also increases the cutting resistance.
**Inclination angle of main cutting edge** ***LAMS*** – determines the point of first contact between the cutting edge and the workpiece, which is important for interrupted cut. If ***LAMS*** is positive, the point of contact is close to the nose of the cutting insert. The negative angle ***LAMS*** moves the point of first contact far from the nose and thereby affects the resistance of the cutting edge against mechanical stress. Furthermore, ***LAMS*** affects the direction of chip evacuation. If ***LAMS*** is negative, the direction of chip evacuation is towards the machined surface. Whereas if ***LAMS*** is positive, the direction of chip evacuation is away from the machined surface.
**Setting angle of main cutting edge** ***KAPR*** has main influence on the values of cutting forces and the cross section shape of the chip. Reducing angle ***KAPR*** makes the chip thinner at a given feed $f$ and depth of cut $a_p$. Whereas if ***KAPR*** = 90° the chip thickness $h = f$ and the chip width $b = a_p$ becomes wider. Regarding the decreasing setting angle the function width of the T-land is increasing and the rake angle of insert is decreasing.
**Setting angle of minor cutting edge** ***KAPR´*** together with corner radius ***RE*** define the final surface quality.




$h = f$ | $h = 0{,}96\ f$ | $h = 0{,}71\ f$ | $h = 0 \div f$

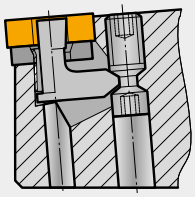
| Parameter | Change | Abrasion of the flank | Crater wear formation | Tendency for plastic deformation | Resistance to adverse working conditions | Surface | Cutting forces | Tendency to vibrate | Medium cutting temperature | Chip formation |
|---|---|---|---|---|---|---|---|---|---|---|
| **Main cutting edge angle** | **Less than or greater than 90°** | Slightly reduced | Slightly reduced | Slightly reduced | Slightly improved | Effect not proven | Slightly increased | Increased | Lower | Chip is thinner and wider (b/h changes) |
| **Minor cutting edge angle** | **Decreased** | Slightly reduced | Effect not proven | Slightly increased | Very slightly improved | Improved (conditional) | Slightly increased | Increased | Very slightly higher | Insignificant effect |
| **Corner angle** | **Increased** | Effect not proven | Effect not proven | Reduced | Improved | Effect not proven | Effect not proven (-) | Slightly increased | Very slightly higher | Insignificant effect |
| **Corner radius** | **Increased** | Reduced (to certain level) | Reduced (to certain level) | Reduced | Improved | Improved (conditional) | Increased (to certain level) | Increased | Slightly higher | Softer formation (mostly – based on the chip breaker) |
| **Flank angle** | **More positive** | Reduced | Effect not proven | Very slightly Reduced | Slightly worse | Improved (conditional) | Slightly reduced | Slightly reduced | Slightly lower | Effect not proven |
| **Face angle** | **More positive** | Very slightly reduced | Reduced | Slightly reduced | Slightly worse | Effect not proven (+) | Slightly reduced | Reduced | Lower | Chip is less compressed, but is forced closer to the cutting edge |
| **Cutting edge angle** | **Positive** | Effect not proven | Slightly reduced | Slightly reduced | Slightly worse | Effect not proven (+) | Slightly reduced | Slightly reduced | Slightly lower | Deflects the chip from the workpiece |
| **T-land width** | **Wider** | Slightly increased | Slightly increased | Slightly increased | Slightly improved | Effect not proven (+) | Increased | Increased | Higher | Chip is more compressed, but presses to a larger surface |
| **T-land angle (working)** | **Positive** | Very slightly reduced | Slightly reduced | Slightly reduced | Slightly worse | Effect not proven (+) | Reduced | Reduced | Slightly lower | Chip is less compressed |

## What affects cutting forces and how?

| Conditions | Carbon steel (HB230) | Stainless steel (HB145) | Grey cast iron (HB130) |
|---|---|---|---|
| **Cutting speed and cutting force**<br>f = 0.2 mm/rev<br>$a_p$ = 2 mm<br>KAPR 90°<br>RE 0.4 |  |  |  |
| **Depth of cut and cutting force**<br>$V_c$ = 100 m/min<br>$a_p$ = 0.2 mm/rev<br>KAPR 90°<br>RE 0.4 |  |  |  |
| **Cutting feed and cutting force**<br>$V_c$ = 100 m/min<br>$a_p$ = 2 mm<br>KAPR 90°<br>RE 0.4 |  |  |  |
| **Corner radius and cutting force**<br>$V_c$ = 100 m/min<br>f = 0.2 mm/rev<br>$a_p$ = 1.2 mm<br>KAPR 90° |  |  |  |
| **Main cutting edge angle**<br>$V_c$ = 100 m/min<br>f = 0.2 mm/rev<br>$a_p$ = 2 mm<br>KAPR 45°, 60°, 75°, 90°<br>(values on the x axis)<br>RE 0.4 |  |  |  |
| **Rake angle and cutting force**<br>$V_c$ = 100 m/min<br>f = 0.2 mm/rev<br>$a_p$ = 2 mm<br>KAPR 90°<br>RE 0.4 |  |  |  |

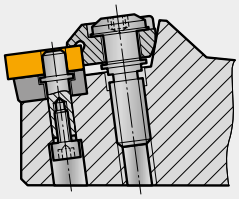
**Tool holder choice with regard to the clamping technique**

The PRAMET TOOLS offer includes tool holders, adjustable holders, turret heads and adjustable holders for external longitudinal, facing, copy turning, and naturally also for internal turning. Tool holders are classified according to the inserts clamping system into six groups that are schematically illustrated in the following passage.



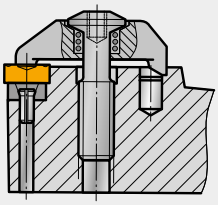
## ISO P

This system serves for the clamping of negative inserts with cylindrical hole, both with chip formers and/or without them. The insert clamping is achieved as a result of an angle lever that after tightening the screw presses the insert down to the holder bed. Tool holders with this clamping system of inserts ensure a reliable and exact clamping of an insert. They perform the best and also the most frequent use at external turning operations, namely both finishing and roughing ones. Alternatively this type of clamping can be also used for holders intended for internal turning of holes with larger diameters.



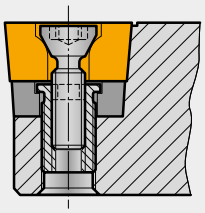
## ISO M

This system is used for the clamping of cutting inserts of the same type as that of the system ISO P. In this case an insert is set onto a strong pin to which it is pressed by a clamp that is also fixing at the same time the top of insert. This clamping system is suitable mainly for holders with supposed enhanced dynamic load. These holders are used almost exclusively for the external turning.



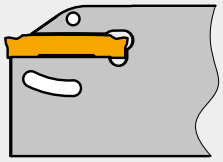
## ISO C

This system serves for the clamping of both negative and positive inserts without holes, namely with both chip formers (pre-pressed, ground and side-pressed ones) and without them. The insert is fixed in the bed of a tool holder by a screw-held clamp, under which there is still embedded a side-pressed chip former at some insert types. Holders with this clamping system are used for both the external and internal surface machining. At present the clamping system C loses its importance. Especially at tools for internal turning it is replaced by the system S with benefit.



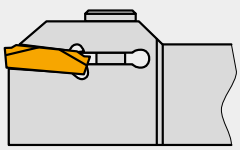
## ISO S

This clamping system is mainly used for small cross-section tools, designed for both external and internal turning (drilling). In this case a special screw, going through an insert cone hole, achieves the clamping. By tightening this screw an insert is fixed in the tool bed. This solution is especially convenient because there is no obstacle for chip flow.



## ISO X

This marking identifies tools with so called special clamping system (i.e. it is different at individual tool manufacturers and suppliers). In our case we have identified under this marking tool holders that use the cutting resistance to clamp an insert into the self-locking bed. This clamping system is used for tools intended for parting and recessing.

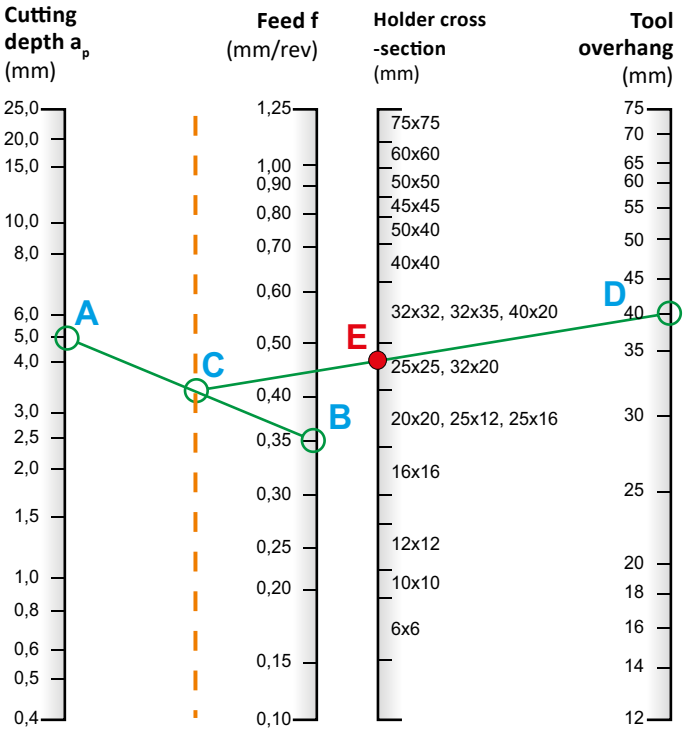


## ISO G

This clamping system is used at tools for recess turning and at tools for copy turning (system CTP). The insert is pushed into the holder bed by a clamp from the top. The contact surface in the holder, in the clamp and also in the insert is shaped in such a way that it hinders the insert displacing by a feeding component of cutting speed.

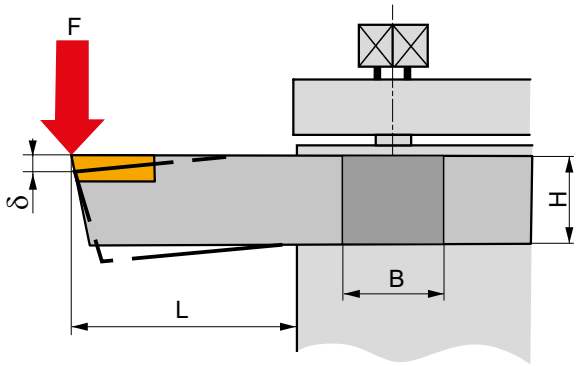
**With reference to square cutting tool**

External cutting tools (square cross section)




Unfortunately, we cannot offer you a similar diagram for choosing the diameter of the inner cutting tool as the situation in internal turning is complicated by the chip. Due to the larger overhang, a holder with the largest possible diameter should be chosen, but if the diameter of the holder is close to the diameter of the hole to be machined, problems can occur with the chip evacuation. It usually gets between the hole wall and the holder body damaging the surface being formed.
In general, if you use tools with a steel body, the overhang should not exceed 4xD, and if you have tools with a carbide or heavy metal body, the maximum overhang should be 6xD. Remember that for both types of tools, the portion for clamping the tool should be at least 3xD.

Use the **maximum possible cross section** with regard to clamping options and process limitations.

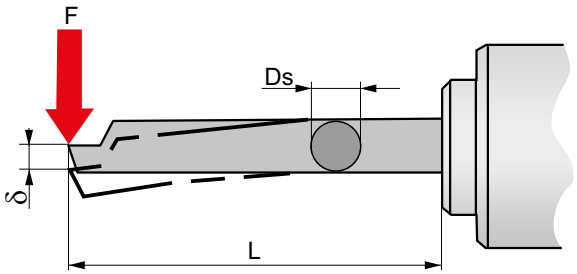



Bending stress

$$\sigma_{(MPa)} = \frac{6 . F . L}{B . H^2}$$

Tool holder deflection

$$\delta_{(mm)} = \frac{4 . F . L^3}{E . B . H^3}$$




Bending stress

$$\sigma_{(MPa)} = \frac{32 . F . L}{\pi . D_s^3}$$

Tool holder deflection

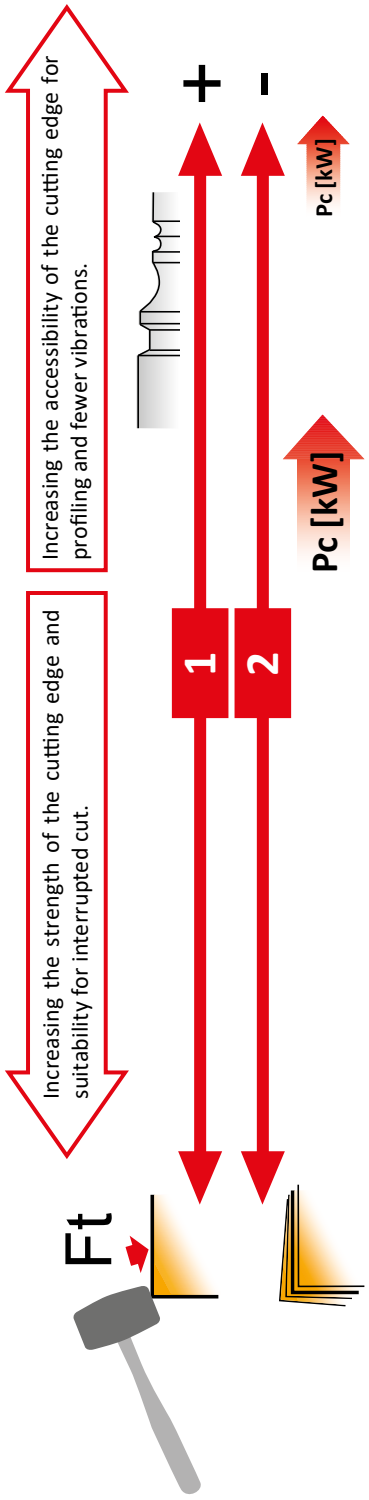
$$\delta_{(mm)} = \frac{64 . F . L^3}{3 . \pi . E . D_s^3}$$

| | |
|---|---|
| σ | Bending stress in the body (MPa) |
| **F** | Cutting force (N) |
| **L** | Tool overhang (mm) |
| **B** | Body width (mm) |
| **H** | Body height (mm) |
| **Ds** | Body diameter (mm) |
| **E** | Body material elastic modulus (MPa) |

| Material | MPa (N/mm²) | (kgf/mm²) |
|---|---|---|
| **Steel** | 210.000 | 21.000 |
| **Sintered carbide** | 560.000 – 620.00 | 56.000 – 62.00 |

**50%** reduction in overhang reduces deflection by **88%.**
**1/3** increase in cross section reduces bending by **68%.**

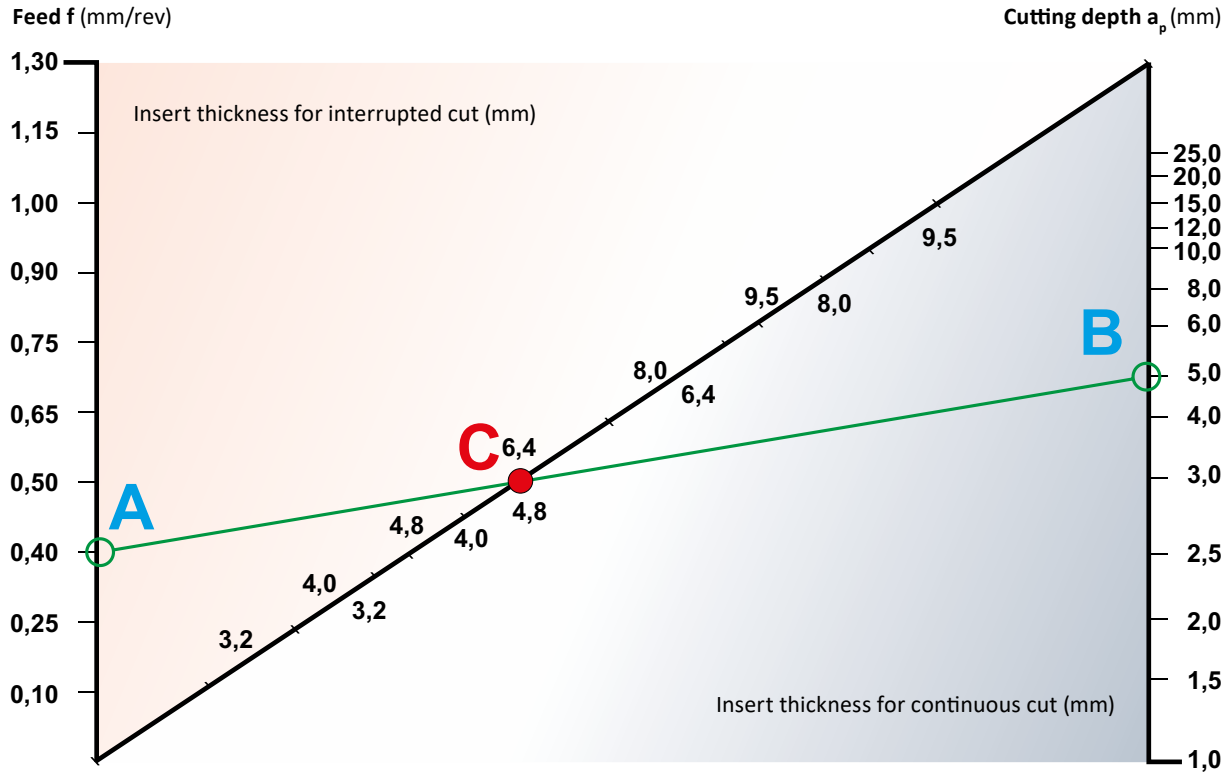
## Choosing the shape and size of the insert




| Priority of choice | Insert shape | | Nose angle | Insert size | | Maximum length of cutting edge Lmax | | | Roughing | Light roughing | Finishing | Profile turning | Face turning | Versatile applications | Tendency to vibrate | Hard material | Interrupted cut |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | ISO | ANSI | | (mm) | (″) | | | | | | | | | |
| | | V | 35° | 11 | 2 | 0.25L | 2.80 | .110″ | | | | | | | | | |
| | | | | 13 | | | 3.30 | .130″ | | | ■ | ■ | | ◪ | ■ | | |
| | | | | 16 | 3 | | 4.20 | .165″ | | | | | | | | | |
| | | D | 55° | 07 | 2 | 0.25L | 2.00 | .078″ | | | | | | | | | |
| | | | | 11 | 3 | | 2.90 | .114″ | | ■ | ■ | ■ | ◪ | ■ | ■ | | |
| | | | | 15 | 4 | | 3.90 | .153″ | | | | | | | | | |
| | | T | 60° | 11 | 2 | 0.33L | 3.60 | .141″ | | | | | | | | | |
| | | | | 16 | 3 | | 5.50 | .216″ | | | | | | | | | |
| | | | | 22 | 4 | | 7.30 | .287″ | ◪ | ■ | ■ | ◪ | ◪ | ◪ | ■ | ◪ | |
| | | | | 27 | 5 | | 9.10 | .358″ | | | | | | | | | |
| | | W | 80° | 06 | 3 | 0.50L | 3.30 | .129″ | ◪ | ■ | ■ | ◪ | ■ | ◪ | ◪ | ◪ | ◪ |
| | | | | 08 | 4 | | 4.40 | .173″ | | | | | | | | | |
| | | C | 80° | 06 | 2 | 0.66L | 4.20 | .165″ | | | | | | | | | |
| | | | | 09 | 3 | | 6.40 | .251″ | | | | | | | | | |
| | | | | 12 | 4 | | 8.50 | .334″ | | | | | | | | | |
| | | | | 16 | 5 | | 10.60 | .417″ | ■ | ■ | ◪ | ◪ | ■ | ■ | ◪ | ■ | ■ |
| | | | | 19 | 6 | | 12.70 | .500″ | | | | | | | | | |
| | | | | 25 | 8 | | 16.50 | .649″ | | | | | | | | | |
| | | S | 90° | 09 | 3 | 0.66L | 6.30 | .248″ | | | | | | | | | |
| | | | | 12 | 4 | | 8.40 | .330″ | | | | | | | | | |
| | | | | 15 | 5 | | 10.40 | .409″ | ■ | ◪ | | | ■ | | | ■ | ■ |
| | | | | 19 | 6 | | 12.60 | .496″ | | | | | | | | | |
| | | | | 25 | 8 | | 16.80 | .661″ | | | | | | | | | |
| | | C | 100° | 12 | 4 | 0.66L | 8.50 | .334″ | | | | | | | | | |
| | | | | 19 | 6 | | 12.70 | .500″ | ■ | | | | ■ | | | ■ | ■ |
| | | | | 25 | 8 | | 16.50 | .649″ | | | | | | | | | |
| | | R | | 06 | | 0.40D | 2.40 | .094″ | | | | | | | | | |
| | | | | 08 | | | 3.20 | .125″ | | | | | | | | | |
| | | | | 10 | | | 4.00 | .157″ | | | | | | | | | |
| | | | | 12 | | | 4.80 | .188″ | | | | | | | | | |
| | | | | 15 | | | 6.00 | .236″ | ■ | | | | ◪ | ◪ | | ■ | ■ |
| | | | | 16 | | | 6.40 | .251″ | | | | | | | | | |
| | | | | 19 | | | 7.60 | .299″ | | | | | | | | | |
| | | | | 20 | | | 8.00 | .315″ | | | | | | | | | |
| | | | | 25 | | | 10.00 | .393″ | | | | | | | | | |
| | | | | 32 | | | 12.80 | .503″ | | | | | | | | | |

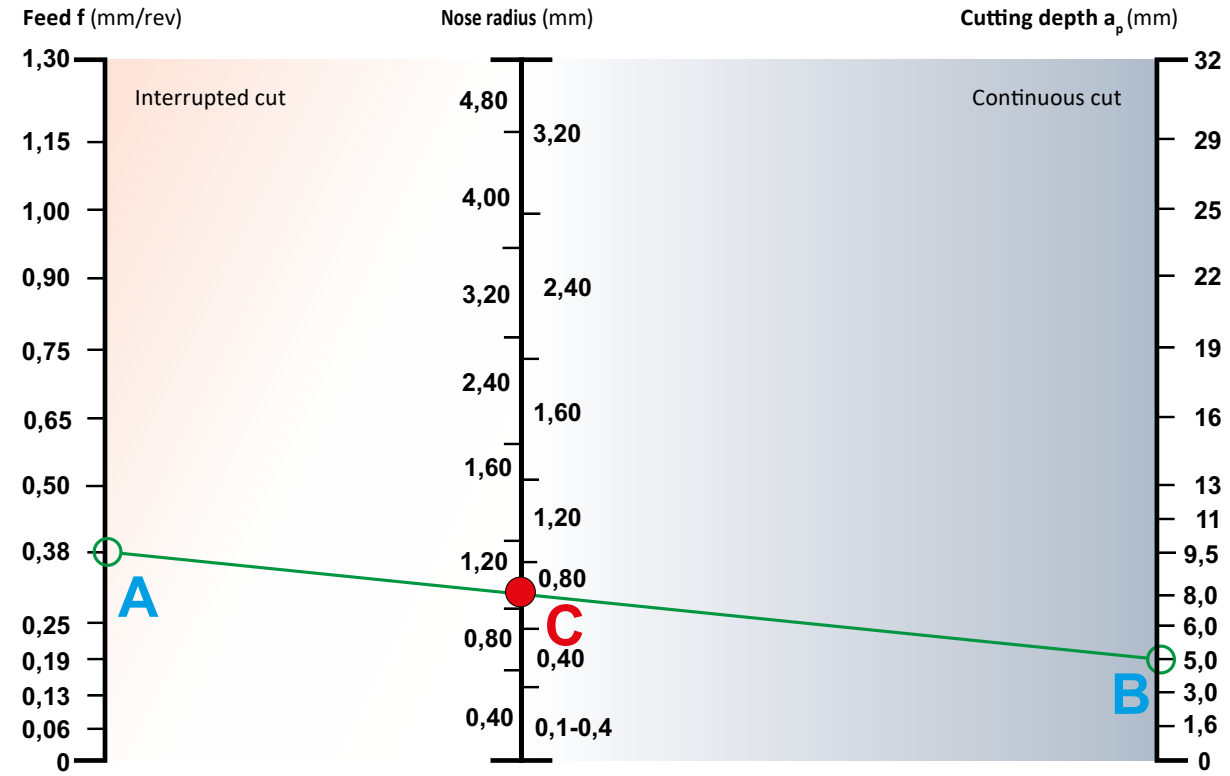
**Choosing the optimum thickness of the insert**

Based on practice, we recommend performing this only for interrupted cut and at a maximum load of inserts.



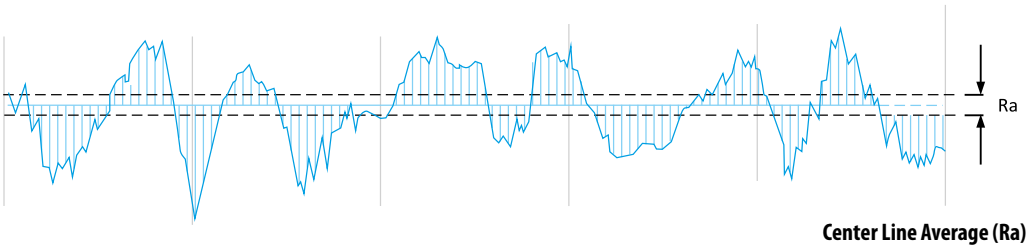

**Choosing the nose radius of the insert**

Based on practice, we recommend performing this only for interrupted cut and at a maximum load of inserts.



The insert radius, together with the feed and the minor cutting edge angle, is one of the main criteria for determining the roughness of the machined surface. Obviously, the properties and type of material being machined, including the cutting environment, have a significant impact.

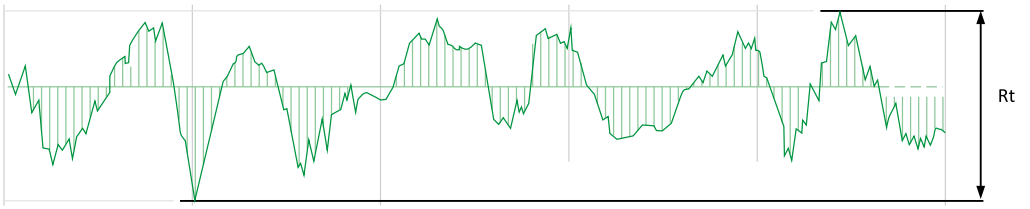
At the beginning of this section, we indicate the main roughness parameters most often specified in engineering practice.




**Center Line Average (Ra)**

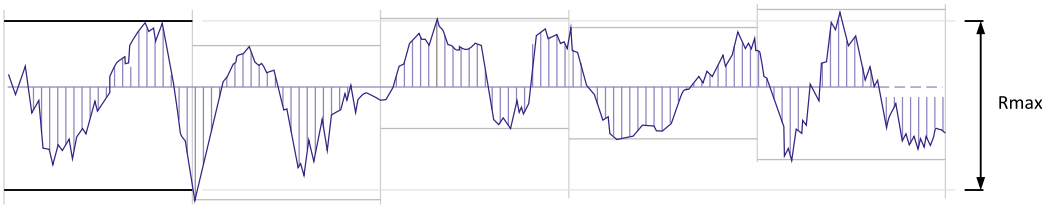
**Ra – Average roughness**
Ra is also known as Arithmetic Average (AA) or Center Line Average (CLA). It is the average roughness in the area between the roughness profile and its mean line. Graphically, Ra is the area between the roughness profile and its center-line divided by the evaluation length. The evaluation length is normally five sample lengths where each sample length is equal to one cut-off length. As shown in the graph.

*Ra is by far the most commonly used Surface Finish parameter and a good starting point for quantifying parts even when there is no parameter callout (surface finish required). However, while common, Ra is not sufficient to completely characterize the roughness of a surface. Depending on the application, surfaces with the same roughness can perform quite differently. Lets look at the same surface roughness analysed in 3 other ways:*



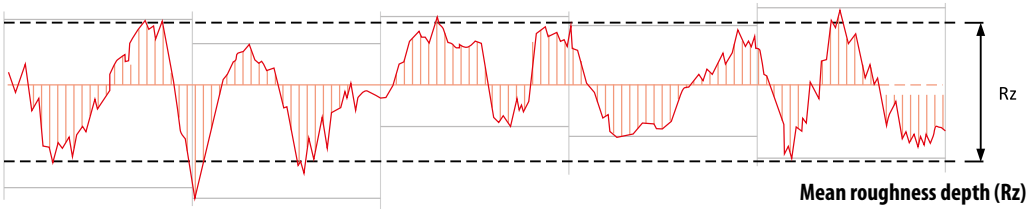

**Total height of the roughness profile (Rt)**

**Rt – Total height of roughness profile**
Difference between height of the highest peak and the depth of the deepest valley within the evaluation length as you can see in the bottom graph.




**Largest single roughness depth (Rmax)**

**Rmax – Maximum distance from highest peak to lowest valley – of the total cut-off length**
Or defining it differently but meaning the same Rmax is the largest single roughness depth measured within one of the sample lengths. Rmax is particularly sensitive to anomalies such as scratches and burrs that may not be obvious from measures such as Ra that rely on averages.




**Mean roughness depth (Rz)**

**Rz – Mean roughness depth**
Rz is often preferred to Ra in Europe and particularly Germany. Instead of measuring from center-line like Ra, Rz measures the average of the 5 largest peak to valley differences within five sampling lengths. While Ra is relatively insensitive to a few extremes, Rz is quite sensitive since it is the extremes it is designed to measure.

**Surface Roughness Grades: "N" Numbers**

The N numbers are common used on technical drawings to described the surface finish roughness. In the past triangles where used but the are not so concrete to explain the correct surface finish.

Relationship with Triangle Symbol

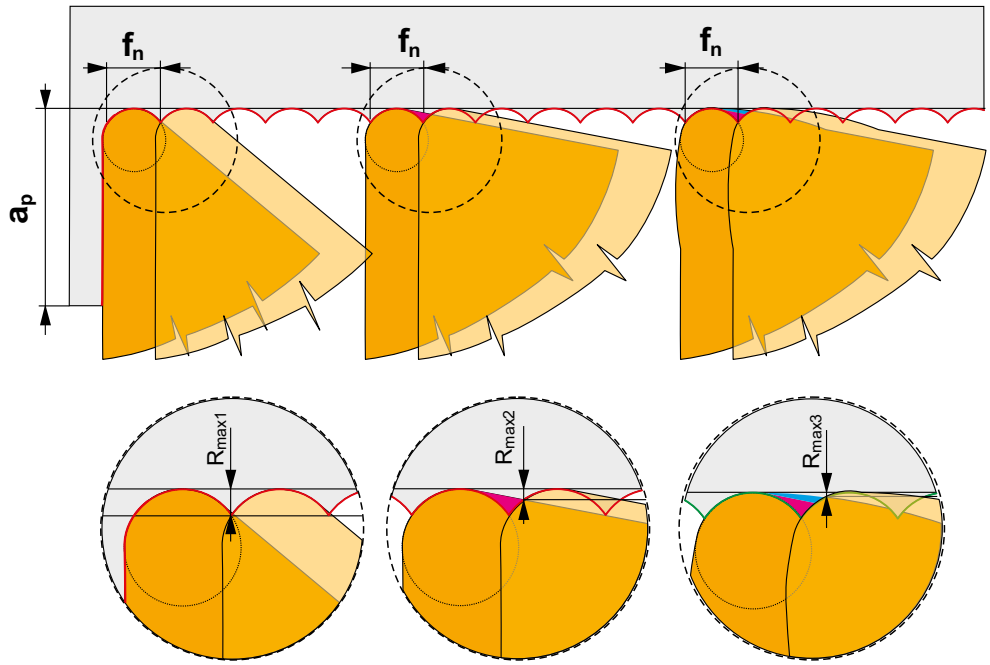
| Arithmetical Mean Roughness Ra (µm) | Max. Height Roughness Rz (µm) | Ten PointsMean Roughness RzJIS (µm) | Roughness Grade | Note: (Relationship with Triangle) |
|---|---|---|---|---|
| 0.025 | 0.1 | 0.1 | N1 | VVVV |
| 0.05 | 0.2 | 0.2 | N2 | |
| 0.1 | 0.4 | 0.4 | N3 | |
| 0.2 | 0.8 | 0.8 | N4 | |
| 0.4 | 1.6 | 1.6 | N5 | VVV |
| 0.8 | 3.2 | 3.2 | N6 | |
| 1.6 | 6.3 | 6.3 | N7 | |
| 3.2 | 12.5 | 12.5 | N8 | VV |
| 6.3 | 25 | 25 | N9 | |
| 12.5 | 50 | 50 | N10 | V |
| 25 | 100 | 100 | N11 | |

**Note**: Finishing symbol (Triangle and wave~) was removed from JIS standard in the 1994 Revision.

In the market you can find some "RugoTest" where the surface finish can be checked visually if there is no electronical equipment available. Be aware that's only a guide and no measurement



Roughness values $R_z$ and $R_a$ specified in the following tables are valid for turning using inserts with larger minor cutting edge angles ***KAPR'***, i.e. inserts of basic shapes **T..., S..., D...., K..., V...** In turning using inserts with shapes **C ..., W ...**, and in particular using inserts with the WIPER geometry – i.e. tools with adjustment angles ***KAPR*** = 90° – 95°, usually lower roughness values $R_a$ are achieved as compared with the data from the table. This is caused by the low value of the minor cutting edge angle ***KAPR'***. In this case rough areas are cut off and theoretical maximum rough areas are reduced to $R_{max3} < R_{max2} < R_{max1}$, as evident from the comparison in picture that follows.



