

DORMER PRAMET

DREIING

2021 – 2022



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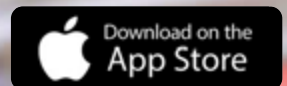
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WORKPIECE MATERIAL GROUPS (WMG)

To select a cutting grade and geometry
for a broad range of workpiece materials

General definition

i.e. Steel, Stainless Steel...

P M K N S H

Subgroup

To navigate and select a tool by suitability
for a more specific range of workpiece materials

Definition

by structure/composition

i.e. Plain Carbon Steel, Alloy Steel...

P M K N S H

P1

P2

P3

P4

To select and provide cutting conditions
within a bandwidth of $\pm 10\%$

Definition

by hardness/ultimate tensile strength

i.e. $160 < 220 \text{ HB}$, $620 < 900 \text{ N/mm}^2 \dots$

P

P1

P1.1

P1.2

P1.3

P2

P2.1

P2.2

P2.3

P3

P3.1

P3.2

P3.3

P4

P4.1

P4.2

P4.3

ABOUT DORMER PRAMET'S WORKPIECE MATERIAL CLASSIFICATION

Workpiece **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.

WMG (WORK MATERIAL GROUP)

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	
	M3	M2.3	Austenitic stainless steel (chromium-nickel and chromium-nickel-manganese alloys)	Precipitation-hardened	280 – 380 HB	> 950 ≤ 1300	
		M3.1		< 200 HB	≤ 750		
		M3.2		200 – 260 HB	> 750 ≤ 870		
	M4	M3.3	Austenitic-ferritic (DUPLEX) or super-austenitic stainless steel		260 – 300 HB	> 870 ≤ 1040	
		M4.1		< 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-pearlitic 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				< 240 HB	≤ 740		
K4.3				< 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		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	–	
		H1.2		Hardened cast iron	< 55 HRC	–	
	H2	H2.1	Hardened steel <55 HRC		> 55 HRC	–	
		H2.2			< 51 HRC	–	
	H3	H3.1	Hardened steel >55 HRC		51 – 55 HRC	–	
		H3.2			55 – 59 HRC	–	
	H4	H4.1	Hardened steel >59 HRC		> 59 HRC	–	
		H4.2				–	

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

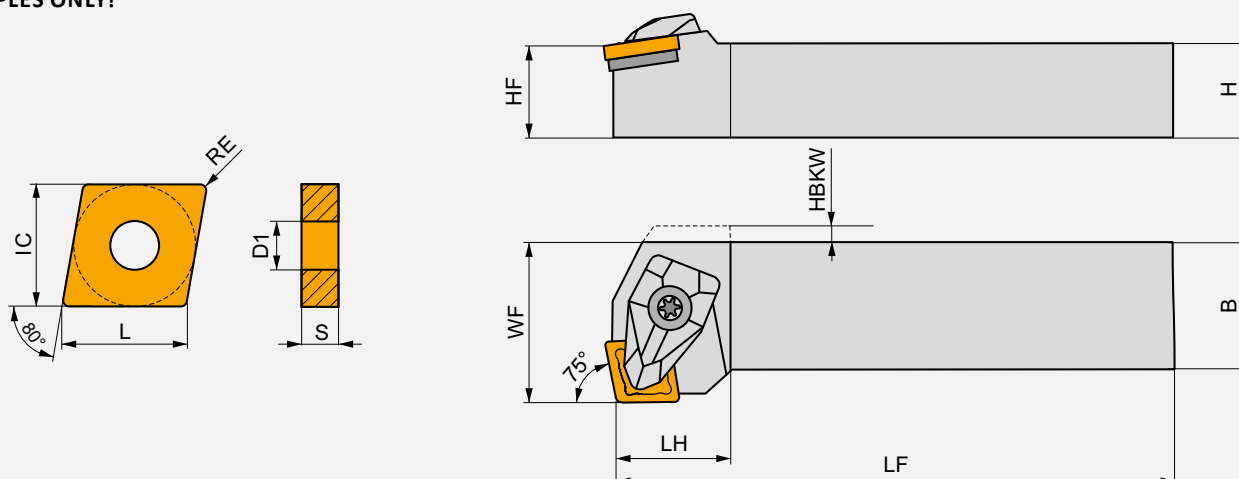
Examples of machining materials – see chapter INDEXABLE MILLS – TECHNICAL INFORMATION (page 539).

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!



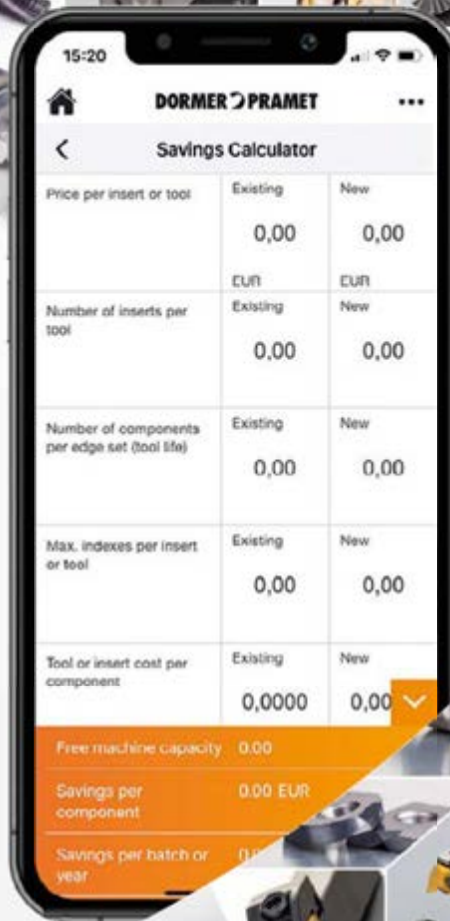
ISO 13399	Description
APMX	Depth of cut maximum
B	Shank width
BD	Body diameter
BLRAD	Blade reinforcement radius
BW	Insert body width
CDX	Cutting depth maximum
CND	Coolant entry diameter
CUTDIA	Work piece parting diameter maximum
CW	Cutting width
CWTOLL	Cutting width lower tolerance
CWTOLU	Cutting width 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	Orthogonal 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



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.
Simply Reliable.



ISO TURNING



TURNING – GENERAL CONTENT

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WMG & ISO 13399

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POSITIVE INSERTS

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NEGATIVE INSERTS

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BROACHING

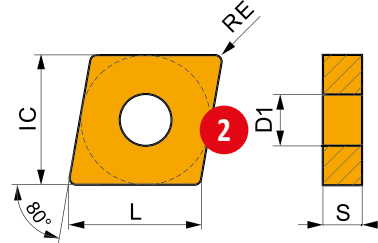
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TECHNICAL INFORMATION

1 CNMM

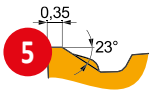
PRAMET

	IC	D1	L	S
	[mm]	[mm]	[mm]	[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



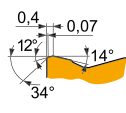
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE	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]



10 DR geometry for semi-rough to rough machining, and continuous to interrupted cuts.

CNMM 160612E-DR	T9315	1.2	225	0.45	6.0	—	—	—	210	0.45	6.0	—	—	—	—	—	—	—	—
	T9335	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	—	—	—	—	—	—	—	—	—	—	—



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

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



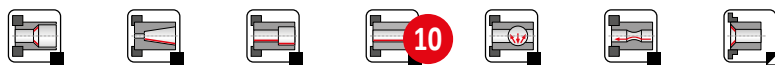
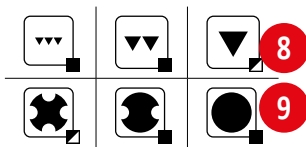
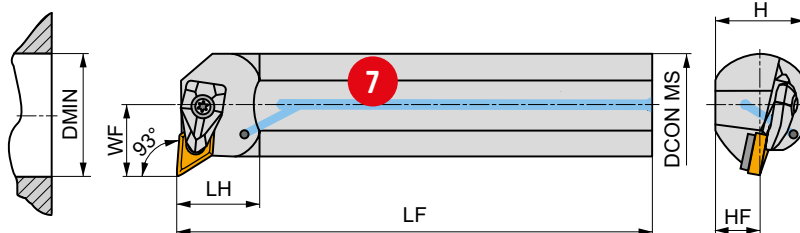
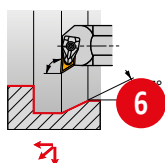
PRAMET 3

D



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.



Product	DCON MS	DMIN	WF	H	HF	LF	LH	LAMS	GAMO		kg			
	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[°]	[°]					
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	✓	5.25	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
GI046

19

DN.. 1506..
DN.. 1104..DD11
DD154DCS 09
DCS 121.7
3.9

20

DDS 267-01
DDS 266-02US 2004-T09P
US 2002-T15PFLAG T09P
FLAG T15P/3,5AT002a
AT002b
AT002cDN.. 1504..
CER DN.N 1506..
CER DN.A 1506..

21

–
DCS 12C4
DCS 12C2

DDS 266-01

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⁾ Dreieholder vises primært i sin høyre-design (R)

²⁾ GAMO = ortogonal rakevinkel (se teknisk del)

LAMS = hellingsvinkel til hovedkutteegg (se teknisk del)

³⁾ Kode til gruppe med compatible skjær, reservedeler og spesialutstyr brukes kun i forbindelse med denne katalogen. Den kan ikke brukes for ordrer.

⁴⁾ Ikoner for reservedeler og spesialutstyr utformes skjematisk for forståelighet. De er ikke inkludert i listen over ikoner. Skruer blir, i noen tilfeller, fullført med info om tiltrekkingsmoment i Nm, lengde til skrue og størrelse til gjenger.

TURNING HOLDERS – ICONS OVERVIEW

GENERAL ICONS

	Primary use		Finishing – very good surface quality		Suitable for stable working conditions
	Possible use		Medium machining – good surface quality		Suitable for unstable working conditions
			Roughing – unlimited surface roughness		Suitable for very unstable working conditions

FEATURES

	First choice		Insert with Wiper geometry		Sharp edge
	For short chipping materials		Large overhang		Rounded edge
	For tough materials (long chipping)		Railway wheel machining		Edge with facet
	Heavy working conditions		Thin-walled and slim workpieces		Rounded edge with facet
	High Feed Cutting		Universal wide range option		Edge with double facet
	High Speed Cutting				Rounded edge with double facet

TURNING OPERATIONS

	Cone turning – external		Chamfering (beveling)		Machining the rear face (shoulder) from the back
	Cone turning – internal		Chamfering (beveling) from the back		Multi directional copy turning – external
	Copy turning (multi directional machining)		Chamfering (beveling) in hole		Multi directional copy turning – internal
	Face copy turning		Longitudinal turning with shoulder – external		One directional copy turning – external
	Face copy turning in hole		Longitudinal turning with shoulder – internal		One directional copy turning – internal
	Face turning with shoulder		Longitudinal turning without shoulder – external		Shallow radial groove
	Face turning without shoulder		Longitudinal turning without shoulder – internal		

TURNING HOLDERS – ICONS OVERVIEW

TEKNISK DEL

	Fin overflatebehandling		Mating [mm/rev]		Svært høy skjærehastighet, utmerket systemstivhet (stabile arbeidsbetingelser)
	Overflatebehandling		Bestandighet [min]		Høy skjærehastighet, høy systemstivhet (stabile arbeidsbetingelser)
	Medium maskinering		Gradering		Høy skjærehastighet, systemstivhet litt begrenset (dybde til kutt endres)
	Grovbearbeiding		Belegg		Medium skjærehastighet, systemstivhet begrenset (litt avbrutt kutt)
	Tung grovbearbeiding		Skjærhastighet		Lav skjærehastighet, lav systemstivhet (avbrutt kutt)
	Multiplication factor for cutting speed		Skjærprofil		Svært lav skjærehastighet, svært lav systemstivhet (svært ustabile arbeidsbetingelser)
	Dybde til kutt [mm]		Kjøling		

OTHERS

	Clamping torque of screw (Nm)		Group of heads for roughing		Internal supply of coolant
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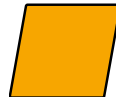
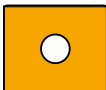
ISO INSERTS POSITIVE – NAVIGATOR

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	

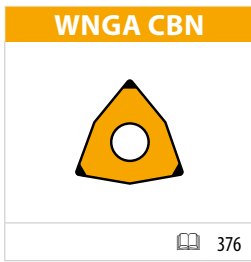
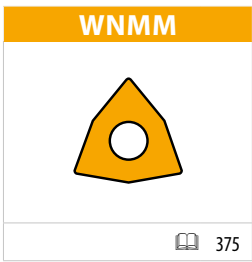
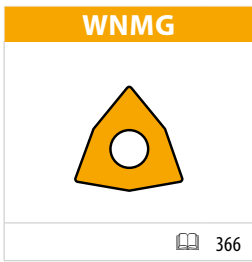
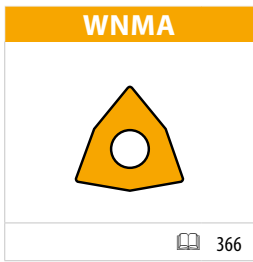
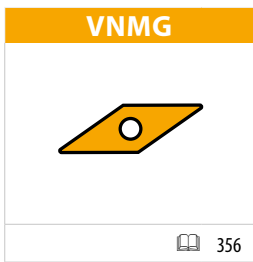
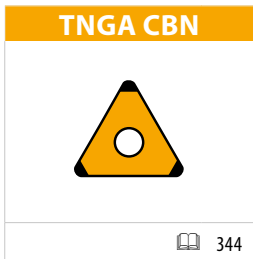
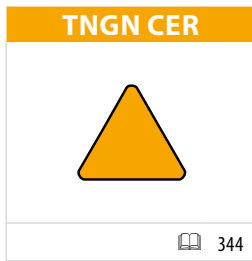
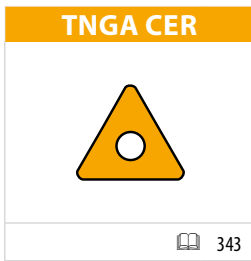
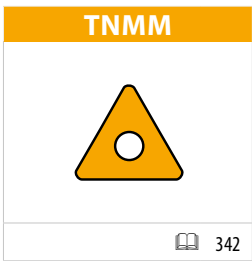
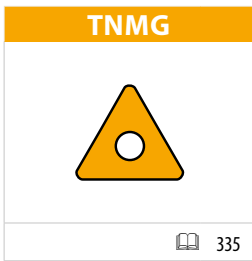
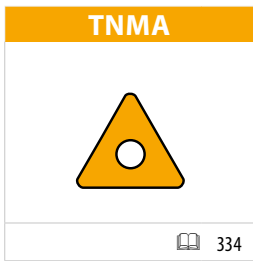
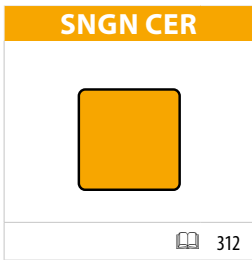
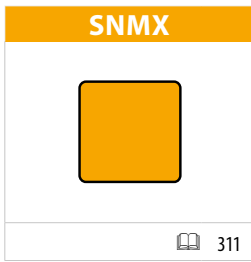
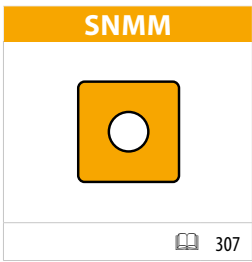
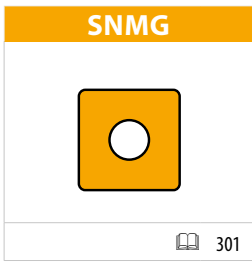
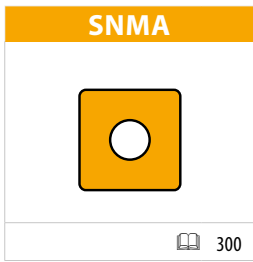
ISO INSERTS POSITIVE – NAVIGATOR

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		

ISO INSERTS NEGATIVE – NAVIGATOR

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			

ISO INSERTS NEGATIVE – NAVIGATOR



P

Svært ustabile arbeidsbetingelser

Ustabile arbeidsbetingelser

Stabile arbeidsbetingelser

Tynnveggede og slanke arbeidsstykker

1st choice

Possible use

RF

SR

FF2

FF

FM2

RM3

OR

UR

FM

RM

DR4

SF3



	0.05 – 0.2 mm/rev	0.05 – 0.2 mm/rev	0.2 – 0.4 mm/rev	0.4 – 1.0 mm/rev	> 1.0 mm/rev
	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 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

M

Legend:

- 1st choice
- Possible use

Work Conditions:

- Svært ustabile arbeidsbetingelser
- Ustabile arbeidsbetingelser
- Stabile arbeidsbetingelser
- Tynnveggede og slanke arbeidsstykker

Insert Selection Matrix:

Work Condition	1st Choice	Possible Use
Svært ustabile arbeidsbetingelser	NF1	SR, OR, DR4
Ustabile arbeidsbetingelser	FM2, RF	OR
Stabile arbeidsbetingelser	SF2, NF2, FM, RM	DR4
Tynnveggede og slanke arbeidsstykker	SF3, SI	



0.05 – 0.2 mm/rev

0.05 – 0.2 mm/rev

0.2 – 0.4 mm/rev

0.4 – 1.0 mm/rev

> 1.0 mm/rev



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 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

K

 Svært ustabile arbeidsbetingelser

 Ustabile arbeidsbetingelser

 Stabile arbeidsbetingelser

 Tynnveggede og slanke arbeidsstykker

 1st choice

 Possible use

RM3

.CMW

RF

RM

SF3

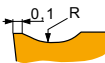
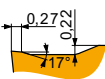
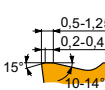
SR

OR

DR4



	0.05 – 0.2 mm/rev	0.05 – 0.2 mm/rev	0.2 – 0.4 mm/rev	0.4 – 1.0 mm/rev	> 1.0 mm/rev
	0.05 – 2 mm	0.05 – 2 mm	2 – 4 mm	4 – 10 mm	> 10 mm

RF	 <table><tr><th>I. C.</th><th>R</th></tr><tr><td>6,35</td><td>1,0</td></tr><tr><td>9,525</td><td>1,5</td></tr><tr><td>12,7</td><td>2,5</td></tr></table>	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
I. C.	R									
6,35	1,0									
9,525	1,5									
12,7	2,5									
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



Svært ustabile
arbeidsbetin-
gelser



Ustabile arbe-
idsbetingelser



Stabile arbeid-
sbetingelser



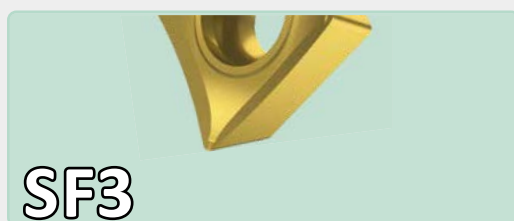
Tynnveggede
og slanke
arbeidsstykker



1st choice



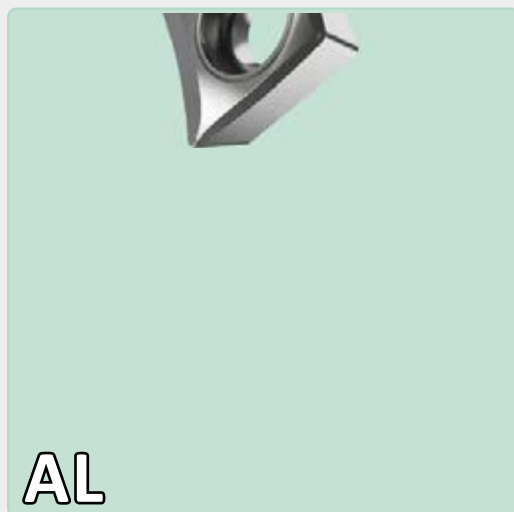
Possible use



NF1



FM



0.05 – 0.2 mm/rev

0.05 – 0.2 mm/rev

0.2 – 0.4 mm/rev

0.4 – 1.0 mm/rev

> 1.0 mm/rev



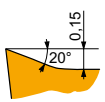
0.05 – 2 mm

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


Svært ustabile
arbeidsbetin-
gelser


Ustabile arbe-
idsbetingelser


Stabile arbeid-
sbetingelser


Tynnveggede
og slanke
arbeidsstykker



1st choice

Possible use

NF1

SF3

NF2

SF2



0.05 – 0.2 mm/rev

0.05 – 0.2 mm/rev

0.2 – 0.4 mm/rev

0.4 – 1.0 mm/rev

> 1.0 mm/rev



0.05 – 2 mm

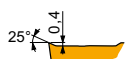
0.05 – 2 mm

2 – 4 mm

4 – 10 mm

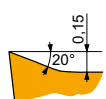
> 10 mm

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



Svært ustabile
arbeidsbetin-
gelser



Ustabile arbe-
idsbetingelser



Stabile arbeid-
sbetingelser



Tynnveggede
og slanke
arbeidsstykker



1st choice



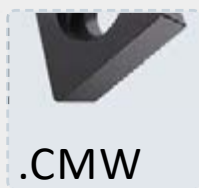
Possible use



RM3



NF1



.CMW



SF3



0.05 – 0.2 mm/rev

0.05 – 0.2 mm/rev

0.2 – 0.4 mm/rev

0.4 – 1.0 mm/rev

> 1.0 mm/rev



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



Svært ustabile arbeidsbetingelser



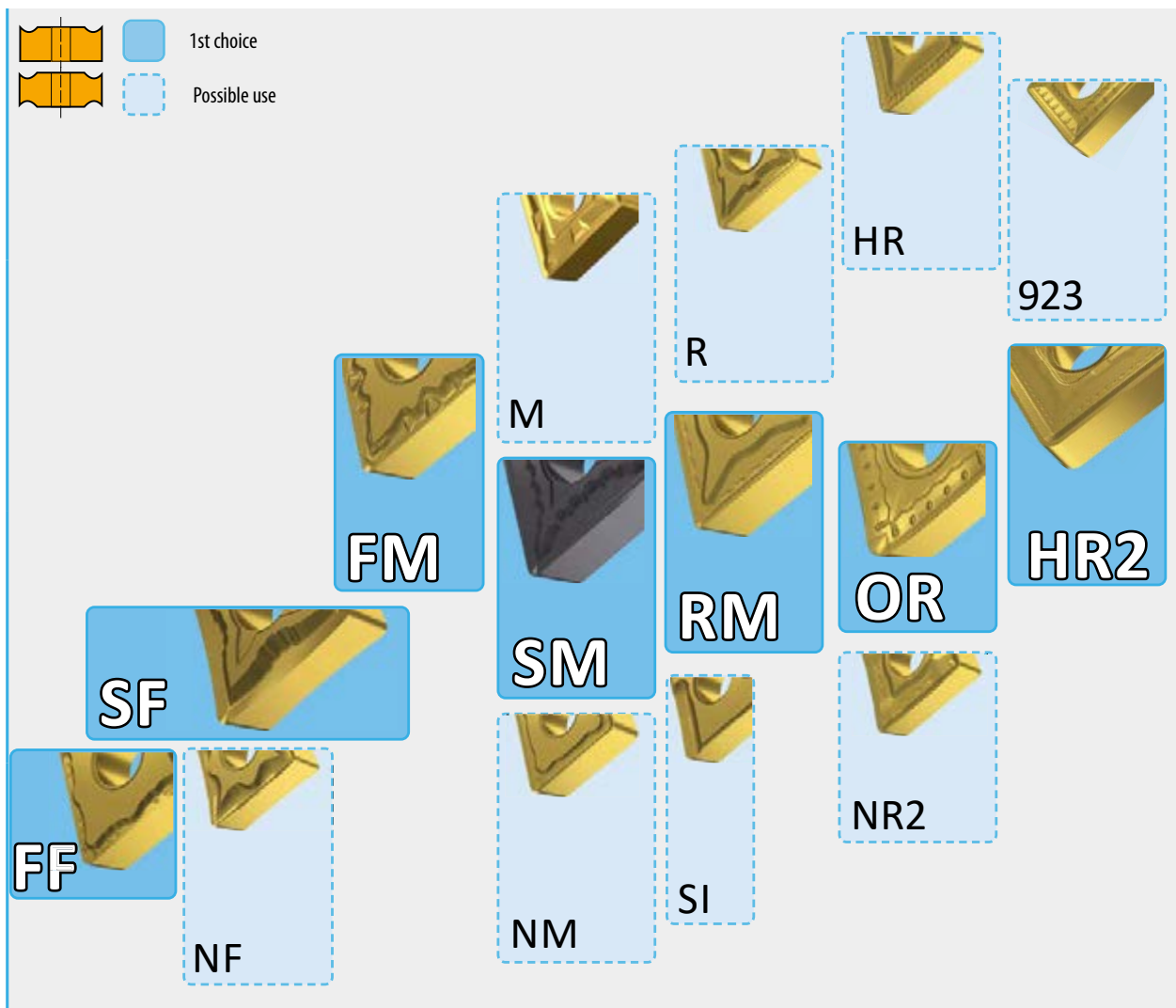
Ustabile arbeidsbetingelser



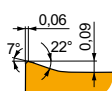
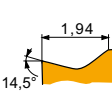
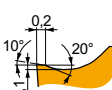
Stabile arbeidsbetingelser

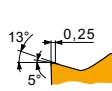
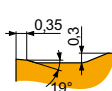
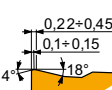


Tynnveggede og slanke arbeidsstykker

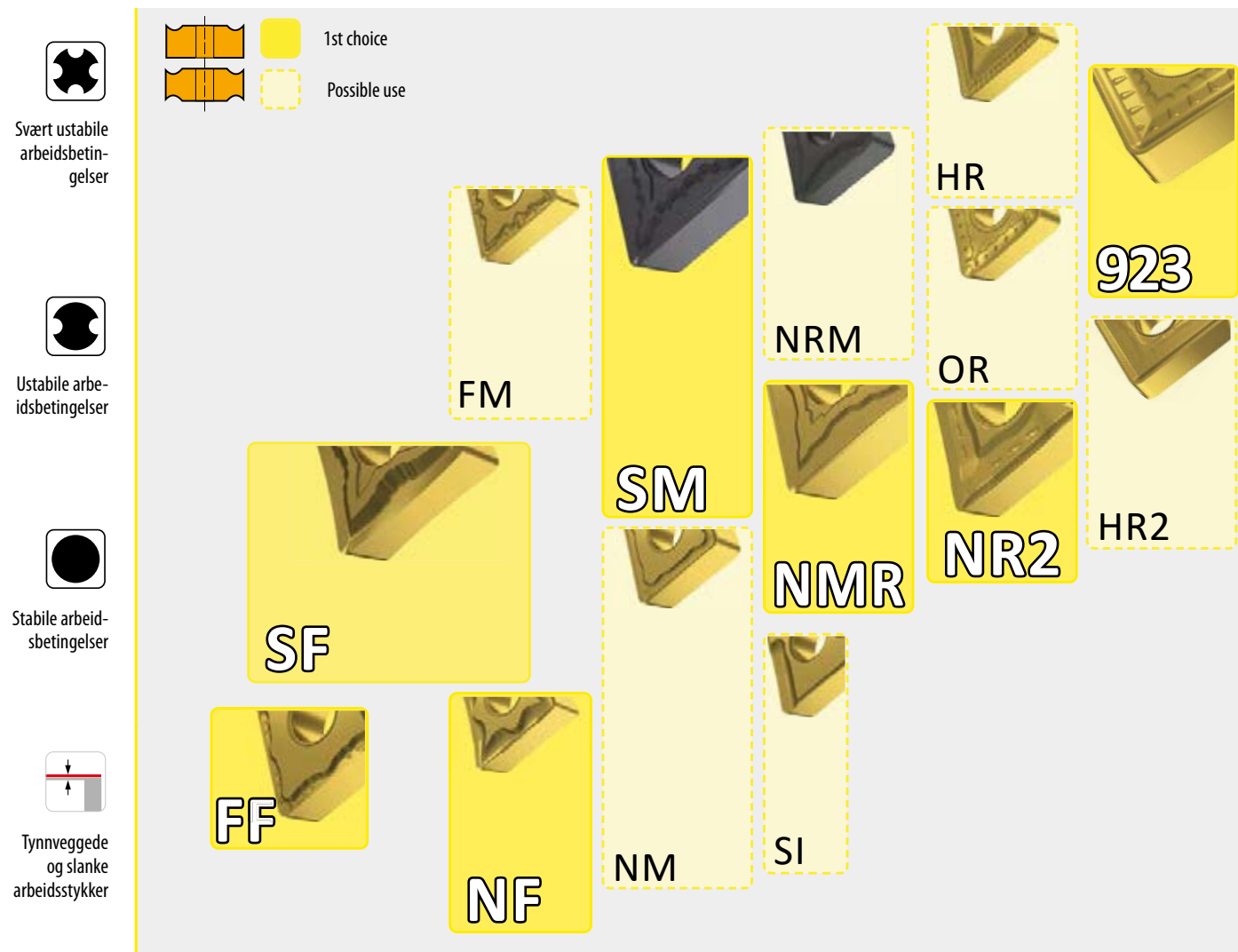


	0.05 – 0.2 mm/rev	0.05 – 0.2 mm/rev	0.2 – 0.4 mm/rev	0.4 – 1.0 mm/rev	> 1.0 mm/rev
	0.05 – 2 mm	0.05 – 2 mm	2 – 4 mm	4 – 10 mm	> 10 mm