**Overfladekvalitet ved drejning $R_{max}$**

$$R_{max} = \frac{f^2}{8.RE} \cdot 1000$$

| f ⇨ | *RE* Radius | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | 0.1 | 0.2 | 0.4 | 0.5 | 0.8 | 1.0 | 1.2 | 1.5 | 1.6 | 2.0 | 2.4 | 2.5 | 3.0 | 3.2 | 3.5 | 4.0 | 5.0 | 6.0 | 8.0 |
| | Overflade $R_{max}$ (µm) | | | | | | | | | | | | | | | | | | |
| **0.05** | 3.13 | 1.56 | 0.78 | 0.63 | 0.39 | 0.31 | 0.26 | 0.21 | 0.20 | 0.16 | 0.13 | 0.13 | 0.10 | 0.10 | 0.09 | 0.08 | 0.06 | 0.05 | 0.04 |
| **0.07** | 6.1 | 3.06 | 1.53 | 1.23 | 0.77 | 0.61 | 0.51 | 0.41 | 0.38 | 0.31 | 0.26 | 0.25 | 0.20 | 0.19 | 0.18 | 0.15 | 0.12 | 0.10 | 0.08 |
| **0.08** | 8.0 | 4.0 | 2.00 | 1.60 | 1.00 | 0.80 | 0.67 | 0.53 | 0.50 | 0.40 | 0.33 | 0.32 | 0.27 | 0.25 | 0.23 | 0.20 | 0.16 | 0.13 | 0.10 |
| **0.10** | | 6.3 | 3.13 | 2.50 | 1.56 | 1.25 | 1.04 | 0.83 | 0.78 | 0.63 | 0.52 | 0.50 | 0.42 | 0.39 | 0.36 | 0.31 | 0.25 | 0.21 | 0.16 |
| **0.12** | | 9.0 | 4.50 | 3.60 | 2.25 | 1.80 | 1.50 | 1.20 | 1.13 | 0.90 | 0.75 | 0.72 | 0.60 | 0.56 | 0.51 | 0.45 | 0.36 | 0.30 | 0.23 |
| **0.15** | | 14 | 7.0 | 5.6 | 3.52 | 2.81 | 2.34 | 1.88 | 1.76 | 1.41 | 1.17 | 1.13 | 0.94 | 0.88 | 0.80 | 0.70 | 0.56 | 0.47 | 0.35 |
| **0.16** | | 16 | 8.0 | 6.4 | 4.00 | 3.20 | 2.67 | 2.13 | 2.00 | 1.60 | 1.33 | 1.28 | 1.07 | 1.00 | 0.91 | 0.80 | 0.64 | 0.53 | 0.40 |
| **0.18** | | 20 | 10.1 | 8.1 | 5.1 | 4.05 | 3.38 | 2.70 | 2.53 | 2.03 | 1.69 | 1.62 | 1.35 | 1.27 | 1.16 | 1.01 | 0.81 | 0.68 | 0.51 |
| **0.20** | | | 13 | 10.0 | 6.3 | 5.0 | 4.17 | 3.33 | 3.13 | 2.50 | 2.08 | 2.00 | 1.67 | 1.56 | 1.43 | 1.25 | 1.00 | 0.83 | 0.63 |
| **0.22** | | | 15 | 12.1 | 7.6 | 6.1 | 5.0 | 4.03 | 3.78 | 3.03 | 2.52 | 2.42 | 2.02 | 1.89 | 1.73 | 1.51 | 1.21 | 1.01 | 0.76 |
| **0.25** | | | 20 | 16 | 9.8 | 7.8 | 6.5 | 5.2 | 4.88 | 3.91 | 3.26 | 3.13 | 2.60 | 2.44 | 2.23 | 1.95 | 1.56 | 1.30 | 0.98 |
| **0.27** | | | 23 | 18 | 11.4 | 9.1 | 7.6 | 6.1 | 5.7 | 4.56 | 3.80 | 3.65 | 3.04 | 2.85 | 2.60 | 2.28 | 1.82 | 1.52 | 1.14 |
| **0.30** | | | 28 | 23 | 14 | 11.3 | 9.4 | 7.5 | 7.0 | 5.6 | 4.69 | 4.50 | 3.75 | 3.52 | 3.21 | 2.81 | 2.25 | 1.88 | 1.41 |
| **0.32** | | | 32 | 26 | 16 | 13 | 10.7 | 8.5 | 8.0 | 6.4 | 5.3 | 5.1 | 4.27 | 4.00 | 3.66 | 3.20 | 2.56 | 2.13 | 1.60 |
| **0.35** | | | 38 | 31 | 19 | 15 | 13 | 10.2 | 9.6 | 7.7 | 6.4 | 6.1 | 5.1 | 4.79 | 4.38 | 3.83 | 3.06 | 2.55 | 1.91 |
| **0.37** | | | 43 | 34 | 21 | 17 | 14 | 11.4 | 10.7 | 8.6 | 7.1 | 6.8 | 5.7 | 5.3 | 4.89 | 4.28 | 3.42 | 2.85 | 2.14 |
| **0.40** | | | | 40 | 25 | 20 | 17 | 13 | 13 | 10.0 | 8.3 | 8.0 | 6.7 | 6.3 | 5.7 | 5.0 | 4.00 | 3.33 | 2.50 |
| **0.45** | | | | 51 | 32 | 25 | 21 | 17 | 16 | 13 | 10.5 | 10.1 | 8.4 | 7.9 | 7.2 | 6.3 | 5.1 | 4.22 | 3.16 |
| **0.50** | | | | | 39 | 31 | 26 | 21 | 20 | 16 | 13 | 13 | 10.4 | 9.8 | 8.9 | 7.8 | 6.3 | 5.2 | 3.91 |
| **0.55** | | | | | 47 | 38 | 32 | 25 | 24 | 19 | 16 | 15 | 13 | 11.8 | 10.8 | 9.5 | 7.6 | 6.3 | 4.73 |
| **0.60** | | | | | 56 | 45 | 38 | 30 | 28 | 23 | 19 | 18 | 15 | 14 | 13 | 11.3 | 9.0 | 7.5 | 5.6 |
| **0.65** | | | | | 66 | 53 | 44 | 35 | 33 | 26 | 22 | 21 | 18 | 17 | 15 | 13 | 10.6 | 8.8 | 6.6 |
| **0.70** | | | | | 77 | 61 | 51 | 41 | 38 | 31 | 26 | 25 | 20 | 19 | 18 | 15 | 12.3 | 10.2 | 7.7 |
| **0.75** | | | | | 88 | 70 | 59 | 47 | 44 | 35 | 29 | 28 | 23 | 22 | 20 | 18 | 14 | 11.7 | 8.8 |
| **0.80** | | | | | | 80 | 67 | 53 | 50 | 40 | 33 | 32 | 27 | 25 | 23 | 20 | 16 | 13 | 10.0 |
| **0.85** | | | | | | 90 | 75 | 60 | 56 | 45 | 38 | 36 | 30 | 28 | 26 | 23 | 18 | 15 | 11.3 |
| **0.90** | | | | | | 101 | 84 | 68 | 63 | 51 | 42 | 41 | 34 | 32 | 29 | 25 | 20 | 17 | 13 |
| **0.95** | | | | | | 113 | 94 | 75 | 71 | 56 | 47 | 45 | 38 | 35 | 32 | 28 | 23 | 19 | 14 |
| **1.00** | | | | | | | 104 | 83 | 78 | 63 | 52 | 50 | 42 | 39 | 36 | 31 | 25 | 21 | 16 |
| **1.20** | | | | | | | | 120 | 113 | 90 | 75 | 72 | 60 | 56 | 51 | 45 | 36 | 30 | 23 |
| **1.30** | | | | | | | | 141 | 132 | 106 | 88 | 85 | 70 | 66 | 60 | 53 | 42 | 35 | 26 |
| **1.40** | | | | | | | | 163 | 153 | 123 | 102 | 98 | 82 | 77 | 70 | 61 | 49 | 41 | 31 |
| **1.50** | | | | | | | | | 176 | 141 | 117 | 113 | 94 | 88 | 80 | 70 | 56 | 47 | 35 |
| **1.60** | | | | | | | | | | 160 | 133 | 128 | 107 | 100 | 91 | 80 | 64 | 53 | 40 |
| **1.70** | | | | | | | | | | 181 | 151 | 145 | 120 | 113 | 103 | 90 | 72 | 60 | 45 |
| **1.80** | | | | | | | | | | 203 | 169 | 162 | 135 | 127 | 116 | 101 | 81 | 68 | 51 |
| **1.90** | | | | | | | | | | 226 | 188 | 181 | 150 | 141 | 129 | 113 | 90 | 75 | 56 |
| **2.00** | | | | | | | | | | | 208 | 200 | 167 | 156 | 143 | 125 | 100 | 83 | 63 |
| **2.20** | | | | | | | | | | | 252 | 242 | 202 | 189 | 173 | 151 | 121 | 101 | 76 |
| **2.50** | | | | | | | | | | | | | 260 | 244 | 223 | 195 | 156 | 130 | 98 |

Fare for hård spånbrydning

**Overfladekvalitet ved drejning $R_a$**

$$R_a = 43{,}9 \frac{f^{1{,}88}}{RE^{0{,}97}}$$

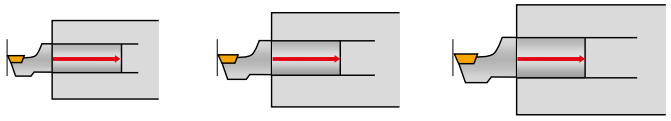
| f ⇨ | *RE* Radius | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | 0.1 | 0.2 | 0.4 | 0.5 | 0.8 | 1.0 | 1.2 | 1.5 | 1.6 | 2.0 | 2.4 | 2.5 | 3.0 | 3.2 | 3.5 | 4.0 | 5.0 | 6.0 | 8.0 |
| | Overflade $R_a$ (µm) | | | | | | | | | | | | | | | | | | |
| **0.05** | 1.47 | 0.75 | 0.38 | 0.31 | 0.20 | 0.16 | 0.13 | 0.11 | 0.10 | 0.08 | 0.07 | 0.06 | 0.05 | 0.05 | 0.05 | 0.04 | 0.03 | 0.03 | 0.02 |
| **0.07** | 2.76 | 1.41 | 0.72 | 0.58 | 0.37 | 0.30 | 0.25 | 0.20 | 0.19 | 0.15 | 0.13 | 0.12 | 0.10 | 0.10 | 0.09 | 0.08 | 0.06 | 0.05 | 0.04 |
| **0.08** | 3.55 | 1.81 | 0.93 | 0.75 | 0.47 | 0.38 | 0.32 | 0.26 | 0.24 | 0.19 | 0.16 | 0.16 | 0.13 | 0.12 | 0.11 | 0.10 | 0.08 | 0.07 | 0.05 |
| **0.10** | | 2.76 | 1.41 | 1.13 | 0.72 | 0.58 | 0.48 | 0.39 | 0.37 | 0.30 | 0.25 | 0.24 | 0.20 | 0.19 | 0.17 | 0.15 | 0.12 | 0.10 | 0.08 |
| **0.12** | | 3.88 | 1.98 | 1.60 | 1.01 | 0.82 | 0.68 | 0.55 | 0.52 | 0.42 | 0.35 | 0.34 | 0.28 | 0.26 | 0.24 | 0.21 | 0.17 | 0.14 | 0.11 |
| **0.15** | | 5.9 | 3.02 | 2.43 | 1.54 | 1.24 | 1.04 | 0.84 | 0.79 | 0.63 | 0.53 | 0.51 | 0.43 | 0.40 | 0.37 | 0.32 | 0.26 | 0.22 | 0.17 |
| **0.16** | | 6.7 | 3.41 | 2.74 | 1.74 | 1.40 | 1.17 | 0.94 | 0.89 | 0.71 | 0.60 | 0.58 | 0.48 | 0.45 | 0.42 | 0.36 | 0.29 | 0.25 | 0.19 |
| **0.18** | | 8.3 | 4.25 | 3.42 | 2.17 | 1.75 | 1.46 | 1.18 | 1.11 | 0.89 | 0.75 | 0.72 | 0.60 | 0.57 | 0.52 | 0.46 | 0.37 | 0.31 | 0.23 |
| **0.20** | | | 5.2 | 4.17 | 2.64 | 2.13 | 1.78 | 1.44 | 1.35 | 1.09 | 0.91 | 0.88 | 0.73 | 0.69 | 0.63 | 0.56 | 0.45 | 0.37 | 0.28 |
| **0.22** | | | 6.2 | 4.99 | 3.16 | 2.55 | 2.14 | 1.72 | 1.62 | 1.30 | 1.09 | 1.05 | 0.88 | 0.82 | 0.76 | 0.66 | 0.53 | 0.45 | 0.34 |
| **0.25** | | | 7.9 | 6.3 | 4.02 | 3.24 | 2.72 | 2.19 | 2.05 | 1.65 | 1.39 | 1.33 | 1.12 | 1.05 | 0.96 | 0.84 | 0.68 | 0.57 | 0.43 |
| **0.27** | | | 9.1 | 7.3 | 4.65 | 3.74 | 3.14 | 2.53 | 2.37 | 1.91 | 1.60 | 1.54 | 1.29 | 1.21 | 1.11 | 0.98 | 0.79 | 0.66 | 0.50 |
| **0.30** | | | 11.1 | 8.9 | 5.7 | 4.57 | 3.83 | 3.08 | 2.89 | 2.33 | 1.95 | 1.88 | 1.57 | 1.48 | 1.35 | 1.19 | 0.96 | 0.80 | 0.61 |
| **0.32** | | | 13 | 10.1 | 6.4 | 5.2 | 4.32 | 3.48 | 3.27 | 2.63 | 2.20 | 2.12 | 1.78 | 1.67 | 1.53 | 1.34 | 1.08 | 0.91 | 0.69 |
| **0.35** | | | 15 | 11.9 | 7.6 | 6.1 | 5.1 | 4.12 | 3.87 | 3.11 | 2.61 | 2.51 | 2.10 | 1.97 | 1.81 | 1.59 | 1.28 | 1.07 | 0.81 |
| **0.37** | | | 16 | 13 | 8.4 | 6.8 | 5.7 | 4.57 | 4.29 | 3.46 | 2.90 | 2.78 | 2.33 | 2.19 | 2.01 | 1.76 | 1.42 | 1.19 | 0.90 |
| **0.40** | | | | 15 | 9.7 | 7.8 | 6.6 | 5.3 | 4.97 | 4.00 | 3.35 | 3.22 | 2.70 | 2.54 | 2.33 | 2.04 | 1.65 | 1.38 | 1.04 |
| **0.45** | | | | 19 | 12.1 | 9.8 | 8.2 | 6.6 | 6.2 | 4.99 | 4.19 | 4.02 | 3.37 | 3.17 | 2.90 | 2.55 | 2.05 | 1.72 | 1.30 |
| **0.50** | | | | | 15 | 11.9 | 10.0 | 8.0 | 7.6 | 6.1 | 5.1 | 4.90 | 4.11 | 3.86 | 3.54 | 3.11 | 2.50 | 2.10 | 1.59 |
| **0.55** | | | | | 18 | 14 | 12.0 | 9.6 | 9.0 | 7.3 | 6.1 | 5.9 | 4.92 | 4.62 | 4.23 | 3.72 | 2.99 | 2.51 | 1.90 |
| **0.60** | | | | | 21 | 17 | 14 | 11.3 | 10.7 | 8.6 | 7.2 | 6.9 | 5.8 | 5.4 | 4.98 | 4.38 | 3.53 | 2.96 | 2.24 |
| **0.65** | | | | | 24 | 20 | 16 | 13 | 12.4 | 10.0 | 8.4 | 8.0 | 6.7 | 6.3 | 5.8 | 5.1 | 4.10 | 3.44 | 2.60 |
| **0.70** | | | | | 28 | 22 | 19 | 15 | 14 | 11.5 | 9.6 | 9.2 | 7.7 | 7.3 | 6.7 | 5.9 | 4.71 | 3.95 | 2.99 |
| **0.75** | | | | | 32 | 26 | 21 | 17 | 16 | 13 | 10.9 | 10.5 | 8.8 | 8.3 | 7.6 | 6.7 | 5.4 | 4.50 | 3.40 |
| **0.80** | | | | | | 29 | 24 | 19 | 18 | 15 | 12.3 | 11.9 | 9.9 | 9.3 | 8.6 | 7.5 | 6.1 | 5.1 | 3.84 |
| **0.85** | | | | | | 32 | 27 | 22 | 21 | 17 | 14 | 13 | 11.1 | 10.5 | 9.6 | 8.4 | 6.8 | 5.7 | 4.30 |
| **0.90** | | | | | | 36 | 30 | 24 | 23 | 18 | 15 | 15 | 12.4 | 11.7 | 10.7 | 9.4 | 7.6 | 6.3 | 4.79 |
| **0.95** | | | | | | 40 | 33 | 27 | 25 | 20 | 17 | 16 | 14 | 13 | 11.8 | 10.4 | 8.4 | 7.0 | 5.3 |
| **1.00** | | | | | | | 37 | 30 | 28 | 22 | 19 | 18 | 15 | 14 | 13 | 11.4 | 9.2 | 7.7 | 5.8 |
| **1.20** | | | | | | | | 42 | 39 | 32 | 26 | 25 | 21 | 20 | 18 | 16 | 13 | 10.9 | 8.2 |
| **1.30** | | | | | | | | 49 | 46 | 37 | 31 | 30 | 25 | 23 | 21 | 19 | 15 | 13 | 9.6 |
| **1.40** | | | | | | | | 56 | 52 | 42 | 35 | 34 | 28 | 27 | 25 | 22 | 17 | 15 | 11.0 |
| **1.50** | | | | | | | | | 60 | 48 | 40 | 39 | 32 | 30 | 28 | 25 | 20 | 17 | 13 |
| **1.60** | | | | | | | | | | 54 | 45 | 44 | 37 | 34 | 32 | 28 | 22 | 19 | 14 |
| **1.70** | | | | | | | | | | 61 | 51 | 49 | 41 | 39 | 35 | 31 | 25 | 21 | 16 |
| **1.80** | | | | | | | | | | 68 | 57 | 54 | 46 | 43 | 39 | 35 | 28 | 23 | 18 |
| **1.90** | | | | | | | | | | 75 | 63 | 60 | 51 | 47 | 44 | 38 | 31 | 26 | 20 |
| **2.00** | | | | | | | | | | | 69 | 66 | 56 | 52 | 48 | 42 | 34 | 28 | 21 |
| **2.20** | | | | | | | | | | | 83 | 79 | 67 | 63 | 57 | 50 | 41 | 34 | 26 |
| **2.50** | | | | | | | | | | | | | 85 | 80 | 73 | 64 | 52 | 43 | 33 |

Fare for hård spånbrydning

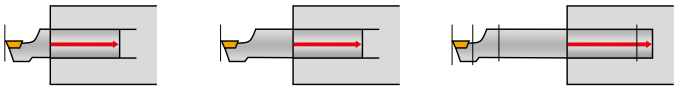




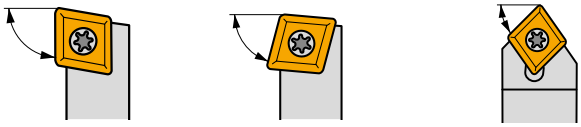
**Hardness of chip formation** – great attention must be paid to proper chip formation (the chip must be easily transportable from the cutting point and, at the same time, it should have the smallest possible plastic deformation, i.e. the lowest possible cutting forces).



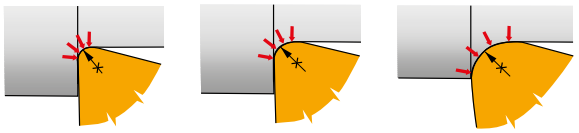
**Tool body cross section (clamping rigidity)** – the rigidity of the clamping itself is important. Therefore, we recommend using cutting tools with the largest possible body cross section that can be clamped. We also prefer to use monoblocks (PSC).



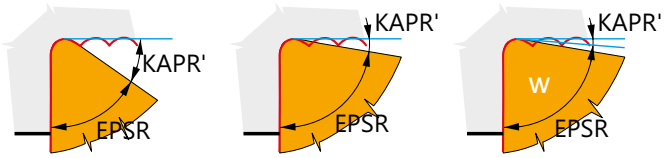
**Overhang (clamping rigidity)** – the tool overhang, or the rigidity of the clamping itself, is of great importance as well. Therefore, we recommend minimising the overhang.



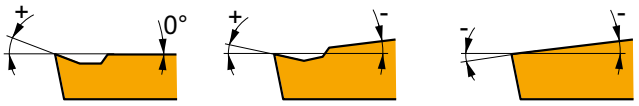
**Main cutting edge angle** – ideally, the tool adjustment angle should be close to 90°, i.e. the forces should be directed as much as possible to the axis of the machine spindle.



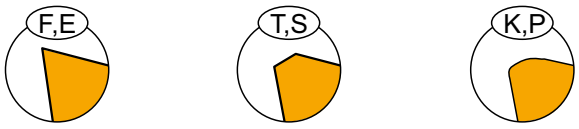
**Insert radius** – if there is a risk of vibration, we recommend selecting an insert with the smallest possible tip radius.



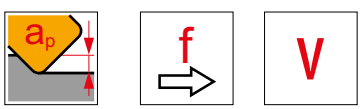

**Corner angle and minor cutting edge angle** – in this case it is recommended to choose an insert with the smallest possible tip angle, i.e. V (35°), D or K (55°), or T (60°).C or W shapes, or inserts with WIPER geometry, are not recommended. Please note this does not always apply (if torsional vibrations also occur, the application of these inserts can be beneficial).




**Geometry** – when turning thin-walled and slim parts, it is recommended to opt for positive inserts with positive geometry, then negative inserts with positive geometry, and only if there is no other choice, then negative inserts with neutral to negative geometry should be chosen.




**Micro-geometry (cutting edge design)** – to reduce the risk of vibration, it is necessary to select inserts with the sharpest possible cutting edge geometry. If you use inserts with t-landing, these should be as narrow and positive as possible. It is very important that the tool generates as little cutting resistance as possible.



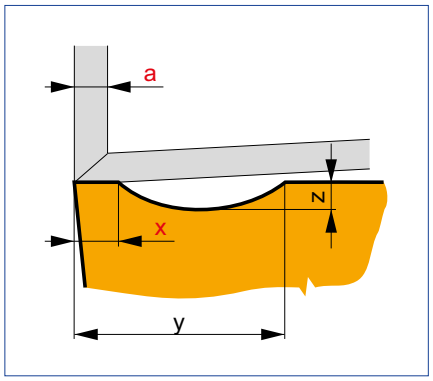

**Cutting conditions:**
1) When choosing the depth of cut, always make sure that the depth of cut is greater than the radius of the insert.
2) When choosing the feed, take into account that the specific cutting resistance increases with decreasing chip thickness, i.e. do not use extremely low feeds (below 0.1 mm).
3) If there are vibrations, cutting speed change (+/-) can also help – this is related to the inherent frequency of the machine.
NOTE: It is often advantageous to reduce the depth of cut (not below the radius) and increase the feed.



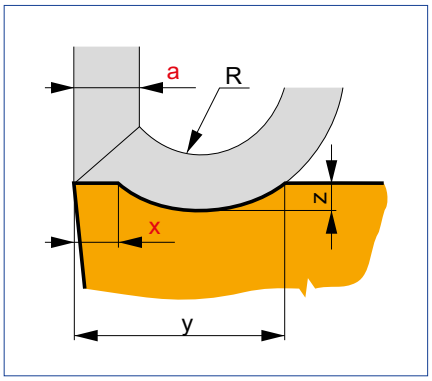
**Do not use worn inserts** – abrasion of the flank causes an increase in cutting forces, and thus the risk of vibration.
If tool clamping allows it, move the cutting edge above the axis (in external turning) by approx. 2% of the diameter.

**Choosing the chip breaker**

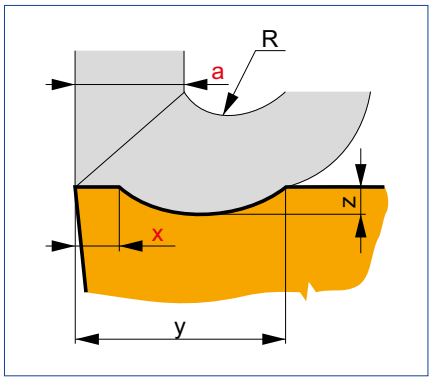
The shape of the chip depends on several factors – the properties of the machined component, material strength, toughness and microstructure, properties of the insert grade, especially the frictional properties (on the rake face), geometry of cutting edge, cutting conditions and the type of chip breaker, also static and dynamic properties of the machine.
Virtually all of these factors in the cutting process work to combine and determine the shape of the chip (shearing action, flow of the chip, or curled chip – which can gather and clog the machining area). Each chip breaker works in a defined range of feed and depth of cut.
The minimum feed at which the chip breaker functions depends on the width of Top Land „*x*“ and it's angle. The maximum feed depends on the distance from the cutting edge to the end of the chip breaker *y* and the depth of the chip breaker *z*.




If the thickness of layer „*a*“ cut away (at setting angle *KAPR* = 90°, equal to the feed) is significantly smaller than the T–land „*x*“, the chip is only in contact with the chamfer. It cannot enter the chip breaker and therefore it cannot be broken (see picture).

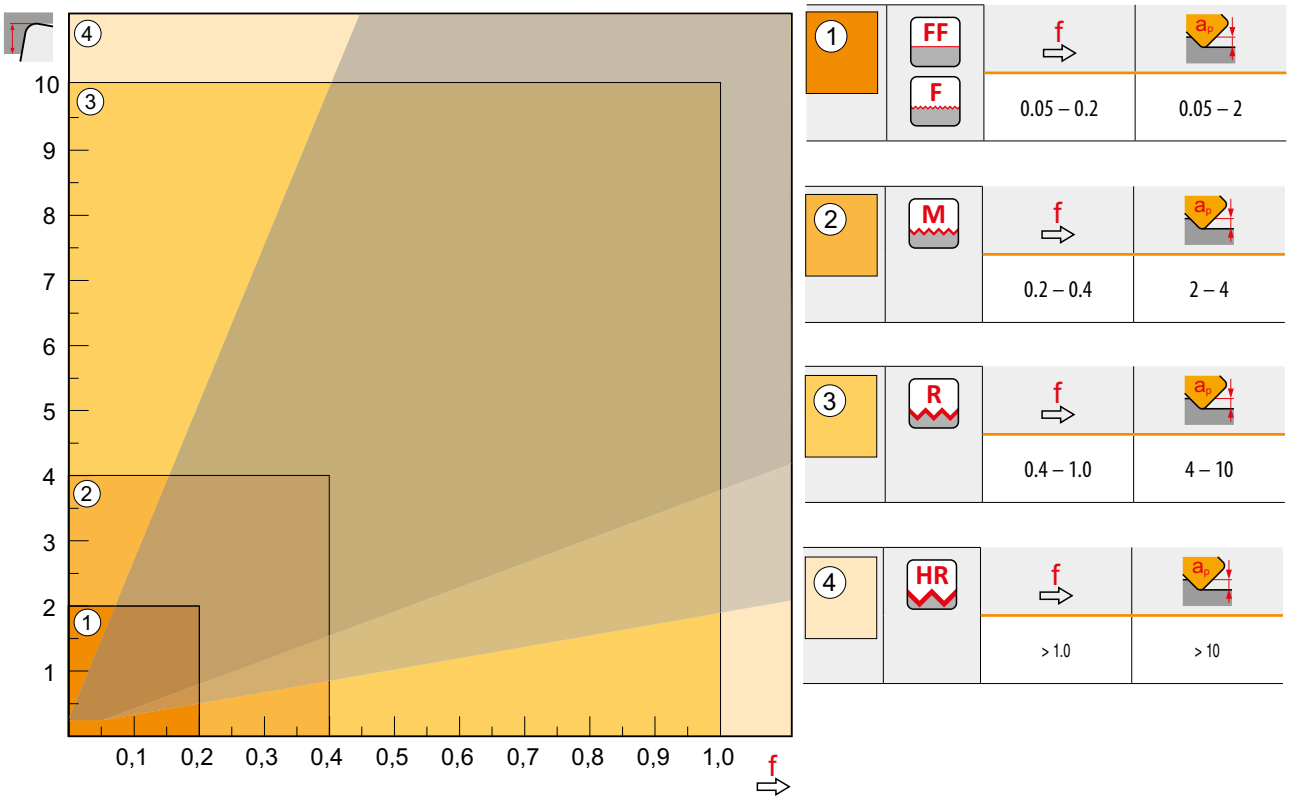


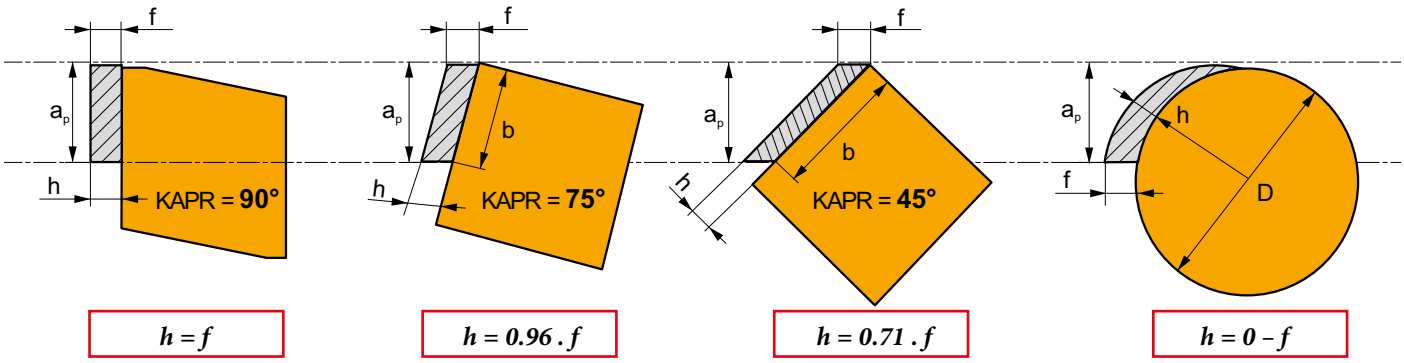

If the feed „*f*“ is greater (thickness greater than the depth of „*a*“ and *x* < *a* (*f*), the chip enters the chip breaker and is curved at specific values of radius *R* (see picture).




If *x* << *a* (see picture) the chip is excessively deformed (chip is crushed). If the chip misses the chip breaker it will not be broken.

All chip breakers work in a defined range of cutting conditions. This is why the chip breaking area is shown as a continuous range in order to define the most commonly used depth of cut and feed combinations (see following picture). The chip breaker application ranges also overlap.





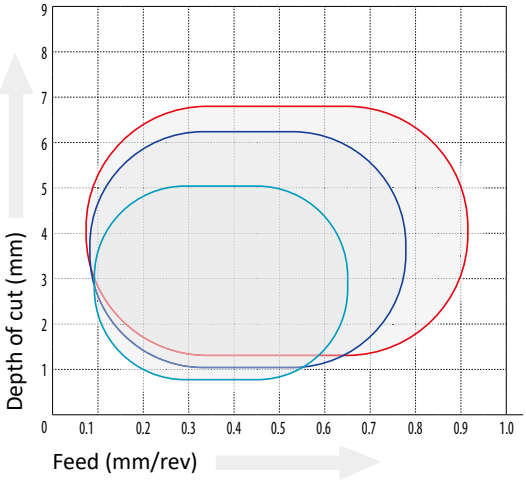

$h = f$ | $h = 0.96 \cdot f$ | $h = 0.71 \cdot f$ | $h = 0 - f$

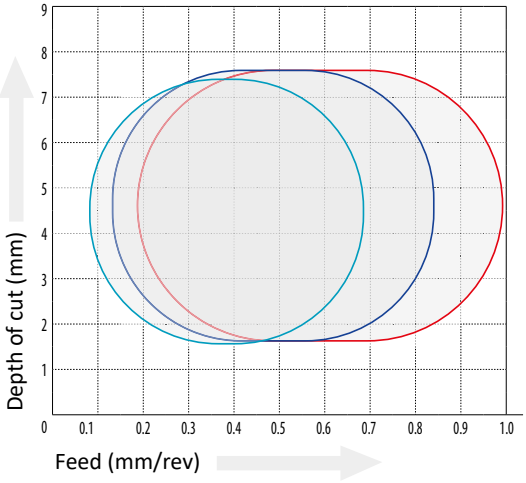
Optimal combination of depth of cut and feed varies for each material. The following table shows ranges of the optimal ratios ***b*** (chip width) to ***h*** (chip thickness). For adjustment angles close to 90°, this is essentially the ratio of depth of cut to feed. See picture.

| Material | | min b/h | max b/h | |
|---|---|---|---|---|
| P |  | 5 | 15 |  |
| M | | 8 | 12 | |
| K | | 3 | 30 | |
| N | | 9 | 11 | |
| S | Square chip b=h | 8 | 12 | Ribbon chip b/ h > 30 |
| H | | 5 | 20 | |

As follows from the table, when choosing cutting conditions, you should avoid the so-called square chip, i.e. values where the width is close to the thickness of the chip and, on the other hand, the ribbon chip, i.e. high depths of cut in combination with low feed.
The above table shows that the most problematic chip formation relates to non-ferrous metal alloys, in particular aluminium alloys with or without a low silicon content. This is followed by superalloys and stainless steels (especially austenitic and duplex steels). Next are steels, and the best situation is with hardened materials and cast irons.

Also, keep in mind that the chip formation diagram moves slightly towards higher depths of cut (up), with increasing cutting edge length (insert size), and towards higher feeds (to the right), with increasing radius.



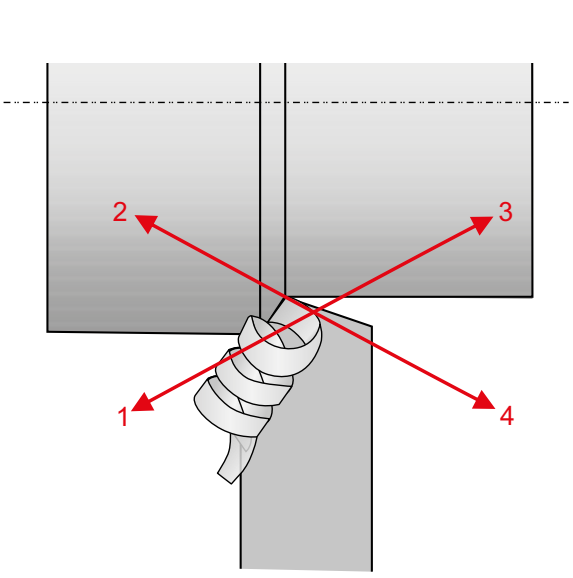



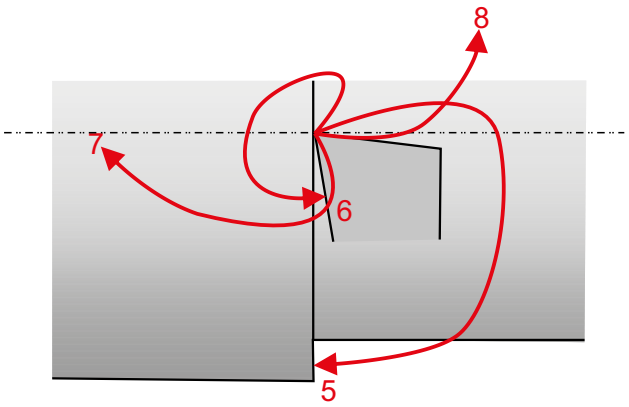

- An insert with the diameter of an inscribed circle IC = 19.050 (mm)
- An insert with the diameter of an inscribed circle IC = 15.875 (mm)
- An insert with the diameter of an inscribed circle IC = 12.700 (mm)
- An insert with the tip radius RE = 1.6 (mm)
- An insert with the tip radius RE = 1.2 (mm)
- An insert with the tip radius RE = 0.8 (mm)

Aside from shape of the chip, the direction of its evacuation is also very important. The following figure shows the basic directions of chip evacuation:

1 – from the workpiece in the feed direction,
2 – to the workpiece in the feed direction
3 – to the workpiece against the feed,
4 – from the workpiece against the feed,
5 – broken against the cutting area surface,
6 – broken against the side of the tool,
7 – broken against the surface being machined,
8 – broken against the machined surface,

Obviously, directions that can cause damage or scratching of the machined surface are undesirable.




The following section clearly specifies all the geometries we offer you in structured groups. These tables should give you an optimal and more accurate choice.

| POSITIVE INSERTS Clamping designation ISO S | |
|---|---|
| 371 (RCMT) | 565 |
| 372 (RCMT) | 565 |
| ...W | 565 |
| AL | 565 |
| DR4 (SCMT) | 566 |
| FF | 566 |
| FF2 | 566 |
| FM | 566 |
| FM (RCMT) | 567 |
| FM2 | 567 |
| NF1 | 567 |
| NF2 | 567 |
| OR (SCMT) | 568 |
| RF | 568 |
| RM | 568 |
| RM3 | 568 |
| SF2 | 569 |
| SF3 | 569 |
| SI | 569 |
| SR (SCMT) | 569 |
| UR (RCMT) | 570 |
| UR | 570 |
| W-FM | 570 |
| W-UR | 570 |
| 46 | 571 |
| 47 | 571 |
| 48 | 571 |
| 61 | 571 |
| .PUN | 572 |

| POSITIVE INSERTS Clamping designation ISO P, M, D | |
|---|---|
| 31 (RCMX) | 573 |
| 321 (RCMX) | 573 |
| 331 (RCMX) | 573 |
| 361 (RCMX) | 573 |
| RF1 (RCMX) | 574 |
| RM1 (RCMX) | 574 |
| RM2 (RCM.) | 574 |
| RR2 (RCM.) | 574 |

| NEGATIVE INSERTS Clamping designation ISO P, M, D | |
|---|---|
| 000 (LNUX) | 575 |
| 002 (LNUX) | 575 |
| 003 (LNUX) | 575 |
| 08 (RNMG) | 575 |
| 81 (RNMG) | 576 |
| 432 (LNMX) | 576 |
| 923 | 576 |
| ...A | 576 |
| DR | 577 |
| FF | 577 |
| FM | 577 |
| HR | 577 |
| HR2 | 578 |
| KR | 578 |
| M | 578 |
| NF | 578 |
| NM | 579 |
| NMR | 579 |
| NR | 579 |
| NRM | 579 |
| NR2 | 580 |
| OR | 580 |
| OR1 | 580 |
| R | 580 |
| RM | 581 |
| SF | 581 |
| SI | 581 |
| SM | 581 |
| SR | 582 |
| W–MR | 582 |
| W–F | 582 |
| W–M | 582 |
| W-NM | 583 |

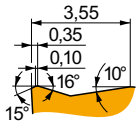
| NEGATIVE INSERTS Clamping designation ISO C | |
|---|---|
| 22 | 584 |
| 32 | 584 |
| 72 | 584 |
| 73 | 584 |
| 74 | 585 |

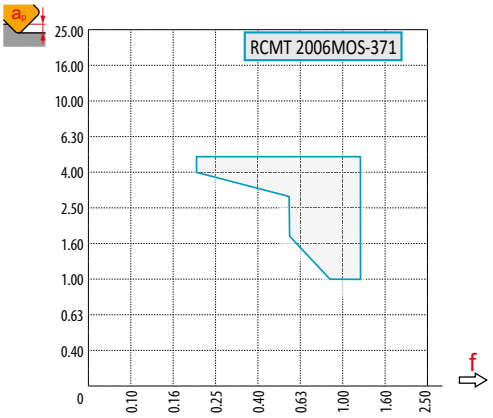
| GEOMETRY OF CUTTING GROOVING INSERTS Clamping designation iso X and G | |
|---|---|
| GM (GL.D) | 586 |
| MM (GL.D) | 586 |
| PM (GL. D) | 586 |
| PR (GL. D) | 586 |
| 13 CM (LCMF) | 587 |
| 13 F (LCM.) | 587 |
| 13 MP (LCM.) | 587 |
| 16 CM (LCM.) | 587 |
| 16 F (LCM.) | 588 |
| 16 M (LCM.) | 588 |
| 16 MP (LCM.) | 588 |
| 20 F1 (LCMF) | 588 |
| 20 M2 (LCMF) | 589 |
| 30 F (LCM.) | 589 |
| F1 (LFMX) | 589 |
| F2 (LFMX) | 589 |
| M2 (LFMX) | 590 |
| LFUX | 590 |
| TN. EXT | 591 |
| TN. INT | 591 |
| X61 | 591 |
| X61 R | 591 |

# GEOMETRY OF CUTTING POSITIVE INSERTS – CLAMPING DESIGNATION ISO S

## 371 (RCMT)






| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | | ■ | | | |

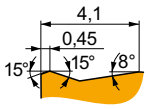
f: 0.20 – 1.20

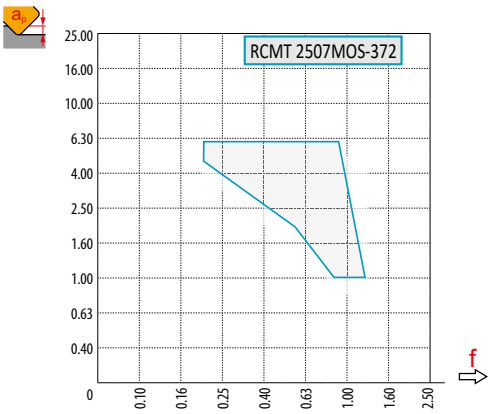
$a_p$: 1.0 – 5.0

RCMT

## 372 (RCMT)






| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | | ■ | | | |

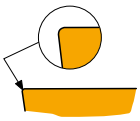
f: 0.20 – 1.20

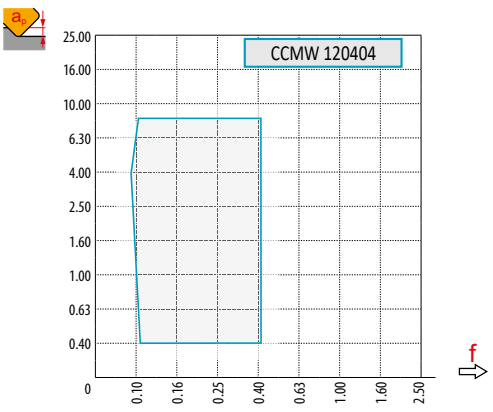
$a_p$: 1.0 – 6.0

RCMT

## ...W








| P | M | K | N | S | H |
|---|---|---|---|---|---|
| | | ■ | | | ◪ |

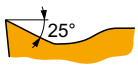
f: 0.05 – 0.60

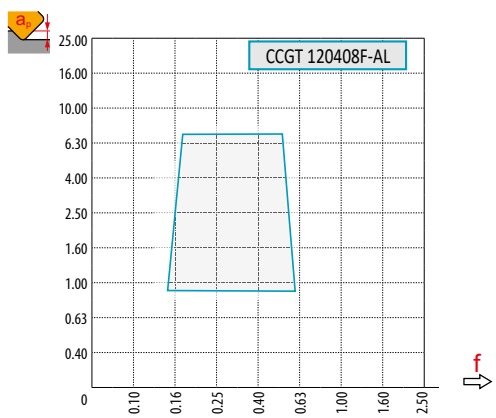
$a_p$: 0.4 – 8.4

CCMW, DCMW, SCMW, RCMW, TCMW, VCMW

## AL






| P | M | K | N | S | H |
|---|---|---|---|---|---|
| | | | ■ | ◪ | |

f: 0.05 – 0.60

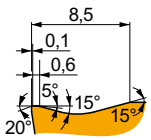
$a_p$: 0.2 – 7.0

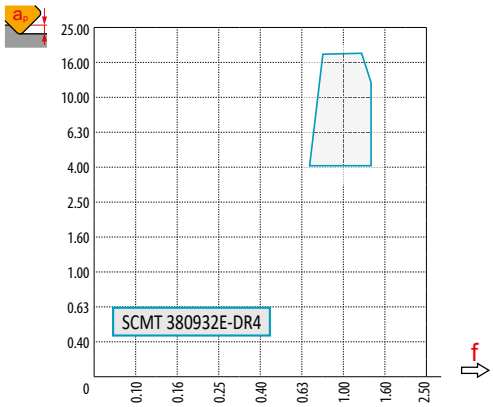
CCGT, DCGT, SCGT, RCGT, TCGT, VCGT, WCGT

# GEOMETRY OF CUTTING POSITIVE INSERTS – CLAMPING DESIGNATION ISO S

## DR4 (SCMT)



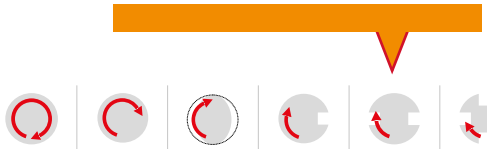



| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ◪ | ■ | | | |

f 0.70 – 1.40

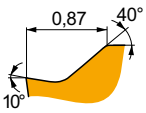
$a_p$ 4.0 – 18.0

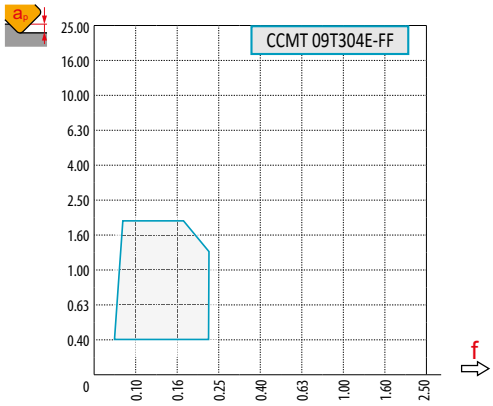


**SCMT**

## FF



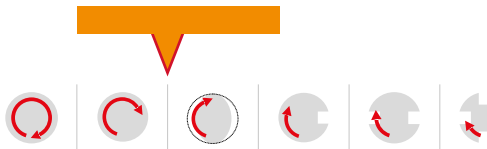



| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ◪ | | | | |

f 0.05 – 0.23

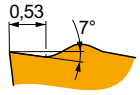
$a_p$ 0.2 – 2.0

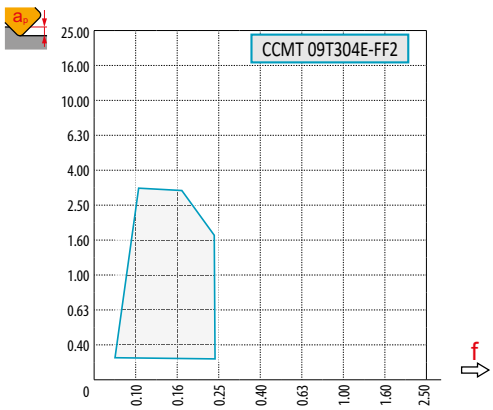


**CCMT, DCMT**

## FF2






| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | | ■ | | | |

f 0.02 – 0.28

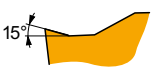
$a_p$ 0.20 – 3.0

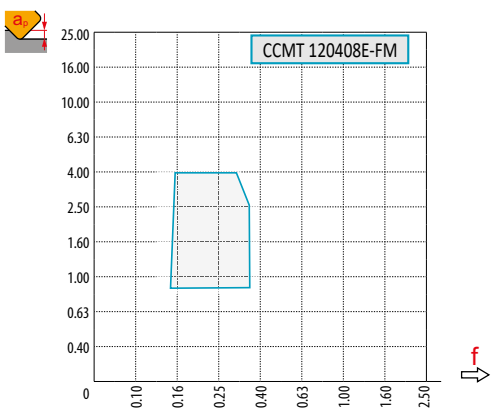


**CCMT, CCGT, DCGT, DCMT, SCMT, TCGT, TCMT, VBMT, VCGT, VCGX, WCGT**

## FM






| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ■ | ◪ | ◪ | | |

f 0.05 – 0.45

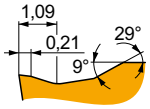
$a_p$ 0.2 – 4.0

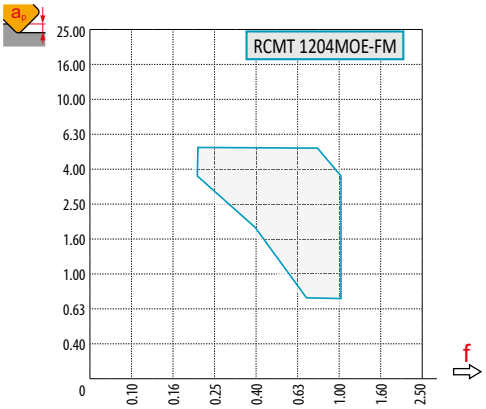


**CCMT, DCMT, SCMT, TCMT, VBMT, WCMT**

## FM (RCMT)





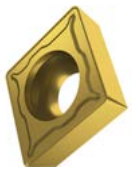

| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ■ | ◪ | ◪ | | |

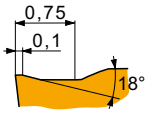
f ⇨ 0.10 – 1.0

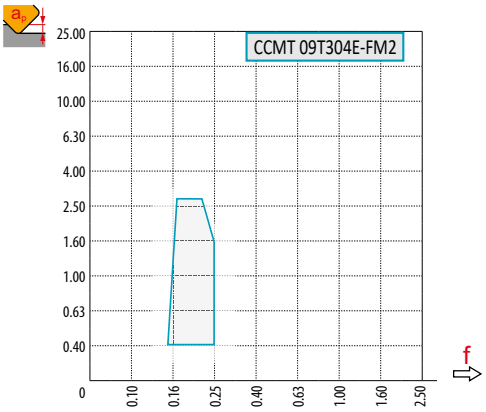
$a_p$ 0.3 – 5.0

**RCMT**

## FM2






| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ◪ | ■ | | | |

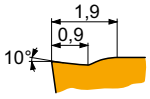
f ⇨ 0.04 – 0.4

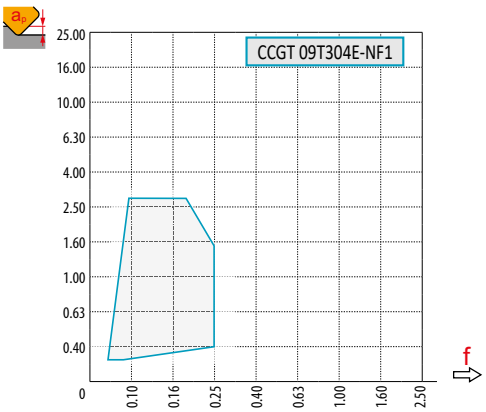
$a_p$ 0.2 – 4.0

**CCMT, DCMT, ECMT, SCMT, TCMT, VBMT, VCGT**

## NF1





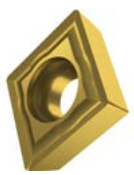

| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ■ | | ◪ | ■ | ◪ |

f ⇨ 0.04 – 0.35

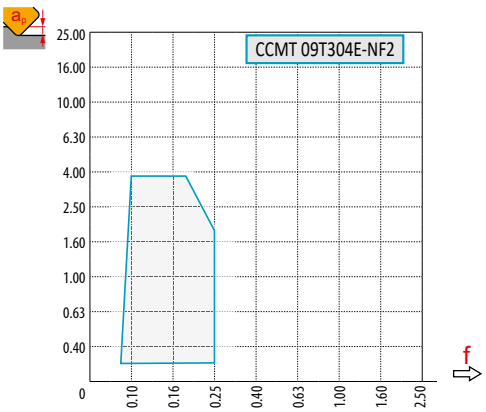
$a_p$ 0.3 – 3.5

**CCGT, DCGT, SCGT, TCGT**

## NF2






| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ◪ | ■ | ◪ | ◪ | ■ | |

f ⇨ 0.05 – 0.45

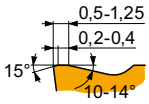
$a_p$ 0.2 – 4.0

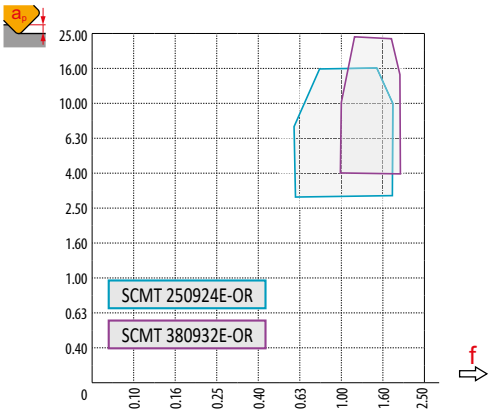
**CCMT, EPMT, SCMT, TCMT, VCGT**

# GEOMETRY OF CUTTING POSITIVE INSERTS – CLAMPING DESIGNATION ISO S

## OR (SCMT)






| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ■ | ■ | | ◪ | |

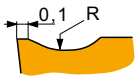
f ⇨ 0.60 – 2.00

$a_p$ 3.0 – 24.0

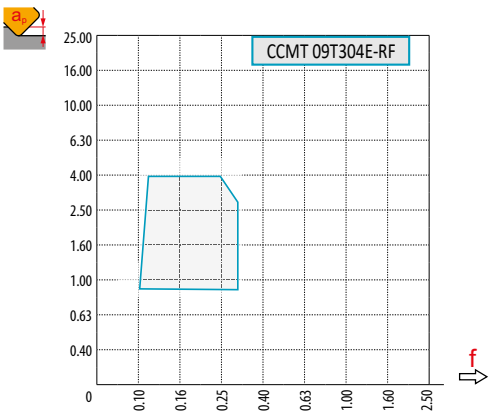
**SCMT**

## RF






| I.C. | R |
|---|---|
| 6,35 | 1,0 |
| 9,525 | 1,5 |
| 12,7 | 2,5 |



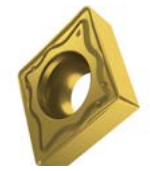

| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ◪ | ■ | | | ◪ |

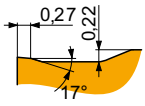
f ⇨ 0.10 – 0.60

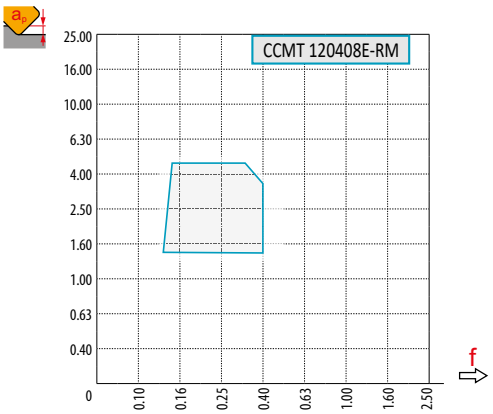
$a_p$ 0.8 – 8.0

**CCMT, DCMT, SCMT, TCMT, WCMT**

## RM






| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ■ | ■ | | ◪ | ◪ |

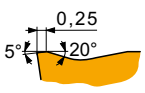
f ⇨ 0.10 – 0.50

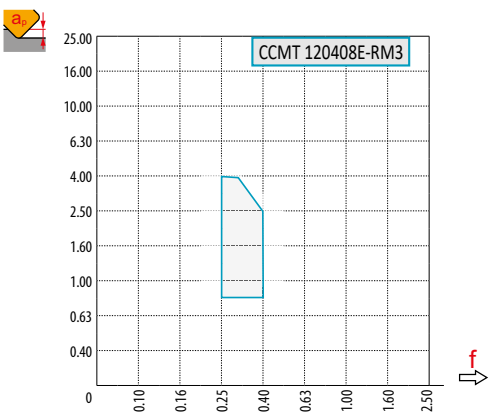
$a_p$ 0.8 – 4.5

**CCMT, DCMT, SCMT, TCMT, VBMT**

## RM3






| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ◪ | ■ | | | ◪ |

f ⇨ 0.15 – 0.90

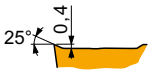
$a_p$ 0.4 – 6.00

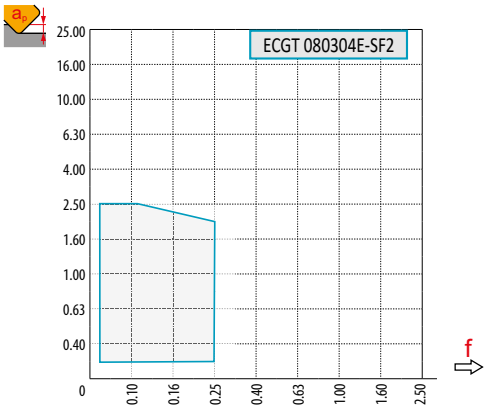
**CCMT, SCMT, TCMT, RCMT**

# GEOMETRY OF CUTTING POSITIVE INSERTS – CLAMPING DESIGNATION ISO S

## SF2






| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ◪ | ■ | | ◪ | ■ | |

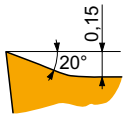
f ⇨ 0.02 – 0.28

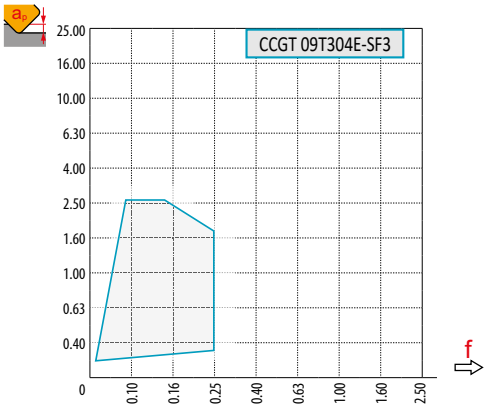
$a_p$ 0.1 – 2.5

**ECGT, VCGT**

## SF3






| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ◪ | ■ | ◪ | ■ | ■ | ◪ |

f ⇨ 0.02 – 0.35

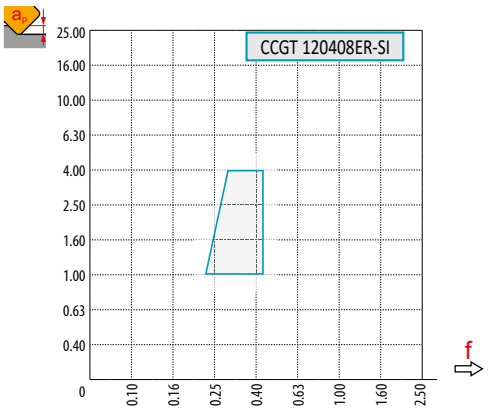
$a_p$ 0.2 – 4.00

**CCGT, DCGT, ECGT, SCGT, TCGT, VCGT**

## SI






| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ■ | ◪ | | ■ | |

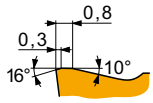
f ⇨ 0.08 – 0.45

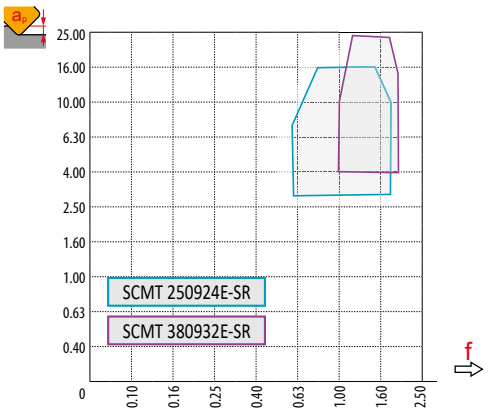
$a_p$ 0.4 – 4.0

**CCGT, TCGT**

## SR (SCMT)






| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ■ | ■ | | | |

f ⇨ 0.60 – 2.0

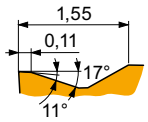
$a_p$ 3.0 – 24.0

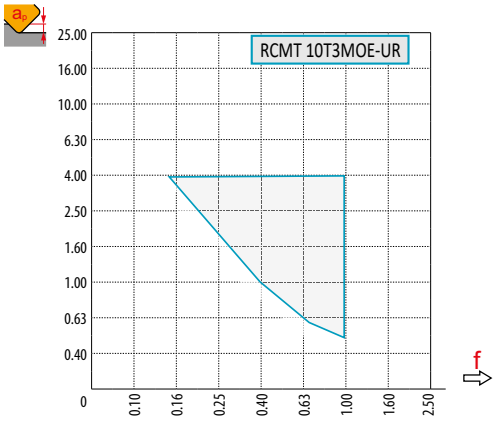
**SCMT**

## GEOMETRY OF CUTTING POSITIVE INSERTS – CLAMPING DESIGNATION ISO S

### UR (RCMT)



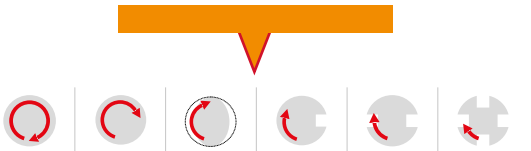



| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ◪ | ■ | | | |

f ⇨ 0.15 – 1.00

$a_p$ 0.5 – 5.0

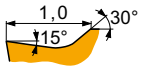


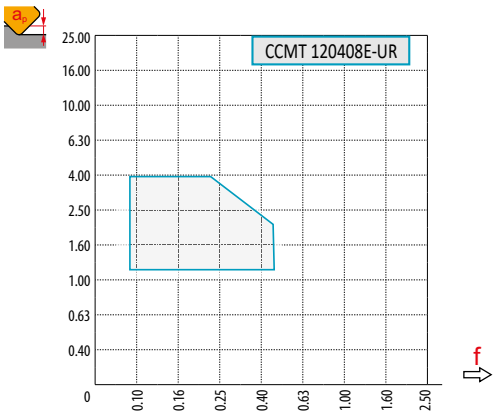


RCMT

### UR






| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ◪ | ■ | | | |

f ⇨ 0.10 – 0.40

$a_p$ 1.0 – 4.0

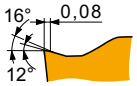


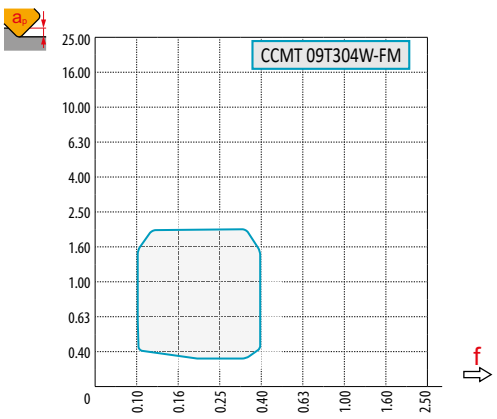


CCMT, DCMT, RCMT, SCMT,
TCMT, VCMT, VBMT, WCMT

### W-FM





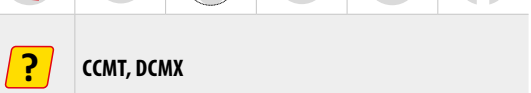




| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ■ | ■ | | | |

f ⇨ 0.1 – 0.4

$a_p$ 0.3 – 3.0

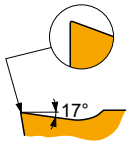


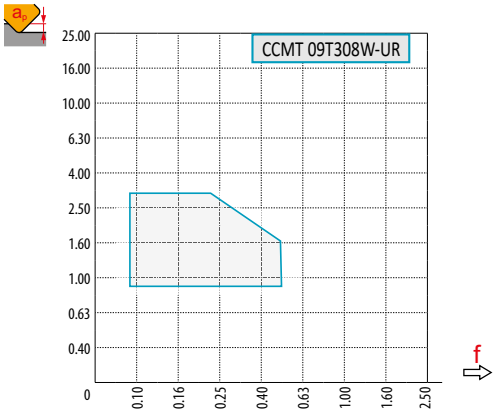


CCMT, DCMX

### W-UR



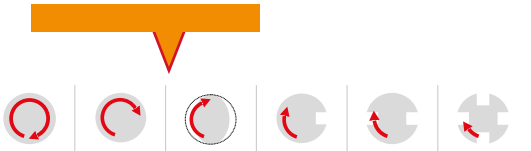



| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ◪ | ■ | | | |

f ⇨ 0.08 – 0.5

$a_p$ 0.4 – 3.0

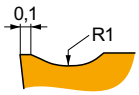


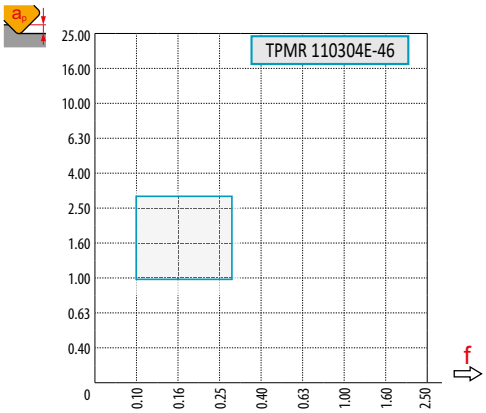


CCMT

## 46






| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ◪ | ■ | | | |

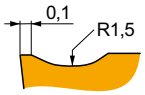
f ⇨ 0.10 – 0.30

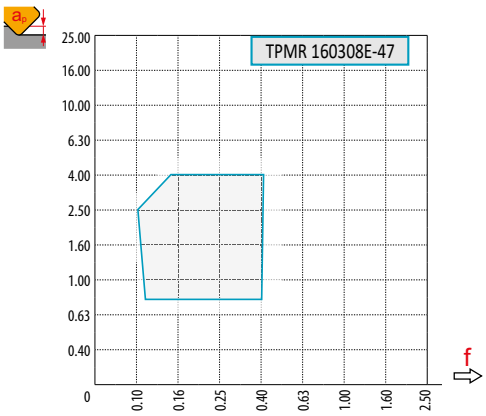
$a_p$ 1.0 – 3.0

**SPMR, TPMR**

## 47





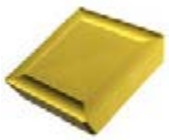

| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ◪ | ■ | | | |

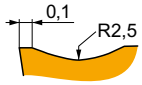
f ⇨ 0.10 – 0.40

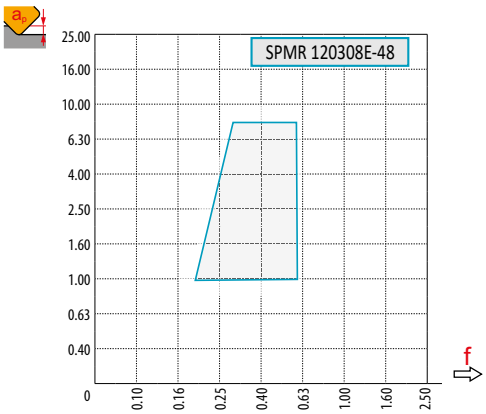
$a_p$ 0.8 – 4.0

**TPMR**

## 48






| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ◪ | ■ | | | |

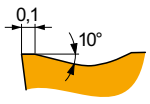
f ⇨ 0.20 – 0.60

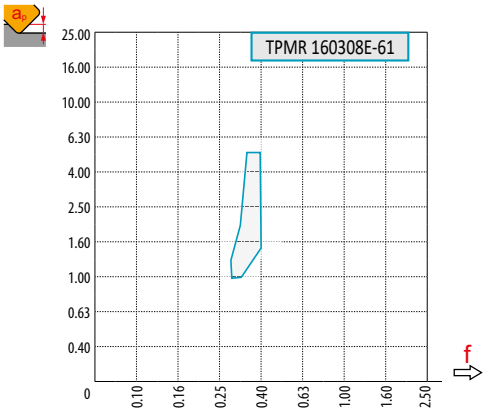
$a_p$ 1.0 – 8.0

**SPMR**

## 61






| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ◪ | ■ | | | |

f ⇨ 0.30 – 0.40

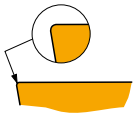
$a_p$ 1.0 – 5.3

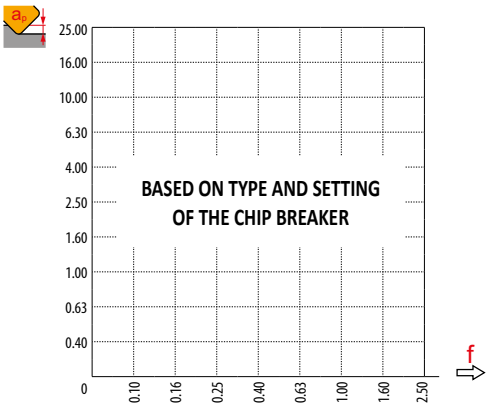
**TPMR**

# GEOMETRY OF CUTTING POSITIVE INSERTS – CLAMPING DESIGNATION ISO C

## .PUN

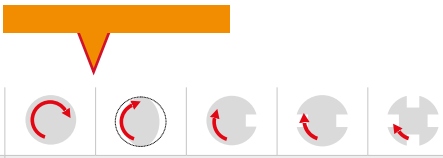







| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ◪ | | ■ | | | ◪ |

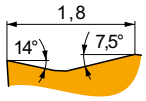
| | |
|---|---|
| f ⇨ | 0.10 – 0.60 |
| $a_p$ | 0.4 – 17.5 |

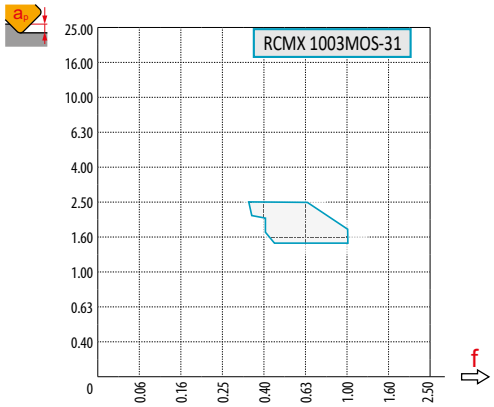


**TPUN, SPUN**

## 31 (RCMX)






| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ◪ | ■ | | | |

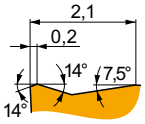
f ⇨ 0.40 – 1.00

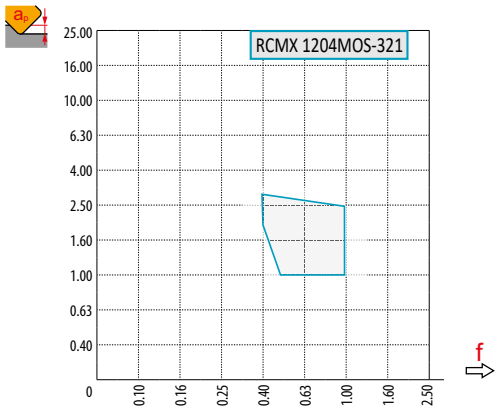
$a_p$ 1.5 – 2.5

RCMX

## 321 (RCMX)






| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | | ■ | | | |

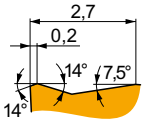
f ⇨ 0.40 – 1.00

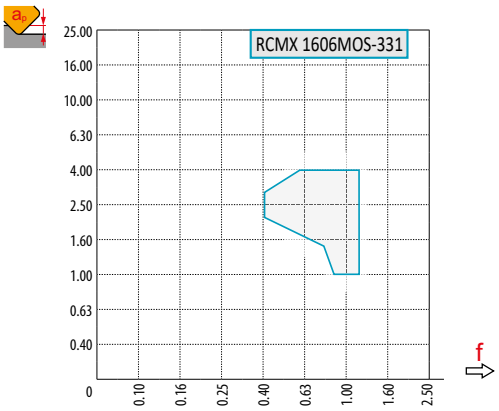
$a_p$ 1.0 – 3.0

RCMX

## 331 (RCMX)






| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | | ■ | | | |

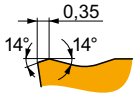
f ⇨ 0.40 – 1.20

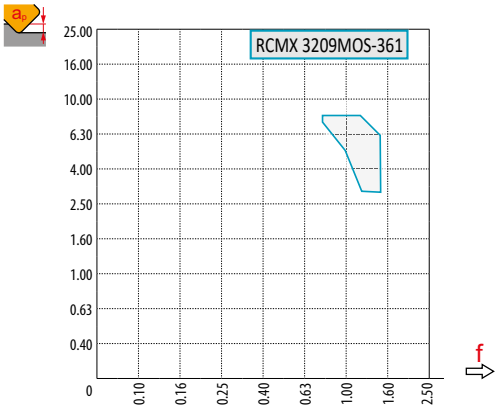
$a_p$ 1.0 – 4.0

RCMX

## 361 (RCMX)






| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | | ■ | | | |

f ⇨ 0.80 – 1.50

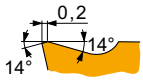
$a_p$ 3.0 – 8.0

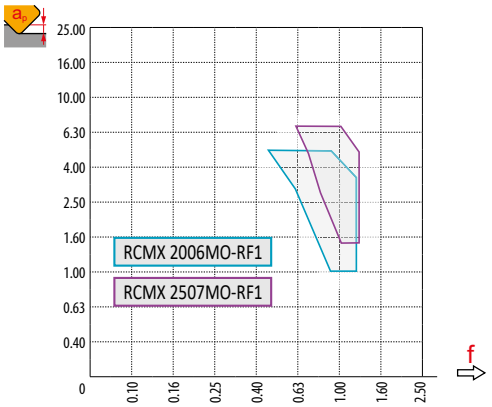
RCMX

# GEOMETRY OF CUTTING POSITIVE INSERTS – CLAMPING DESIGNATION ISO P, M, D

## RF1 (RCMX)






| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | | ◪ | | | |

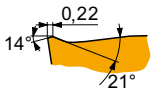
f ⇨ 0.45 (0.60) – 1.20 (1.25)

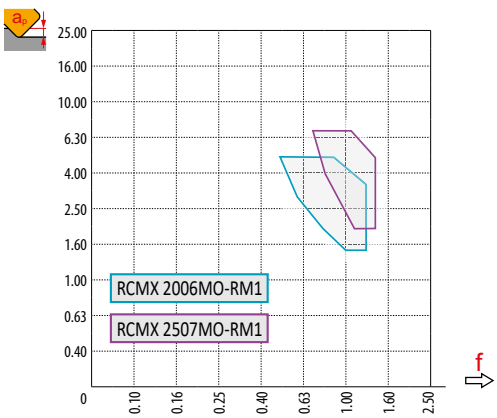
$a_p$ 1.0 (1.5) – 5.0 (7.0)

**RCMX 20, RCMX 25**

## RM1 (RCMX)






| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | | ◪ | | | |

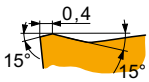
f ⇨ 0.50 (0.70) – 1.30 (1.40)

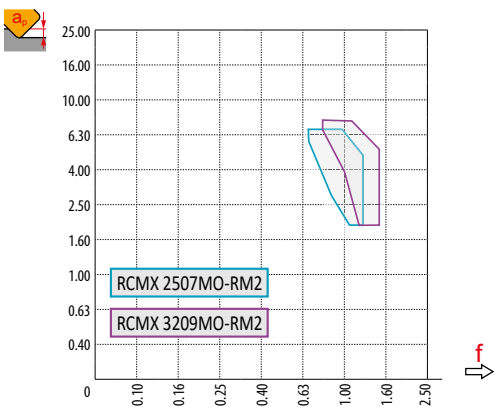
$a_p$ 1.5 (2.0) – 5.0 (8.0)

**RCMX 20, RCMX 25**

## RM2 (RCM.)






| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | | ◪ | | | |

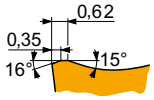
f ⇨ 0.70 (0.80) – 1.30 (1.50)

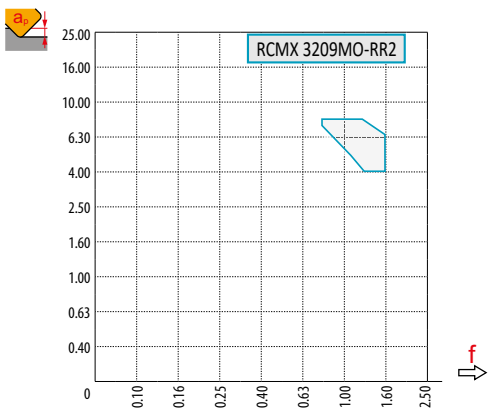
$a_p$ 2.0 – 7.0 (8.0)

**RCMX 25, RCMX 32**

## RR2 (RCM.)






| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | | ■ | | | ◪ |

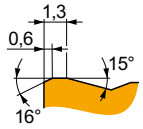
f ⇨ 0.80 – 1.60

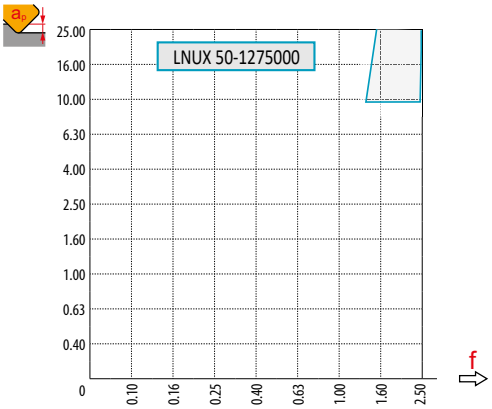
$a_p$ 4.0 – 8.0

**RCMX 32**

## 000 (LNUX)






| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | | ■ | | | |

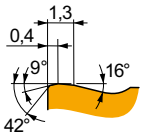
f 1.20 – 2.50

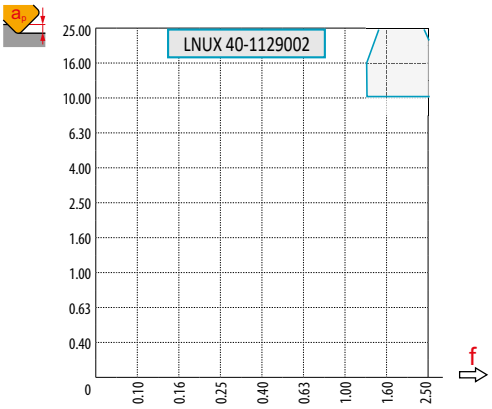
$a_p$ 10.0 – 36.0

**LNUX 50**

## 002 (LNUX)






| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | | ■ | | | |

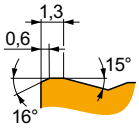
f 1.30 – 2.60

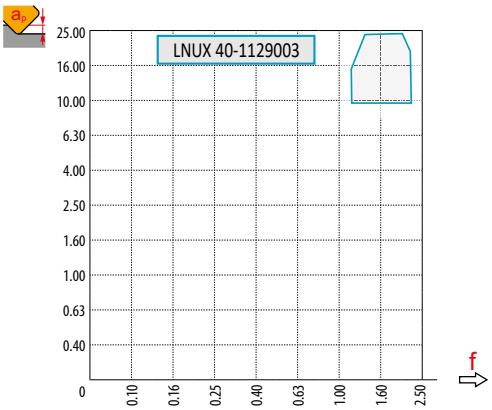
$a_p$ 10.0 – 27.0

**LNUX 40**

## 003 (LNUX)






| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | | ■ | | | |

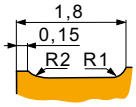
f 1.20 – 2.50

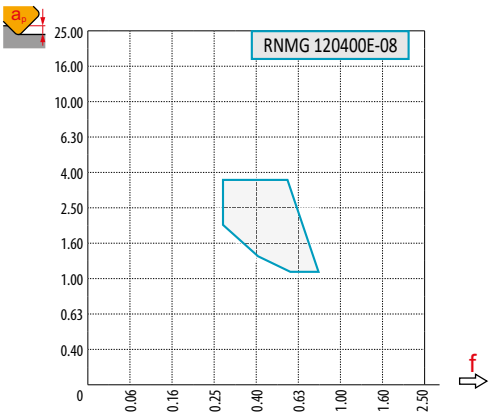
$a_p$ 10.0 – 27.0

**LNUX 40**

## 08 (RNMG)






| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ◪ | | ◪ | | | ◪ |

f 0.30 – 0.80

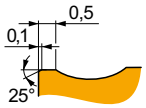
$a_p$ 1.0 – 4.0

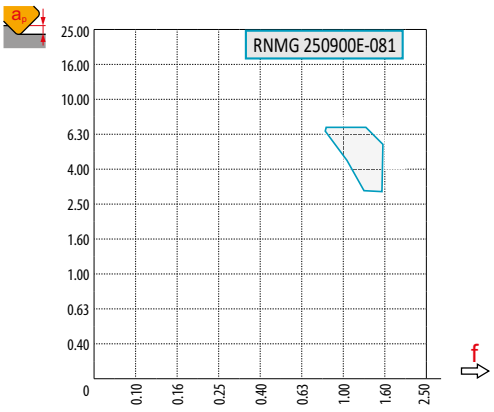
**RNMG**

# GEOMETRY OF CUTTING NEGATIVE INSERTS – CLAMPING DESIGNATION ISO P, M, D

## 81 (RNMG)





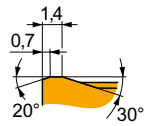

| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ◪ | | ◪ | | | ◪ |

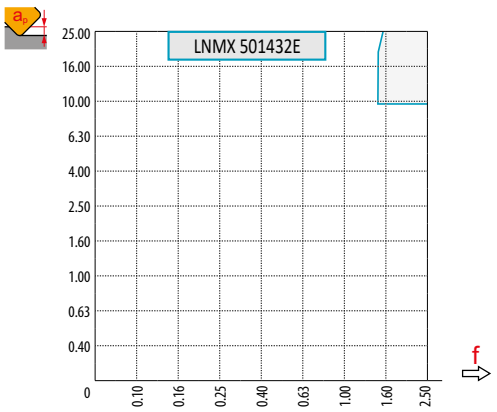
| | |
|---|---|
| f | 0.80 – 1.20 |
| $a_p$ | 3.0 – 7.0 |