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 ferrous 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, potentially 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

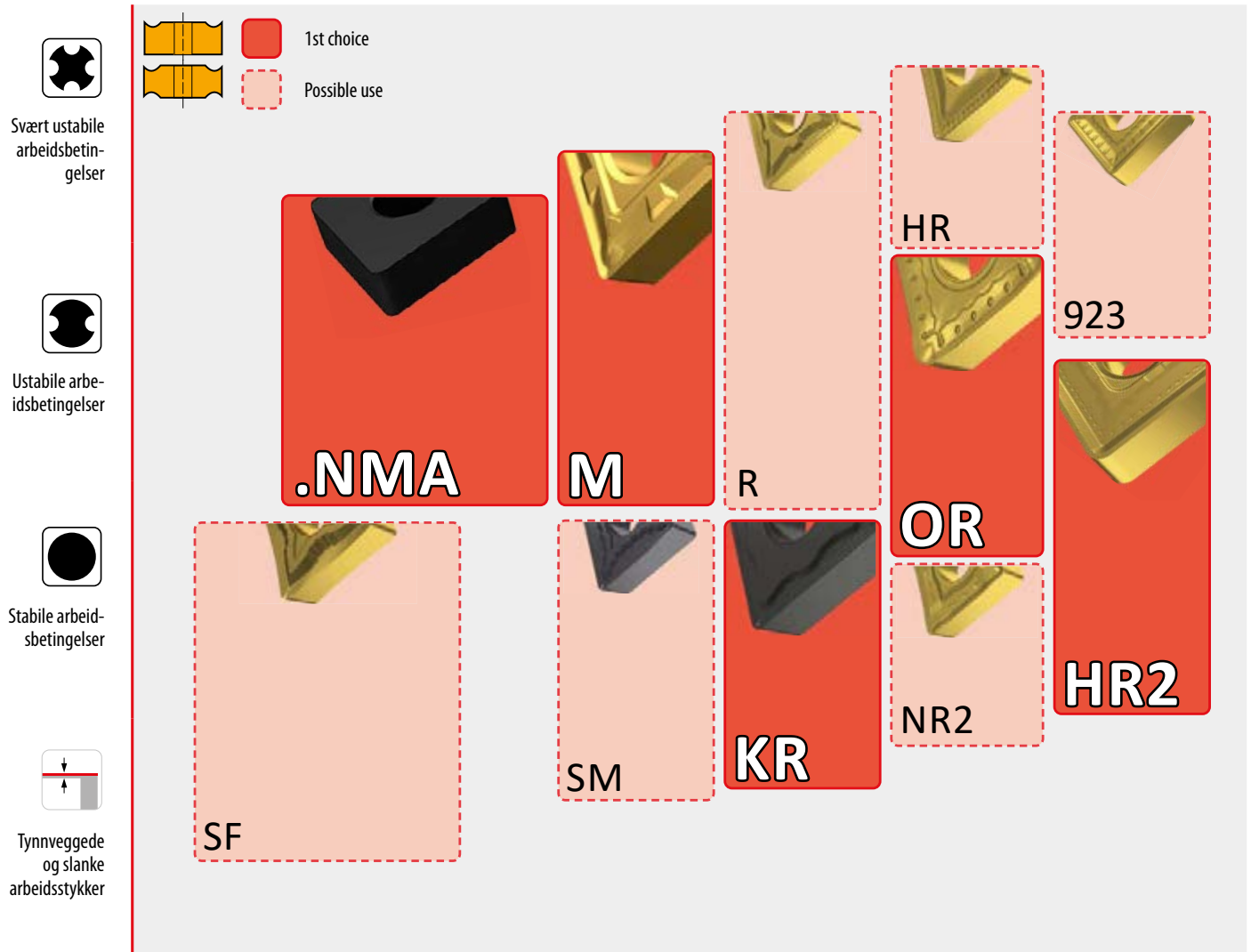


	FF	F	M	R	HR
f	0.05 – 0.2 mm/rev	0.05 – 0.2 mm/rev	0.2 – 0.4 mm/rev	0.4 – 1.0 mm/rev	> 1.0 mm/rev
a_p	0.05 – 2 mm	0.05 – 2 mm	2 – 4 mm	4 – 10 mm	> 10 mm

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 ferrous 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

ISO INSERTS NEGATIVE – CHIPBREAKER NAVIGATOR

K



f	0.05 – 0.2 mm/rev	0.05 – 0.2 mm/rev	0.2 – 0.4 mm/rev	0.4 – 1.0 mm/rev	> 1.0 mm/rev
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

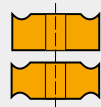
N


Svært ustabile
arbeidsbetin-
gelser

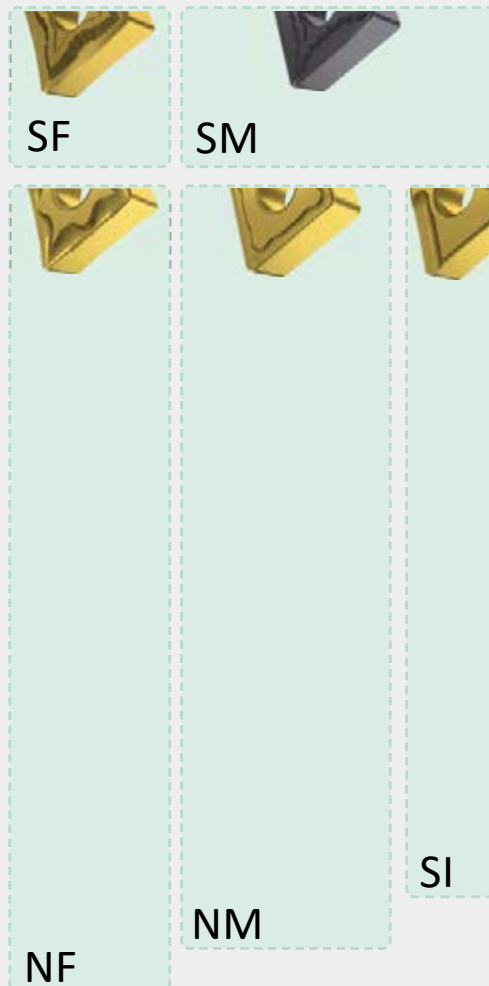

Ustabile arbe-
idsbetingelser


Stabile arbeid-
sbetingelser


Tynnveggede
og slanke
arbeidsstykker



 1st choice
 Possible use



0.05 – 0.2 mm/rev

0.05 – 0.2 mm/rev

0.2 – 0.4 mm/rev

0.4 – 1.0 mm/rev

> 1.0 mm/rev



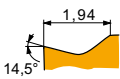
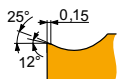
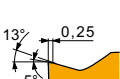
0.05 – 2 mm

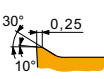
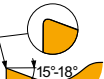
0.05 – 2 mm

2 – 4 mm

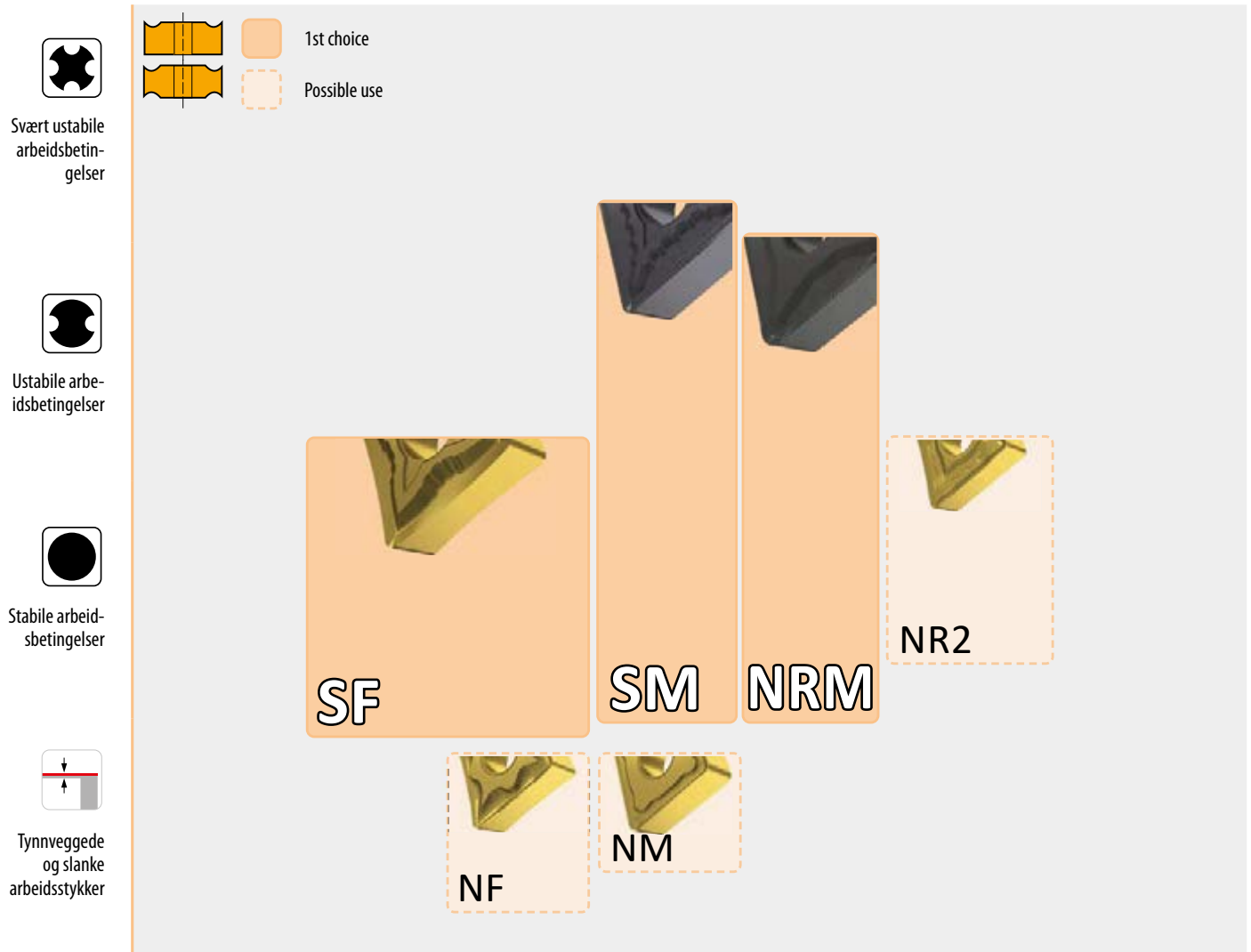
4 – 10 mm

> 10 mm

SF		Versatile positive geometry designed for fine finish machining, steels, stainless steels, cast irons and super alloys and hard materials, potentially non ferrous 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 ferrous 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



	FF	F	M	R	HR
f	0.05 – 0.2 mm/rev	0.05 – 0.2 mm/rev	0.2 – 0.4 mm/rev	0.4 – 1.0 mm/rev	> 1.0 mm/rev
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 ferrous 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



Svært ustabile arbeidsbetingelser



Ustabile arbeidsbetingelser



Stabile arbeidsbetingelser



Tynnveggede og slanke arbeidsstykker



0.05 – 0.2 mm/rev

0.05 – 0.2 mm/rev

0.2 – 0.4 mm/rev

0.4 – 1.0 mm/rev

> 1.0 mm/rev



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 ferrous 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

TURNING GRADES – NAVIGATOR

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

Group	Cemented carbide with MTCVD		Cemented carbide with PVD	Cemented carbide	CERMET
M01					
M05					
M10	T7325		T6310		
M15					
M20		T9325	T8315		
M25	T7335				
M30			T8430		
M35					
M40					

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

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

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

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

TURNING GRADES – NAVIGATOR

Grade Identification	Area of Application	Application	Feed	Cutting speed	Resistance to adverse Working Conditions	Coating	Colour	Substrate	Coolant benefit	Grade description
T9310	P01 - P15	■				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.
	K05 - K20	■								
	H10 - H20	■								
T9315	P05 - P25	■				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 its well balanced properties this grade can be first choice for a wide range of turning operations. Not suited to low cutting speeds.
	K05 - K25	■								
	H10 - H20	■								
T9325	P15 - P35	■				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.
	M10 - M30	■								
	K15 - K35	■								
	S10 - S20	■								
T9335	P20 - P45	■				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.
	M15 - M40	■								
	S15 - S25	■								
T7325	P15 - P35	■				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.
	M10 - M25	■								
	S10 - S25	■								
T7335	P20 - P40	■				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.
	M20 - M40	■								
	S15 - S25	■								
T5305	P05 - P15	■				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.
	K01 - K15	■								
	H05 - H15	■								
T5315	P10 - P25	■				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.
	K10 - K25	■								
	H15 - H25	■								
6640	P20 - P40	■				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.
	M20 - M35	■								
	K25 - K40	■								

TURNING GRADES – NAVIGATOR

Grade Identification	Area of Application	Application	Feed	Cutting speed	Resistance to adverse Working Conditions	Coating	Colour	Substrate	Coolant benefit	Grade description
T8315	P05 - P20	■				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.
	M05 - M20	■								
	K05 - K25	■								
	N05 - N25	■								
	S05 - S15	■								
	H05 - H15	■								
T8430 NEW	P20 - P40	■				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.
	M20 - M35	■								
	K25 - K40	■								
	N15 - N30	■								
	S15 - S25	■								
	H15 - H25	■								
T8330	P25 - P40	■				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.
	M20 - M35	■								
	K20 - K40	■								
	N15 - N30	■								
	S15 - S25	■								
	H15 - H25	■								
T8345	P30 - P50	■				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.
	M20 - M40	■								
	K30 - K40	■								
	S20 - S30	■								
T6310	P01 - P15	■				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
	M01 - M15	■								
	K05 - K20	■								
	N05 - N20	■								
	S01 - S15	■								
	H01 - H15	■								
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	■				×		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.
	K10 - K25	■								
	N10 - N25	■								
H07	M05 - M15	■				×		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.
	K10 - K25	■								
	N10 - N30	■								
	S01 - S20	■								
TT310	P10 - P25	■				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.
	M15 - M25	■								