**RNMG**

## 432 (LNMX)





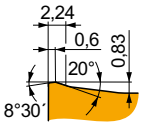

| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | | ■ | | | |

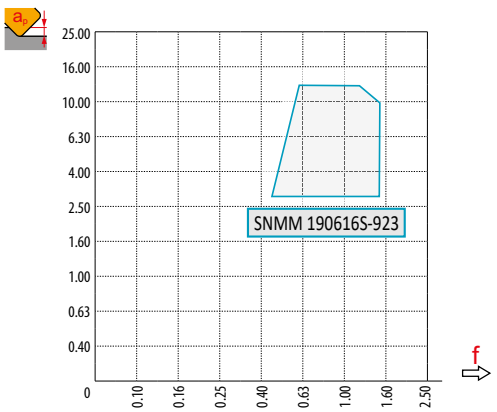
| | |
|---|---|
| f | 1.50 – 2.60 |
| $a_p$ | 10.0 – 35.0 |

**LNMX 50**

## 923





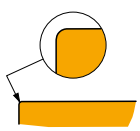

| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ■ | ◪ | | ◪ | |

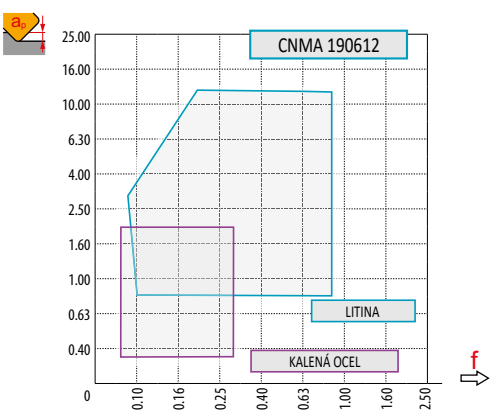
| | |
|---|---|
| f | 0.45 – 1.50 |
| $a_p$ | 3.0 – 16.0 |

**CNMM, SNMM**

## ...A








| P | M | K | N | S | H |
|---|---|---|---|---|---|
| | | ■ | | | ◪ |

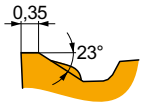
| | |
|---|---|
| f | 0.10 – 1.10 |
| $a_p$ | 0.8 – 12.7 |

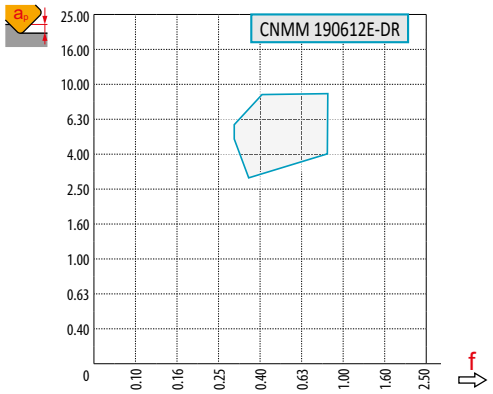
**CNMA, DNMA, SNMA, TNMA, WNMA**

# GEOMETRY OF CUTTING NEGATIVE INSERTS – CLAMPING DESIGNATION ISO P, M, D

## DR






| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ◪ | ◪ | | | |

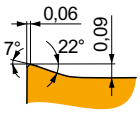
f ⇨ 0.30 – 0.85

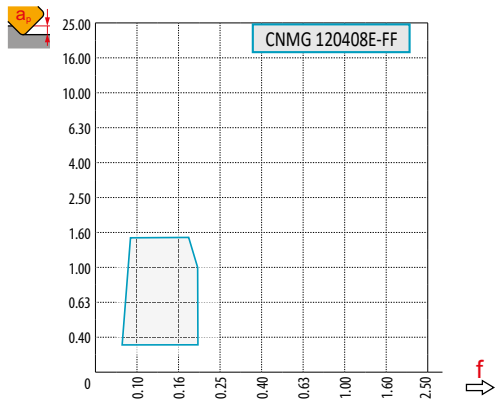
$a_p$ 2.5 – 9.0

CNMM, DNMM, SNMM, TNMM, WNMM

## FF






| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ■ | ◪ | | | |

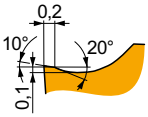
f ⇨ 0.06 – 0.25

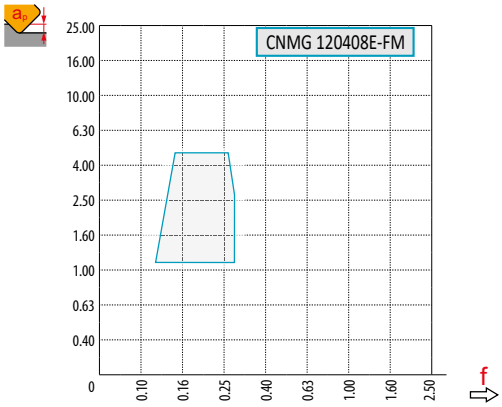
$a_p$ 0.2 – 1.6

CNMG, DNMG, TNMG, VNMG, WNMG

## FM






| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ◪ | ■ | | ◪ | |

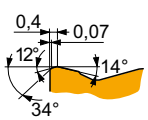
f ⇨ 0.1 – 0.5

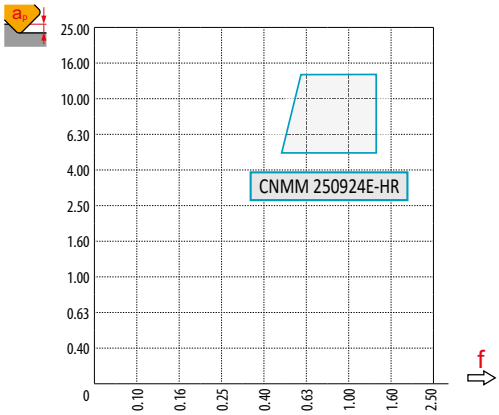
$a_p$ 0.4 – 5.0

CNMG, DNMG, SNMG, TNMG, VNMG, WNMG

## HR






| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ◪ | ■ | | | |

f ⇨ 0.50 – 1.40

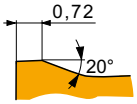
$a_p$ 5.0 – 14.0

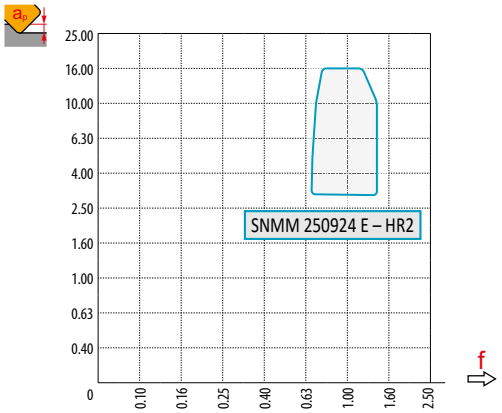
CNMM, SNMM, TNMM

# GEOMETRY OF CUTTING NEGATIVE INSERTS – CLAMPING DESIGNATION ISO P, M, D

## HR2






| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ◪ | ■ | | | |

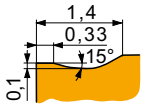
f ⇨ 0.5 – 1.4

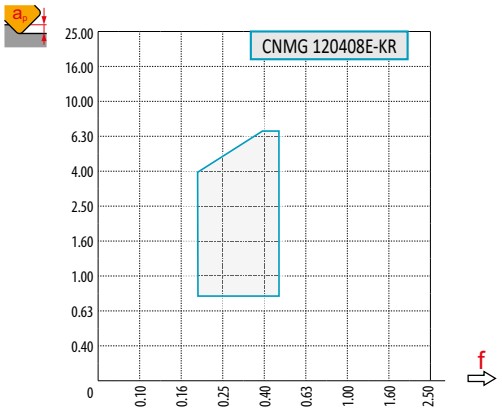
$a_p$ 3.0 – 16.0

CNMM, SNMM

## KR






| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | | ■ | | | ◪ |

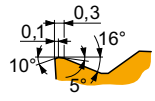
f ⇨ 0.2 – 0.7

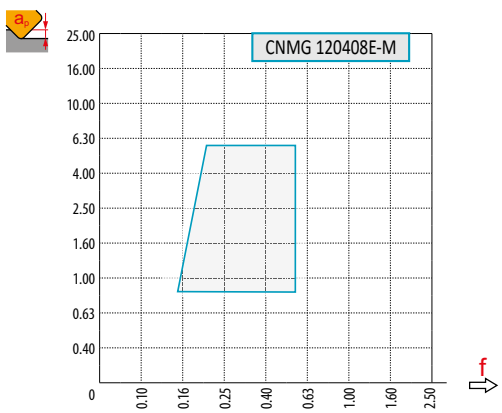
$a_p$ 0.4 – 7

CNMG, SNMG, TNMG, WNMG

## M






| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | | ■ | | | ◪ |

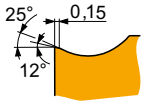
f ⇨ 0.17 – 0.80

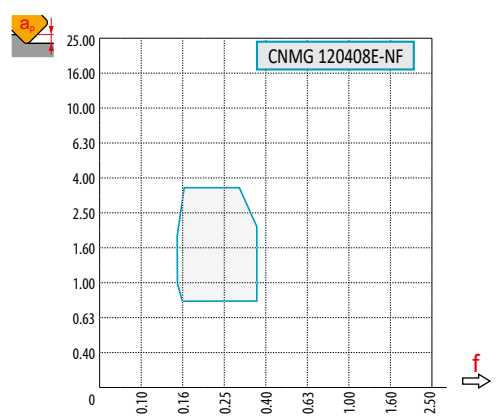
$a_p$ 0.8 – 8.0

CNMG, DNMG, SNMG, TNMG, VNMG, WNMG

## NF






| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ■ | ◪ | ◪ | ◪ | |

f ⇨ 0.1 – 0.35

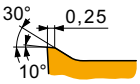
$a_p$ 0.4 – 4.0

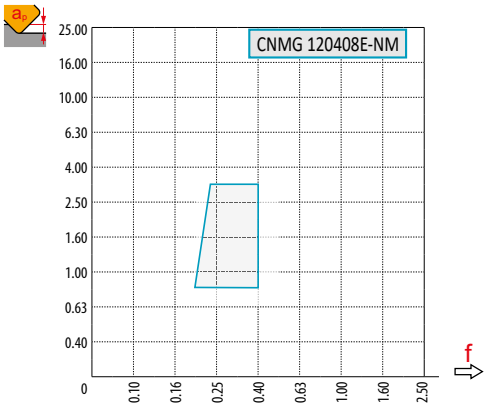
CNMG, DNMG, SNMG, TNMG, VNMG, WNMG

# GEOMETRY OF CUTTING NEGATIVE INSERTS – CLAMPING DESIGNATION ISO P, M, D

## NM






| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ■ | | ◪ | ■ | |

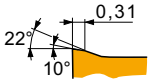
f ⇨ 0.15 – 0.55

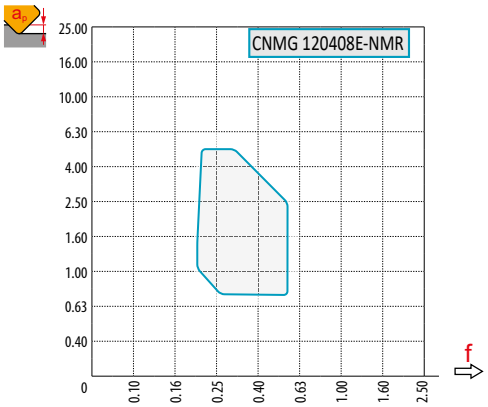
$a_p$ 0.5 – 8.0

CNMG, DNMG, TNMG, VNMG, WNMG

## NMR






| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ■ | | | ■ | |

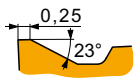
f ⇨ 0.18 – 0.70

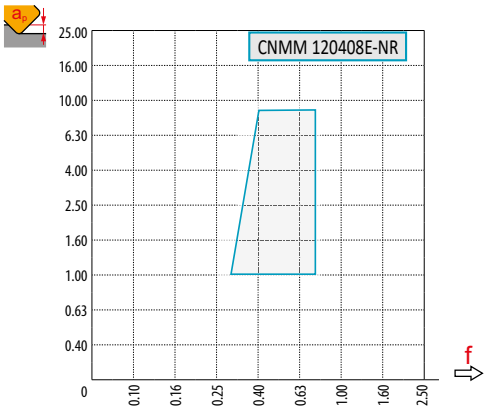
$a_p$ 0.4 – 8.0

CNMG, DNMG, SNMG, TNMG, VNMG, WNMG

## NR






| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ■ | ◪ | | ◪ | |

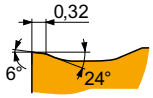
f ⇨ 0.25 – 0.80

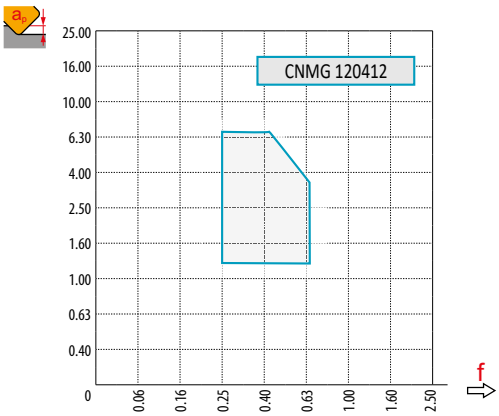
$a_p$ 1.0 – 9.0

CNMM, DNMM, SNMM, TNMM, WNMM

## NRM






| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ■ | | | ■ | |

f ⇨ 0.23 – 1.0

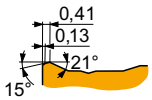
$a_p$ 0.8 – 16.0

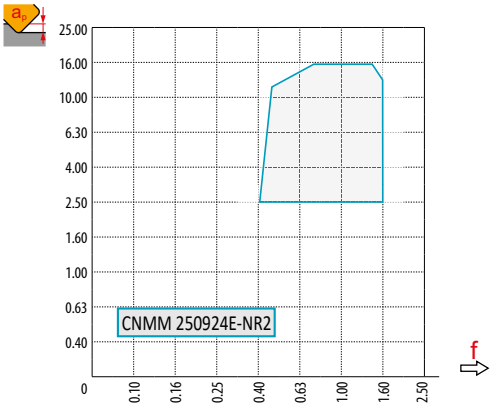
CNMG, CNMM, SNMG, SNMM

# GEOMETRY OF CUTTING NEGATIVE INSERTS – CLAMPING DESIGNATION ISO P, M, D

## NR2






| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ■ | ◪ | | ◪ | |

f ⇨ 0.2 – 1.6

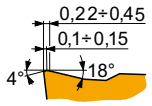
$a_p$ 1.0 – 16.0

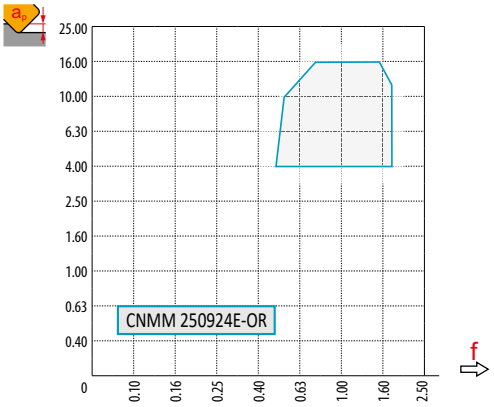


CNMM, DNMM, SNMM, TNMM, WNMM

## OR






| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ◪ | ■ | | ◪ | |

f ⇨ 0.25 – 1.70

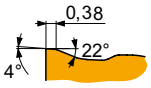
$a_p$ 2.0 – 16.0

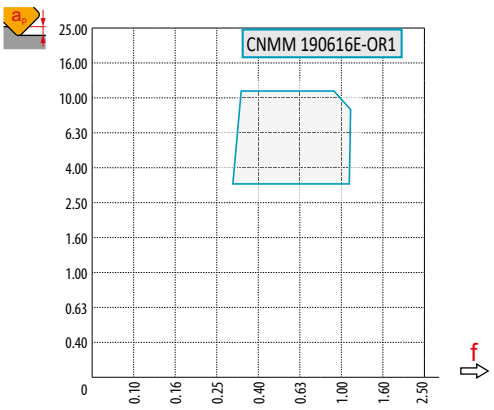


CNMM, DNMM, SNMM, TNMM, WNMM, SCMT

## OR1






| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ◪ | ◪ | | ◪ | |

f ⇨ 0.3 – 1.0

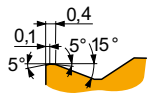
$a_p$ 3.0 – 11.0

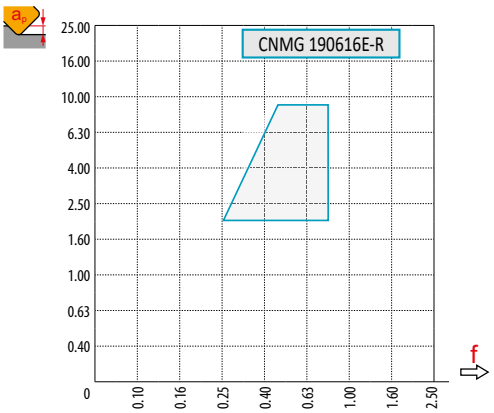


CNMM, SNMM

## R



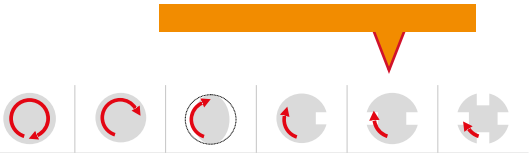



| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | | ■ | | | ◪ |

f ⇨ 0.25 – 0.80

$a_p$ 2.0 – 9.0

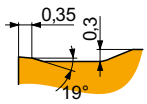


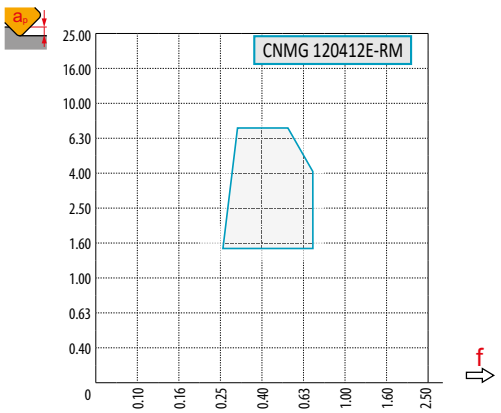
CNMG, DNMG, SNMG, TNMG, WNMG

# GEOMETRY OF CUTTING NEGATIVE INSERTS – CLAMPING DESIGNATION ISO P, M, D

## RM






| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ◪ | ◪ | | | |

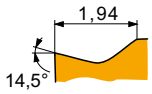
f ⇨ 0.20 – 1.20

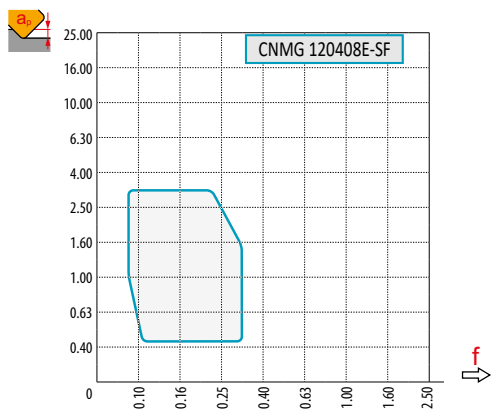
$a_p$ 1.0 – 15.0

CNMG. DNMG, SNMG, TNMG, WNMG

## SF






| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ■ | ■ | ◪ | ■ | ■ |

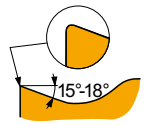
f ⇨ 0.08 – 0.35

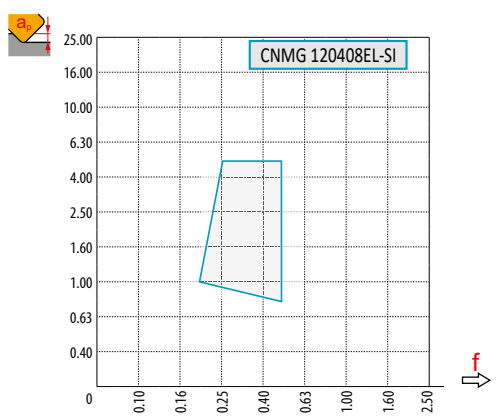
$a_p$ 0.2 – 3.5

CNGG, CNMG, DNMG,
SNMG, TNMG, VNMG, WNMG

## SI





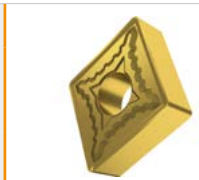

| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ■ | | ◪ | ◪ | |

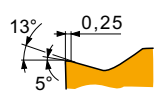
f ⇨ 0.20 – 0.50

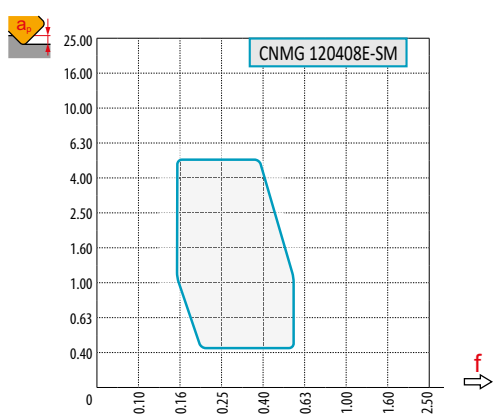
$a_p$ 0.4 – 5.0

CNMG, DNMG, TNMG, WNMG

## SM






| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ■ | ■ | ◪ | ■ | ◪ |

f ⇨ 0.15 – 0.55

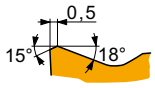
$a_p$ 0.4 – 6.0

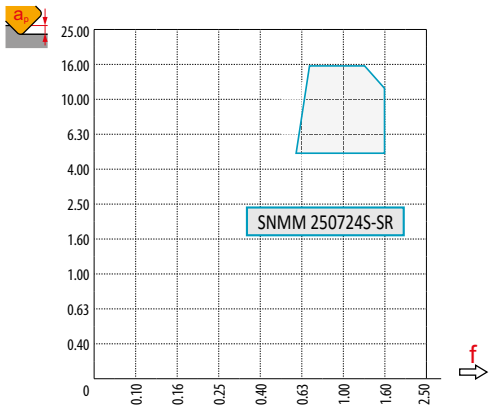
CNMG, DNMG, SNMG, TNMG, VNMG, WNMG

# GEOMETRY OF CUTTING NEGATIVE INSERTS – CLAMPING DESIGNATION ISO P, M, D

## SR






| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ◪ | ■ | | | |

f ⇨ 0.70 – 1.60

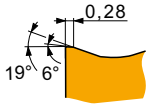
$a_p$ 5.0 – 16.0

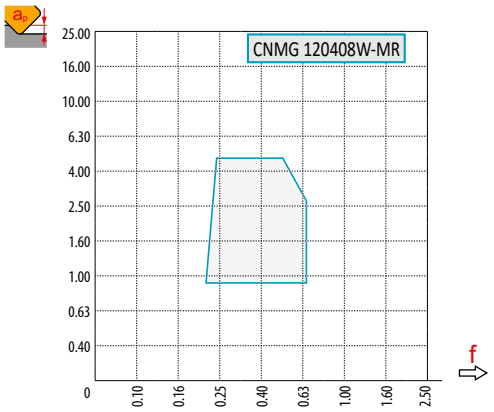


**SNMM, SNMX**

## W–MR



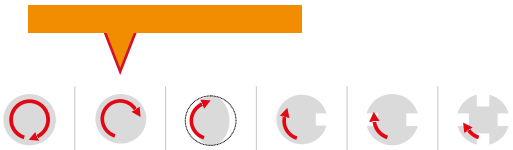



| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ◪ | ◪ | | | |

f ⇨ 0.2 – 0.75

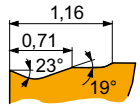
$a_p$ 0.5 – 5.0

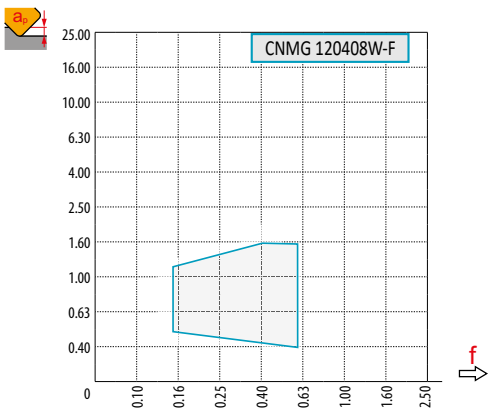


**CNMG, WNMG, DNMG**

## W–F



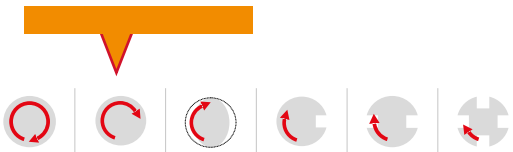



| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | | ■ | | | |

f ⇨ 0.10 – 0.60

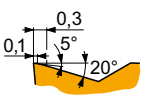
$a_p$ 0.4 – 1.6

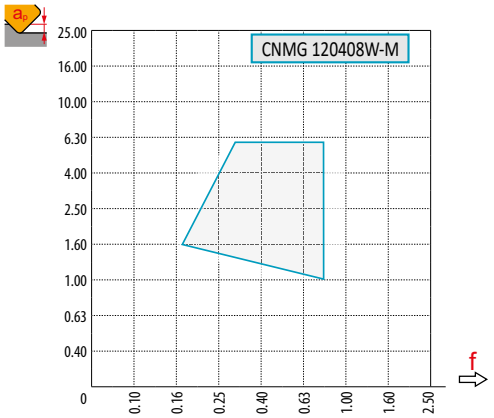


**CNMG, WNMG**

## W–M



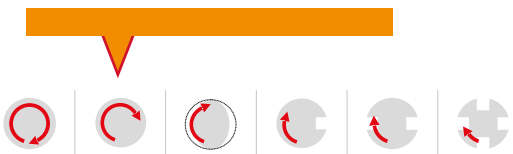



| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | | ◪ | | | |

f ⇨ 0.15 – 1.00

$a_p$ 0.8 – 4.0

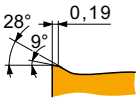


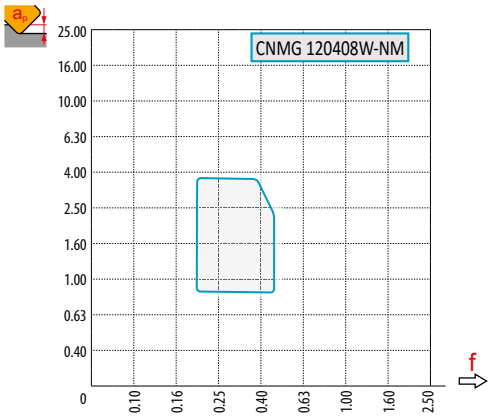
**CNMG, WNMG**

# GEOMETRY OF CUTTING NEGATIVE INSERTS – CLAMPING DESIGNATION ISO P, M, D

**W-NM**

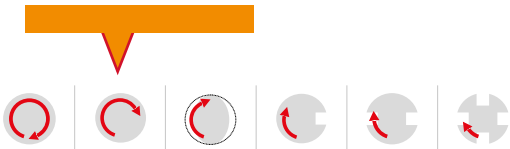





| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ◪ | ◪ | | ◪ | |

| | |
|---|---|
| f | 0.15 – 0.55 |
| $a_p$ | 0.5 – 3.5 |

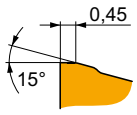


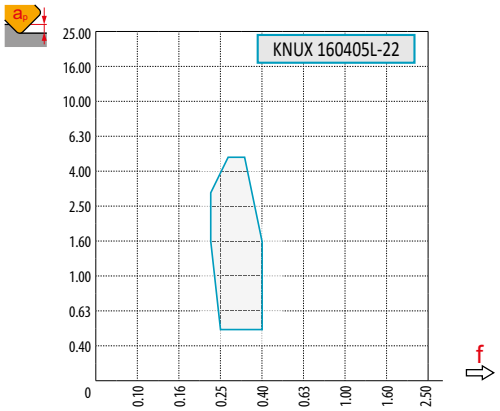
| | |
|---|---|
| ? | CNMG, DNMX, WNMG |

# GEOMETRY OF CUTTING NEGATIVE INSERTS – CLAMPING DESIGNATION ISO C

## 22

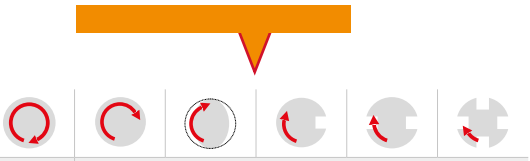





| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ◪ | ◪ | | | |

| | |
|---|---|
| f | 0.23 – 0.55 |
| $a_p$ | 0.50 – 4.80 |

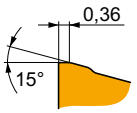


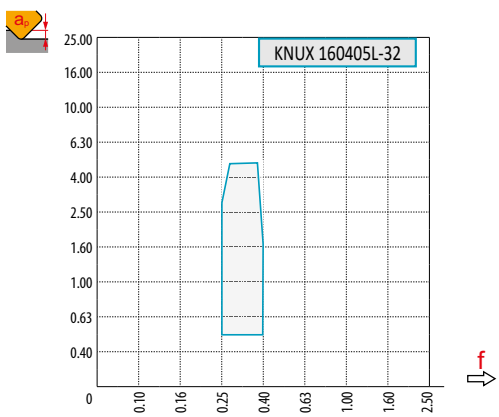


**KNUX**

## 32

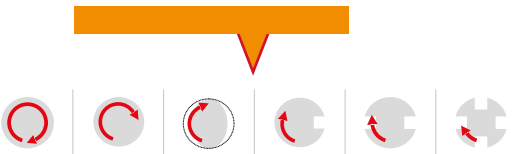





| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ◪ | ◪ | | | |

| | |
|---|---|
| f | 0.25 – 0.6 |
| $a_p$ | 0.50 – 4.80 |

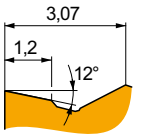


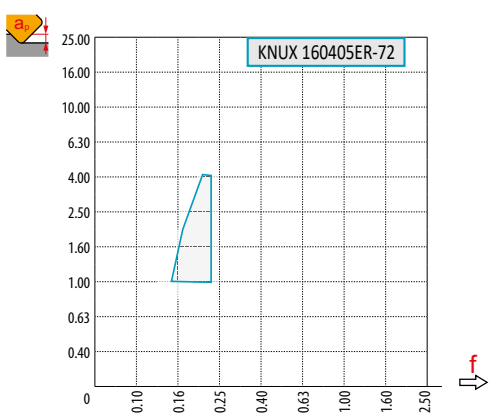


**KNUX**

## 72






| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ◪ | ■ | | ◪ | |

| | |
|---|---|
| f | 0.15 – 0.23 |
| $a_p$ | 1.0 – 4.0 |

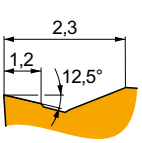


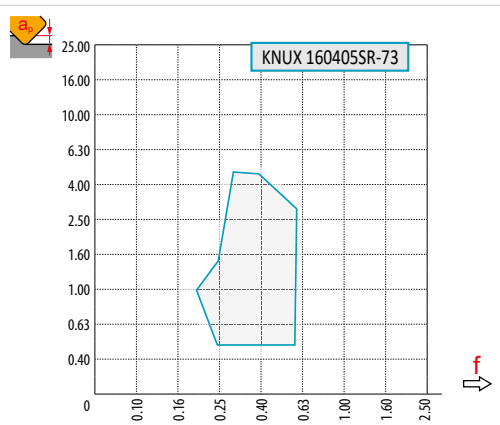


**KNUX**

## 73



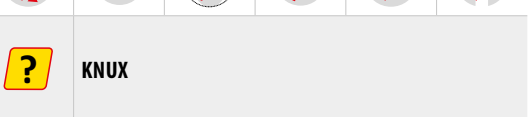



| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ◪ | ■ | | ◪ | |

| | |
|---|---|
| f | 0.20 – 0.60 |
| $a_p$ | 0.5 – 4.8 |



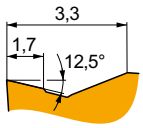


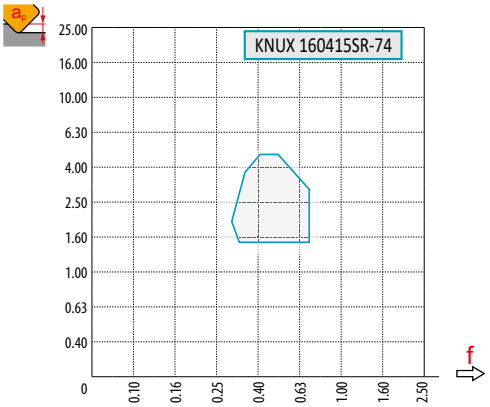
**KNUX**

# GEOMETRY OF CUTTING NEGATIVE INSERTS – CLAMPING DESIGNATION ISO C

74






| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ◪ | ■ | | ◪ | |

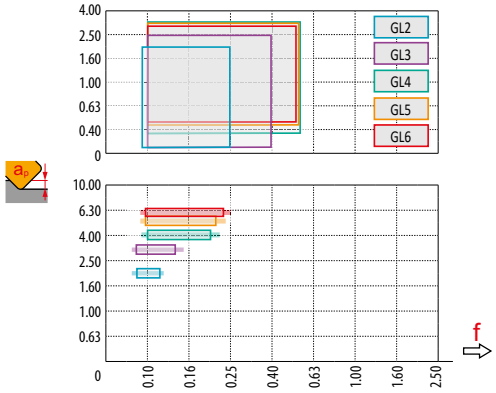
| | |
|---|---|
| f | 0.30 – 0.7 |
| $a_p$ | 1.5 – 4.8 |



| | |
|---|---|
| ? | KNUX |

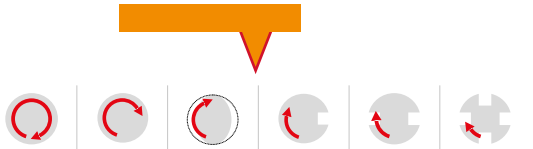
## GM (GL.D) NEW




| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ■ | ◪ | | ◪ | |

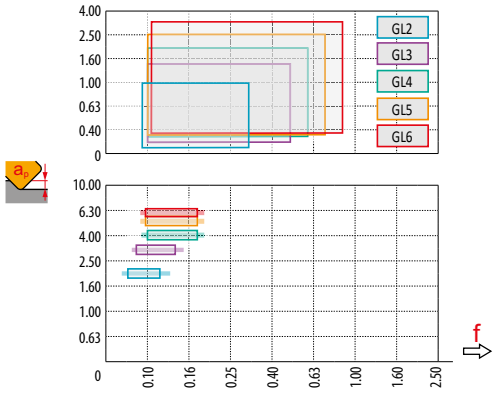
f
$a_p$
See diagram



?
GL. D

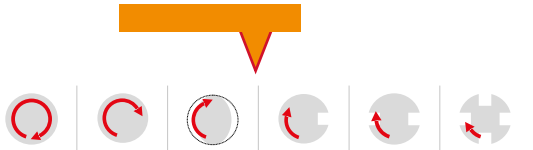
## MM (GL.D) NEW




| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ■ | ■ | | ◪ | |

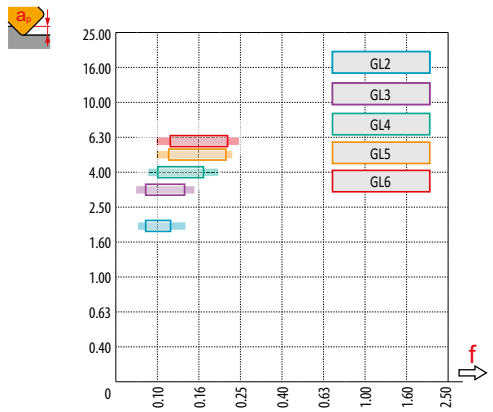
f
$a_p$
See diagram



?
GL. D

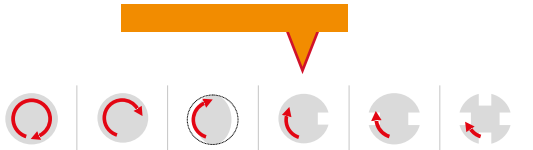
## PM (GL. D) NEW




| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ■ | ◪ | | ◪ | |

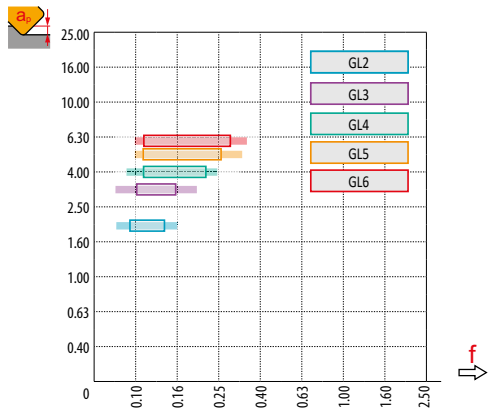
f
$a_p$
See diagram



?
GL. D

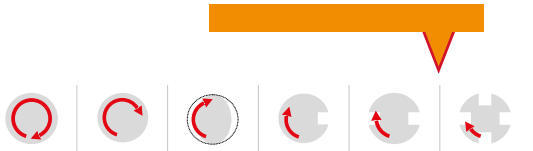
## PR (GL. D) NEW




| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ◪ | ■ | | | |

f
$a_p$
See diagram

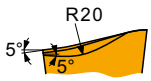


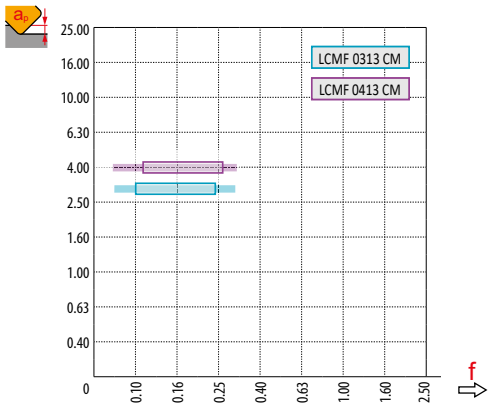
?
GL. D

# GEOMETRY OF CUTTING GROOVING INSERTS – CLAMPING DESIGNATION ISO X AND G

## 13 CM (LCMF)





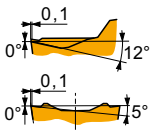

| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | | ◪ | | | |

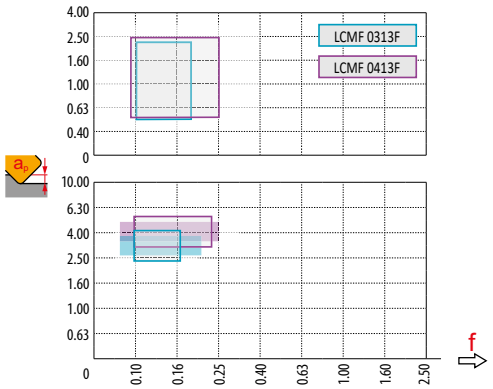
f, $a_p$ — See diagram

**LCMF 13 CM**

## 13 F (LCM.)





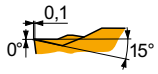

| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | | ◪ | | | |

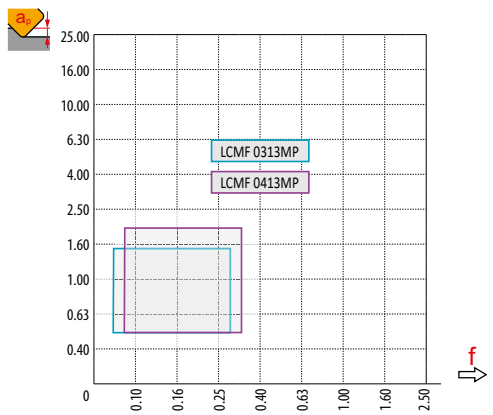
f, $a_p$ — See diagram

**LCMF 13 F, LCMR 13 F**

## 13 MP (LCM.)





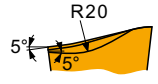

| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | | ■ | | | |

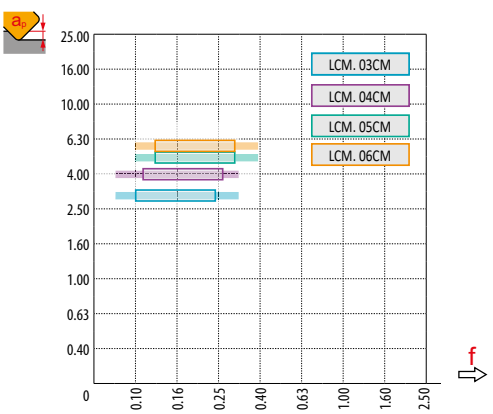
f, $a_p$ — See diagram

**LCMF 13 MP, LCMR 13 MP**

## 16 CM (LCM.)






| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | | ◪ | | | |

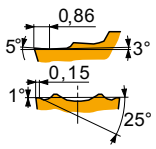
f, $a_p$ — See diagram

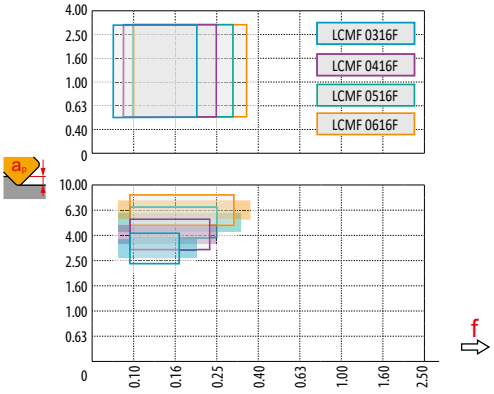
**LCMF 16 CM, LCMR 16 CM**

## GEOMETRY OF CUTTING GROOVING INSERTS – CLAMPING DESIGNATION ISO X AND G

### 16 F (LCM.)





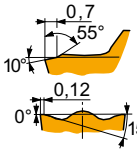

| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | | ◪ | | | |

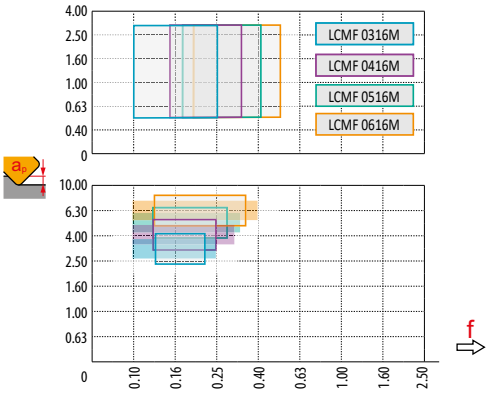
See diagram

**LCMF 16 F, LCMR 16 F**

### 16 M (LCM.)





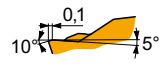

| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | | ■ | | | ◪ |

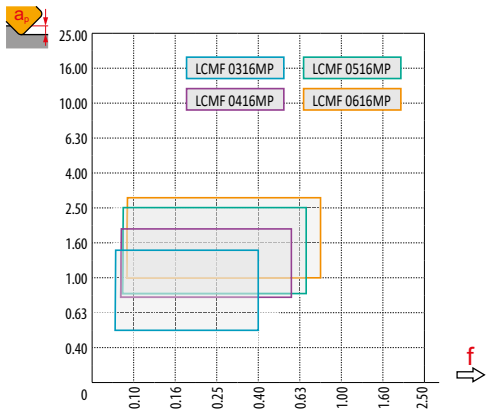
See diagram

**LCMF 16 M, LCMR 16 M**

### 16 MP (LCM.)





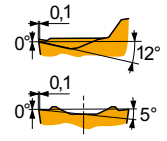

| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | | ■ | | | |

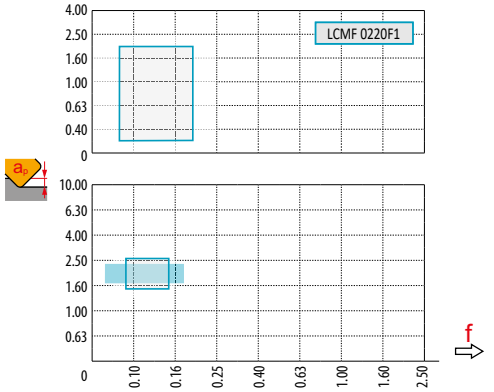
See diagram

**LCMF 16 MP, LCMR 16 MP**

### 20 F1 (LCMF)






| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ◪ | ◪ | | | |

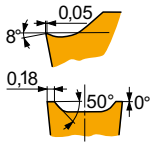
See diagram

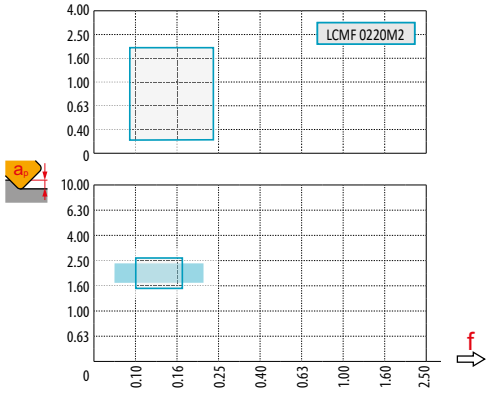
**LCMF**

# GEOMETRY OF CUTTING GROOVING INSERTS – CLAMPING DESIGNATION ISO X AND G

## 20 M2 (LCMF)



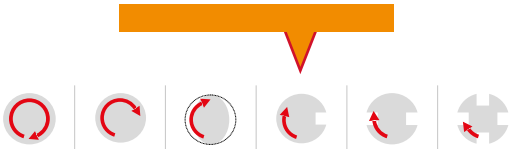



| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ◪ | ◪ | | | |

f ⇨ 0.09 – 0.23

$a_p$ 0.3 – 1.5

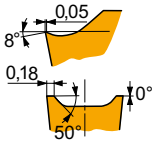


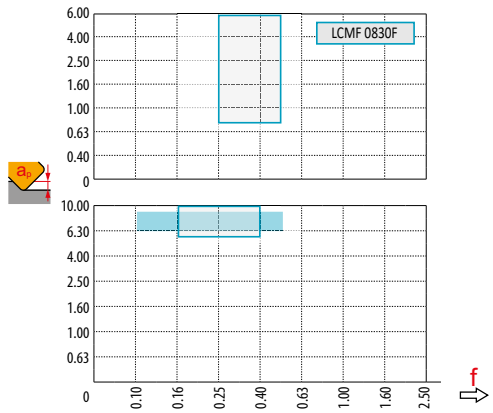


? **LCMF**

## 30 F (LCM.)



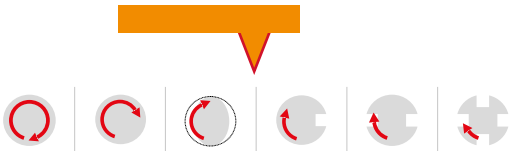



| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | | ◪ | | | |

f ⇨ 0.1 – 0.5

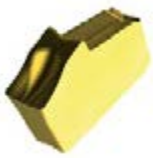
$a_p$ 0.8 – 6.0



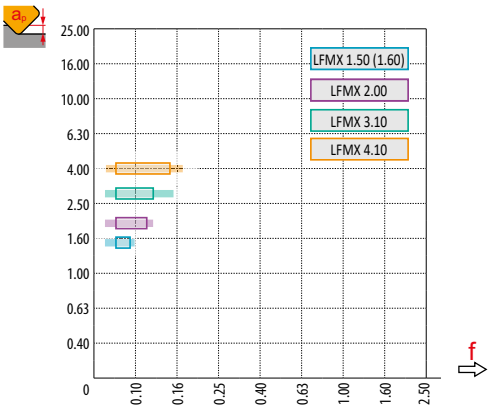


? **LCMF 30 F, LCMR 30 F**

## F1 (LFMX)



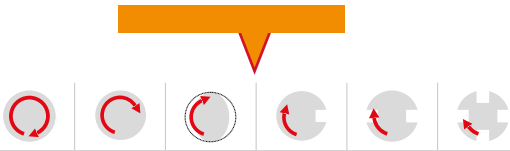



| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ◪ | ■ | | | |

f ⇨

$a_p$ See diagram

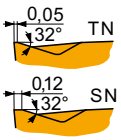


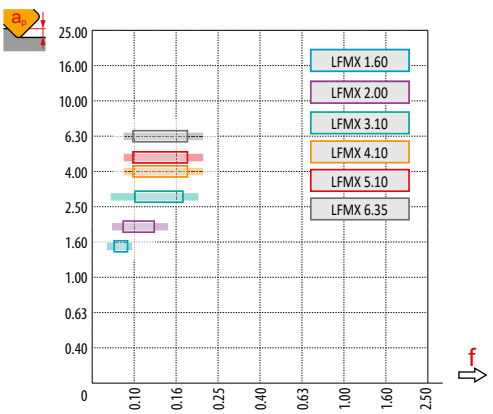


? **LFMX**

## F2 (LFMX)



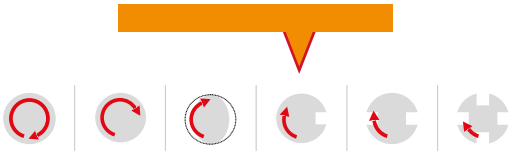



| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ◪ | ■ | | | |

f ⇨

$a_p$ See diagram



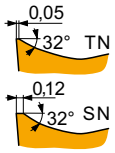


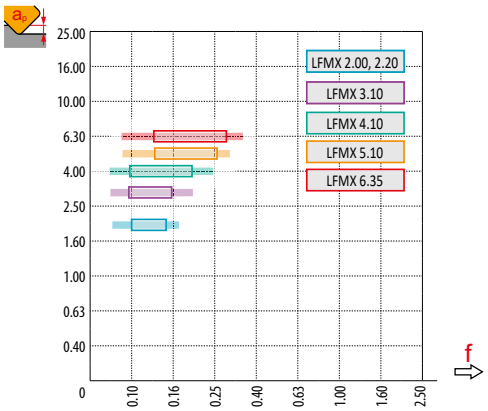
? **LFMX**

## GEOMETRY OF CUTTING GROOVING INSERTS – CLAMPING DESIGNATION ISO X AND G

### M2 (LFMX)



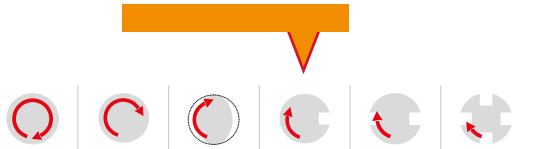



| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ◪ | ◪ | | | |

f
$a_p$

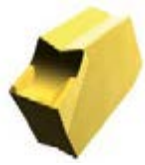
See diagram

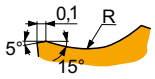


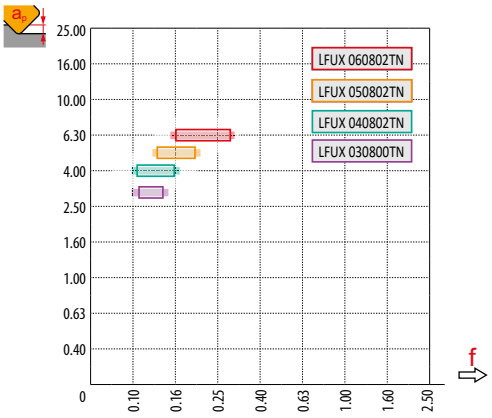
?

**LFMX**

### LFUX



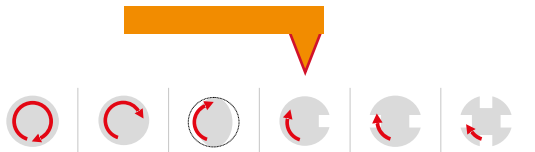



| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | | ■ | | | |

f
$a_p$

See diagram

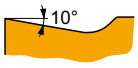


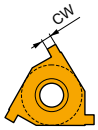
?

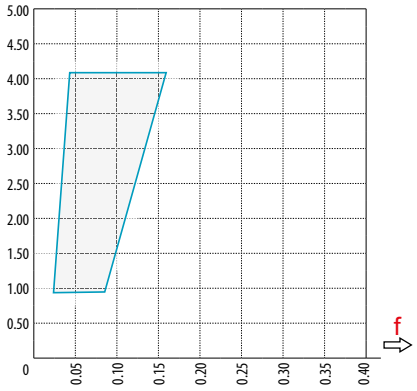
**LFUX**

## TN. EXT



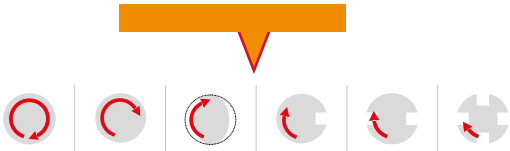



| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ◪ | ◪ | | | |

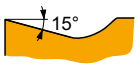
f ⇨ CW — See diagram

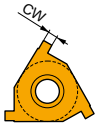


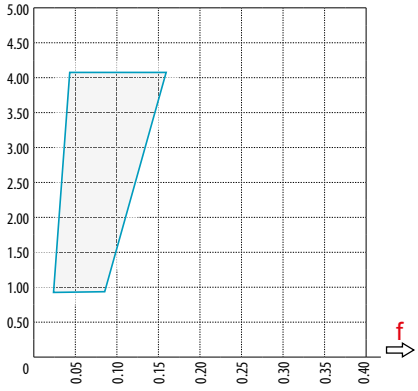
TN R EXT; TN ZZ EXT

## TN. INT



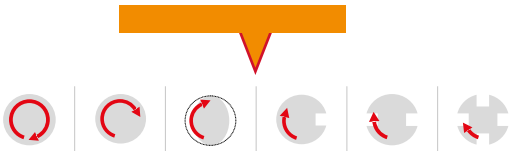



| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ◪ | ◪ | | | |

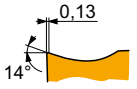
f ⇨ CW — See diagram



TN R INT; TN ZZ INT

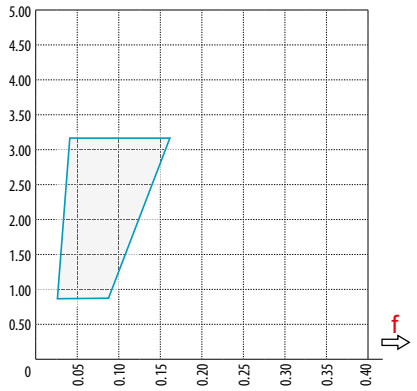
## X61 NEW





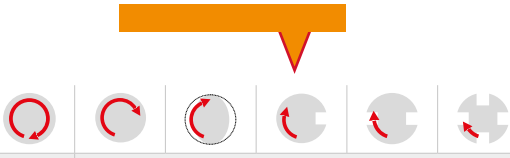







| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ◪ | ◪ | | | |

f ⇨ CW — See diagram



X61; X61-1

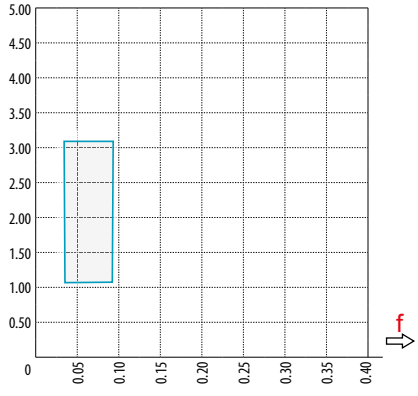
## X61 R NEW





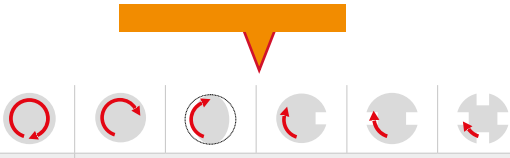







| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ■ | ◪ | ◪ | | | |

f ⇨ CW — See diagram



X61 R; X61 R-1

| T | 9 | 3 | 1 | 5 |
|---|---|---|---|---|
| Operation | Belægning/substrat | Generation | ISO-område | |

| D | Boring |
|---|---|
| M | Fræsning |
| T | Drejning |
| G | Grooving and Parting off |

| 0 PVD<br>1 CVD | Specialanvendelse |
|---|---|
| 2 PVD<br>3 CVD | Fri |
| 4 PVD<br>5 CVD | Gruppe K, H |
| 6 PVD<br>7 CVD | Gruppe M, S |
| 8 PVD<br>9 CVD | Universel |
| B | CBN |
| C | Keramisk |
| D | PCD |
| T | Cermet |

| 1 – 9 |
|---|

| 01 – 50 | |
|---|---|
|  | 01 – 05 |
|  | 05 – 10 |
|  | 10 – 20 |
|  | 20 – 30 |
|  | 30 – 40 |
|  | 40 – 50 |

| Grade Identification | Area of Application | Application | Feed | Cutting speed | Resistance to adverse Working Conditions | Coating | Colour | Substrate | Coolant benefit | Grade description |
|---|---|---|---|---|---|---|---|---|---|---|
| **T9226** | P15 - P35<br>M10 - M30<br>K15 - K35<br>S15 - S25 | ■<br>■<br>◪<br>□ | | | | MT-CVD | | FGM | + + + | Grade designed for heave roughing applications. A versatile grade with high resistance to mechanical damage and retains very good wear resistance. Usable at lower cutting speeds. |
| **T9310** | P01 - P15<br>K05 - K20<br>H10 - H20 | ■<br>◪<br>◪ | | | | MT-CVD | | FGM | + + | Grade with high abrasion resistance which can be used for slightly interrupted cutting. It will be used for finishing or semi-roughing operations. This material can also be used for roughing operations provided the machine-tool-workpiece configuration is sufficiently rigid. |
| **T9315** | P05 - P25<br>K05 - K25<br>H10 - H20 | ■<br>◪<br>◪ | | | | MT-CVD | | FGM | + + | A versatile grade with excellent wear resistance properties even under intense cutting conditions. It can also be used for operations with interrupted cuts. With it's well balanced properties this grade can be first choice for a wide range of turning operations. Not suited to low cutting speeds. |
| **T9316** | P10 - P20<br>M05 - M15<br>K10 - K30<br>H15 - H25 | ■<br>◪<br>■<br>◪ | | | | MT-CVD | | FGM | + + + | Grade designed for railway applications. A versatile grade with excellent wear resistance properties. Usable at lower and high cutting speeds. |
| **T9325** | P15 - P35<br>M10 - M30<br>K15 - K35<br>S10 - S20 | ■<br>■<br>◪<br>◪ | | | | MT-CVD | | FGM | + + | From a technological perspective this is an extremely versatile grade with high resistance to mechanical damage in adverse cutting conditions and retains excellent wear resistance. The correct application of this material requires high cutting speeds. |
| **T9335** | P20 - P45<br>M15 - M40<br>S15 - S25 | ■<br>■<br>◪ | | | | MT-CVD | | FGM | + + + | One of the toughest grades which is especially suitable for adverse cutting conditions at medium to high feed rates and medium cutting speeds. Compared to its predecessors, M15 – M40 it is not only tougher, but also more abrasion resistant which will be useful when using intensive cutting conditions. |
| **T7325** | P15 - P35<br>M10 - M25<br>S10 - S25 | ◪<br>■<br>■ | | | | MT-CVD | | FGM | + + + | One of the most universal turning grades. Especially designed for stainless steel machining. Optimal balance between wear resistance and performance reliability. Suitable for broad variety of application in turning operations. |
| **T7335** | P20 - P40<br>M20 - M40<br>S15 - S25 | ◪<br>■<br>■ | | | | MT-CVD | | FGM | + + + | Grade with functionally graded substrate, featuring very high operational reliability and very good wear-resistance. It is best suited to use in the machining of very tough M20 – M40 materials. |
| **T5305** | P05 - P15<br>K01 - K15<br>H05 - H15 | ◪<br>■<br>◪ | | | | MT-CVD | | H | + | Grade with very high resistance to chemical wear; suitable for finishing operations using high cutting speeds. With its high abrasion resistance, it is also suitable for productive K01 – K15, machining of hardened and treated materials. |
| **T5315** | P10 - P25<br>K10 - K25<br>H15 - H25 | ◪<br>■<br>◪ | | | | MT-CVD | | H | + | Grade intended primarily for productive machining which has high abrasion resistance and good operational reliability. Due to its properties, this material is particularly suitable for roughing and finishing operations for good or slightly adverse cutting conditions. |
| **6640** | P20 - P40<br>M20 - M35<br>K25 - K40 | ■<br>■<br>■ | | | | MT-CVD | | H | + + + | One of the toughest turning materials which can be used especially in roughing operations, or where operational reliability under adverse cutting conditions is a priority. Another ideal choice for machines working with low to medium cutting speeds and medium to high feed rates. |

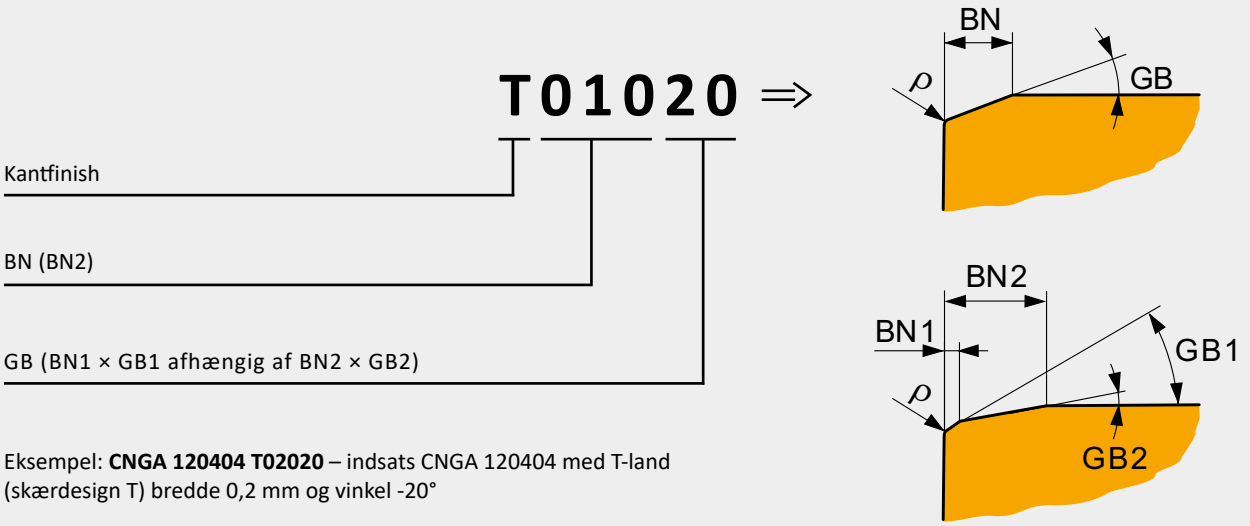
| Grade Identification | Area of Application | Application | Feed | Cutting speed | Resistance to adverse Working Conditions | Coating | Colour | Substrate | Coolant benefit | Grade description |
|---|---|---|---|---|---|---|---|---|---|---|
| **G8330** | P25 - P40<br>M20 - M35<br>K20 - K40<br>S15 - S25 | ■<br>■<br>■<br>◪ | ▰▰▰▰ | ▰▰▱▱ | ▰▰▰▰ | PVD | | submicron H | + + + | Universal cutting grade for grooving and parting-off applications. This grade is characterized by its exceptional reliability and versatility. Developed to fit machining conditions for most workpiece materials. |
| **T0315** | N05 - N20 | ■ | ▰▰▱▱ | ▰▰▰▱ | ▰▰▰▱ | PVD | | submicron H | + + | Submicron grade for turning non-ferrous metals and their alloys with a balance of wear resistance and toughness. It is provided with a unique coating with excellent friction properties. |
| **T6310** | P01 - P15<br>M01 - M15<br>K05 - K20<br>N05 - N20<br>S01 - S15<br>H01 - H15 | ■<br>■<br>■<br>■<br>■<br>■ | ▰▰▰▱ | ▰▰▰▱ | ▰▰▱▱ | PVD | | ultra submicron H | + + + | High wear resistant turning grade with top PVD coating. Suitable for finishing operation and applications, where sharp cutting edge together with high flank wear resistance is of high importance |
| **T8010** | P05 - P15<br>M05 - M15<br>K10 - K20<br>S10 - S15 | ■<br>■<br>■<br>◪ | ▰▰▰▱ | ▰▰▰▱ | ▰▰▰▱ | PVD | | submicron H | + + + | This grade is suitable for continuous high precision thread turning of steels, stainless steel, cast iron and super alloys. Offering excellent wear resistance while ensuring operational reliability |
| **T8030** | P25 - P40<br>M20 - M35<br>K20 - K40<br>N15 - N30<br>S15 - S25 | ■<br>■<br>■<br>◪<br>◪ | ▰▰▰▰ | ▰▰▱▱ | ▰▰▰▰ | PVD | | submicron H | + + + | Undoubtedly the most versatile grade it is suitable for machining all types of materials and can be applied in almost all turning operations. It's main benefits are high operational reliability and excellent frictional properties; it is therefore suited to applications at medium to low cutting speeds. |
| **T8315** | P05 - P20<br>M05 - M20<br>K05 - K25<br>N05 - N25<br>S05 - S15<br>H05 - H15 | ◪<br>■<br>■<br>■<br>◪<br>■ | ▰▰▰▱ | ▰▰▰▱ | ▰▰▰▱ | PVD | | submicron H | + + | Grade featuring excellent abrasion resistance while maintaining above average operational reliability, it is suitable for machining at medium to high cutting speeds in short chipping harder materials. |
| **T8330** | P25 - P40<br>M20 - M35<br>K20 - K40<br>N15 - N30<br>S15 - S25<br>H15 - H25 | ■<br>■<br>■<br>◪<br>◪<br>◪ | ▰▰▰▰ | ▰▰▱▱ | ▰▰▰▰ | PVD | | submicron H | + + + | Undoubtedly the most versatile cutting material, this is useful for machining of all types of machined materials and is practically applicable in almost all types of turning operations. Its main benefits are its high operational reliability and very good frictional properties; it is therefore suitable for applications at medium and lower cutting speeds. |
| **T8430**<br>**NEW** | P20 - P40<br>M20 - M35<br>K25 - K40<br>N15 - N30<br>S15 - S25<br>H15 - H25 | ■<br>■<br>◪<br>◪<br>◪<br>◪ | ▰▰▰▰ | ▰▰▱▱ | ▰▰▰▰ | PVD | | submicron H | + + + | Undoubtedly the most versatile cutting material, this is useful for machining of all types of machined materials and is practically applicable in almost all types of turning operations. Its main benefits are its high operational reliability and very good frictional properties; it is therefore suitable for applications at medium and lower cutting speeds. |
| **T8345** | P30 - P50<br>M20 - M40<br>K30 - K40<br>S20 - S30 | ■<br>◪<br>◪<br>◪ | ▰▰▰▰ | ▰▰▱▱ | ▰▰▰▰+ | PVD | | submicron H | + + + | This is the toughest turning grade, which is intended mainly for machining under the worst cutting conditions and in applications with the highest requirements for operating reliability. Because of these properties, this material is recommended for lower cutting speeds. |
| **HF7** | M10 - M20<br>K10 - K25<br>N10 - N25 | ◪<br>■<br>■ | ▰▰▰▰ | ▰▰▱▱ | ▰▰▰▰ | × | | submicron H | + + | Uncoated grade which is primarily designed for machining non-ferrous metals; but can also be used for other machined materials (except steel). This material can be used in turning, milling, and even boring. |

| Grade Identification | Area of Application | Application | Feed | Cutting speed | Resistance to adverse Working Conditions | Coating | Colour | Substrate | Coolant benefit | Grade description |
|---|---|---|---|---|---|---|---|---|---|---|
| **H07** | M05 - M15<br>K10 - K25<br>N10 - N30<br>S01 - S20 | ◪<br>■<br>■<br>■ | ▰▰▰▱ | ▰▰▰▱ | ▰▰▰▱ | × | | submicron H | + + | Uncoated turning grade suitable for machining applications where oxidation resistance is not dominating criterion of tool life. Designed for machining of Ti-based alloys. Grade exhibits high strength of cutting edge together with good wear resistance. |
| **TT310** | P10 - P25<br>M15 - M25 | ■<br>◪ | ▰▰▱▱ | ▰▰▱▱ | ▰▰▱▱ | PVD | | cermet | + / - | Coated cermet used for fine and finish turning of carbon and alloy steels (including stainless). Its excellent friction properties are further improved by the coating applied using the PVD technique. |
| **TT010** | P01 - P10<br>M01 - M10 | ■<br>◪ | ▰▰▱▱ | ▰▰▱▱ | ▰▰▱▱ | × | | cermet | + / - | Uncoated cermet, which is suitable for fine machining of all types of steel (including stainless) at very low feed rates. Its main advantage is the minimal radius of the cutting edge and its high resistance to physical and chemical wear mechanisms. |
| **TC100** | K01 - K15 | ■ | ▰▰▱▱ | ▰▰▱▱+ | ▰▰▱▱ | × | | ceramics | - - | Ceramic grade for cast iron machining. Suitable for machining with high cutting speed at stable conditions. |
| **TB310** | K01 - K10<br>S05 - S10<br>H01 - H10 | ■<br>◪<br>◪ | ▰▰▱▱ | ▰▰▱▱+ | ▰▰▱▱ | × | | CBN | - - | CBN grade for machining of hardened materials. Suitable for machining with high cutting speed and small feeds at stable conditions. |
| **PD1** | N05 - N25 | ■ | ▰▰▱▱ | ▰▰▱▱+ | ▰▰▱▱ | × | | PCD | - | PKD grade for turning non-ferrous materials. Ideal choice for working with high cutting speed and small feeds at stable conditions. |
| **333TN** | P45 - P50<br>M35 - M40<br>K35 - K40 | ■<br>◪<br>◪ | ▰▰▰▱ | ▰▰▱▱ | ▰▰▰▱+ | PVD | | HSS | + + + | Special grade composed of HSS substrate and thin hard PVD coating. The most tough cutting grade in the portfolio. Inserts with this grade are one and only used for slotting of key groove. |

| Substrat | |
|---|---|
| **H** | WC-Co-baseret substrat |
| **submicron H** | WC-Co-baseret substrat fintkornet (< 1 µm) |
| **ultra submicron H** | WC-Co-baseret substrat meget fintkornet (< 0,5 µm) |
| **FGM** | Substrat med funktionel klassificering |
| **Cermet** | Hårdmetal uden WC |
| **ceramics** | Keramisk skær |
| **PCD** | Polykrystallinsk diamant |
| **CBN** | Kubik bornitrid |
| **HSS** | SS |

| Coating | |
|---|---|
| **MT-CVD** | Kemikaliemetode til belægning ved mellemhøj temperatur |
| **PVD** | Fysisk metode til coating ved lav temperatur |
| × | Ubelagt kvalitet |

| Benefits of cutting fluid | |
|---|---|
| + + + | Use of coolant is essential |
| + + | Highly recommended |
| + | Recommended |
| + / – | Optional |
| – - | Do not use coolant |
| – | Coolant not recommended |

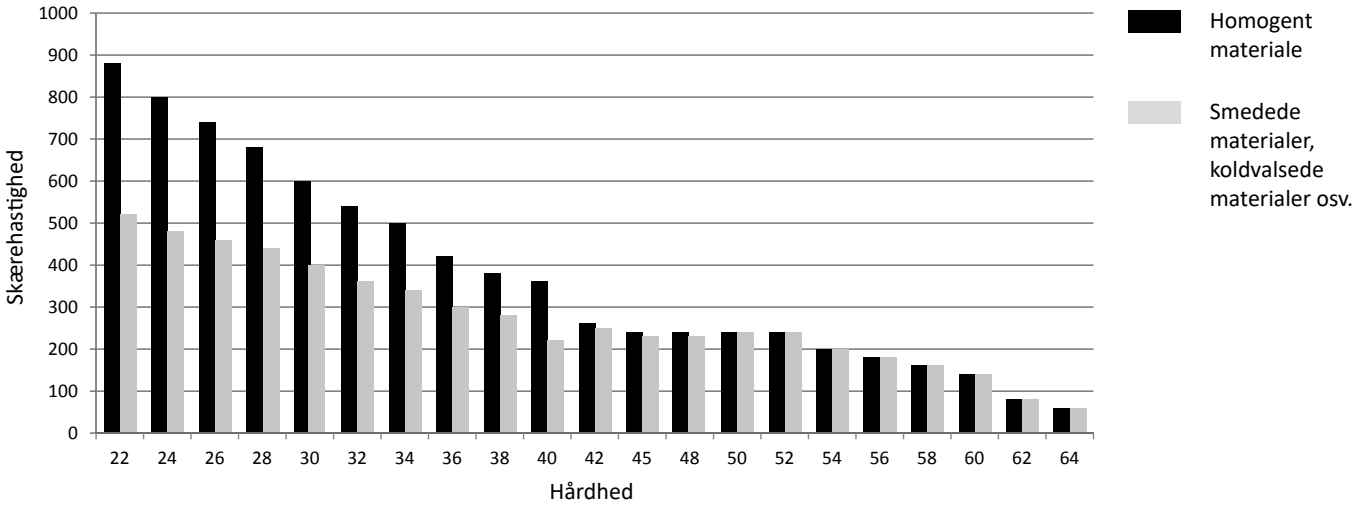



Eksempel: **CNGA 120404 T02020** – indsats CNGA 120404 med T-land (skærdesign T) bredde 0,2 mm og vinkel -20°

Keramiske skær er materialer, der har et af de højeste niveauer af varmestabilitet.
Ved anvendelse i praksis er det dog nødvendigt at reducere skærehastigheden for det maskinbearbejdede materiale og andre egenskaber.

Til illustrationsformål har vi brugt et konkret eksempel med en rund indsats, der bruges til færdigbearbejdning.

**Skærehastighed for RNGN ($a_p$ = 1.5 mm)**



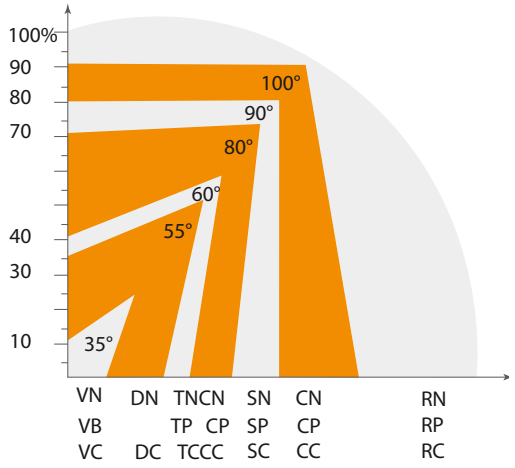

Følgende tabel indeholder yderligere parametre, der skal tages højde for ved valg af den skærehastighed, der skal bruges.

| **Corner radius RE [mm]** | **0.4** | **0.8** | **1.2** | **1.6** | **2.4** | **3** |
|---|---|---|---|---|---|---|
| Reduction $v_c$ by | 20 % | 16 % | 12 % | 10 % | 5 % | 2 % |
| **Main cutting edge angle** | **90°** | **75°** | **60°** | **45°** | **30°** | **< 15°** |
| Reduction $v_c$ by | 0 % | 5 % | 8 % | 12 % | 15 % | 18 % |
| **Insert shape** | **V** | **D** | **T** | **C, W** | **S** | **R** |
| **Corner angle** | 35° | 55° | 60° | 80° | 90° | – |
| Reduction $v_c$ by | 17 % | 12 % | 10 % | 6 % | 4 % | 0 % |
| **Depth of cut $a_p$ [mm]** | **<1.4** | **3** | **6** | **10** | **13** | **20** |
| Reduction $v_c$ by | 5 % | 8 % | 13 % | 16 % | 18 % | 20 % |

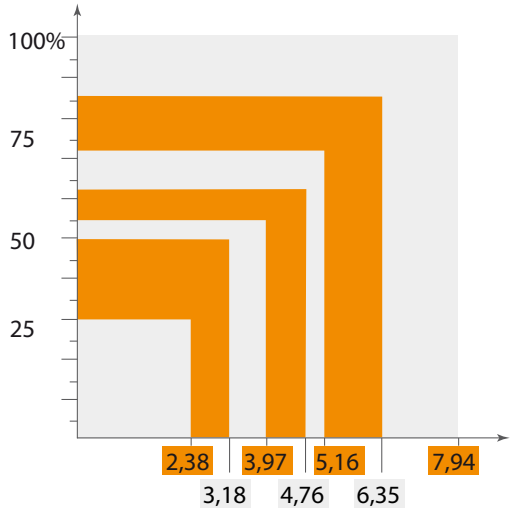
Som tidligere nævnt er keramik et af de materialer, der har det højeste niveau af slidbestandighed, men samtidig har det også et af de laveste styrkeniveauer.