TURNING GRADES – NAVIGATOR

Grade Identification	Area of Application	Application	Feed	Cutting speed	Resistance to adverse Working Conditions	Coating	Colour	Substrate	Coolant benefit	Grade description
TT010	P01 - P10	■				×		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.
	M01 - M10	■				×		cermet	+ / -	
TC100	K01 - K15	■				×		ceramics	- -	Ceramic grade for cast iron machining. Suitable for machining with high cutting speed at stable conditions.
TB310	K01 - K10	■				×		CBN	- -	CBN grade for machining of hardened materials. Suitable for machining with high cutting speed and small feeds at stable conditions.
	S05 - S10	■				×		CBN	- -	
	H01 - H10	■				×		CBN	- -	
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	■				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.
	M35 - M40	■				PVD		HSS	+++	
	K35 - K40	■				PVD		HSS	+++	

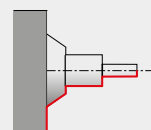
Substrat	
H	WC-Co basert substrat
submicron H	WC-Co-basert substrat, finkornet (< 1 µm)
ultra submicron H	WC-Co-basert substrat, svært finkornet (< 0,5 µm)
FGM	Funksjonelt gradert substrat
Cermet	Sementert karbid uten WC
ceramics	Keramisk skær
PCD	Polykrystallinsk diamant
CBN	Kubisk bornitrid
HSS	High speed steel

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

Belegg	
MT-CVD	Medium-temperatur kjemisk metode for belegging
PVD	Lav-temperatur fysisk metode for belegging
×	Ubelagt grad

ISO DREIING – EKSTERN

LANGE OG USTABILE KOMPONENTER (Positive innsatser)



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

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

SEGC(RL) EXT	
90°	EC..
	08
	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
	12×12 32×25
	127
	118 – 123

SRSC(RL) EXT	
	RC..
	06 08 10 12 16
	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
	12×12 25×25
	140
	134 – 138

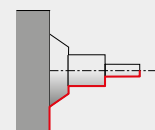
SSKC(RL) EXT	
75°	SC..
	09 12
	12×12 25×25
	141
	134 – 138

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 DREIING – EKSTERN

LANGE OG USTABILE KOMPONENTER (Positive innsatser)



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**

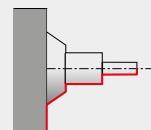
	RC..
	10 12
	C4 C5
	130
	118 – 123

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

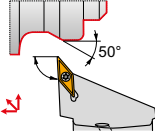
107°30'	VB, VC..
	16
	C4 C6
	177, 201
	168 – 171 186 – 192

ISO DREIING – EKSTERN

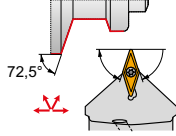
LANGE OG USTABILE KOMPONENTER (Positive innsatser)



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

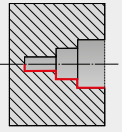
93°		VB, VC..
		
		11 16
	C3 C6	
	178, 202	 168 – 171 186 – 192

C.-SVVBN EXT **NEW**

72°30′		VB, VC..
		
		16
	C4 C6	
	179, 203	 168 – 171 186 – 192

ISO DREIING – INTERNT

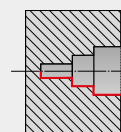
LANGE OG USTABILE KOMPONENTER (Positive innsatser)



SCFC(RL) INT 90° 76	CC.. 06 06 09 12 60 – 69
SCKC(RL) INT 75° 77	CC.. 06 09 12 60 – 69
SCLC(RL) INT 95° 78	CC.. 06 09 12 60 – 69
SCXC(RL) INT 40° 80	CC.. 06 60 – 69
SDQC(RL) INT 107°30' 98	DC.. 07 11 86 – 93
SDUC(RL) INT 93° 99	DC.. 07 11 86 – 93
SDUC(RL)-E INT 93° 100	DC.. 07 11 86 – 93
SDZC(RL) INT 93° 101	DC.. 07 11 86 – 93
SELP(RL) INT 95° 111	EP.. 05 110
SELP(RL)-E INT 95° 112	EP.. 05 110
SEUC(RL) INT 93° 108	EC.. 06 08 104 – 106
SEUP(RL) INT 93° 113	EP.. 05 110
SEXP(RL) INT 52°30' 114	EP.. 05 110
SEXP(RL)-E INT 52°30' 115	EP.. 05 110
SSSC(RL) INT 45° 144	SC.. 09 134 – 138
STFC(RL) INT 90° 158	TC.. 06 09 11 16 149 – 154

ISO DREIING – INTERNT

LANGE OG USTABILE KOMPONENTER (Positive innsatser)



STFC(RL)-E INT	
90°	TC..
	06 09 11
	$\frac{8.5}{20}$
	160
	149 – 154

SVJB(RL) INT	
93°	VB, VC..
	11
	$\frac{25}{32}$
	180, 204
	168 – 171 186 – 192

SVLC(RL) INT	
95°	VC..
	13
	$\frac{27}{43}$
	205
	186 – 192

SVQB(C)(RL) INT	
107°30'	VB, VC..
	11 13 16
	$\frac{20}{50}$
	181, 206
	168 – 171 186 – 192

SVUB(C)(RL) INT	
93°	VB, VC..
	11 13 16
	$\frac{20}{50}$
	182, 207
	168 – 171 186 – 192

SVXC(RL) INT	
113°	VC..
	07
	$\frac{12.5}{17.5}$
	208
	186 – 192

SVXC(RL)-E INT	
113°	VC..
	07
	$\frac{12.5}{17.5}$
	209
	186 – 192

SWLC(RL) INT	
95°	WC..
	06 08
	$\frac{25}{40}$
	216
	212 – 214

SWUC(RL) INT	
93°	WC..
	02
	$\frac{5.8}{7.8}$
	217
	212 – 214

SWUC(RL)-E INT	
93°	WC..
	02
	$\frac{5.8}{7.8}$
	218
	212 – 214

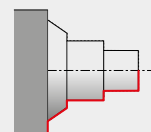
C.-SCLC(RL) INT NEW	
95°	CC..
	09
	$\frac{C3}{C5}$
	81
	60 – 69

C.-SDUC(RL) INT NEW	
93°	DC..
	07 11
	$\frac{20}{32}$
	102
	86 – 93

C.-SVQB(C)(RL) INT NEW	
108°	VB, VC..
	16
	33
	183, 210
	168 – 171 186 – 192

ISO DREIING – EKSTERN

KORTE OG STABILE KOMPONENTER (negative innsatser)



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 32×32
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

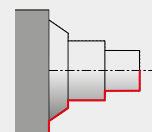
PRSN(RL) EXT	
	RN..
	12 15 19
	25×25 40×40
296	294

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 DREIING – EKSTERN

KORTE OG STABILE KOMPONENTER (negative innsatser)



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

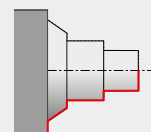
MVJN(RL) EXT	
93°	VN..
	16
20×20 32×25	
362	356 – 376

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 DREIING – EKSTERN

KORTE OG STABILE KOMPONENTER (negative innsatser)



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..

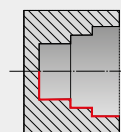
06
08

C4
C6

381 366 – 376

ISO DREIING – INTERNT

KORTE OG STABILE KOMPONENTER (negative innsatser)



DCLN(RL) INT	
95°	CN..
	09 12
	$\frac{32}{50}$
254	222 – 239

PCLN(RL) INT	
95°	CN..
	09 12 16 19
	$\frac{20}{80}$
255	222 – 239

DDUN(RL) INT	
93°	DN..
	11 15
	$\frac{25}{50}$
280	260 – 272

PDUN(RL) INT	
93°	DN..
	11 15
	$\frac{25}{60}$
281	260 – 272

PSKN(RL) INT	
93°	SN..
	11 15
	$\frac{32}{80}$
331	300 – 312

DTFN(RL) INT	
90°	TN..
	16 22
	$\frac{32}{50}$
352	334 – 344

PTFN(RL) INT	
90°	TN..
	16 22
	$\frac{32}{50}$
353	334 – 344

DVUN(RL) INT	
	VN..
	16
	50
364	356 – 376

DWLN(RL) INT	
95°	WN..
	06 08
	$\frac{32}{63}$
382	366 – 376

PWLN(RL) INT	
95°	WN..
	06 08
	$\frac{20}{80}$
383	366 – 376

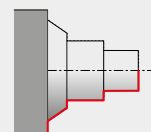
C.-DCLN(RL) INT NEW	
95°	CN..
	09 12 16
	$\frac{25}{50}$
257	222 – 239

C.-DDUN(RL) INT NEW	
93°	DN..
	11
	12
282	260 – 272

C.-DTFN(RL) INT NEW	
91°	TN..
	16
	32
354	334 – 344

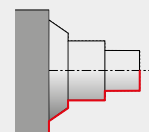
C.-DWLN(RL) INT NEW	
95°	WN..
	06 08
	$\frac{27}{33}$
385	366 – 376

ISO DREIING – TUNG GROVBEARBEIDING – EKSTERNT
FAST VERKTØYHOLDER



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 DREIING – TUNG GROVBEARBEIDING – EKSTERNT
FAST VERKTØYHOLDER



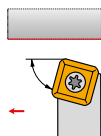
SSBC(RL) EXT

75°

SC..



25
38



40×40
60×60

139

134 – 138

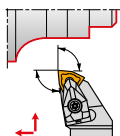
DWLN(RL) EXT

95°

WN..



13

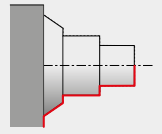


40×40

377

366 – 376

ISO DREIING – TUNG GROVBEARBEIDING – EKSTERNT
HEAD (KH)



KHP-CBNR + DKH(RL)		KHP-CBNL + DKH(RL)		KHP-CLNR/L + DKH(RL)		KHP-LBNR + DKH(RL)	
75°	CN..	75°	CN..	95°	CN..	75°	LN..
25		25		19 25		40	
	40×50 60×80		40×50 60×80		40×50 60×80		40×50 60×80
	251, 253		222 – 239		252, 253		291, 292
					222 – 239		289
KHP-LBNL + DKH(RL)		KHP-RSCR/L + DKH(RL)		KHP-SBNR + DKH(RL)		KHP-SBNL + DKH(RL)	
75°	LN..		RC..	75°	SN..	75°	SN..
40		20 25 32		25		25	
	40×50 60×80		40×50 60×80		40×50 60×80		40×50 60×80
	291, 292		131, 132		328, 330		328, 330
	289		118 – 123		300 – 312		300 – 312
KHP-SSNR/L + DKH(RL)		KHS-SBCR + DKH(RL)		KHS-SBCL + DKH(RL)			
45°	SN..	75°	SC..	75°	SC..		
19 25		25 38		25 38			
	40×50 60×80		40×50 60×80		40×50 60×80		
	329, 330		142, 143		142, 143		
	300 – 312		134 – 138		134 – 138		



ALWAYS CONNECT

No wifi or internet connection? The machining calculator works perfectly even when you are offline, making sure it's always available when you need it. **Simply Reliable.**



DORMER PRAMET

FOLLOW US



SHARE



LIKE



COMMENT



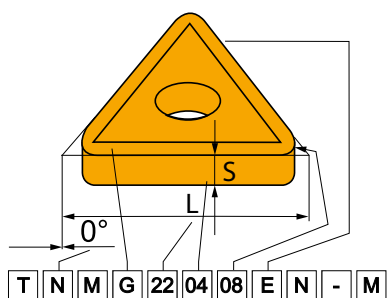
TAG



RE-TWEET



VENDESKJÆR – ISO KODEBETEGNELSE



ISO

ANSI

1

T
T

1

T
T

2

N
N

2

N
N

3

U
M

3

U
M

4

N
G

4

G

1

1

Skjærform

H



O



P



R



S



T



C



D



E



M



V



W



L



A



B



K



2

2

Frivinkel for skjør

A



B



C



D



E



F



G



N



P



O

Spesial

4

4

Skjærtype

N



R



F



A



M



G



W



T



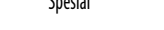
Q



U



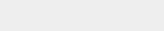
B



H



C



J



X

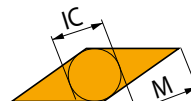
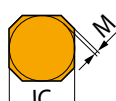
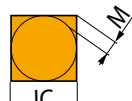
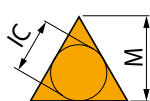
Spesial

3

3

Toleranser

	(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"



VENDESKJÆR – ISO KODEBETEGNELSE

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

5			5											
Skjærlengde (skjærsstørrelse)														
d = IC		H	O	P	S	T	C	D	E	M	V	W	R	K
(mm)	(in)													
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		
Skjærtykkelse		
		
		
	S	
	(mm)	(")
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		
Skjær neseradius		
	RE	
	(mm)	(")
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 skjær		
d = I.C.		
(")	00	
(mm)	M0	



ANSI

5

Innskrevet sirkel






6

Skjærtykkelse






7

Innsats neseradius



Symbol	d = I.C.	
	(mm)	(")
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"

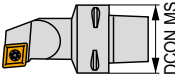
Symbol	S	
	(mm)	(")
1	1.588	1/16"
1.2	1.984	5/64"
1.5	2.381	3/32"
2	3.175	1/8"
2.5	3.969	5/32"
3	4.763	3/16"
3.5	5.556	7/32"
4	6.350	1/4"
5	7.938	5/16"
6	9.525	3/8"
7	11.113	7/16"
8	12.700	1/2"
9	14.288	9/16"
10	15.875	5/8"

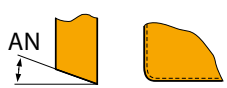
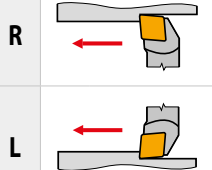
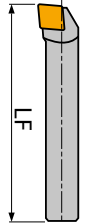
Symbol	RE	
	(mm)	(")
0	0	0"
0.2	0.099	1/256"
0.5	0.198	1/128"
1	0.397	1/64"
2	0.794	1/32"
3	1.191	3/64"
4	1.588	1/16"
5	1.984	5/64"
6	2.381	3/32"
7	2.778	7/64"
8	3.175	1/8"
10	3.969	5/32"
12	4.763	3/16"
14	5.556	7/32"
16	6.350	1/4"

8	8
Skjæreggdesign	
 Skarpe egger	 Rundede egger
 Egger med fasett	 Rundede egger med fasett
 Egger med fasett	 Rundede egger med dobbel fasett
9	9
Materetning	
 Mating	 Mating
 Mating	 Mating
10	10
Sponbryter betegnelse	

EXTERNAL TURNING TOOLS – ISO CODE DESIGNATION

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

1		1		2		2		3		3		4		4		
Coupling size				Infestningsmetode				Skjærform				Holdertype – kutteeggvinkel				
	C					H	O	P	R			A	B	C	D	D
	D											E	F	G	H	J
	P					S	T	C	D			K	L	M	N	P
	M											Q	R	S	S	T
	S					E	M	V	W			U	V	W	X	Y
C	DCON MS															
C3	32															
C4	40															
C5	50															
C6	63															
C8	80															
		G										Z				