Når det gælder stivhed, er det derfor også nødvendigt at tage højde for andre begrænsende kriterier ved valg af den rette skær.

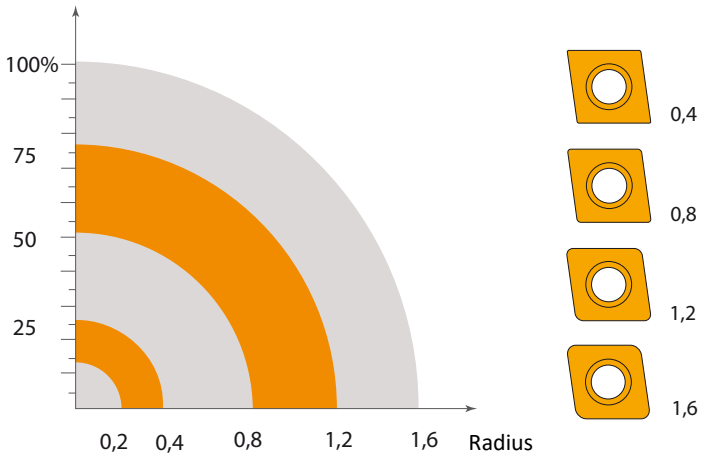
**Stivhed i forhold til skærform**




**Stivhed i forhold til skærtykkelse**

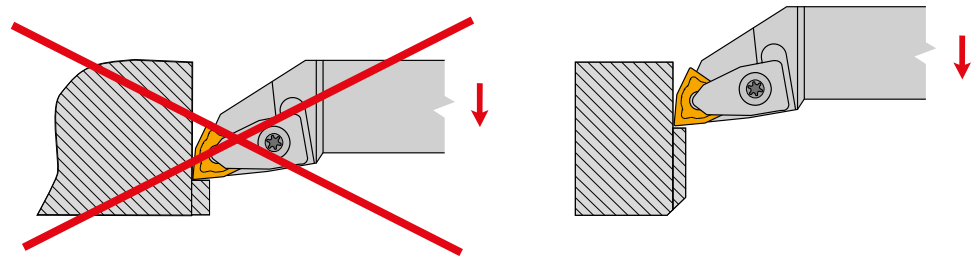



**Stivhed i forhold til næseradie**

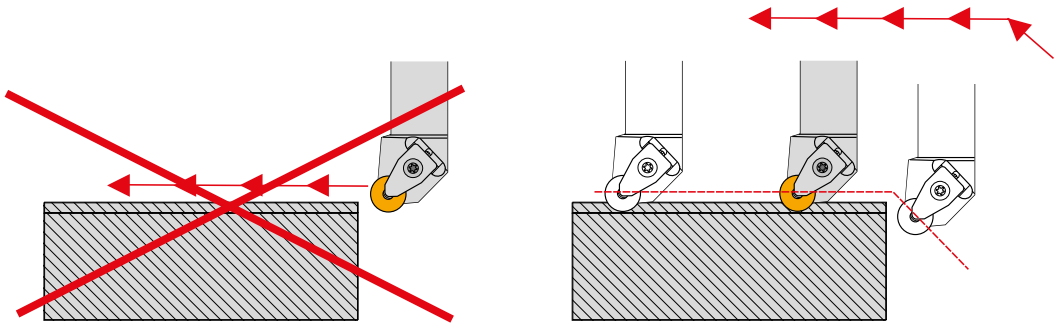


**Til sidst vil vi også gerne komme med nogle praktiske anbefalinger vedrørende praktisk anvendelse:**

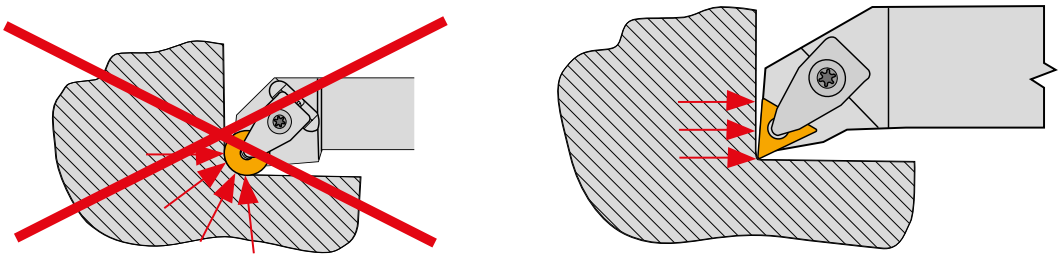
1) Grater ved værktøjets udgang kan medføre skårede skær og beskadige hele skæret. Det er derfor nødvendigt først at affase skæret for at undgå grater.



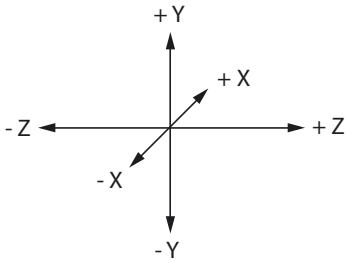
2) Det anbefales at ændre standardprogrammet (tilføjelse af materiale), da det giver mindre dannelse af grater på skæret, hvilket er med til at øge skærets holdbarhed og betyder, at der er mindre behov for affasning af skæret.

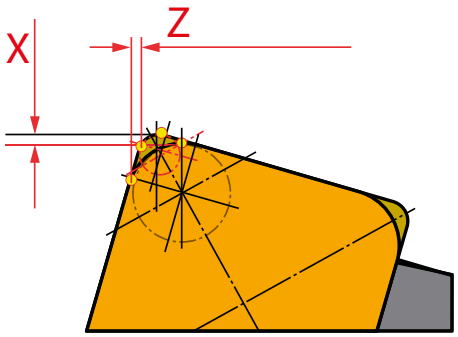


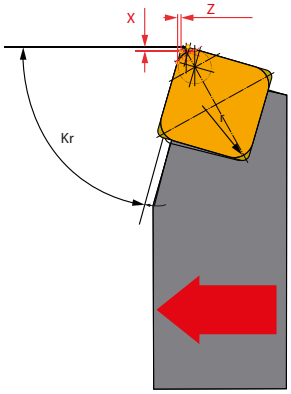
3) Hvis der er risiko for problemer på grund af værktøjsvibration, er det bedre at bruge skær med en mindre radius for at eliminere radialkraft.



**Korrigering af X- og Z-koordinater med radius og holder:**




**BEMÆRK** – Dataene gælder for højresidede holdere, der vender som vist på billede. For indvendige holdere, venstresidede holdere eller andre retninger er det nødvendigt at korrigere eller mærke +/- (til erstatning af værdierne X/Z)

| Holder | | Koordinater | Radius 0,5 | Radius 1,0 | Radius 1,5 | | | | |
|---|---|---|---|---|---|---|---|---|---|
| **Udvendig holder** | CKJNR/L | x | 0.443 | 0.000 | -0.433 | | | | |
| | | z | -0.050 | 0.000 | 0.050 | | | | |

| Holder | | Koordinater | Radius 02 | Radius 04 | Radius 08 | Radius 12 | Radius 16 | Radius 24 | Radius 32 |
|---|---|---|---|---|---|---|---|---|---|
| **Udvendig holder** | DCLNR/L | x | 0.060 | 0.040 | 0.000 | -0.040 | -0.080 | -0.160 | -0.240 |
| | | z | -0.062 | -0.042 | 0.000 | 0.042 | 0.083 | 0.166 | 0.249 |
| | DDJNR/L | x | 0.516 | 0.347 | 0.000 | -0.329 | -0.667 | -1.343 | -2.019 |
| | | z | -0.056 | -0.041 | 0.000 | 0.022 | 0.054 | 0.117 | 0.180 |
| | DSBNR/L | x | 0.252 | 0.170 | 0.000 | -0.158 | -0.322 | -0.649 | -0.977 |
| | | z | 0.422 | 0.280 | 0.000 | -0.285 | -0.568 | -1.134 | -1.700 |
| | DSDNN | x | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 |
| | | z | 0.247 | 0.165 | 0.000 | -0.165 | -0.33 | -0.659 | -0.989 |
| | DSKNR/L | x | 0.134 | 0.089 | 0.000 | -0.089 | -0.178 | -0.358 | -0.537 |
| | | z | -0.167 | -0.111 | 0.000 | 0.111 | 0.222 | 0.444 | 0.667 |
| | DSSNR/L | x | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 |
| | | z | 0.245 | 0.162 | 0.000 | -0.167 | -0.322 | -0.662 | -0.992 |
| | DTFNR/L | x | 0.426 | 0.284 | 0.000 | -0.284 | -0.569 | -1.137 | -1.705 |
| | | z | 0.029 | 0.019 | 0.000 | -0.019 | -0.04 | -0.078 | -0.117 |
| | DTGNR/L | x | 0.437 | 0.294 | 0.000 | -0.277 | -0.562 | -1.133 | -1.703 |
| | | z | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 |
| | DVJNR/L | x | 0.063 | 0.042 | 0.000 | -0.042 | -0.084 | -0.169 | -0.253 |
| | | z | 1.234 | 0.823 | 0.000 | -0.823 | -1.646 | -3.291 | -4.937 |
| | DVPNR/L | x | 0.79 | 0.527 | 0.000 | -0.527 | -1.054 | -2.108 | -3.161 |
| | | z | 0.834 | 0.554 | 0.000 | -0.554 | -1.109 | -2.217 | -3.326 |
| | DWLNR/L | x | 0.061 | 0.044 | 0.000 | -0.026 | -0.061 | -0.131 | -0.200 |
| | | z | -0.063 | -0.045 | 0.000 | 0.027 | 0.062 | 0.134 | 0.206 |

## KORRIGERING AF X- OG Z-KOORDINATER MED RADIUS OG HOLDER

| Holder | | Koordinater | Radius 02 | Radius 04 | Radius 08 | Radius 12 | Radius 16 | Radius 24 | Radius 32 |
|---|---|---|---|---|---|---|---|---|---|
| Indvendig holder | DCLNR/L | x | -0.053 | -0.035 | 0.000 | 0.035 | 0.070 | 0.140 | 0.210 |
| | | z | -0.060 | -0.040 | 0.000 | 0.040 | 0.080 | 0.159 | 0.239 |
| | DDUNR/L | x | -0.512 | -0.341 | 0.000 | 0.0341 | 0.683 | 1.365 | 2.047 |
| | | z | -0.073 | -0.049 | 0.000 | 0.049 | 0.097 | 0.195 | 0.292 |
| | DTFNR/L | x | -0.425 | -0.289 | 0.000 | 0.254 | 0.526 | 1.069 | 1.613 |
| | | z | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 |
| | DVUNR/L | x | 1.254 | -0.836 | 0.000 | 0.836 | 1.671 | 3.343 | 5.014 |
| | | z | -0.129 | -0.086 | 0.000 | 0.086 | 0.172 | 0.344 | 0.516 |
| | DWLNR/L | x | -0.053 | -0.035 | 0.000 | 0.035 | 0.07 | 0.14 | 0.21 |
| | | z | -0.06 | -0.04 | 0.000 | 0.04 | 0.08 | 0.159 | 0.239 |
| Udvendig holder | MTJNR/L | x | 0.437 | 0.294 | 0.000 | -0.277 | -0.562 | -1.133 | -1.703 |
| | | z | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 |
| | MVJNR/L | x | 1.263 | 0.847 | 0.000 | -0.819 | -1.651 | -3.317 | -4.982 |
| | | z | -0.075 | -0.055 | 0.000 | 0.025 | 0.065 | 0.146 | 0.226 |
| | MWLNR/L | x | 0.609 | 0.044 | 0.000 | -0.026 | -0.061 | -0.131 | -0.200 |
| | | z | -0.063 | -0.045 | 0.000 | 0.027 | 0.062 | 0.134 | 0.206 |
| | PCBNR/L | x | 0.045 | 0.033 | 0.000 | -0.016 | -0.040 | -0.088 | -0.137 |
| | | z | 0.128 | 0.083 | 0.000 | -0.096 | -0.185 | -0.364 | -0.543 |
| | PCKNR/L | x | 0.171 | 0.115 | 0.000 | -0.110 | -0.223 | -0.448 | -0.672 |
| | | z | 0.685 | 0.457 | 0.000 | -0.457 | -0.914 | -1.827 | -2.741 |
| | PCLNR/L | x | 0.061 | 0.044 | 0.000 | -0.026 | -0.061 | -0.131 | -0.200 |
| | | z | -0.063 | -0.045 | 0.000 | 0.027 | 0.062 | 0.134 | 0.206 |
| | PDJNR/L | x | 0.516 | 0.347 | 0.000 | -0.329 | -0.667 | -1.343 | -2.019 |
| | | z | -0.056 | -0.041 | 0.000 | 0.022 | 0.054 | 0.117 | 0.180 |
| | PDNNR/L | x | 0.699 | 0.469 | 0.000 | -0.453 | -0.915 | -1.837 | -2.759 |
| | | z | 0.524 | 0.348 | 0.000 | -0.357 | -0.710 | -1.415 | -2.120 |
| | PDXNR/L | x | 0.453 | 0.305 | 0.000 | -0.288 | -0.584 | -1.177 | -1.770 |
| | | z | -0.156 | -0.107 | 0.000 | 0.088 | 0.185 | 0.380 | 0.575 |
| | PLBNR/L | x | 0.137 | 0.094 | 0.000 | -0.078 | -0.163 | -0.335 | -0.507 |
| | | z | 0.153 | 0.100 | 0.000 | -0.110 | -0.220 | -0.433 | -0.646 |
| | PSBNR/L | x | 0.137 | 0.094 | 0.000 | -0.078 | -0.163 | -0.335 | -0.507 |
| | | z | 0.153 | 0.100 | 0.000 | -0.110 | -0.220 | -0.433 | -0.646 |
| | PSDNN | x | 0.252 | 0.170 | 0.000 | -0.158 | -0.322 | -0.649 | -0.977 |
| | | z | 0.422 | 0.280 | 0.000 | -0.285 | -0.568 | -1.134 | -1.699 |
| | PSKNR/L | x | 0.140 | 0.094 | 0.000 | -0.090 | -0.152 | -0.366 | -0.550 |
| | | z | 0.574 | 0.383 | 0.000 | -0.384 | -0.767 | -1.533 | -2.300 |
| | PSSNR/L | x | 0.246 | 0.164 | 0.000 | -0.164 | -0.328 | -0.656 | -0.983 |
| | | z | 0.424 | 0.283 | 0.000 | -0.283 | -0.566 | -1.131 | -1.697 |
| | PTFNR/L | x | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 |
| | | z | -0.411 | -0.243 | 0.000 | 0.429 | 0.765 | 1.437 | 2.110 |
| | PTGNR/L | x | 0.437 | 0.294 | 0.000 | -0.277 | -0.562 | -1.133 | -1.703 |
| | | z | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 |
| | PTTNR/L | x | 0.601 | 0.403 | 0.000 | -0.389 | -0.784 | -1.575 | -2.367 |
| | | z | 0.519 | 0.345 | 0.000 | -0.354 | -0.703 | -1.401 | -2.099 |
| | PWLNR/L | x | 0.609 | 0.044 | 0.000 | -0.026 | -0.061 | -0.131 | -0.200 |
| | | z | -0.063 | -0.045 | 0.000 | 0.027 | 0.062 | 0.134 | 0.206 |
| Indvendig holder | PCLNR/L | x | -0.061 | -0.046 | 0.000 | 0.012 | 0.040 | 0.098 | 0.156 |
| | | z | -0.062 | -0.047 | 0.000 | 0.015 | 0.046 | 0.160 | 0.169 |
| | PDUNR/L | x | -0.500 | -0.339 | 0.000 | 0.305 | 0.627 | 1.271 | 1.915 |
| | | z | -0.052 | -0.040 | 0.000 | 0.006 | 0.029 | 0.076 | 0.122 |
| | PSKNR/L | x | -0.153 | -0.097 | 0.000 | 0.063 | 0.143 | 0.303 | 0.463 |
| | | z | 0.137 | 0.098 | 0.000 | -0.124 | -0.234 | -0.456 | -0.677 |
| | PTFNR/L | x | -0.425 | -0.289 | 0.000 | 0.254 | 0.526 | 1.069 | 1.613 |
| | | z | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 |
| | PWLNR/L | x | -0.060 | -0.046 | 0.000 | 0.012 | 0.043 | 0.098 | 0.156 |
| | | z | -0.065 | -0.049 | 0.000 | 0.012 | 0.040 | 0.105 | 0.166 |

## KORRIGERING AF X- OG Z-KOORDINATER MED RADIUS OG HOLDER

| Holder | | Koordinater | Radius 02 | Radius 04 | Radius 08 | Radius 12 | Radius 16 | Radius 24 | Radius 32 |
|---|---|---|---|---|---|---|---|---|---|
| Udvendig holder | SCACR/L | x | 0.115 | 0.077 | 0.000 | -0.077 | -0.153 | -0.307 | -0.460 |
| | | z | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 |
| | SCBCR/L | x | 0.042 | 0.028 | 0.000 | -0.028 | -0.055 | -0.111 | -0.166 |
| | | z | 0.130 | 0.087 | 0.000 | -0.087 | -0.174 | -0.347 | -0.521 |
| | SCDCR/L | x | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 |
| | | z | -0.279 | -0.186 | 0.000 | 0.186 | 0.372 | 0.745 | 1.117 |
| | SCFCR/L | x | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 |
| | | z | -0.124 | -0.083 | 0.000 | 0.083 | 0.166 | 0.331 | 0.497 |
| | SCLCR/L | x | 0.060 | 0.040 | 0.000 | -0.040 | -0.080 | -0.160 | -0.240 |
| | | z | -0.062 | -0.042 | 0.000 | 0.042 | 0.083 | 0.166 | 0.249 |
| | SDJCR/L | x | 0.520 | 0.346 | 0.000 | -0.346 | -0.693 | -1.386 | -2.078 |
| | | z | -0.060 | -0.040 | 0.000 | 0.040 | 0.080 | 0.161 | 0.241 |
| | SDNCN | x | 0.699 | 0.466 | 0.000 | -0.466 | -0.933 | -1.865 | -2.798 |
| | | z | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 |
| | SEGCR/L | x | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 |
| | | z | -0.182 | -0.121 | 0.000 | 0.121 | 0.243 | 0.485 | 0.728 |
| | SSBCR/L | x | 0.135 | 0.090 | 0.000 | -0.090 | -0.180 | -0.360 | -0.539 |
| | | z | 0.155 | 0.104 | 0.000 | -0.104 | -0.207 | -0.414 | -0.621 |
| | SSDCN | x | 0.249 | 0.166 | 0.000 | -0.166 | -0.331 | -0.663 | -0.994 |
| | | z | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 |
| | SSKCR/L | x | -0.376 | -0.517 | 0.000 | -1.083 | -1.366 | -1.931 | -2.497 |
| | | z | -0.135 | -0.090 | 0.000 | 0.090 | 0.180 | 0.360 | 0.539 |
| | STCFR/L | x | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 |
| | | z | – | – | 0.000 | – | – | – | – |
| | STJCR/L | x | 0.406 | 0.271 | 0.000 | -0.271 | -0.542 | -1.084 | -1.626 |
| | | z | -0.054 | -0.036 | 0.000 | 0.036 | 0.071 | 0.143 | -0.214 |
| | SVACR/L | x | 00 / 0 | 01 / – 0.107 | – | – | – | – | – |
| | | z | 00 / 0 | 01 / – 0.107 | – | – | – | – | – |
| | SVGCR/L | x | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 |
| | | z | -1.303 | -0.869 | 0.000 | 0.869 | 1.737 | 3.475 | 5.212 |
| | SVHBR/L | x | 1.034 | 0.690 | 0.000 | -0.690 | -1.379 | -2.759 | -4.138 |
| | | z | -0.544 | -0.363 | 0.000 | 0.363 | 0.726 | 1.452 | 2.178 |
| | SVHCR/L | x | 1.034 | 0.690 | 0.000 | -0.690 | -1.379 | -2.759 | -4.138 |
| | | z | -0.544 | -0.363 | 0.000 | 0.363 | 0.726 | 1.452 | 2.178 |
| | SVJBR/L | x | 1.269 | 0.846 | 0.000 | -0.846 | -1.692 | -3.384 | -5.076 |
| | | z | -0.099 | -0.066 | 0.000 | 0.066 | 0.132 | 0.263 | 0.395 |
| | SVJCR/L | x | 1.269 | 0.846 | 0.000 | -0.846 | -1.692 | -3.384 | -5.076 |
| | | z | -0.099 | -0.066 | 0.000 | 0.066 | 0.132 | 0.263 | 0.395 |
| | SVPBR/L | x | 0.811 | 0.541 | 0.000 | -0.541 | -1.081 | -2.162 | -3.244 |
| | | z | -0.811 | -0.541 | 0.000 | 0.541 | 1.081 | 2.162 | 3.244 |
| | SVPCR/L | x | 0.811 | 0.541 | 0.000 | -0.541 | -1.081 | -2.162 | -3.244 |
| | | z | -0.811 | -0.541 | 0.000 | 0.541 | 1.081 | 2.162 | 3.244 |
| | SVVBN | x | 1.395 | 0.930 | 0.000 | -0.930 | -1.860 | -3.721 | -5.581 |
| | | z | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 |
| | SVVCN | x | 1.395 | 0.930 | 0.000 | -0.930 | -1.860 | -3.721 | -5.581 |
| | | z | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 |
| | SVXBR/L | x | 1.201 | 0.801 | 0.000 | -0.080 | -1.601 | -3.202 | -4.804 |
| | | z | -0.259 | -0.173 | 0.000 | 0.173 | 0.345 | 0.691 | 1.036 |
| | SVXCR/L | x | 1.201 | 0.801 | 0.000 | -0.080 | -1.601 | -3.202 | -4.804 |
| | | z | -0.259 | -0.173 | 0.000 | 0.173 | 0.345 | 0.691 | 1.036 |
| | SWLCR/L | x | 0.060 | 0.040 | 0.000 | -0.040 | -0.080 | -0.160 | -0.240 |
| | | z | -0.060 | -0.040 | 0.000 | 0.040 | 0.080 | 0.160 | 0.240 |

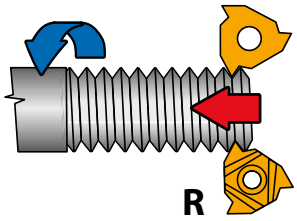
## KORRIGERING AF X- OG Z-KOORDINATER MED RADIUS OG HOLDER

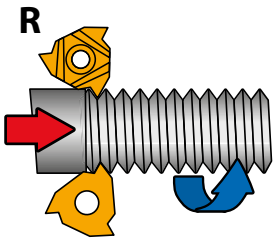
| Holder | | Koordinater | Radius 02 | Radius 04 | Radius 08 | Radius 12 | Radius 16 | Radius 24 | Radius 32 |
|---|---|---|---|---|---|---|---|---|---|
| Indvendig holder | SCFCR/L | x | -0.420 | -0.280 | 0.000 | 0.280 | 0.560 | 1.121 | 1.681 |
| | | z | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 |
| | SCKCR/L | x | -0.040 | -0.027 | 0.000 | 0.027 | 0.054 | 0.108 | 0.161 |
| | | z | 0.130 | 0.087 | 0.000 | -0.087 | -0.174 | -0.348 | 0.521 |
| | SCLCR/L | x | -0.058 | -0.039 | 0.000 | 0.039 | 0.078 | 0.155 | 0.233 |
| | | z | -0.062 | -0.042 | 0.000 | 0.042 | 0.083 | 0.166 | 0.249 |
| | SCXCR/L | x | -0.178 | -0.119 | 0.000 | 0.119 | 0.237 | 0.474 | 0.711 |
| | | z | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 |
| | SDQCR/L | x | -0.309 | -0.194 | 0.000 | 0.206 | 0.412 | 0.825 | 1.237 |
| | | z | -0.310 | -0.206 | 0.000 | 0.268 | 0.499 | 0.961 | 1.423 |
| | SDUCR/L | x | -0.504 | -0.336 | 0.000 | 0.336 | 0.672 | 1.344 | 2.016 |
| | | z | -0.059 | -0.039 | 0.000 | 0.041 | 0.082 | 0.162 | 0.242 |
| | SDZCR/L | x | -0.520 | -0.346 | 0.000 | 0.346 | 0.693 | 0.139 | 2.078 |
| | | z | 0.059 | 0.039 | 0.000 | -0.041 | -0.082 | -0.162 | -0.242 |
| | SELPR/L | x | -0.126 | -0.084 | 0.000 | 0.084 | 0.168 | 0.337 | 0.051 |
| | | z | -0.066 | -0.044 | 0.000 | 0.044 | 0.088 | 0.176 | 0.264 |
| | SEUCR/L | x | -0.149 | -0.099 | 0.000 | 0.099 | 0.199 | 0.397 | 0.596 |
| | | z | -0.041 | -0.027 | 0.000 | 0.027 | 0.053 | 0.107 | 0.160 |
| | SEUPR/L | x | -0.148 | -0.099 | 0.000 | 0.099 | 0.198 | 0.396 | 0.593 |
| | | z | -0.040 | -0.027 | 0.000 | 0.027 | 0.053 | 0.107 | 0.160 |
| | SEXPR/L | x | -0.384 | -0.256 | 0.000 | 0.256 | 0.512 | 1.024 | 1.537 |
| | | z | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 |
| | SSSCR/L | x | -0.249 | -0.166 | 0.000 | 0.166 | 0.331 | 0.663 | 0.994 |
| | | z | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 |
| | STFCR/L | x | -0.433 | -0.289 | 0.000 | 0.289 | 0.577 | 1.154 | 1.731 |
| | | z | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 |
| | SVLCR/L | x | -1.243 | -0.828 | 0.000 | 0.828 | 1.657 | 3.314 | 4.971 |
| | | z | 0.239 | 0.692 | 0.000 | -0.108 | -0.215 | -0.430 | -0.645 |
| | SVQBR/L | x | -1.027 | -0.684 | 0.000 | 0.690 | 1.369 | 2.738 | 4.106 |
| | | z | -0.545 | -0.363 | 0.000 | 0.363 | 0.726 | 1.452 | 2.178 |
| | SVQCR/L | x | -1.027 | -0.684 | 0.000 | 0.690 | 1.369 | 2.738 | 4.106 |
| | | z | -0.545 | -0.363 | 0.000 | 0.363 | 0.726 | 1.452 | 2.178 |
| | SVUBR/L | x | -1.259 | -0.840 | 0.000 | 0.840 | 1.679 | 3.358 | 5.037 |
| | | z | 0.099 | -0.066 | 0.000 | 0.066 | 0.132 | 0.263 | 0.395 |
| | SVUCR/L | x | -1.259 | -0.840 | 0.000 | 0.840 | 1.679 | 3.358 | 5.037 |
| | | z | 0.099 | -0.066 | 0.000 | 0.066 | 0.132 | 0.263 | 0.395 |
| | SVXCR/L | x | -0.917 | -0.611 | 0.000 | 0.611 | 1.222 | 2.445 | 3.667 |
| | | z | -0.696 | -0.464 | 0.000 | 0.464 | 0.928 | 1.856 | 2.783 |
| | SWLCR/L | x | -0.060 | -0.039 | 0.000 | 0.039 | 0.079 | 0.158 | 0.237 |
| | | z | -0.060 | -0.040 | 0.000 | 0.040 | 0.080 | 0.160 | 0.240 |
| | SWUCR/L | x | -0.080 | -0.053 | 0.000 | 0.053 | 0.107 | 0.213 | 0.319 |
| | | z | -0.034 | -0.024 | 0.000 | 0.024 | 0.049 | 0.098 | 0.146 |

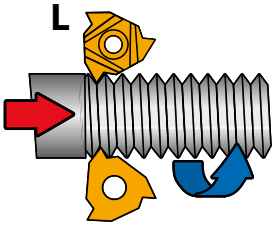
**BEMÆRK** – Dataene gælder for højresidede holdere, der vender som vist på billede. For indvendige holdere, venstresidede holdere eller andre retninger er det nødvendigt at korrigere eller mærke +/- (til erstatning af værdierne X/Z)

Valget af produktionsmetode afhænger af arbejdsemnet og maskinen. Arbejdsemne – udvendigt eller indvendigt gevind, højre- eller venstre-gevind. Maskine – højre- eller venstreværktøj. Du kan bruge følgende tabel.

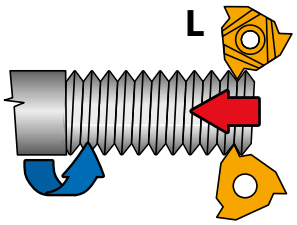
## UDVENDIGT GEVIND, HØJRE

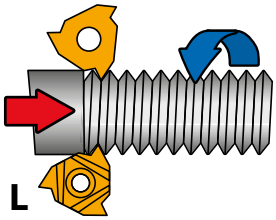


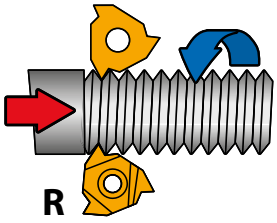



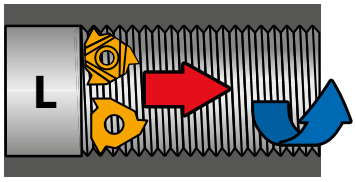

## UDVENDIGT GEVIND, VENSTRE

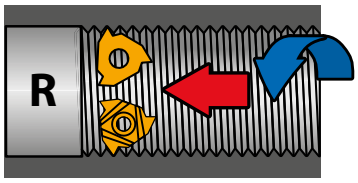


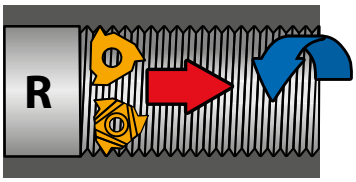



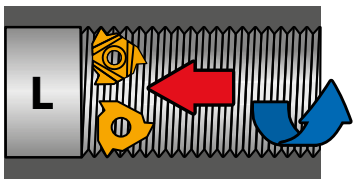

## INDVENDIGT GEVIND, HØJRE




## INDVENDIGT GEVIND, VENSTRE




Bevægelse af arbejdsemnet

Værktøjsbevægelse

**L / R** Skærdesign

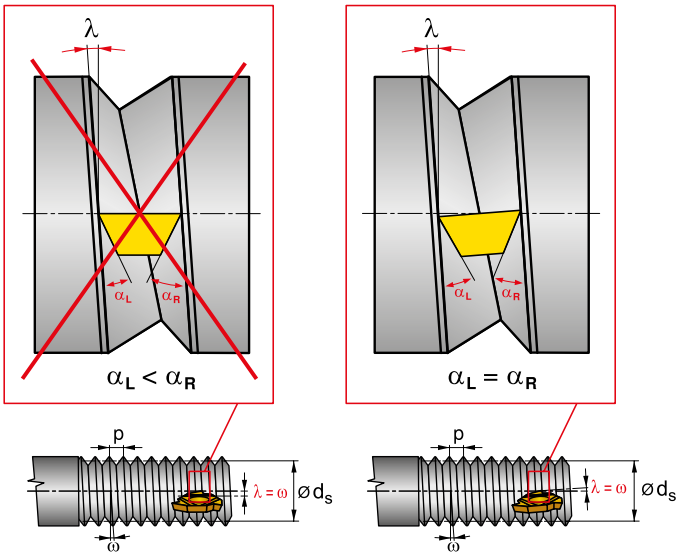
**Følgende formel kan bruges til at beregne skruevinklen:**

$$tg\ \omega = \frac{p}{d_s \cdot \pi}$$

$\omega$ Skruevinkel [°]

$p$ Stigning [mm]

$d_s$ Stigningsdiameter [mm]



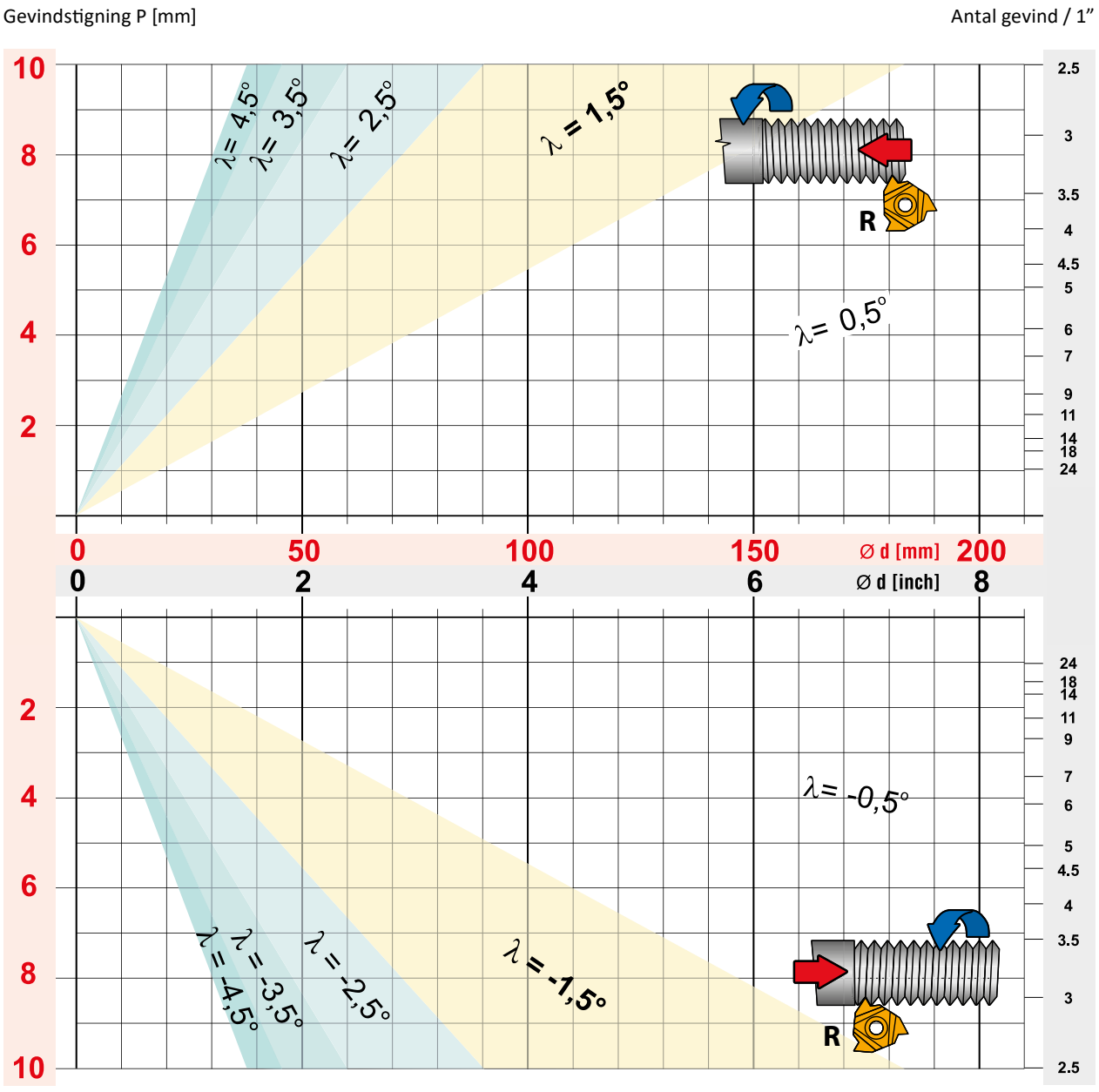

Generering af den korrekte form for gevindet og ensartet slid på indsatsen kræver, at skærets skruevinkel er lig med gevindets stigningsvinkel.
Værktøjsholderne leveres normalt med skruevinkel λ = 1.5°. Der kan vælges en anden skruevinkel ved at ændre ambolten.
Brug diagrammet eller tabellen nedenfor til at vælge den korrekte ambolt. Tabel og diagram – billede.

Valg af afstandsstykke

| **Skruevinkel λ** | **Positiv** | | | | | **Negativ** | | **For sporstikskær TN16.. ... ZZ, TN22.. ... ZZ** |
|---|---|---|---|---|---|---|---|---|
| | 4.5° | 3.5° | 2.5° | **1.5°** | 0.5° | -0.5° | -1.5° | |
| **Tool holder** | **Amboltspecifikation** | | | | | | | |
| **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 | PE16ZZ |
| **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 | PI16ZZ |
| **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 | PE22ZZ |
| **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 | PI22ZZ |
| **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 | - |

Værktøjsholderne leveres normalt med skruevinkel λ = 1.5°. Der kan vælges en anden skruevinkel ved at ændre ambolten.
Afstandsstykker for holderne SER-S .... ..., SIR-S .... ... er markeret med „***S***“

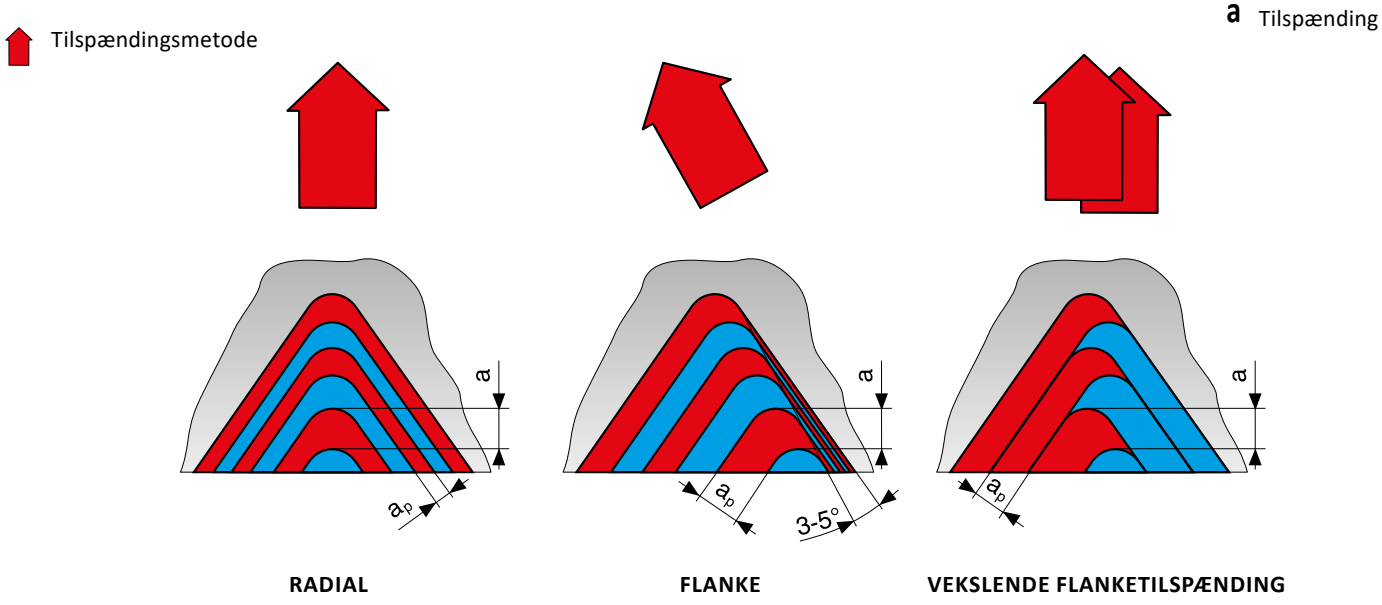
**Diagram for valg af afstandsstykke**




Bevægelse af arbejdsemnet  Værktøjsbevægelse  **L / R** Skærdesign

**Tilspændingsmetode og dybde**

Valg af tilspændingsmetode er vigtigt for materialer med lang spåndannelse for at sikre god spånkontrol.