5		5		6		6		7 & 8			11		11																																	
Frivinkel skjær				Skjæreretning				Skafthbredde og skafthøyde (")					Holder total lengde																																	
								<table><thead><tr><th>Symbol</th><th>B (")</th><th>H (")</th></tr></thead><tbody><tr><td>05</td><td>5/16"</td><td>5/16"</td></tr><tr><td>06</td><td>3/8"</td><td>3/8"</td></tr><tr><td>08</td><td>1/2"</td><td>1/2"</td></tr><tr><td>10</td><td>5/8"</td><td>5/8"</td></tr><tr><td>12</td><td>3/4"</td><td>3/4"</td></tr><tr><td>16</td><td>1"</td><td>1"</td></tr><tr><td>85</td><td>1"</td><td>1 1/4"</td></tr><tr><td>86</td><td>1"</td><td>1 1/2"</td></tr><tr><td>20</td><td>1 1/4"</td><td>1 1/4"</td></tr></tbody></table>					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"				
Symbol	B (")	H (")																																												
05	5/16"	5/16"																																												
06	3/8"	3/8"																																												
08	1/2"	1/2"																																												
10	5/8"	5/8"																																												
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85	1"	1 1/4"																																												
86	1"	1 1/2"																																												
20	1 1/4"	1 1/4"																																												
N	B	C	P										<table><thead><tr><th>D</th><th>E</th><th>F</th><th>H</th><th>J</th><th>K</th><th>L</th></tr></thead><tbody><tr><td>60</td></tr><tr><td>70</td></tr><tr><td>80</td></tr><tr><td>100</td></tr><tr><td>110</td></tr><tr><td>125</td></tr><tr><td>140</td></tr></tbody></table>				D	E	F	H	J	K	L	60	70	80	100	110	125	140																
D	E	F	H	J	K	L																																								
60																																														
70																																														
80																																														
100																																														
110																																														
125																																														
140																																														
0°	5°	7°	11°																																											

7					
Skafthøyde (mm)					
08	10	12	16	20	25
32	38	40	45	50	60

8					
Skafthbredde (mm)					
08	10	12	16	20	25
32	38	40	45	50	60

7 & 8		
Skaftbredde og skafthøjde (")		
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 kvadratiske skaft, er dette antall 16-deler av en tomme i bredde og høyde. For rektangulære skaft, er det første sifferet antall 8-deler av en tomme i bredde, og det andre sifferet er antallet 4-deler av en tomme i høyde.

9	10
Functional width (mm)  The diagram shows a side view of a mechanical component with a flange. A vertical dimension line on the left indicates the functional width (WF) across the flange face.	Functional length (mm)  The diagram shows a side view of the same mechanical component. A horizontal dimension line at the bottom indicates the functional length (LF) from the front face of the flange to the end of the shaft.

11

11

Holder totallengde

</

INTERNAL TURNING TOOLS – ISO CODE DESIGNATION

ISO	15	16	17		2	3	4	5	6	12		14
	A	25	T	-	P	C	L	N	L	12	-	X
ANSI	15	16	17		2	3	4	5	6	12		
	A	16	T	-	D	C	L	N	L	4		

12							12							
Skjærkantlengde (skjærstørrelse)														
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												

13	
Produsentens betegnelse	
M	Klemmesystem «S» med shim

14	
Produsentens betegnelse	
X	Spesial skafstil
.	
.	
93	Z – type verktøynnstillingsvinkel
.	
.	

15	15
Skaft	
S	Stålskaft
A	Stålskaft med kjøling
E	Wolframkarbidskaft med kjøling

16		16	
Shank Ø (mm)			
DICON MS (mm)		DICON 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"

Holder totallengde		LF (mm)	
	LF	D	60
		E	70
		F	80
		H	100
		J	110
	LF (")	K	125
F	3.250"	L	140
H	4.000"	M	150
K	5.000"	N	160
M	6.000"	P	170
P	6.250"	Q	180
Q	7.250"	R	200
R	8.000"	S	250
S	10.000"	T	300
T	12.000"	U	350
U	14.000"	V	400
V	15.750"	W	450
W	17.750"	X	Spec.
Y	20.000"	Y	500
X	Spec.		

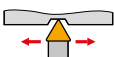
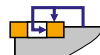
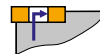
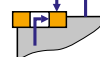
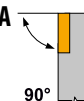
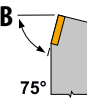
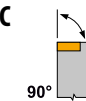
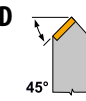
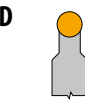
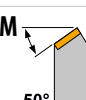
HEADS – ISO CODE DESIGNATION

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		2		3		4					
Patron		Infestningsmetode		Skjærform		Holderstil – kutteeggvinkel					
5											
Klaringsvinkel											
											
N 0°	C 7°	P 11°									
6											
Skjæretretning											
R											
L											
N											
C											
D											
P											
M											
S											
X											
G											
S		C									
T		D									
R		K									
W		V									
L		X		Special							
A		B			C			D			
E		F			G			H			
K		L			M			N			
Q		R			S			S			
U		V			W			X		Special	
Z											

7	Skjærkantlengde (innsatsstørrelse)												
d = I.C.	H	O	P	S	T	C	D	E	M	V	W	R	K
(mm)													
3.97				03	06		04			06	02		
4.76				04	08	1.2	05	04	04	08	L3		
5.56				05	09	1.5	06	05	05	09	03		
6.35	03	02	04	08	11	1.8	07	08	08	11	04	06	
7.94	04	03	05	07	13	2	08	09	06	07	13	05	07
9.525	05	04	07	09	16	2.5	09	11	09	16	06	09	16
12.7	07	05	09	12	22	3	12	15	13	12	22	08	12
15.875	09	06	11	15	27	4	16	19	16	15	27	10	15
19.05	11	07	13	19	33	5	19	23	19	19	33	13	19
25.40	14	10	18	25	44	6	25	31	26	25	44	17	25
31.75	18	13	23	31	54	8	32	38	32	31	54	21	31
1 1/4"						10							

8	Kasettholder					

9	Skaft høyde (mm)					

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

10	Skaft bredde (mm)					

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

11	Holder lengde	

		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)

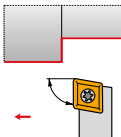
Insert	Tool Holder
CCMT 120404E-UR	S32U-SCKCR 12-A

ISO DREIING – EKSTERN

SCAC(RL) EXT

90°

CC..



06
09

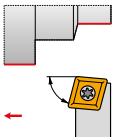
08×08
16×16

70

SCBC(RL) EXT

75°

CC..



09
12

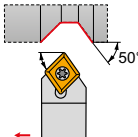
12×12
25×25

71

SCDCR EXT

45°

CC..



06

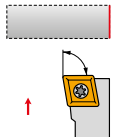
10×10

72

SCFC(RL) EXT

90°

CC..



06
09

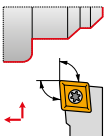
08×08
16×16

73

SCLC(RL) EXT

95°

CC..



06
08
09
12

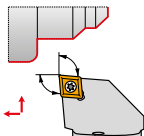
08×08
25×25

74

C.-SCLC(RL) EXT NEW

95°

CC..



09
12

C3
C5

75

CC

06 / 08 / 09 / 12

ISO DREIING – INTERNT

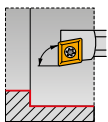
SCFC(RL) INT

90°

CC..



06


 $\frac{13}{16}$


76

60 – 69

SCKC(RL) INT

75°

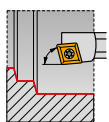
CC..



06

09

12


 $\frac{11}{40}$


77

60 – 69

SCLC(RL) INT

95°

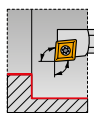
CC..



06

09

12


 $\frac{11}{40}$


78

60 – 69

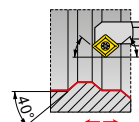
SCXC(RL) INT

40°

CC..



06


 $\frac{13}{20}$


80

60 – 69

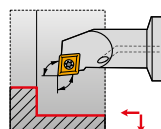
C.-SCLC(RL) INT **NEW**

95°

CC..



09


 $\frac{20}{32}$


81

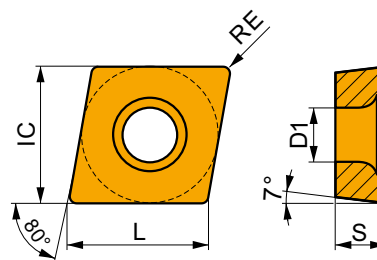
60 – 69

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
----	----	----	----	----	----	----	----	----	----	----	----	----

CCGT

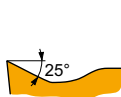
PRAMET

	IC	D1	L	S
	(mm)	(mm)	(mm)	(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



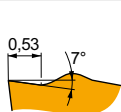
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

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)



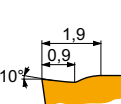
AL-geometri med meget positiv design for fin til grov bearbejding, kontinuerlige til lett avbrutte kutt.

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 positiv design for fin til ferdig bearbejding, kontinuerlige til lett avbrutte kutt.

CCGT 09T302E-FF2	T7325	0.2	235	0.05	1.0	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	T9325	0.2	345	0.05	1.0	—	—	—	325	0.05	1.0	—	—	—	—	—	—	—	—



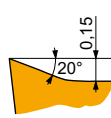
NF1-geometri med positiv design for finbearbejding til middels bearbejding og kontinuerlige kutt.

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
	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
	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
	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
	T7325	0.8	215	0.14	1.2	165	0.13	1.2	—	—	—	—	—	—	65	0.13	1.0	—	—

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
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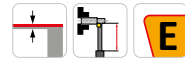
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	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)



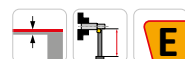
SF3-geometri med meget positiv design for finbearbeiding og kontinuerlige kutt.

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 positiv høyrehendt design for finbearbeiding og kontinuerlige kutt.

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 positiv venstrehendt design for finbearbeiding og kontinuerlige kutt.

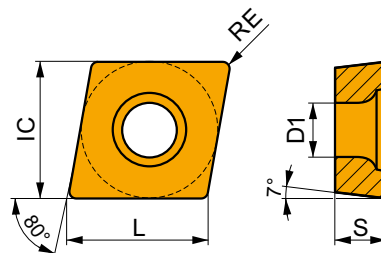
CCGT 060202EL-SI	T8330	0.2	215	0.10	0.8	125	0.09	0.8	200	0.10	0.8	—	—	—	50	0.08	0.6	—	—	—
	T8430	0.2	260	0.10	0.8	140	0.09	0.8	215	0.10	0.8	—	—	—	55	0.08	0.6	—	—	—
CCGT 060204EL-SI	T8315	0.4	225	0.12	0.8	135	0.11	0.8	210	0.12	0.8	—	—	—	55	0.10	0.6	—	—	—
	T8330	0.4	215	0.12	0.8	125	0.11	0.8	200	0.12	0.8	—	—	—	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	—	—	—

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
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CCMT

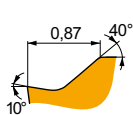


	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
0602	6.350	2.80	6.40	2.38
0803	7.940	3.40	8.10	3.18
09T3	9.525	4.40	9.70	3.97
1204	12.700	5.50	12.90	4.76



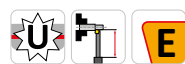
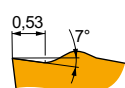
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

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)



FF-geometri med positiv design for fin til ferdig bearbeiding, og kontinuerlige til lett avbrutte kutt.

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	—	—	—	—	—	—	—	—	—	—	—	—	—	—



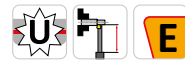
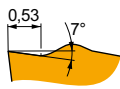
FF2-geometri med positiv design for fin til ferdig bearbeiding, og kontinuerlige til lett avbrutte kutt.

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	—	—	—	—	—	—	—	—
CCMT 060204E-FF2	TT010	0.2	345	0.05	0.5	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	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	—	—	—	—	—	—	—	—
CCMT 080302E-FF2	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	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	T7325	0.2	240	0.05	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	T8330	0.2	205	0.05	0.8	—	—	—	190	0.05	0.8	—	—	—	—	—	—	—	—
CCMT 080304E-FF2	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	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	T7325	0.4	190	0.12	1.0	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	T8330	0.4	165	0.12	1.0	—	—	—	155	0.12	1.0	—	—	—	—	—	—	—	—
CCMT 080304E-FF2	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	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	TT010	0.4	350	0.06	0.5	—	—	—	—	—	—	—	—	—	—	—	—	—	—

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
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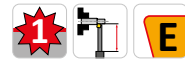
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

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)



FF2-geometri med positiv design for fin til ferdig bearbeiding, og kontinuerlige til lett avbrutte kutt.

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	█	—	—	—	█	—	—	—	—	—	—	—	—	—



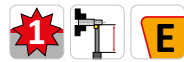
FM-geometri for fin til halv-grov bearbeiding, og kontinuerlige til lett avbrutte kutt.

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	█	—	—	—	—	—
	TT010	0.8	█	350	0.10	0.8	█	—	—	—	█	—	—	—	█	—	—	—	—	—
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	█	—	—	—	—	—
	TT010	0.2	█	350	0.10	0.8	█	—	—	—	█	—	—	—	█	—	—	—	—	—
	TT010	0.2	█	350	0.10	0.8	█	—	—	—	█	—	—	—	█	—	—	—	—	—
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	█	—	—	—	—	—

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
----	----	----	----	----	----	----	----	----	----	----	----	----

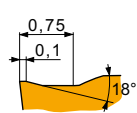
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(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)



FM-geometri for fin til halv-grov bearbeiding, og kontinuerlige til lett avbrutte kutt.

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	—	—	—	—	—	—	—	—	—
	T9335	0.8	200	0.20	1.2	155	0.18	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	—	—	—	—	—	—	—	—	—
	T9335	0.4	200	0.15	1.7	140	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	—	—	—	—	—	—	—	—	—
	T9335	0.8	200	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	—	—	—	—	—	—	—	—	—



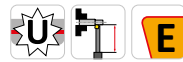
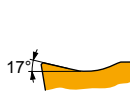
FM2 geometri for fin til middels bearbeiding, og kontinuerlig til avbrutt kutt.

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	—	—	—	—	—	—	—	—	—	—	—	—

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
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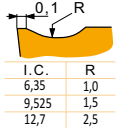
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

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



NF2-geometri med positiv design for finbehandling til middels bearbeiding og kontinuerlige kutt.