Valget afhænger af maskintypen, det materiale, der maskinbearbejdes, og stigningen.

**Radial tilspænding** – den enkleste og mest udbredte metode. Tilspændingen står lodret i forhold til arbejdsemnets rotationsakse. Det er med til at give d ogod spåndannelse og ensartet slid på skæret. Egnet til gevind med en lille stigning (***p*** <1,5 mm). Der er risiko for vibration ved højere tilspændingshastigheder. Førstevalg ved arbejde med hårde materialer (f.eks. austenitisk rustfrit stål, stål med lavt kulstofindhold).

**Flanketilspænding** – reducerer varmebelastningen på skæret og dermed sliddet.

God spånkontrol. Egnet til gevind med en stigning på ***p*** >1,5 mm for TR-gevind.

Flanketilspænding med en afvigelse på 3-5° eliminerer friktion på gevindflanken.

**Vekslende flanketilspænding** – anbefales til grove gevind og materialer med dårlig spåndannelse. Lang værktøjslevetid. For CNC-maskiner stilles der større krav til CNCprogrammering.

**Tilspændingsmetode og antal arbejdsgange** afhænger af gevindstigningen. Tabellerne indeholder grundlæggende anbefalinger og gælder for alle geometrier. Hvis der opstår brud på indsatsen, skal tilspændingsværdien reduceres, og antal arbejdsgange skal øges. Tilspændingsdybden må ikke være under 0,05 mm/arbejdsgang. Ved austenitisk og blødt stål skal tilspændningsdybden pr. arbejdsgang være over 0,08 mm.

| DEN RØRFORMEDE CYLINDRISKE GEVINDPROFIL SVARER TIL W (WHITWORTH 55°) | | | | | |
|---|---|---|---|---|---|
| **Gevindmærkning** | **Antal gevind / 1″** | **Gevindstigning P [mm]** | **Gevindets nominelle diameter [mm]** | **Gevindets lille diameter [mm]** | **Gevindskærsmærkning** |
| **G 1/16″** | 28 | 0,907 | 7.723 | 6.561 | **TN xxxx280W** |
| **G 1/8″** | | | 9.728 | 8.566 | |
| **G 1/4″** | 19 | 1,337 | 13.157 | 11.445 | **TN xxxx190W** |
| **G 3/8″** | | | 16.662 | 14.950 | |
| **G 1/2″** | 14 | 1,814 | 20.955 | 18.631 | **TN xxxx140W** |
| **G 5/8″** | | | 22.911 | 20.587 | |
| **G 3/4″** | | | 26.441 | 24.117 | |
| **G 7/8″** | | | 30.201 | 27.877 | |
| **G 1″** | 11 | 2,309 | 33.249 | 30.291 | **TN xxxx110W** |
| **G1 1/8″** | | | 37.897 | 34.939 | |
| **G1 1/4″** | | | 41.910 | 38.952 | |
| **G1 1/2″** | | | 47.803 | 44.845 | |
| **G1 3/4″** | | | 53.746 | 50.788 | |
| **G 2″** | | | 59.614 | 56.656 | |
| **G2 1/4″** | | | 65.710 | 62.752 | |
| **G2 1/2″** | | | 75.184 | 72.226 | |
| **G2 3/4″** | | | 81.534 | 78.576 | |
| **G3″** | | | 87.884 | 84.926 | |
| **G3 1/2″** | | | 100.330 | 97.372 | |
| **G4″** | | | 113.030 | 110.072 | |
| **G4 1/2″** | | | 125.730 | 122.772 | |
| **G5″** | | | 138.430 | 135.472 | |
| **G5 1/2″** | | | 151.130 | 148.172 | |
| **G6″** | | | 163.830 | 160.872 | |

Eksempel: for højre udvendigt gevind for rør 1 ½´´ skal der bruges gevindindsats TN 16ER110W; 8030

### M – metrisk 60° – udvendig

| Antal arbejdsgange | REDUCER SKÆREHASTIGHEDEN PROPORTIONALT FOR AT ØGE GEVINDSTIGNINGEN | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | Stigning [mm] | | | | | | | | | | | | | | |
| | 6.0 | 5.5 | 5.0 | 4.5 | 4.0 | 3.5 | 3.0 | 2.5 | 2.0 | 1.75 | 1.5 | 1.25 | 1.0 | 0.75 | 0.50 |
| 1 | 0.46 | 0.43 | 0.41 | 0.37 | 0.34 | 0.34 | 0.28 | 0.27 | 0.24 | 0.22 | 0.22 | 0.21 | 0.18 | 0.16 | 0.11 |
| 2 | 0.43 | 0.40 | 0.39 | 0.34 | 0.32 | 0.31 | 0.26 | 0.24 | 0.22 | 0.20 | 0.20 | 0.17 | 0.16 | 0.14 | 0.09 |
| 3 | 0.35 | 0.32 | 0.32 | 0.28 | 0.25 | 0.25 | 0.21 | 0.20 | 0.18 | 0.17 | 0.17 | 0.14 | 0.12 | 0.11 | 0.07 |
| 4 | 0.30 | 0.28 | 0.27 | 0.24 | 0.22 | 0.21 | 0.18 | 0.17 | 0.16 | 0.14 | 0.14 | 0.11 | 0.11 | 0.07 | 0.06 |
| 5 | 0.29 | 0.26 | 0.24 | 0.22 | 0.20 | 0.18 | 0.16 | 0.15 | 0.14 | 0.12 | 0.12 | 0.10 | 0.08 | | |
| 6 | 0.26 | 0.24 | 0.24 | 0.22 | 0.18 | 0.18 | 0.15 | 0.15 | 0.12 | 0.10 | 0.08 | 0.08 | | | |
| 7 | 0.24 | 0.21 | 0.22 | 0.20 | 0.17 | 0.16 | 0.14 | 0.12 | 0.11 | 0.10 | | | | | |
| 8 | 0.23 | 0.20 | 0.20 | 0.18 | 0.15 | 0.15 | 0.13 | 0.11 | 0.08 | 0.08 | | | | | |
| 9 | 0.22 | 0.19 | 0.19 | 0.17 | 0.14 | 0.14 | 0.12 | 0.11 | | | | | | | |
| 10 | 0.19 | 0.18 | 0.18 | 0.16 | 0.13 | 0.12 | 0.11 | 0.08 | | | | | | | |
| 11 | 0.18 | 0.17 | 0.16 | 0.14 | 0.12 | 0.11 | 0.10 | | | | | | | | |
| 12 | 0.16 | 0.15 | 0.15 | 0.13 | 0.12 | 0.08 | 0.08 | | | | | | | | |
| 13 | 0.15 | 0.14 | 0.12 | 0.12 | 0.11 | | | | | | | | | | |
| 14 | 0.13 | 0.13 | 0.10 | 0.10 | 0.08 | | | | | | | | | | |
| 15 | 0.13 | 0.12 | | | | | | | | | | | | | |
| 16 | 0.10 | 0.10 | | | | | | | | | | | | | |
| **Samlet tilspændingsdybde** | **3.83** | **3.52** | **3.19** | **2.87** | **2.53** | **2.23** | **1.92** | **1.60** | **1.25** | **1.13** | **0.93** | **0.81** | **0.65** | **0.48** | **0.33** |

### Metrisk 60° – indvendig

| Antal arbejdsgange | REDUCER SKÆREHASTIGHEDEN PROPORTIONALT FOR AT ØGE GEVINDSTIGNINGEN | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | Stigning [mm] | | | | | | | | | | | | | | |
| | 6.0 | 5.5 | 5.0 | 4.5 | 4.0 | 3.5 | 3.0 | 2.5 | 2.0 | 1.75 | 1.5 | 1.25 | 1.0 | 0.75 | 0.50 |
| 1 | 0.46 | 0.43 | 0.42 | 0.37 | 0.34 | 0.32 | 0.28 | 0.26 | 0.23 | 0.22 | 0.20 | 0.17 | 0.17 | 0.16 | 0.10 |
| 2 | 0.43 | 0.40 | 0.40 | 0.34 | 0.31 | 0.30 | 0.26 | 0.25 | 0.21 | 0.20 | 0.18 | 0.17 | 0.15 | 0.13 | 0.08 |
| 3 | 0.35 | 0.33 | 0.32 | 0.28 | 0.24 | 0.24 | 0.21 | 0.18 | 0.17 | 0.15 | 0.15 | 0.14 | 0.11 | 0.10 | 0.07 |
| 4 | 0.30 | 0.26 | 0.26 | 0.23 | 0.21 | 0.19 | 0.16 | 0.15 | 0.15 | 0.13 | 0.13 | 0.10 | 0.09 | 0.07 | 0.06 |
| 5 | 0.26 | 0.22 | 0.22 | 0.21 | 0.18 | 0.17 | 0.14 | 0.13 | 0.12 | 0.10 | 0.11 | 0.09 | 0.08 | | |
| 6 | 0.22 | 0.20 | 0.20 | 0.19 | 0.15 | 0.15 | 0.13 | 0.12 | 0.11 | 0.09 | 0.08 | 0.08 | | | |
| 7 | 0.20 | 0.18 | 0.17 | 0.16 | 0.14 | 0.14 | 0.12 | 0.11 | 0.10 | 0.08 | | | | | |
| 8 | 0.19 | 0.17 | 0.16 | 0.15 | 0.13 | 0.13 | 0.11 | 0.10 | 0.08 | 0.08 | | | | | |
| 9 | 0.18 | 0.16 | 0.16 | 0.14 | 0.12 | 0.12 | 0.10 | 0.10 | | | | | | | |
| 10 | 0.16 | 0.15 | 0.15 | 0.13 | 0.12 | 0.11 | 0.10 | 0.08 | | | | | | | |
| 11 | 0.15 | 0.14 | 0.14 | 0.12 | 0.11 | 0.10 | 0.09 | | | | | | | | |
| 12 | 0.15 | 0.14 | 0.14 | 0.12 | 0.10 | 0.08 | 0.08 | | | | | | | | |
| 13 | 0.14 | 0.13 | 0.12 | 0.11 | 0.10 | | | | | | | | | | |
| 14 | 0.13 | 0.12 | 0.10 | 0.10 | 0.08 | | | | | | | | | | |
| 15 | 0.12 | 0.12 | | | | | | | | | | | | | |
| 16 | 0.10 | 0.10 | | | | | | | | | | | | | |
| **Samlet tilspændingsdybde** | **3.54** | **3.25** | **2.96** | **2.65** | **2.33** | **2.05** | **1.78** | **1.48** | **1.17** | **1.05** | **0.85** | **0.75** | **0.60** | **0.46** | **0.31** |

**W – Whitworth 55° – udvendig og indvendig**

| Antal arbejdsgange | REDUCER SKÆREHASTIGHEDEN PROPORTIONALT FOR AT ØGE GEVINDSTIGNINGEN | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | Stigning [antal gevind/tomme] | | | | | | | | | | | | | | | | |
| | 4 | 4.5 | 5 | 6 | 7 | 8 | 9 | 10 | 11 | 12 | 14 | 16 | 18 | 19 | 20 | 26 | 28 |
| 1 | 0.49 | 0.46 | 0.45 | 0.38 | 0.37 | 0.32 | 0.30 | 0.29 | 0.28 | 0.28 | 0.24 | 0.24 | 0.23 | 0.22 | 0.21 | 0.19 | 0.18 |
| 2 | 0.46 | 0.43 | 0.43 | 0.36 | 0.35 | 0.30 | 0.28 | 0.27 | 0.26 | 0.26 | 0.22 | 0.22 | 0.22 | 0.22 | 0.21 | 0.18 | 0.17 |
| 3 | 0.38 | 0.38 | 0.38 | 0.30 | 0.29 | 0.24 | 0.23 | 0.22 | 0.22 | 0.22 | 0.18 | 0.19 | 0.19 | 0.18 | 0.17 | 0.15 | 0.14 |
| 4 | 0.36 | 0.33 | 0.32 | 0.26 | 0.25 | 0.21 | 0.20 | 0.19 | 0.19 | 0.18 | 0.15 | 0.16 | 0.16 | 0.14 | 0.14 | 0.12 | 0.12 |
| 5 | 0.34 | 0.29 | 0.28 | 0.22 | 0.22 | 0.19 | 0.18 | 0.17 | 0.16 | 0.16 | 0.13 | 0.13 | 0.13 | 0.12 | 0.11 | 0.08 | 0.08 |
| 6 | 0.31 | 0.25 | 0.25 | 0.21 | 0.19 | 0.17 | 0.15 | 0.15 | 0.14 | 0.14 | 0.11 | 0.11 | 0.08 | 0.08 | 0.08 | | |
| 7 | 0.29 | 0.24 | 0.22 | 0.19 | 0.18 | 0.15 | 0.14 | 0.14 | 0.13 | 0.13 | 0.09 | 0.08 | | | | | |
| 8 | 0.27 | 0.22 | 0.20 | 0.17 | 0.16 | 0.14 | 0.13 | 0.13 | 0.12 | 0.08 | 0.08 | | | | | | |
| 9 | 0.24 | 0.20 | 0.19 | 0.16 | 0.15 | 0.13 | 0.12 | 0.12 | 0.08 | | | | | | | | |
| 10 | 0.22 | 0.18 | 0.18 | 0.15 | 0.14 | 0.12 | 0.12 | 0.08 | | | | | | | | | |
| 11 | 0.20 | 0.17 | 0.17 | 0.14 | 0.12 | 0.12 | 0.08 | | | | | | | | | | |
| 12 | 0.19 | 0.16 | 0.15 | 0.14 | 0.08 | 0.08 | | | | | | | | | | | |
| 13 | 0.17 | 0.15 | 0.12 | 0.12 | | | | | | | | | | | | | |
| 14 | 0.15 | 0.14 | 0.10 | 0.10 | | | | | | | | | | | | | |
| 15 | 0.12 | 0.12 | | | | | | | | | | | | | | | |
| 16 | 0.10 | 0.10 | | | | | | | | | | | | | | | |
| Samlet tilspændingsdybde | 4.29 | 3.82 | 3.44 | 2.90 | 2.50 | 2.17 | 1.93 | 1.76 | 1.58 | 1.45 | 1.20 | 1.13 | 1.01 | 0.96 | 0.92 | 0.72 | 0.69 |

**UN – UN 60° – udvendig**

| Antal arbejdsgange | REDUCER SKÆREHASTIGHEDEN PROPORTIONALT FOR AT ØGE GEVINDSTIGNINGEN | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | Stigning [antal gevind/tomme] | | | | | | | | | | | | | | | | | |
| | 4 | 4.5 | 5 | 6 | 7 | 8 | 9 | 10 | 11 | 12 | 13 | 14 | 16 | 18 | 20 | 24 | 28 | 32 |
| 1 | 0.47 | 0.45 | 0.43 | 0.36 | 0.35 | 0.30 | 0.28 | 0.27 | 0.27 | 0.27 | 0.25 | 0.23 | 0.22 | 0.23 | 0.20 | 0.19 | 0.17 | 0.17 |
| 2 | 0.44 | 0.41 | 0.40 | 0.34 | 0.33 | 0.28 | 0.26 | 0.26 | 0.25 | 0.26 | 0.24 | 0.22 | 0.21 | 0.21 | 0.19 | 0.17 | 0.15 | 0.15 |
| 3 | 0.40 | 0.39 | 0.36 | 0.27 | 0.26 | 0.25 | 0.21 | 0.20 | 0.20 | 0.20 | 0.18 | 0.17 | 0.16 | 0.16 | 0.15 | 0.14 | 0.11 | 0.13 |
| 4 | 0.36 | 0.31 | 0.31 | 0.23 | 0.22 | 0.21 | 0.20 | 0.17 | 0.19 | 0.18 | 0.17 | 0.15 | 0.14 | 0.14 | 0.12 | 0.12 | 0.09 | 0.08 |
| 5 | 0.32 | 0.26 | 0.26 | 0.22 | 0.21 | 0.18 | 0.17 | 0.16 | 0.16 | 0.15 | 0.14 | 0.13 | 0.13 | 0.12 | 0.10 | 0.08 | 0.08 | |
| 6 | 0.27 | 0.23 | 0.23 | 0.20 | 0.19 | 0.16 | 0.15 | 0.15 | 0.14 | 0.13 | 0.12 | 0.11 | 0.11 | 0.08 | 0.08 | | | |
| 7 | 0.25 | 0.21 | 0.20 | 0.18 | 0.17 | 0.14 | 0.14 | 0.14 | 0.12 | 0.12 | 0.11 | 0.10 | 0.08 | | | | | |
| 8 | 0.23 | 0.20 | 0.19 | 0.16 | 0.15 | 0.13 | 0.12 | 0.12 | 0.11 | 0.08 | 0.08 | 0.08 | | | | | | |
| 9 | 0.22 | 0.18 | 0.19 | 0.15 | 0.14 | 0.12 | 0.12 | 0.11 | 0.08 | | | | | | | | | |
| 10 | 0.21 | 0.17 | 0.18 | 0.14 | 0.12 | 0.12 | 0.11 | 0.08 | | | | | | | | | | |
| 11 | 0.19 | 0.16 | 0.17 | 0.13 | 0.11 | 0.11 | 0.08 | | | | | | | | | | | |
| 12 | 0.18 | 0.15 | 0.15 | 0.12 | 0.08 | 0.08 | | | | | | | | | | | | |
| 13 | 0.16 | 0.14 | 0.12 | 0.11 | | | | | | | | | | | | | | |
| 14 | 0.15 | 0.14 | 0.10 | 0.10 | | | | | | | | | | | | | | |
| 15 | 0.12 | 0.12 | | | | | | | | | | | | | | | | |
| 16 | 0.10 | 0.10 | | | | | | | | | | | | | | | | |
| **Samlet tilspændingsdybde** | **4.07** | **3.62** | **3.29** | **2.71** | **2.33** | **2.08** | **1.84** | **1.66** | **1.52** | **1.39** | **1.29** | **1.19** | **1.05** | **0.94** | **0.84** | **0.70** | **0.60** | **0.53** |

**UN 60° – indvendig**

| Antal arbejdsgange | REDUCER SKÆREHASTIGHEDEN PROPORTIONALT FOR AT ØGE GEVINDSTIGNINGEN | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | Stigning [antal gevind/tomme] | | | | | | | | | | | | | | | | | |
| | 4 | 4.5 | 5 | 6 | 7 | 8 | 9 | 10 | 11 | 12 | 13 | 14 | 16 | 18 | 20 | 24 | 28 | 32 |
| 1 | 0.44 | 0.41 | 0.42 | 0.35 | 0.34 | 0.30 | 0.28 | 0.27 | 0.27 | 0.27 | 0.25 | 0.23 | 0.22 | 0.23 | 0.20 | 0.18 | 0.17 | 0.17 |
| 2 | 0.41 | 0.38 | 0.38 | 0.33 | 0.32 | 0.28 | 0.26 | 0.25 | 0.23 | 0.23 | 0.20 | 0.18 | 0.18 | 0.17 | 0.16 | 0.15 | 0.14 | 0.14 |
| 3 | 0.39 | 0.34 | 0.33 | 0.25 | 0.24 | 0.22 | 0.19 | 0.18 | 0.18 | 0.18 | 0.15 | 0.14 | 0.14 | 0.14 | 0.13 | 0.13 | 0.09 | 0.10 |
| 4 | 0.33 | 0.28 | 0.27 | 0.21 | 0.21 | 0.18 | 0.16 | 0.15 | 0.15 | 0.15 | 0.13 | 0.13 | 0.12 | 0.12 | 0.10 | 0.10 | 0.08 | 0.08 |
| 5 | 0.28 | 0.23 | 0.23 | 0.18 | 0.17 | 0.15 | 0.14 | 0.13 | 0.13 | 0.13 | 0.12 | 0.11 | 0.10 | 0.10 | 0.09 | 0.08 | 0.08 | |
| 6 | 0.24 | 0.20 | 0.20 | 0.16 | 0.15 | 0.13 | 0.13 | 0.12 | 0.11 | 0.11 | 0.11 | 0.10 | 0.09 | 0.08 | 0.08 | | | |
| 7 | 0.22 | 0.19 | 0.18 | 0.15 | 0.14 | 0.12 | 0.12 | 0.11 | 0.11 | 0.10 | 0.10 | 0.09 | 0.08 | | | | | |
| 8 | 0.21 | 0.18 | 0.17 | 0.14 | 0.13 | 0.11 | 0.11 | 0.10 | 0.10 | 0.08 | 0.08 | 0.08 | | | | | | |
| 9 | 0.20 | 0.17 | 0.16 | 0.13 | 0.12 | 0.11 | 0.10 | 0.10 | 0.08 | | | | | | | | | |
| 10 | 0.18 | 0.16 | 0.15 | 0.12 | 0.12 | 0.10 | 0.09 | 0.08 | | | | | | | | | | |
| 11 | 0.17 | 0.15 | 0.14 | 0.12 | 0.11 | 0.10 | 0.08 | | | | | | | | | | | |
| 12 | 0.16 | 0.14 | 0.14 | 0.11 | 0.08 | 0.08 | | | | | | | | | | | | |
| 13 | 0.15 | 0.14 | 0.12 | 0.11 | | | | | | | | | | | | | | |
| 14 | 0.14 | 0.13 | 0.10 | 0.10 | | | | | | | | | | | | | | |
| 15 | 0.12 | 0.12 | | | | | | | | | | | | | | | | |
| 16 | 0.10 | 0.10 | | | | | | | | | | | | | | | | |
| **Samlet tilspændingsdybde** | **3.74** | **3.32** | **2.99** | **2.46** | **2.13** | **1.88** | **1.66** | **1.49** | **1.36** | **1.25** | **1.14** | **1.06** | **0.93** | **0.84** | **0.76** | **0.64** | **0.56** | **0.49** |

**NPT 60° – indvendig og udvendig**

| Antal arbejdsgange | REDUCER SKÆREHASTIGHEDEN PROPORTIONALT FOR AT ØGE GEVINDSTIGNINGEN | | | | |
|---|---|---|---|---|---|
| | Stigning [antal gevind/tomme] | | | | |
| | 8 | 11.5 | 14 | 18 | 27 |
| 1 | 0.28 | 0.25 | 0.24 | 0.22 | 0.19 |
| 2 | 0.25 | 0.22 | 0.22 | 0.18 | 0.15 |
| 3 | 0.22 | 0.18 | 0.17 | 0.15 | 0.13 |
| 4 | 0.19 | 0.16 | 0.15 | 0.14 | 0.11 |
| 5 | 0.18 | 0.16 | 0.14 | 0.13 | 0.09 |
| 6 | 0.18 | 0.14 | 0.13 | 0.12 | 0.08 |
| 7 | 0.17 | 0.14 | 0.12 | 0.10 | |
| 8 | 0.17 | 0.12 | 0.10 | 0.08 | |
| 9 | 0.16 | 0.12 | 0.10 | | |
| 10 | 0.16 | 0.10 | 0.08 | | |
| 11 | 0.14 | 0.09 | | | |
| 12 | 0.13 | 0.08 | | | |
| 13 | 0.12 | | | | |
| 14 | 0.11 | | | | |
| 15 | 0.08 | | | | |
| **Samlet tilspændingsdybde** | **2.54** | **1.76** | **1.45** | **1.12** | **0.75** |

**RD – RD 30° – udvendig**

| Antal arbejdsgange | REDUCER SKÆREHASTIGHEDEN PROPORTIONALT FOR AT ØGE GEVINDSTIGNINGEN | | | |
|---|---|---|---|---|
| | Stigning [antal gevind/tomme] | | | |
| | 4 | 6 | 8 | 10 |
| 1 | 0.44 | 0.33 | 0.29 | 0.26 |
| 2 | 0.40 | 0.29 | 0.26 | 0.25 |
| 3 | 0.34 | 0.25 | 0.21 | 0.23 |
| 4 | 0.32 | 0.23 | 0.19 | 0.20 |
| 5 | 0.28 | 0.20 | 0.18 | 0.16 |
| 6 | 0.26 | 0.18 | 0.16 | 0.12 |
| 7 | 0.24 | 0.16 | 0.14 | 0.10 |
| 8 | 0.22 | 0.15 | 0.12 | 0.08 |
| 9 | 0.20 | 0.14 | 0.10 | |
| 10 | 0.19 | 0.12 | 0.08 | |
| 11 | 0.17 | 0.10 | | |
| 12 | 0.15 | 0.08 | | |
| 13 | 0.12 | | | |
| 14 | 0.10 | | | |
| **Samlet tilspændingsdybde** | **3.43** | **2.23** | **1.73** | **1.40** |

**RD – RD 30° – indvendig**

| Antal arbejdsgange | REDUCER SKÆREHASTIGHEDEN PROPORTIONALT FOR AT ØGE GEVINDSTIGNINGEN | | | |
|---|---|---|---|---|
| | Stigning [antal gevind/tomme] | | | |
| | 4 | 6 | 8 | 10 |
| 1 | 0.46 | 0.38 | 0.26 | 0.27 |
| 2 | 0.43 | 0.34 | 0.22 | 0.26 |
| 3 | 0.40 | 0.30 | 0.21 | 0.25 |
| 4 | 0.35 | 0.25 | 0.19 | 0.22 |
| 5 | 0.30 | 0.21 | 0.18 | 0.18 |
| 6 | 0.26 | 0.19 | 0.16 | 0.13 |
| 7 | 0.24 | 0.17 | 0.14 | 0.10 |
| 8 | 0.22 | 0.16 | 0.12 | 0.08 |
| 9 | 0.20 | 0.14 | 0.10 | |
| 10 | 0.19 | 0.12 | 0.08 | |
| 11 | 0.17 | 0.10 | | |
| 12 | 0.15 | 0.08 | | |
| 13 | 0.12 | | | |
| 14 | 0.10 | | | |
| **Samlet tilspændingsdybde** | **3.59** | **2.44** | **1.66** | **1.49** |

**TR 30° indvendig**

| Antal arbejdsgange | REDUCER SKÆREHASTIGHEDEN PROPORTIONALT FOR AT ØGE GEVINDSTIGNINGEN | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | Stigning [mm] | | | | | | | | | | | |
| | 14,0 | 12,0 | 10,0 | 9,0 | 8,0 | 7,0 | 6,0 | 5,0 | 4,0 | 3,0 | 2,0 | 1,5 |
| 1 | 0.40 | 0.38 | 0.38 | 0.38 | 0.37 | 0.37 | 0.37 | 0.34 | 0.31 | 0.27 | 0.25 | 0.23 |
| 2 | 0.37 | 0.36 | 0.36 | 0.35 | 0.35 | 0.34 | 0.35 | 0.33 | 0.28 | 0.25 | 0.24 | 0.22 |
| 3 | 0.36 | 0.34 | 0.34 | 0.34 | 0.34 | 0.33 | 0.32 | 0.27 | 0.24 | 0.21 | 0.20 | 0.18 |
| 4 | 0.36 | 0.34 | 0.34 | 0.33 | 0.33 | 0.31 | 0.29 | 0.25 | 0.20 | 0.17 | 0.17 | 0.14 |
| 5 | 0.35 | 0.32 | 0.32 | 0.31 | 0.31 | 0.29 | 0.27 | 0.23 | 0.19 | 0.15 | 0.14 | 0.12 |
| 6 | 0.35 | 0.32 | 0.32 | 0.30 | 0.29 | 0.26 | 0.25 | 0.21 | 0.18 | 0.13 | 0.13 | 0.08 |
| 7 | 0.34 | 0.30 | 0.31 | 0.29 | 0.28 | 0.26 | 0.23 | 0.20 | 0.16 | 0.13 | 0.11 | |
| 8 | 0.34 | 0.30 | 0.29 | 0.28 | 0.27 | 0.26 | 0.22 | 0.20 | 0.15 | 0.12 | 0.09 | |
| 9 | 0.34 | 0.30 | 0.28 | 0.26 | 0.25 | 0.24 | 0.22 | 0.18 | 0.15 | 0.12 | | |
| 10 | 0.33 | 0.29 | 0.27 | 0.25 | 0.24 | 0.23 | 0.20 | 0.16 | 0.15 | 0.10 | | |
| 11 | 0.33 | 0.29 | 0.25 | 0.24 | 0.23 | 0.22 | 0.18 | 0.15 | 0.14 | 0.10 | | |
| 12 | 0.32 | 0.29 | 0.24 | 0.23 | 0.21 | 0.22 | 0.17 | 0.14 | 0.13 | 0.08 | | |
| 13 | 0.32 | 0.28 | 0.23 | 0.22 | 0.20 | 0.20 | 0.17 | 0.13 | 0.10 | | | |
| 14 | 0.31 | 0.27 | 0.22 | 0.21 | 0.19 | 0.19 | 0.16 | 0.10 | | | | |
| 15 | 0.31 | 0.25 | 0.22 | 0.21 | 0.19 | 0.17 | 0.14 | | | | | |
| 16 | 0.30 | 0.25 | 0.20 | 0.19 | 0.18 | 0.16 | 0.12 | | | | | |
| 17 | 0.30 | 0.24 | 0.19 | 0.18 | 0.17 | 0.12 | | | | | | |
| 18 | 0.29 | 0.22 | 0.18 | 0.16 | 0.15 | | | | | | | |
| 19 | 0.28 | 0.20 | 0.17 | 0.15 | 0.13 | | | | | | | |
| 20 | 0.27 | 0.20 | 0.16 | 0.15 | | | | | | | | |
| 21 | 0.23 | 0.19 | 0.15 | 0.13 | | | | | | | | |
| 22 | 0.23 | 0.18 | 0.15 | | | | | | | | | |
| 23 | 0.21 | 0.17 | 0.13 | | | | | | | | | |
| 24 | 0.19 | 0.16 | | | | | | | | | | |
| 25 | 0.17 | 0.15 | | | | | | | | | | |
| 26 | 0.16 | 0.13 | | | | | | | | | | |
| 27 | 0.16 | | | | | | | | | | | |
| 28 | 0.15 | | | | | | | | | | | |
| 29 | 0.13 | | | | | | | | | | | |
| **Samlet tilspændingsdybde** | **8.2** | **6.72** | **5.7** | **5.16** | **4.68** | **4.17** | **3.66** | **2.89** | **2.38** | **1.83** | **1.33** | **0.97** |

**TR – TR 30° – indvendig**

| Antal arbejdsgange | REDUCER SKÆREHASTIGHEDEN PROPORTIONALT FOR AT ØGE GEVINDSTIGNINGEN | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | Stigning [mm] | | | | | | | | | | | |
| | 14,0 | 12,0 | 10,0 | 9,0 | 8,0 | 7,0 | 6,0 | 5,0 | 4,0 | 3,0 | 2,0 | 1,5 |
| 1 | 0.40 | 0.38 | 0.38 | 0.38 | 0.37 | 0.37 | 0.37 | 0.34 | 0.31 | 0.27 | 0.25 | 0.23 |
| 2 | 0.37 | 0.36 | 0.36 | 0.35 | 0.35 | 0.34 | 0.34 | 0.33 | 0.28 | 0.25 | 0.24 | 0.22 |
| 3 | 0.36 | 0.34 | 0.34 | 0.34 | 0.34 | 0.33 | 0.32 | 0.27 | 0.24 | 0.22 | 0.21 | 0.19 |
| 4 | 0.36 | 0.34 | 0.34 | 0.33 | 0.33 | 0.31 | 0.29 | 0.25 | 0.20 | 0.17 | 0.17 | 0.14 |
| 5 | 0.35 | 0.32 | 0.32 | 0.31 | 0.31 | 0.29 | 0.27 | 0.23 | 0.19 | 0.15 | 0.14 | 0.12 |
| 6 | 0.35 | 0.32 | 0.32 | 0.31 | 0.29 | 0.26 | 0.25 | 0.21 | 0.18 | 0.14 | 0.13 | 0.08 |
| 7 | 0.34 | 0.30 | 0.31 | 0.29 | 0.28 | 0.26 | 0.23 | 0.20 | 0.16 | 0.13 | 0.11 | |
| 8 | 0.34 | 0.30 | 0.29 | 0.29 | 0.27 | 0.26 | 0.22 | 0.20 | 0.15 | 0.12 | 0.09 | |
| 9 | 0.34 | 0.30 | 0.28 | 0.26 | 0.25 | 0.24 | 0.22 | 0.18 | 0.15 | 0.12 | | |
| 10 | 0.33 | 0.29 | 0.27 | 0.25 | 0.24 | 0.23 | 0.20 | 0.16 | 0.15 | 0.10 | | |
| 11 | 0.33 | 0.29 | 0.25 | 0.24 | 0.23 | 0.22 | 0.18 | 0.15 | 0.14 | 0.10 | | |
| 12 | 0.32 | 0.28 | 0.24 | 0.23 | 0.21 | 0.22 | 0.17 | 0.14 | 0.13 | 0.08 | | |
| 13 | 0.32 | 0.28 | 0.23 | 0.22 | 0.20 | 0.20 | 0.17 | 0.13 | 0.10 | | | |
| 14 | 0.31 | 0.27 | 0.22 | 0.21 | 0.19 | 0.19 | 0.16 | 0.10 | | | | |
| 15 | 0.31 | 0.25 | 0.22 | 0.21 | 0.19 | 0.17 | 0.14 | | | | | |
| 16 | 0.30 | 0.25 | 0.20 | 0.20 | 0.18 | 0.16 | 0.12 | | | | | |
| 17 | 0.30 | 0.24 | 0.19 | 0.18 | 0.17 | 0.12 | | | | | | |
| 18 | 0.29 | 0.22 | 0.18 | 0.16 | 0.15 | | | | | | | |
| 19 | 0.28 | 0.20 | 0.17 | 0.15 | 0.13 | | | | | | | |
| 20 | 0.27 | 0.20 | 0.16 | 0.15 | | | | | | | | |
| 21 | 0.27 | 0.19 | 0.15 | 0.13 | | | | | | | | |
| 22 | 0.23 | 0.18 | 0.15 | | | | | | | | | |
| 23 | 0.23 | 0.17 | 0.13 | | | | | | | | | |
| 24 | 0.21 | 0.16 | | | | | | | | | | |
| 25 | 0.19 | 0.15 | | | | | | | | | | |
| 26 | 0.17 | 0.13 | | | | | | | | | | |
| 27 | 0.16 | | | | | | | | | | | |
| 28 | 0.16 | | | | | | | | | | | |
| 29 | 0.15 | | | | | | | | | | | |
| 30 | 0.13 | | | | | | | | | | | |
| **Samlet tilspændingsdybde** | **8.47** | **6.71** | **5.7** | **5.19** | **4.68** | **4.17** | **3.65** | **2.89** | **2.38** | **1.85** | **1.34** | **0.98** |

**BSPT 55° – indvendig og udvendig**

| Antal arbejdsgange | REDUCER SKÆREHASTIGHEDEN PROPORTIONALT FOR AT ØGE GEVINDSTIGNINGEN | | | |
|---|---|---|---|---|
| | Stigning [antal gevind/tomme] | | | |
| | 11 | 14 | 19 | 28 |
| 1 | 0.22 | 0.19 | 0.19 | 0.15 |
| 2 | 0.21 | 0.18 | 0.18 | 0.14 |
| 3 | 0.20 | 0.17 | 0.17 | 0.13 |
| 4 | 0.19 | 0.16 | 0.15 | 0.12 |
| 5 | 0.18 | 0.15 | 0.13 | 0.08 |
| 6 | 0.16 | 0.14 | 0.08 | |
| 7 | 0.15 | 0.12 | | |
| 8 | 0.13 | 0.08 | | |
| 9 | 0.08 | | | |
| **Samlet tilspændingsdybde** | **1.52** | **1.19** | **0.90** | **0.62** |

**ACME – ACME 29° – udvendig**

| Antal arbejdsgange | REDUCER SKÆREHASTIGHEDEN PROPORTIONALT FOR AT ØGE GEVINDSTIGNINGEN | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| | Stigning [antal gevind/tomme] | | | | | | | |
| | 4 | 5 | 6 | 8 | 10 | 12 | 14 | 16 |
| 1 | 0.37 | 0.34 | 0.32 | 0.29 | 0.27 | 0.25 | 0.22 | 0.23 |
| 2 | 0.34 | 0.32 | 0.28 | 0.25 | 0.23 | 0.22 | 0.20 | 0.21 |
| 3 | 0.30 | 0.25 | 0.23 | 0.21 | 0.20 | 0.17 | 0.18 | 0.18 |
| 4 | 0.27 | 0.23 | 0.21 | 0.17 | 0.18 | 0.14 | 0.15 | 0.14 |
| 5 | 0.25 | 0.22 | 0.18 | 0.15 | 0.14 | 0.13 | 0.13 | 0.12 |
| 6 | 0.24 | 0.20 | 0.18 | 0.13 | 0.12 | 0.12 | 0.11 | 0.08 |
| 7 | 0.21 | 0.19 | 0.16 | 0.13 | 0.12 | 0.10 | 0.08 | |
| 8 | 0.20 | 0.19 | 0.16 | 0.12 | 0.11 | 0.09 | | |
| 9 | 0.20 | 0.18 | 0.16 | 0.12 | 0.11 | | | |
| 10 | 0.18 | 0.16 | 0.15 | 0.11 | 0.09 | | | |
| 11 | 0.17 | 0.15 | 0.14 | 0.11 | | | | |
| 12 | 0.16 | 0.14 | 0.13 | 0.09 | | | | |
| 13 | 0.16 | 0.13 | 0.11 | | | | | |
| 14 | 0.15 | 0.11 | | | | | | |
| 15 | 0.14 | | | | | | | |
| 16 | 0.12 | | | | | | | |
| **Samlet tilspændingsdybde** | **3.46** | **2.83** | **2.41** | **1.88** | **1.57** | **1.22** | **1.07** | **0.96** |

**ACME – ACME 29° – indvendig**

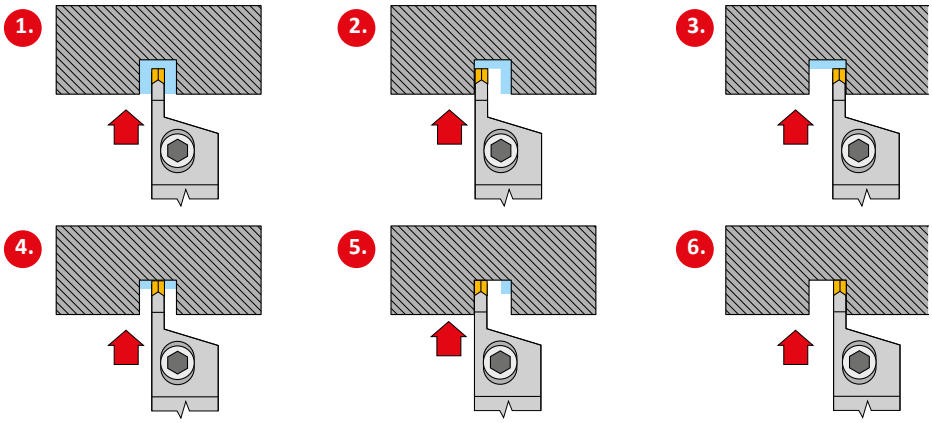
| Antal arbejdsgange | REDUCER SKÆREHASTIGHEDEN PROPORTIONALT FOR AT ØGE GEVINDSTIGNINGEN | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| | Stigning [antal gevind/tomme] | | | | | | | |
| | 4 | 5 | 6 | 8 | 10 | 12 | 14 | 16 |
| 1 | 0.37 | 0.34 | 0.32 | 0.29 | 0.27 | 0.25 | 0.22 | 0.23 |
| 2 | 0.33 | 0.31 | 0.27 | 0.25 | 0.23 | 0.22 | 0.20 | 0.21 |
| 3 | 0.30 | 0.25 | 0.23 | 0.21 | 0.20 | 0.17 | 0.18 | 0.17 |
| 4 | 0.27 | 0.23 | 0.20 | 0.17 | 0.18 | 0.15 | 0.15 | 0.14 |
| 5 | 0.25 | 0.22 | 0.18 | 0.15 | 0.15 | 0.13 | 0.13 | 0.12 |
| 6 | 0.23 | 0.20 | 0.18 | 0.14 | 0.12 | 0.12 | 0.11 | 0.08 |
| 7 | 0.21 | 0.19 | 0.16 | 0.13 | 0.12 | 0.10 | 0.08 | |
| 8 | 0.20 | 0.19 | 0.15 | 0.12 | 0.11 | 0.09 | | |
| 9 | 0.20 | 0.17 | 0.15 | 0.12 | 0.11 | | | |
| 10 | 0.18 | 0.16 | 0.15 | 0.12 | 0.09 | | | |
| 11 | 0.17 | 0.15 | 0.14 | 0.11 | | | | |
| 12 | 0.16 | 0.14 | 0.13 | 0.09 | | | | |
| 13 | 0.16 | 0.13 | 0.11 | | | | | |
| 14 | 0.15 | 0.11 | | | | | | |
| 15 | 0.14 | | | | | | | |
| 16 | 0.12 | | | | | | | |
| **Samlet tilspændingsdybde** | **3.44** | **2.78** | **2.38** | **1.90** | **1.59** | **1.23** | **1.07** | **0.95** |

**Recesses, parting and copy turning.**

Pramet offers a comprehensive range of tools for turning shallow and deep recesses, both radially and axially (face grooving). Circular/copy profile turning can also be performed through side cutting.