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	—	—	—
CCMT 060204E-NF2	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	—	—	—
CCMT 080304E-NF2	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	—	—	—



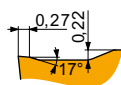
RF-geometri for halv-grov til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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	🟢	—	—	—	🔴	—	—	—

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
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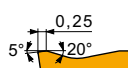
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

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



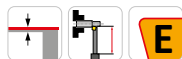
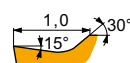
RM-geometri for halv-grov til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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 for halv-grov til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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



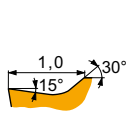
UR-geometri for finbearbeiding og kontinuerlige til lett avbrutte kutt.

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	—	—	—	—	—	—	—	—	—	—	—	—

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
----	----	----	----	----	----	----	----	----	----	----	----	----

Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(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)



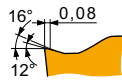
UR-geometri for finbearbeiding og kontinuerlige til lett avbrutte kutt.

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	—	—	—	—	—	—	—	—	—	—	—	—
	T5315	0.8	270	0.20	1.0	—	—	—	255	0.20	1.0	—	—	—	—	—	—	—	—	—
CCMT 060208E-UR	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	—	—	—	—	—	—	—	—	—
CCMT 120412E-UR	T9325	0.8	215	0.20	1.7	125	0.18	1.7	200	0.20	1.7	—	—	—	—	—	—	—	—	—
	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	—	—	—	—	—	—	—	—	—

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
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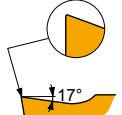
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product	RE (mm)	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-Wipergeometri for finbearbeiding med økt tmating og forbedret overflate.

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	—	—	—	—	—	—	—	—
CCMT 09T308W-FM	T9325	0.4	190	0.30	0.8	110	0.27	0.8	180	0.30	0.8	—	—	—	—	—	—	—	—
	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	—	—	—	—	—	—	—	—



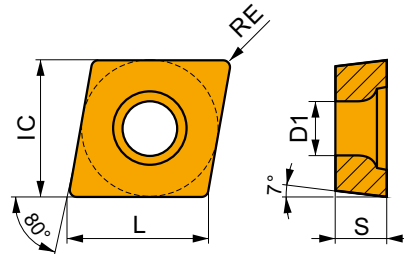
W-UR wipergeometri for finbearbeiding med økt mating og forbedret overflate.

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

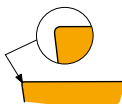
PRAMET

	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



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product	RE (mm)	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)

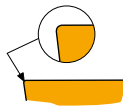


For fin til halv-grov bearbeiding og kontinuerlige til lett avbrutte kutt.

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

Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(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)



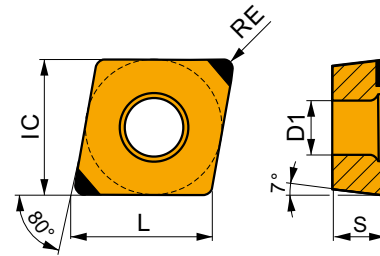
For fin til halv-grov bearbeiding og kontinuerlige til lett avbrutte kutt.

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

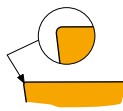
PRAMET

	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



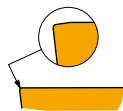
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(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)



For ferdig bearbeiding.

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



For ferdig bearbeiding.

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

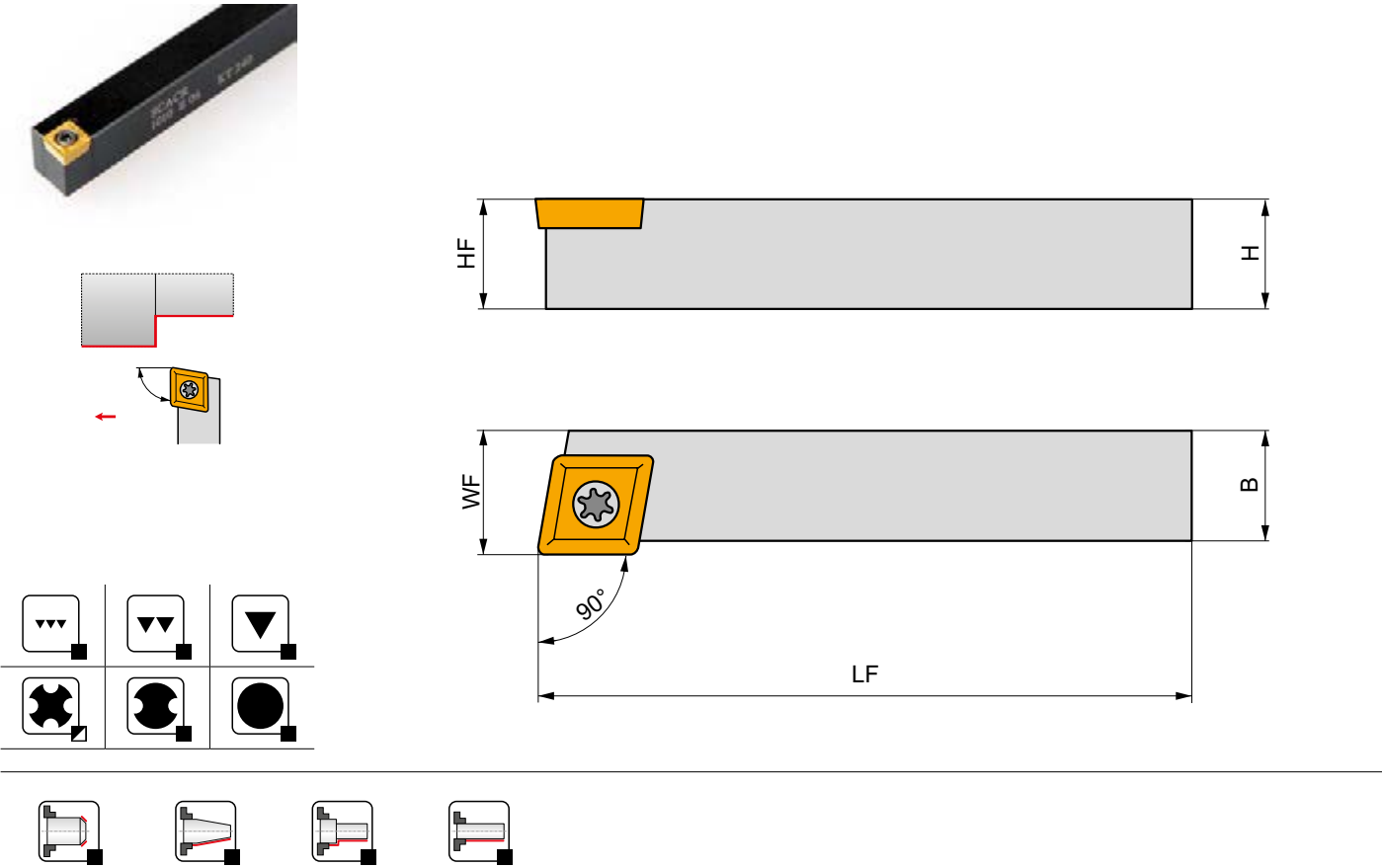
N

S

H

PRAMET

S



		H	B	HF	WF	LF	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	SCACR 0808 D 06	8	8	8	8.5	60	0	0	0.04	GI045	S07
	SCACR 1010 E 06	10	10	10	10.5	70	0	0	0.09	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..

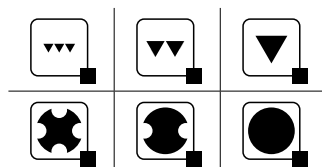
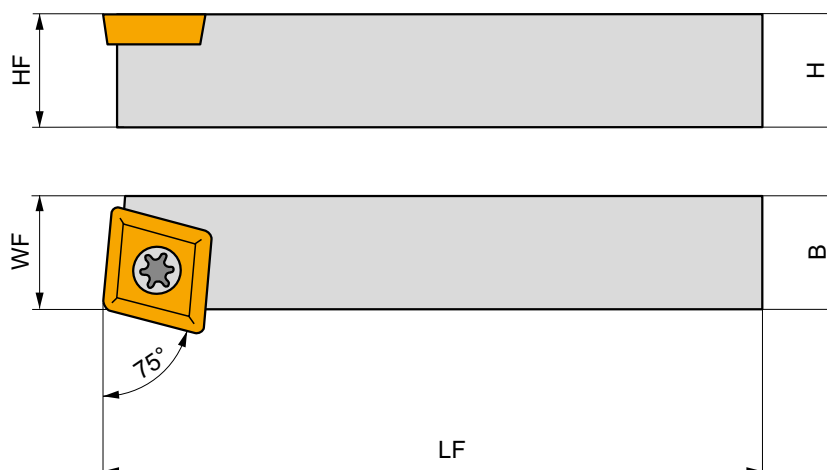
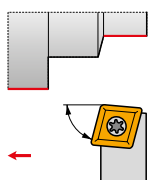
					
S04	US 3510-T15P	3.0	M 3.5	10.6	FLAG T15P
S07	US 2506-T07P	0.9	M 2.5	6.3	FLAG T07P

SCBC(RL) EXT

P M K N S H

PRAMET

S



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

GI011											
GI041											

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

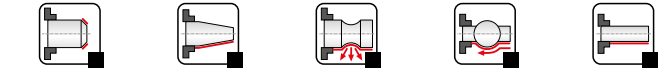
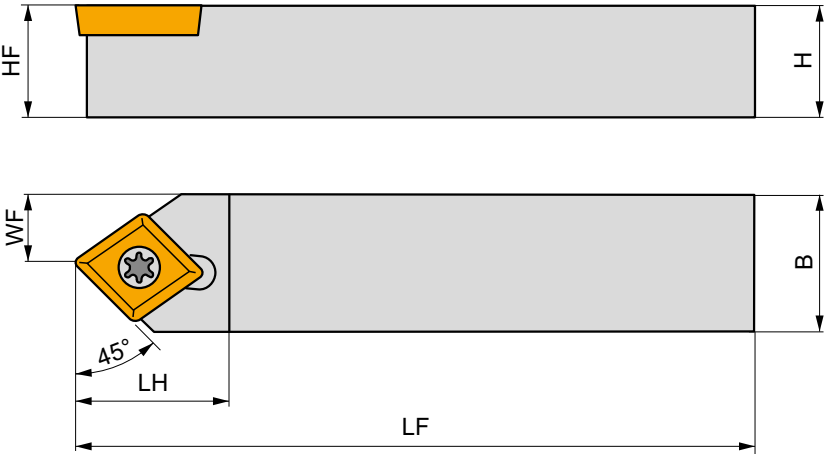
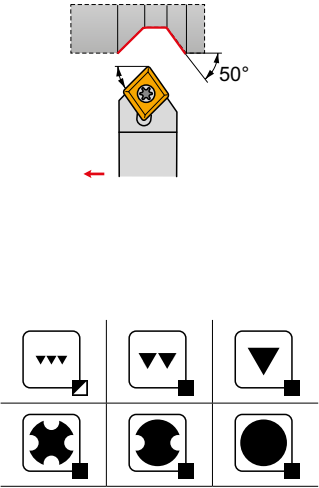
N

S

H

PRAMET

S



		H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
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

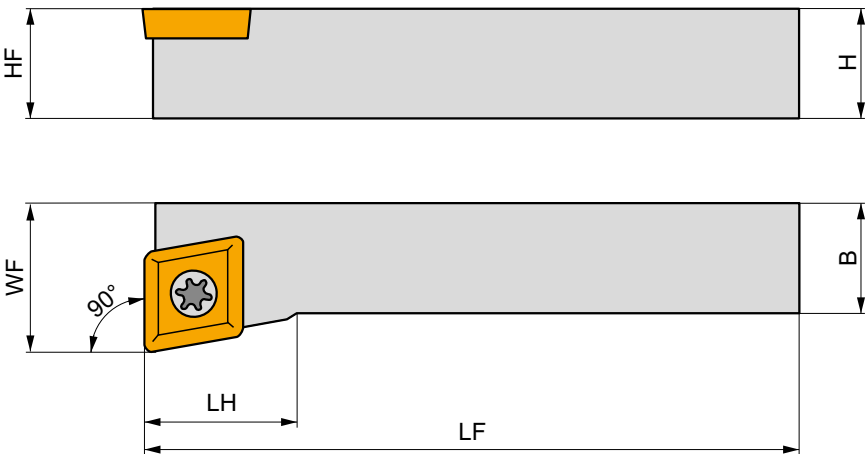
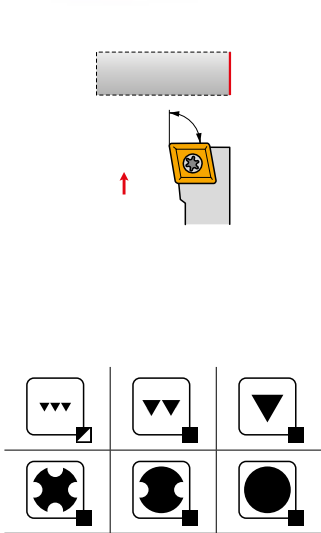
N

S

H

PRAMET

S

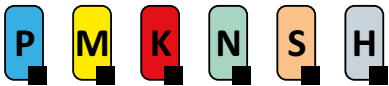


		H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	SCFCR 0808 D 06	8	8	8	10	60	8	0	0	0.04	GI045	S07
	SCFCR 1010 E 06	10	10	10	12	70	8	0	0	0.07	GI045	S07
	SCFCR 1212 F 09	12	12	12	16	80	16	0	0	0.12	GI041	S04
	SCFCR 1616 H 09	16	16	16	20	100	16	0	0	0.22	GI041	S04
L	SCFCL 0808 D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

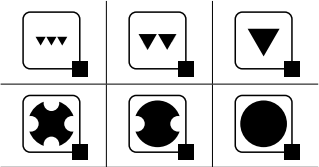
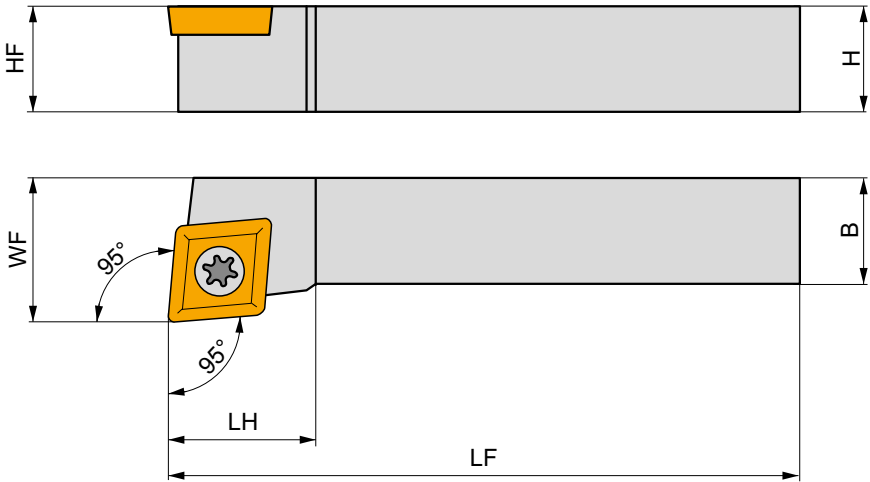
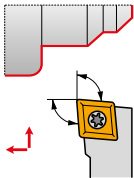
S04	US 3510-T15P	3.0	M 3.5	10.6	FLAG T15P
S07	US 2506-T07P	0.9	M 2.5	6.3	FLAG T07P

SCLC(RL) EXT



PRAMET

S



		H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	SCLCR 0808 D 06	8	8	8	10	60	8	0	0	0.06	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
L	SCLCR 2525 M 12-M-A	20	25	20	32	150	20	0	0	0.68	GI011	SC20
	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..

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	—

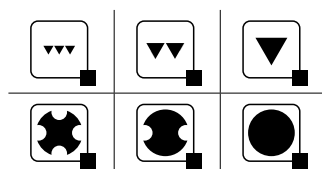
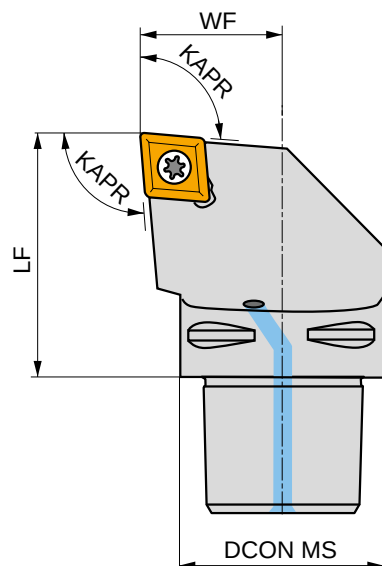
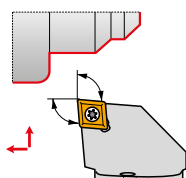
NEW

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

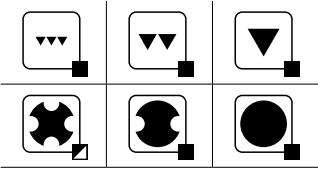
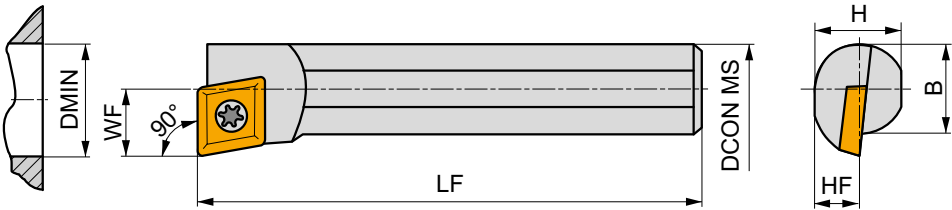
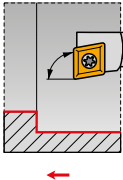
N

S

H

PRAMET

S



		DCON MS	DMIN	WF	H	B	LF	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
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..											

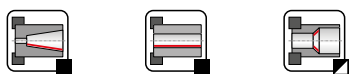
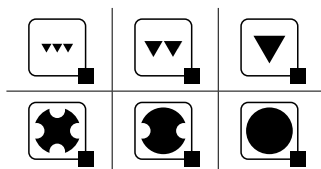
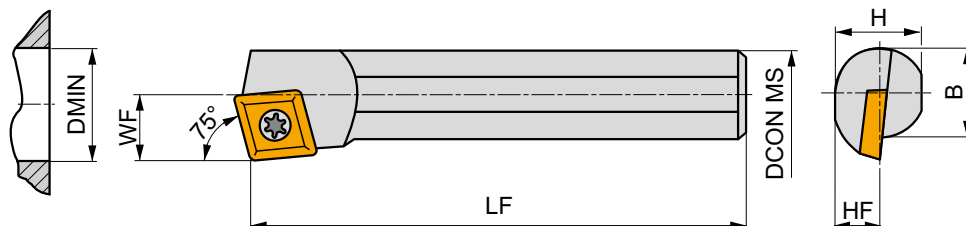
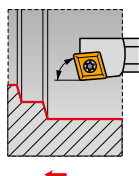
S06	US 2505-T07P	0.9	M 2.5	5.2	FLAG T07P	

SCKC(RL) INT



PRAMET

S



		DCON MS	DMIN	WF	H	B	LF	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
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..



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

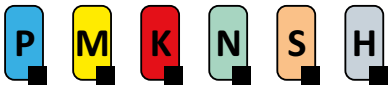
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FLAG T15P

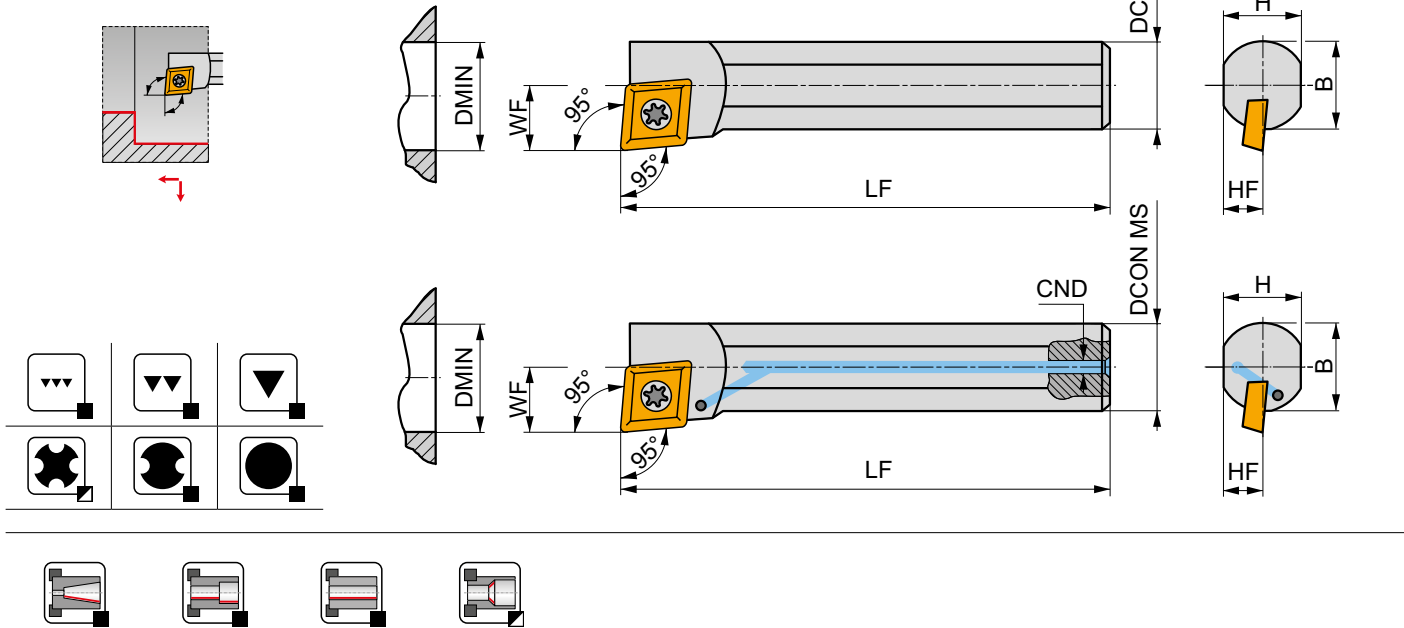
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SCLC(RL) INT



PRAMET

S



		DCON MS	DMIN	WF	H	B	LF	CND	LAMS	GAMO				
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)				
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	D MIN	WF	H	B	LF	CND	LAMS	GAMO				
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)				
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..

								
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

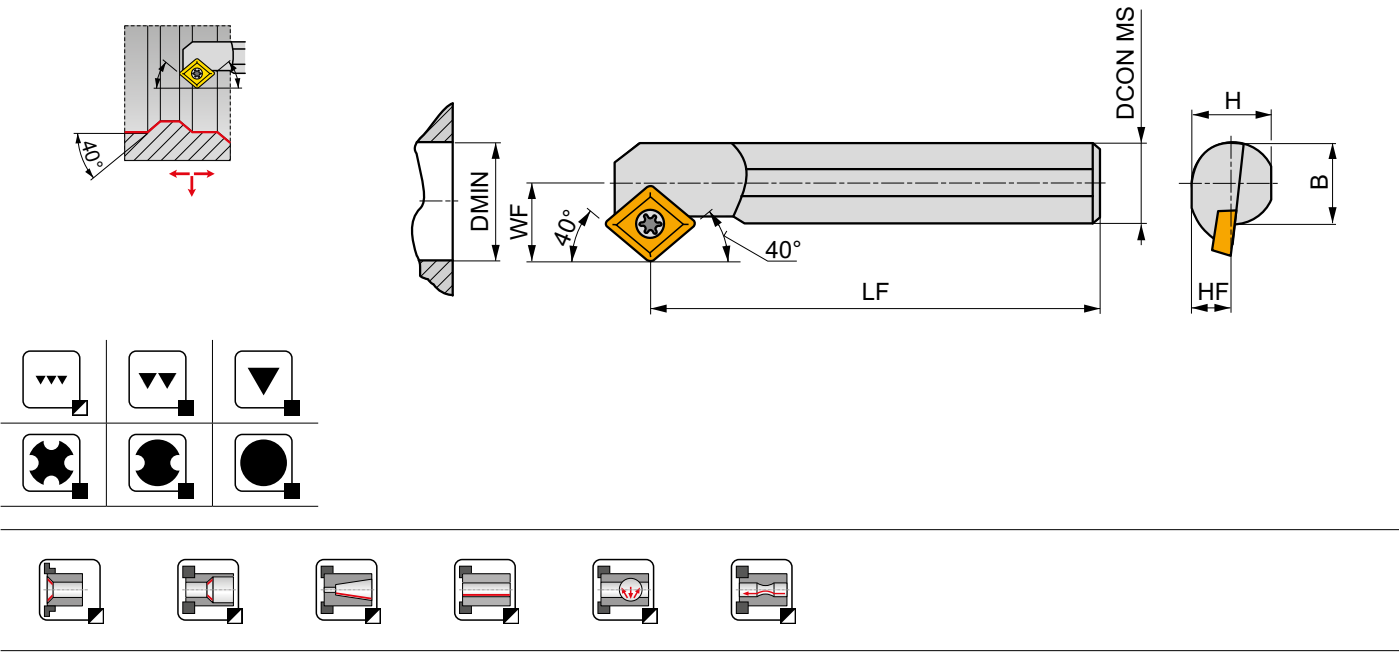
N

S

H

PRAMET

S

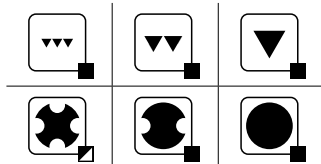
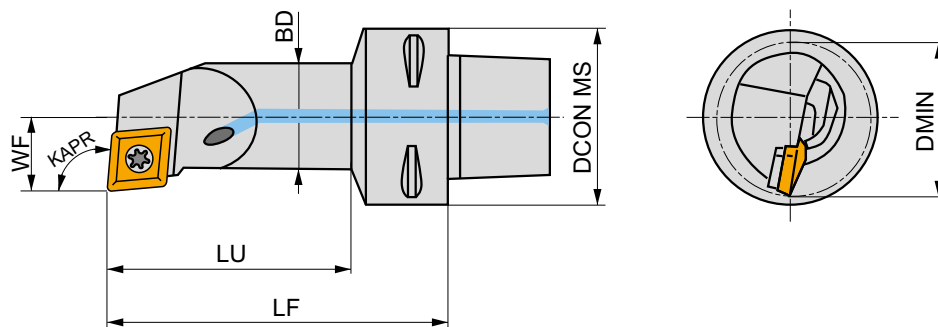
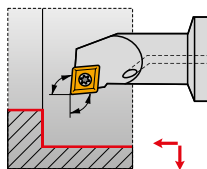


		DCON MS	DMIN	WF	H	B	LF	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	S10H-SCXCR 06	10	13	7	9	9.5	100	-10	0	0.06	GI045	S06
	S12K-SCXCR 06	12	16	9	11	11.5	125	-8	0	0.11	GI045	S06
	S16Q-SCXCR 06	16	20	11	14.5	15	180	-7	0	0.31	GI045	S07
L	S10H-SCXCL 06	10	13	7	9	9.5	100	-10	0	0.06	GI045	S06
	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..

S06	US 2505-T07P	0.9	M 2.5	5.2	FLAGT07P
S07	US 2506-T07P	0.9	M 2.5	6.3	FLAGT07P

NEW**C.-SCLC(RL) INT****PRAMET****S**

		DCON MS	DMIN	WF	LF	LU	BD	KAPR	LAMS	GAMO				
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)	(°)		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
L	C5-SCLCR-13080-09	50	25	13	80	56	20	95	-5.8	0	✓	0.60	GI041	SC09M
	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..