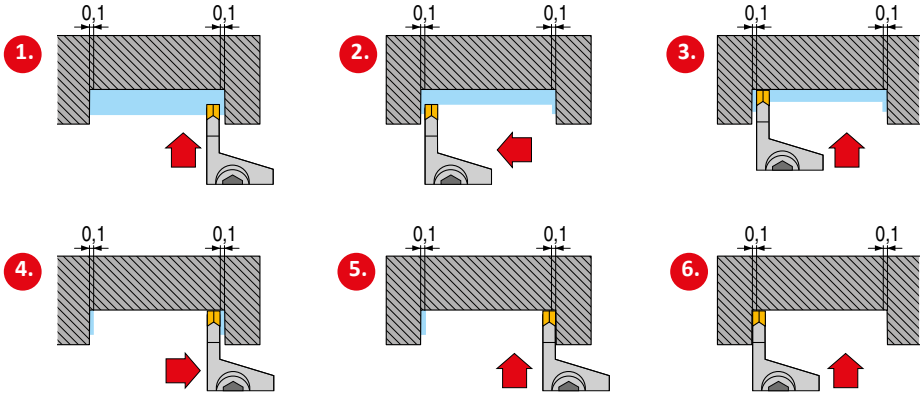
**Recommendation for practical usage:**

The procedure for turning a recess (deepening and widening) is shown in the following illustration.

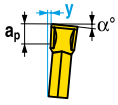



Note: To create a flat seating surface, use insert type **GL** with chip breaker **GM** or **LCMF** with chipbreaker **F.** The outboard radial grooving passes should overlap the central pass by two times the insert corner radius.

When machining a wide recess, follow the procedure shown in the following illustration.

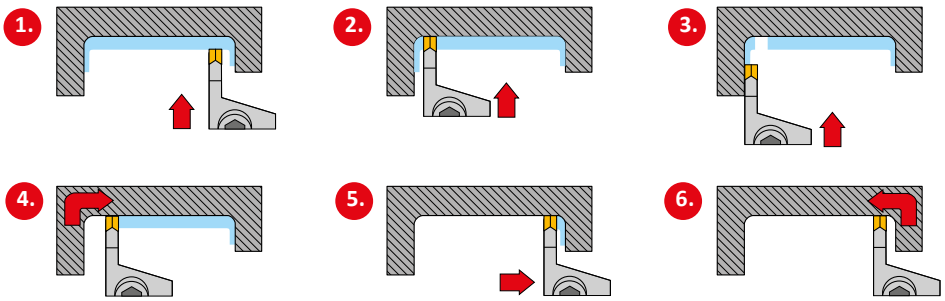



Note: Use the cutting insert LCMF with chip breaker M. You must consider the tool's deformation "*y*":

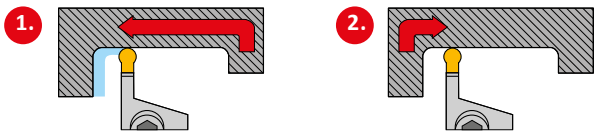



– for *f* =0,15 mm/rev; $a_p$ = 3 mm ***y = 0,07 mm***
– for *f* =0,25 mm/rev; $a_p$ = 3 mm ***y = 0,08 mm***
– for *f* =0,35 mm/rev; $a_p$ = 3 mm ***y = 0,10 mm***

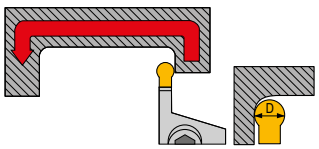
When opening up or deepening a contour using side turning, use the procedure shown in the following illustration.




**Roughing of contour (insert with round cutting edge)**



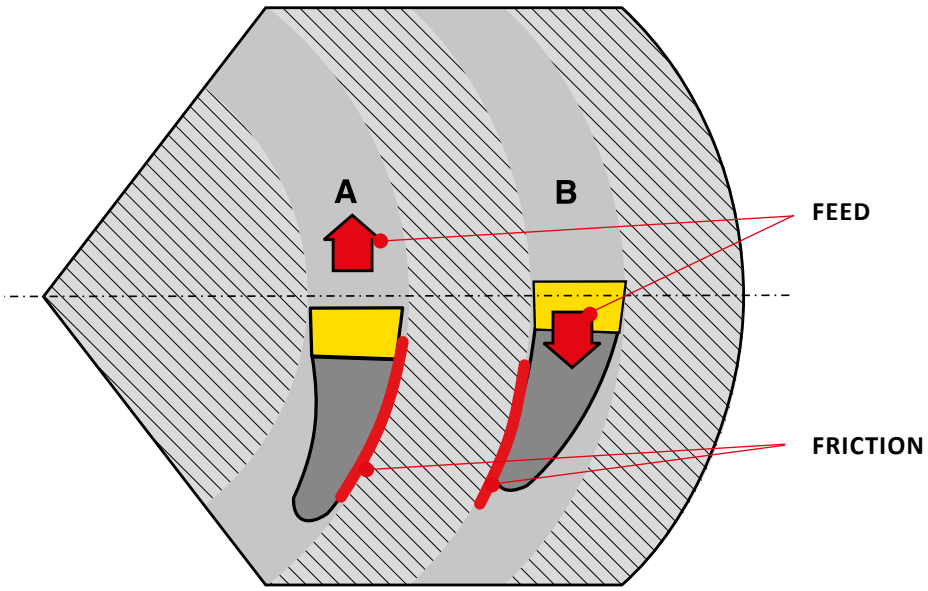

**Finishing of contour (insert with round cutting edge)**




| D (mm) | $a_p$ (mm) |
|---|---|
| 3 | 0.15 |
| 4 | 0.20 |
| 5 | 0.22 |
| 6 | 0.25 |
| 8 | 0.40 |

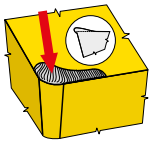
**When copy turning using indexable inserts with a round cutting edge, the maximum depth of cut is 50% of the diameter of the insert.**
**Choose the tool holder with the maximum cross-section and minimum tool overhang to eliminate vibrations.**
**The longitudinal axis of the cutting insert must be perpendicular to the axis of rotation of the workpiece (at radial recesses).**
**The cutting edge must be on centerline within a tolerance of + – 0,1 mm**
**Coolant must be applied directly onto the cutting edge, and onto the support area of the tool holder under the insert cutting edge, in sufficient quantities to guarantee effective cooling of the insert.**
When face grooving it is necessary to select a tool holder with the correct range of diameters for the groove to be machined. The tool must be set parallel to the axis of rotation of the workpiece (perpendicular to the face of the groove). Otherwise there is a risk of rubbing against the wall(s) of the groove during machining.
In the event of the tool rubbing against the outer wall of the groove, it may be necessary to raise the cutting edge above centre (see example A in picture).

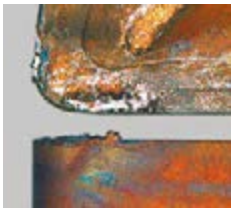
When face grooving, the tool must be set to be perpendicular to the face of the workpiece with high accuracy, otherwise the side of the tool will rub against the groove being created.




**Using effective coolant, applied directly to the cutting edge in sufficient quantities**, is very important. Cooling reduces the temperature of the cutting edge and also the lower part of the tool holder, in which the cutting insert is seated.

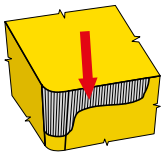
## AKKUMULERET KANT

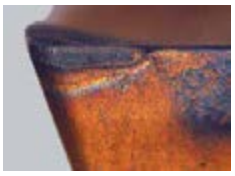




| | | |
|---|---|---|
| | | Dette har ingen betydning |
| (MT)CVD / PVD | + + | Enhver belægning (den afgørende faktor er anti-adhæsionseffekt) |
| f | ↑ | Jo højere tilspændingshastighed, jo mindre sandsynlighed for dannelse af løsæg. |
| v | ↓ ↑ | Ændr (normalt = øg) skærehastigheden |
| $a_p$ | | Dette har ingen betydning |
| | ↓ ↑ | Brug en mere positiv geometri (der opstår ikke løsæg, hvis hældningsvinklen er større end 40°) |
| | - | Brug et kølemiddel med mere effektve egenskaber til modvirkning af sammenklæbning (eller slet ikke kølemiddel) |

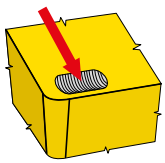
## FLANKESLID

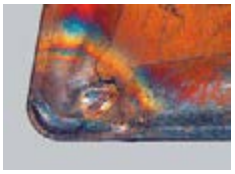




| | | |
|---|---|---|
| | ↑ | Brug et mere slidbestandigt substrat (S) |
| (MT)CVD / PVD | + + | Enhver belægning (den afgørende faktor er bestandighed mod oxidation – $\alpha$ $Al_2O_3$) |
| f | ↑ | Tilspændingen påvirker rillens form og position |
| v | ↓ | Reducer skærehastigheden |
| | ↑ | Minimal effekt |
| $a_p$ | + | Brug en anden (mere positiv) skæregeometri |
| | + | Brug kølemiddel, eller øg intensiteten |

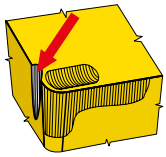
## KRATERDANNELSE

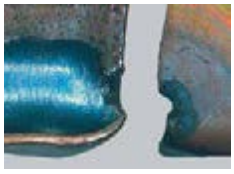




| | | |
|---|---|---|
| | ↑ | Brug et mere slidbestandigt substrat (S) |
| (MT)CVD / PVD | + + | Enhver belægning (den afgørende faktor er termisk modstand – $\alpha$ $Al_2O_3$) |
| f | ↑ | Tilspændingen påvirker kraterets form og position |
| v | ↓ | Reducer skærehastigheden |
| $a_p$ | ↓ | Minimal effekt |
| | ↑ | Brug en mere positiv skæregeometri |
| | + + | Brug kølemiddel, eller øg intensiteten |

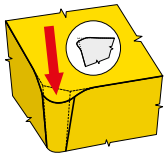
## OXIDATIONSRILLE PÅ MINDRE SKÆR

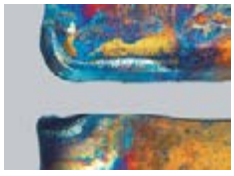




| | | |
|---|---|---|
| | ↑ | Brug et mere slidbestandigt substrat (H) |
| (MT)CVD / PVD | + + | Enhver belægning (den afgørende faktor er hårdheden – TiC,TiCN) |
| f | ↓ | øg tilspændingen (især hvis den er under 0,1 mm) |
| V | ↓ | Reducer skærehastigheden |
| $a_p$ | ↓ | Dette har ingen betydning |
| | ↑ | Det vigtigste er at øge frivinklen |
| | + + | brug kølemiddel, eller øg intensiteten |

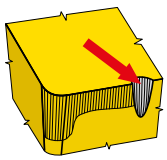
## PLASTDEFORMERING

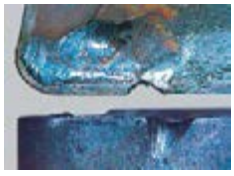




| | | |
|---|---|---|
| | ↑ | Abrug en mere slidbestandig kvalitet (Co-indholdet er afgørende) |
| (MT)CVD / PVD | + | Enhver belægning (den afgørende faktor er friktion) |
| f | ↓ | Reducer tilspændingshastigheden |
| V | ↓ | Reducer skærehastigheden |
| $a_p$ | ↓ | Minimal effekt |
| | ↑ | Brug en anden (mere positiv) skæregeometri |
| | + + | Brug kølemiddel, eller øg intensiteten |

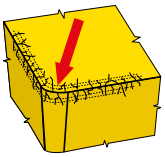
## SIDEFLANKEINDSNIT – AFHJÆLPNING





| | | |
|---|---|---|
| | ↑ ↓ | Det afhænger af skadens karakter (slibende – brug et mere slidbestandigt substrat; brud – brug et sejere substrat) |
| (MT)CVD / PVD | + + | CVD-belægning (den afgørende faktor er bestandighed mod oxidation – $\alpha$ $Al_2O_3$) |
| f | ↓ | Tilspændingen påvirker intensiteten, men mindre end skærehastigheden |
| V | ↓ | Reducer skærehastigheden |
| $a_p$ | ↑↓ | Brug en anden skæredybde |
| | ↓ | Brug en mindre positiv skæregeometri |
| | + | Brug kølemiddel, eller øg intensiteten |
| | | Brug værktøj med mindre indstillingsvinkel |

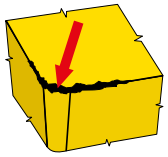
## DANNELSE AF REVNER

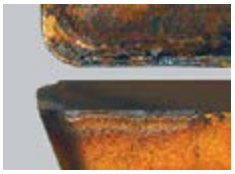




| | | |
|---|---|---|
| | ↓ | (H) partikel har stor betydning |
| (MT)CVD / PVD | + + | PVD-belægning anbefales |
| f | ↓ | Tilspændingen påvirker intensiteten, men mindre end skærehastigheden |
| v | ↓ | Lavere hastighed betyder lavere temperatur |
| $a_p$ | | Dette har ingen betydning |
| | ↓ | Brug en mindre positiv skæregeometri |
| | - - - | Intet kølemiddel (det er dog muligt at bruge luft til at fjerne spåner fra skæreområdet) |

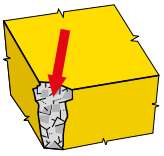
## SKØRE REVNER VED SKÆRET





| | | |
|---|---|---|
| | ↓ | (H) partikel har stor betydning |
| (MT)CVD / PVD | + | PVD-belægning anbefales |
| f | ↓ | God spånbrydning er meget vigtigt |
| v | ↑↓ | Det handler om spånbrydning og vibrationer |
| $a_p$ | ↓ | Reducerer belastningen (vigtigt for maskinbearbejdning med lang overlapning) |
| | ↓ | Brug en mindre positiv skæregeometri |
| | | Dette har ingen betydning |
| | | Brug bedre arbejdsforhold, reducer skærefrigangstilspændingen (skæring) |

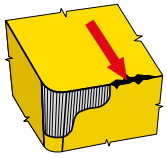
## INDSATSFRAKTUR





| | | |
|---|---|---|
| | ↓ | (H) partikel har stor betydning |
| (MT)CVD / PVD | + | PVD-belægning anbefales |
| f | ↓ | Reducerer belastningen |
| v | ↑↓ | Det handler om spånbrydning og vibrationer |
| $a_p$ | ↓ | Reducerer belastningen |
| | ↓ | Brug en mindre positiv skæregeometri |
| | | Dette har ingen betydning |
| | | Brug bedre arbejdsforhold |

## FEJL FOR SKÆR





| | | |
|---|---|---|
|  | ↓ | (H) partikel har stor betydning |
|  | + | PVD-belægning anbefales |
|  | ↑↓ | God spånbrydning er meget vigtigt |
|  | ↑↓ | Det handler om spånbrydning og vibrationer |
|  | ↑↓ | God spånbrydning er meget vigtigt |
|  | ↓ | Brug en mindre positiv skæregeometri |
|  | | Dette har ingen betydning |
| | | Problemet er dårlig spånbrydning, afgang eller fjernelse af spåner |

## DÅRLIG OVERFLADEKVALITET



**Beskrivelse og årsag:**

Utallige årsager afhængigt af arbejdsemnets materiale, skæreforholdene (tilspændingshastighed og skæreforhold), skærets tilstand, omfanget og typen af slid samt tilstanden og stivheden for maskine-værktøj-arbejdsemne-opsætningen.

- forkert værktøj valgt
- forkert spåntykkelse
- forkert skærehastighed
- der skal bruges kølemiddel
- høj tilspændingshastighed

**Afhjælpning:**

- brug en wiperskær
- brug en skær med den rette geometri
- reducer tilspændingshastigheden
- ændr (normalt = øg) skærehastigheden
- brug et kølemiddel
- øg stabiliteten for værktøjet og arbejdsemnet
- ændr spåntværsnittet
- vælg en mere letskærende spånbryder
- øg næseradien

## VIBRATIONER



**Beskrivelse og årsag:**

Dette er et meget almindeligt problem, som primært skyldes et uafbalanceret arbejdsemne eller værktøj, ustabil fastgørelse af arbejdsemnet, høj skærekraft eller værktøjsoverlapning.

**Afhjælpning:**

- øg stabiliteten for værktøjet og arbejdsemnet
- reducer skæredybden
- minimer værktøjsoverlapning
- reducer skærehastigheden
- brug et værktøj med mindre indstillingsvinkel
- reducer spåntværsnittet
- brug et værktøj med lav skæremodstand
- øg tilspændingshastigheden
- vælg en mere letskærende spånbryder
- øg næseradien

## GRATER



**Beskrivelse og årsag:**

Dette forekommer normalt ved blødt stål og plastmaterialer.

**Afhjælpning:**

- brug en vendeskær med et skarpt skær
- brug en vendeskær med positiv geometri
- brug et værktøj med mindre indstillingsvinkel

## FEJL I ARBEJDSEMNETS MÅL OG FORM



**Beskrivelse og årsag:**

Afhænger af en række faktorer.

**Afhjælpning:**

- brug en slidbestandig skær
- øg stabiliteten for fræseren og arbejdsemnet
- minimer værktøjsudhæng
- brug et arbejdsemne med en passende maskinbearbejdningstolerance

## UTILSTRÆKKELIG SPÅNDANNELSE



**Beskrivelse og årsag:**

Brug af en spån med en egnet form er lige så vigtigt som holdbarheden (værktøjets servicelevetid). Arbejdsemnets materiale, tilspændingshastigheden, skæredybden og skæregeometrien er alt sammen med til at påvirke spåndannelsen. En spån, der er for lang, er uacceptabel af forskellige årsager, mens en spån, der er for kort, er uønsket, da den hænger ud over skæret og forårsager vibrationer.

**Afhjælpning:**

- ændr tilspændingshastigheden og skæredybden
- brug en mere velegnet skæregeometri
- ændr skæreforholdene

## KONTROLLER SKÆREINDSATSENS LEJETILSTAND

Før fastspænding af en ny skæreindsats eller ændring af skæret skal lejet rengøres, og dets tilstand eller tilstanden for ambolten og kilen skal kontrolleres (der skal især kontrolleres for skader under skæreindsatsens hjørne).

## KONTROL OG SERVICE FOR FASTSPÆNDINGSDELENE

Det er også vigtigt at kontrollere fastspændingsdelene, herunder spændegreb, skruer, kiler og klemmer. Brug kun originale, ubeskadigede dele (kan findes i kataloget). Smør regelmæssigt gevindene og skruernes kontaktflade, f.eks. ved hjælp af varmeresistent smøremiddel (Molykote G.). Ved montering og demontering må der kun bruges de skruetrækkere og nøgler, der er anført i vores katalog, eller som anbefales af værktøjsproducenten. Sørg for at bruge den korrekte tilspænding (proportionelt) – det anbefales at bruge en momentnøgle.

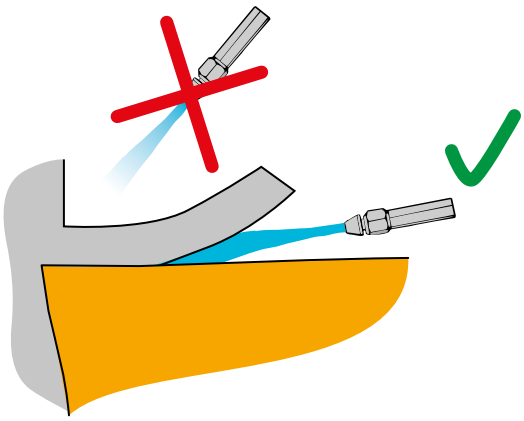
## KONTROLLER TILSPÆNDINGEN

Kontrollér før tilspænding, at vendeskær sidder korrekt på hele bindefladen og i den radiale og aksiale retning. Vendeskær og værktøjer skal altid være rene og ubeskadigede.



**Machined material** – the influence of the cutting environment increases with worsening machinability of the workpiece material.
**Cutting grade** – the influence of the cutting environment increases with increasing toughness (Co content). Cooling is not only recommended for high-speed machining, i.e. for the application of CBN and ceramics.
**Feed** – the increasing feed increases the contribution of the cutting fluid to the tool life.
**Cutting speed** (typical for the machined material) – the higher the cutting speed, the more important the cooling effect of the cutting fluid and, conversely, the lower the cutting speed, the more important the lubricating effect of the cutting fluid.

**Fluid supply** is also one of the criteria that strongly affects the economy and productivity of the cutting process. In an ideal case, the liquid can be supplied to both the face and the flank of the tool. The supply of cutting fluid from the flank only affects the tool life. While the supply of fluid from the face of the tool can in some cases help you to form chips (especially in the case of high-pressure cooling). If only one of the alternatives is possible, the type of wear will indicate the right direction. If the inserts are worn on the flank, try to bring the liquid from below, i.e. to the flank of the insert. If a crater is formed, the fluid should be directed to the face of the tool (under the chip, not to its root).



| Værdi | Formel | Enhed | Bemærkning |
|---|---|---|---|
| **Antal omdrejninger** | $n = \frac{v_c \cdot 1000}{D \cdot \pi}$ | (1/min) | $n$ Antal omdrejninger [1/min]<br>$D$ Diameter (for værktøj eller arbejdsemne) [mm]<br>$v_c$ Skærehastighed [m/min]<br>$f_{rev}$ Tilspænding pr. omdrejning [mm/omdr.]<br>$f_{min}$ Tilspænding pr. minut (Lineær tilspændingshastighed) [mm/min] |
| **Skærehastighed** | $v_c = \frac{\pi \cdot D \cdot n}{1000}$ | (m/min) | |
| **Tilspænding pr. omdrejning** | $f_{rev} = \frac{f_{min}}{n}$ | (mm/omdr.) | |
| **Tilspænding pr. minut (lineær tilspændingshastighed)** | $f_{min} = v_f = f_{rev} \cdot n$ | (mm/min) | |
| **Maks. højde for profil $R_{max}$** | $R_{max} = \frac{125 \cdot f_{rev}^{\ 2}}{RE}$ | (mm) | $R_{max}$ Maks. højde for profil [mm]<br>$R_a$ Overfladefinish [mm]<br>$f_{rev}$ Tilspænding pr. omdrejning [mm/omdr.]<br>$RE$ Spidsradius [mm] |
| **Overfladefinish $R_a$** | $R_a = \frac{43{,}9 \cdot f_{rev}^{\ 1{,}88}}{RE^{\ 0{,}97}}$ | (mm) | |
| **Spåntværsnit** | $A = f_{rev} \cdot a_p$ | ($mm^2$) | $A$ Spåntværsnit [$mm^2$]<br>$f_{rev}$ Tilspænding pr. omdrejning [mm/omdr.]<br>$a_p$ Aksial skæredybde [mm]<br>$\kappa_r$ Primær indstillingsvinkel for skær [°]<br>$h$ Spåntykkelse [mm]<br>$v_c$ Skærehastighed [m/min]<br>$f_{min}$ Tilspænding pr. minut (Lineær tilspændingshastighed) [mm/min]<br>$Q$ Materialefjernelseshastighed pr. minut [$cm^3$/min]<br>$INSD$ Insert diameter (mm) |
| **Spåntykkelse (For indsats med lige skær)** | $h = f_{rev} \cdot \sin \kappa_r$ | (mm) | |
| **Spåntykkelse (For rund skæreindsats)** | $h = f_{rev} \cdot \sqrt{\frac{a_p}{INSD}}$ | (mm) | |
| **Spånvolume** | $Q = a_p \cdot f_{rev} \cdot v_c$ | ($cm^3$/min) | |
| **Strømforbrug** | $P_c = \frac{a_p \cdot f_{rev}^{\ 1-c} \cdot k_{c1} \cdot v_c \cdot k\kappa_r}{6 \cdot 10^4 \cdot \eta}$ | (kW) | $P_c$ Strømforbrug [kW]<br>$a_p$ Skæredybde [mm]<br>$f_{rev}$ Tilspænding [mm/omdr.]<br>$c$ Konstant KTV [1]<br>$k_c$ Specifik skærekraft [MPa]<br>$k_{\kappa_r}$ κr vinkelkonstant [1]<br>$\eta$ Effektivitet (normalt η = 0,75) [1]<br>$x$ Konstant for maskinbearbejdet materiale [1] |
| **Omtrentligt strømforbrug** | $P_c = \frac{a_p \cdot f_{rev} \cdot v_c}{x}$ | (kW) | |

| Materiale | Stål | Støbejern | Al |
|---|---|---|---|
| Koefficient $x$ | 20 | 25 | 100 |

# ANBEFALEDE DREJNINGSMOMENTER FOR SKRUE

## SPÆNDESKRUE

| Skruebetegnelse | Skruetrækker | Tilspændingsmoment (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 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 |
| **PS 6026-709P** | SRD T09P | 2 |

## SPÆNDESKRUE

| Skruebetegnelse | Skruetrækker | Tilspændingsmoment (Nm)* |
|---|---|---|
| **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 |
| **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 |

## TILSPÆNDINGSMOMENT FOR SKRUETRÆKKERE

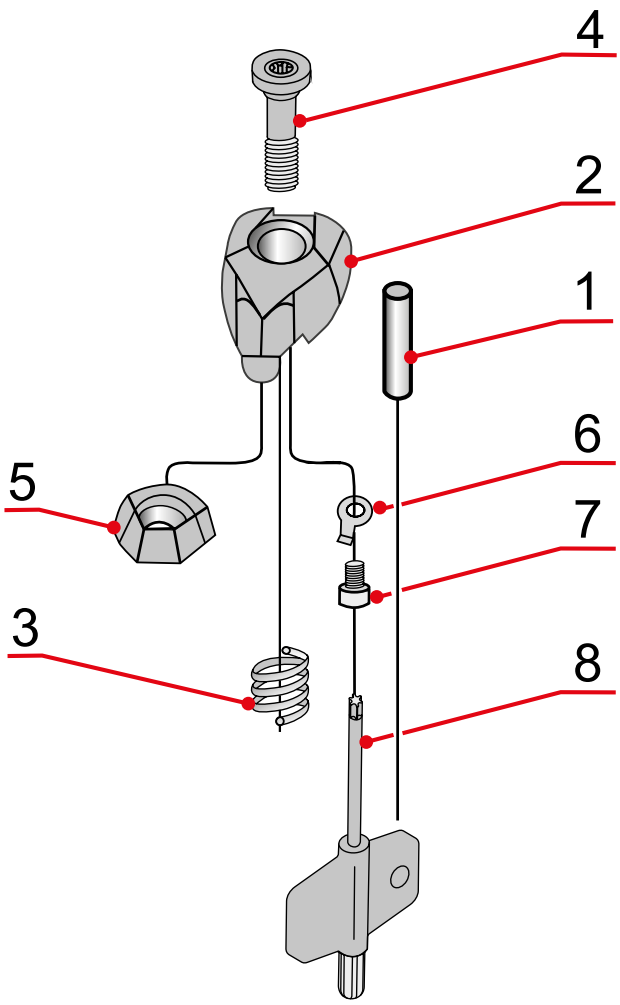
| Tilspændingsgreb | Tilspændingsmoment (Nm) | Spændeskruegevind |
|---|---|---|
| **MR-0.8-2.0 vario** | 0.5 – 2.0 | M 2 – M 3 |
| **MR-1.0-5.0 vario** | 0.8 – 5.0 | M 2.5 – M 5 |
| | | |
| **MR-0.9 fix** | 0.9 | M 2 |
| **MR-2.0 fix** | 2.0 | M 3 |
| **MR-3.0 fix** | 3.0 | M 3.5 |
| **MR-3.5 fix** | 3.5 | M 4 |
| **MR-5.0 fix** | 5.0 | M 5 |

## UDSKIFTELIGE SKAFTER

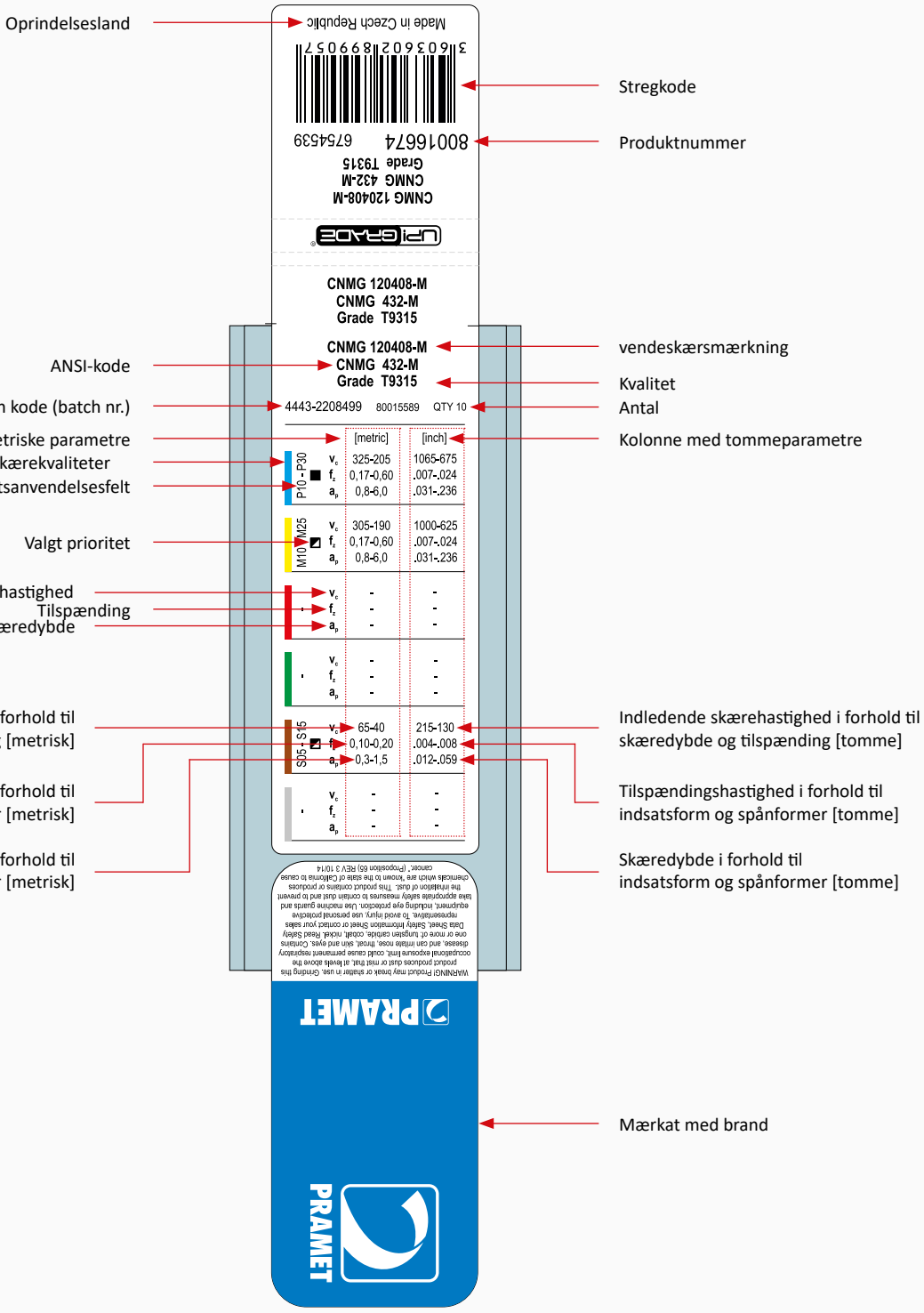
| Udskiftelige skafter | | |
|---|---|---|
| **D-T6** | **D-T8** | **D-T15** |
| **D-T6P** | **D-T8P** | **D-T15P** |
| **D-T7** | **D-T9** | **D-T20** |
| **D-T7P** | **D-T9P** | **D-T20P** |

## SKRUESMØRING

Indsatsfastspændingsskruer udsættes for høj varmebelastning. Det anbefales, at alle skruer smøres med et middel af høj kvalitet som f.eks. MOLYCOTE 1000.




| | 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 |


Oprindelsesland
Made in Czech Republic
Stregkode
Produktnummer
8001667 4 6754539
Grade T9315
CNMG 432-M
CNMG 120408-M
CNMG 120408-M
CNMG 432-M
Grade T9315
vendeskærsmærkning
ANSI-kode
CNMG 120408-M
CNMG 432-M
Grade T9315
Kvalitet
Intern kode (batch nr.)
4443-2208499 80015589 QTY 10
Antal
Kolonne med metriske parametre
Klassificering af skærekvaliteter
Kvalitetsanvendelsesfelt
[metric] [inch]
Kolonne med tommeparametre
P10 - P30
$v_c$ 325-205 1065-675
$f_z$ 0,17-0,60 .007-.024
$a_p$ 0,8-6,0 .031-.236
Valgt prioritet
M10 - M25
$v_c$ 305-190 1000-625
$f_z$ 0,17-0,60 .007-.024
$a_p$ 0,8-6,0 .031-.236
Skærehastighed
Tilspænding
Skæredybde
$v_c$ - -
$f_z$ - -
$a_p$ - -
Indledende skærehastighed i forhold til skæredybde og tilspænding [metrisk]
Indledende skærehastighed i forhold til skæredybde og tilspænding [tomme]
S05 - S15
$v_c$ 65-40 215-130
$f_z$ 0,10-0,20 .004-.008
$a_p$ 0,3-1,5 .012-.059
Tilspændingshastighed i forhold til indsatsform og spånformer [metrisk]
Tilspændingshastighed i forhold til indsatsform og spånformer [tomme]
Skæredybde i forhold til indsatsform og spånformer [metrisk]
Skæredybde i forhold til indsatsform og spånformer [tomme]
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