SC09M



US 2009-T15P



3.0



M 3.5



8.1



FLAG T15P/3,5

CP

05

CARBIDE INSERTS

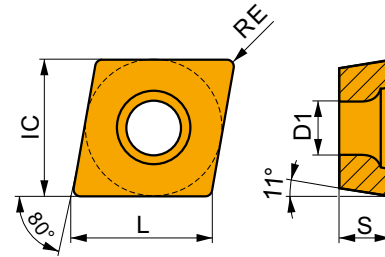
CPGX



 83

CPGX

	IC	D1	L	S
	(mm)	(mm)	(mm)	(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



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere 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)
 FR-JQ positiv geometri med høyrehendt design for finbearbeiding og kontinuerlige kutt.	TT010	0.4	350	0.06	0.5	210	0.05	0.5	—	—	—	—	—	—	—	—	—	—	—
	CPGX 080304FR-JQ	TT010	0.4	350	0.06	0.5	210	0.05	0.5	—	—	—	—	—	—	—	—	—	—
 FL-JQ positiv geometri med venstrehendt design for finbearbeiding og kontinuerlige kutt.	TT010	0.4	350	0.06	0.5	210	0.05	0.5	—	—	—	—	—	—	—	—	—	—	—
	CPGX 080304FL-JQ	TT010	0.4	350	0.06	0.5	210	0.05	0.5	—	—	—	—	—	—	—	—	—	—
 FR-JR positiv geometri med høyrehendt design for finbearbeiding og kontinuerlige kutt.	TT010	0.4	350	0.06	0.5	210	0.05	0.5	—	—	—	—	—	—	—	—	—	—	—
	CPGX 060204FR-JR	TT010	0.4	350	0.06	0.5	210	0.05	0.5	—	—	—	—	—	—	—	—	—	—
 FL-JR positiv geometri med venstrehendt design for finbearbeiding og kontinuerlige kutt.	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 høyrehendt design for finbearbeiding og kontinuerlige kutt.	TT010	0.2	330	0.06	0.5	195	0.05	0.5	—	—	—	—	—	—	—	—	—	—	—
	CPGX 060202FR-JZ	TT010	0.2	330	0.06	0.5	195	0.05	0.5	—	—	—	—	—	—	—	—	—	—
 FL-JZ positiv geometri med venstrehendt design for finbearbeiding og kontinuerlige kutt.	TT010	0.2	330	0.06	0.5	195	0.05	0.5	—	—	—	—	—	—	—	—	—	—	—
	CPGX 060202FL-JZ	TT010	0.2	330	0.06	0.5	195	0.05	0.5	—	—	—	—	—	—	—	—	—	—

DC

07 / 11 / 15

CARBIDE INSERTS

DCGT	DCMT	DCMW
		
 86	 87	 92

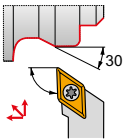
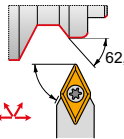
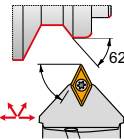
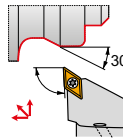
CBN & PCD INSERTS

DCGW CBN	DCMW PCD
	
 92	 93

MATCH THE RIGHT SIZE (example)

Insert	Tool Holder
DCMT 070204E-UR	SDJCR 0808 D 07

ISO DREIING – EKSTERN

SDJC(RL) EXT	SDNCN EXT	C.-SDNCN EXT NEW	C.-SDJC(RL) EXT NEW
93°  DC..  07 11 15  08×08 25×25  94	62°30′  DC..  7 11  08×08 25×25  95	62°30′  DC..  11  C4 C5  97	93°  DC..  11  C3 C5  96
86 – 93	86 – 93	86 – 93	86 – 93

DC

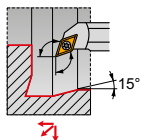
07 / 11 / 15

ISO DREIING – INTERN

SDQC(RL) INT

107°30'

DC..

07
1113
40

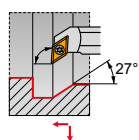
98

86 – 93

SDUC(RL) INT

93°

DC..

07
1113
40

99

86 – 93

SDUC(RL)-E INT

93°

DC..

07
1113
40

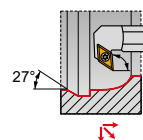
100

86 – 93

SDZC(RL) INT

93°

DC..

07
1127
65

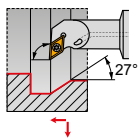
101

86 – 93

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

93°

DC..

07
1120
32

102

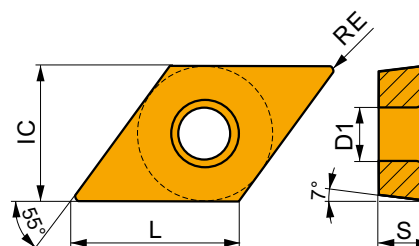
86 – 93

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
----	----	----	----	----	----	----	----	----	----	----	----	----

DCGT

PRAMET

	IC	D1	L	S
	(mm)	(mm)	(mm)	(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



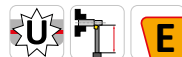
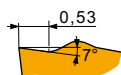
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

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)



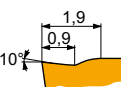
AL-geometri med svært positiv design for fin til grov bearbeiding, og kontinuerlige til lett avbrutte kutt.

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	—	—	—	—	—	—



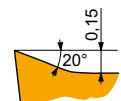
FF2-geometri med positiv design for fin til ferdig bearbeiding, og kontinuerlige til lett avbrutte kutt.

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	—	—	—	—	—	—	—	—	—	—	—	—	—	—



NF1-geometri med positiv design for finbearbeiding til middels bearbeiding og kontinuerlige kutt.

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	—	—	—



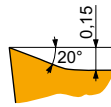
SF3-geometri med meget positiv design for finbearbeiding og kontinuerlige kutt.

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

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
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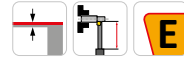
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(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)



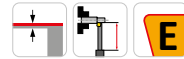
SF3-geometri med meget positiv design for finbearbeiding og kontinuerlige kutt.

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
DCGT 11T308E-SF3	T8315	0.4	155	0.10	0.8	90	0.09	0.8	145	0.10	0.8	465	0.12	0.8	35	0.07	0.6	30	0.15	1.0
	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 positiv høyrehendt design for finbearbeiding og kontinuerlige kutt.

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	—	—	—



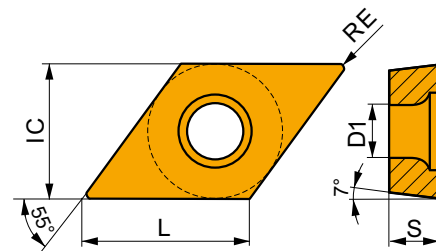
EL-SI geometri med positiv venstrehendt design for finbearbeiding og kontinuerlige kutt.

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	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	—	—	—

DCMT

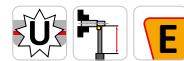
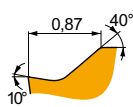


	IC (mm)	D1 (mm)	L (mm)	S (mm)
0702	6.350	2.80	7.80	2.38
11T3	9.525	4.40	11.60	3.97
1504	12.700	5.50	15.50	4.76



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(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)



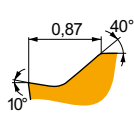
FF-geometri med positiv design for fin til ferdig bearbeiding, og kontinuerlige til lett avbrutte kutt.

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	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
----	----	----	----	----	----	----	----	----	----	----	----	----

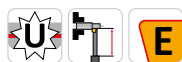
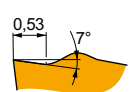
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(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)



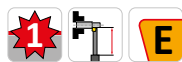
FF-geometri med positiv design for fin til ferdig bearbeiding, og kontinuerlige til lett avbrutte kutt.

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 positiv design for fin til ferdig bearbeiding, og kontinuerlige til lett avbrutte kutt.

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	—	—	—	—	—	—	—	—	—
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	—	—	—	—	—	—	—	—	—



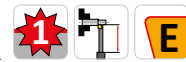
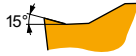
FM-geometri for fin til halv-grov bearbeiding, og kontinuerlige til lett avbrutte kutt.

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	—	—	—	—	—	—	—	—	—

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
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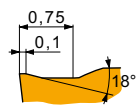
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	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 for fin til halv-grov bearbeiding, og kontinuerlige til lett avbrutte kutt.

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	—	—	—	—	—	—	—	—	—
DCMT 11T302E-FM	T9325	0.4	190	0.18	0.8	110	0.16	0.8	180	0.18	0.8	—	—	—	—	—	—	—	—	—
	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	—	—	—	—	—	—	—	—	—
DCMT 11T304E-FM	T9325	0.2	230	0.10	0.8	135	0.09	0.8	215	0.10	0.8	—	—	—	—	—	—	—	—	—
	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	—	—	—	—	—	—	—	—	—
DCMT 11T308E-FM	T9325	0.4	190	0.18	0.8	110	0.16	0.8	180	0.18	0.8	—	—	—	—	—	—	—	—	—
	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	—	—	—	—	—	—	—	—	—
DCMT 11T312E-FM	T9325	0.8	235	0.17	0.8	140	0.15	0.8	220	0.17	0.8	—	—	—	—	—	—	—	—	—
	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	—	—	—	—	—	—	—	—	—



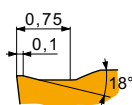
FM2 geometri for fin til middels bearbeiding, og kontinuerlig til avbrutt kutt.

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	—	—	—	—	—	—	—	—	—
DCMT 11T304E-FM2	T9325	0.4	205	0.12	0.8	120	0.11	0.8	190	0.12	0.8	—	—	—	—	—	—	—	—	—
	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	—	—	—	—	—	—	—	—	—	—	—	—

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
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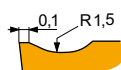
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

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



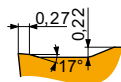
FM2 geometri for fin til middels bearbeiding, og kontinuerlig til avbrutt kutt.

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 for halv-grov til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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	—	—	—	—	—	—	—	—	—



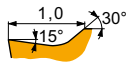
RM-geometri for halv-grov til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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	—	—	—	—	—	—

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
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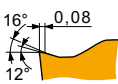
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(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)



UR-geometri for finbearbeiding og kontinuerlige til lett avbrutte kutt.

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	–	–	–	–	–	–
DCMT 11T302E-UR	TT310	0.4	■	210	0.12	0.8	✓	125	0.11	0.8	–	–	–	–	–	–	–	–	–	–
	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	–	–	–	–	–	–
DCMT 11T304E-UR	TT310	0.2	■	210	0.10	0.8	✓	125	0.09	0.8	–	–	–	–	–	–	–	–	–	–
	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	–	–	–	–	–	–
DCMT 11T308E-UR	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	–	–	–	–	–	–	–	–	–	–
	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	–	–	–	–	–	–	–	–	–	–
DCMT 11T312E-UR	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	–	–	–	–	–	–
DCMT 11T312E-UR	TT310	0.8	■	225	0.17	0.8	✓	135	0.15	0.8	–	–	–	–	–	–	–	–	–	–
	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-Wipergeometri for finbearbeiding med økt tmating og forbedret overflate.

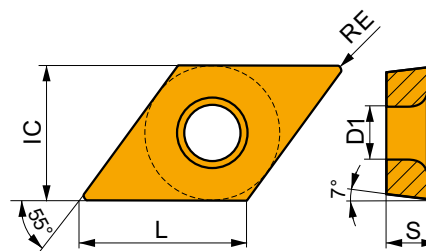
DCMX 11T304W-FM	T7325	0.4	✓	130	0.30	0.8	■	100	0.27	0.8	–	–	–	–	–	–	–	–	–	–
	T8330	0.4	■	115	0.30	0.8	■	65	0.27	0.8	■	105	0.30	0.8	–	–	–	–	–	–
	T8430	0.4	■	130	0.30	0.8	■	70	0.27	0.8	✓	105	0.30	0.8	–	–	–	–	–	–
	T9315	0.4	■	170	0.30	0.8	–	–	–	–	✓	160	0.30	0.8	–	–	–	–	–	–
	T9325	0.4	■	155	0.30	0.8	■	90	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	–	–	–	–	–	–

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
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DCMW

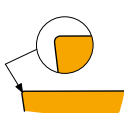
PRAMET

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



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere 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)



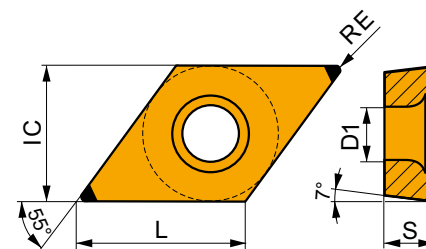
For fin til halv-grov bearbeiding og kontinuerlige til lett avbrutte kutt.

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

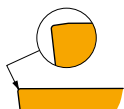
PRAMET

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



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere 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)



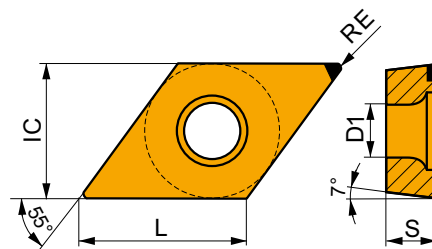
For ferdig bearbeiding.

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

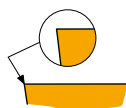


	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
11T3	9.525	4.40	11.60	3.97



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

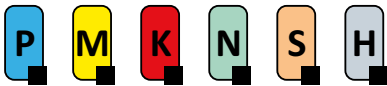
Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)



For ferdig bearbeiding, høye hastigheter og stabile bearbeidingsforhold.

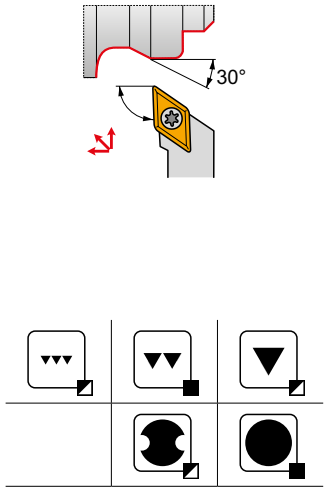
DCMW 11T304FN	PD1	0.4	—	—	—	—	—	—	—	—	1035	0.12	0.5	—	—	—	—	—	—
DCMW 11T308FN	PD1	0.8	—	—	—	—	—	—	—	—	1200	0.12	1.0	—	—	—	—	—	—

SDJC(RL) EXT



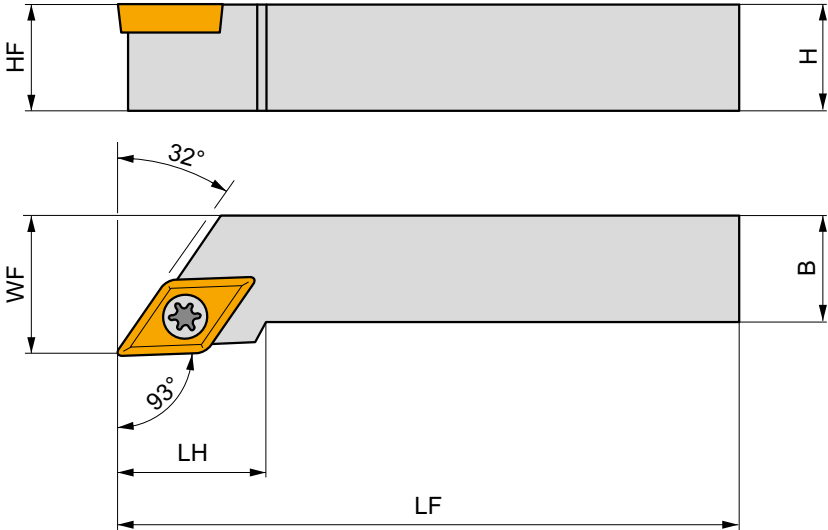
PRAMET

S



Utvendig dreieholder med 93 ° skjærevinkel for DC .. Skjær

Utvendig høyre/venstre hånd dreieholder med 93 ° skjærevinkel for positiv DC .. 07, 11 eller 15 skjær. Passer for utvendig langsgående dreieing med skulder, kopi, konisk og fasing. Tilgjengelig med skafstørrelse 08x08 opp til 25x25 mm. Behandlet for lengre levetid.



Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
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											
GI052											
GI243											

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

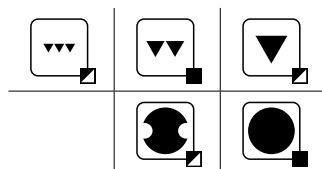
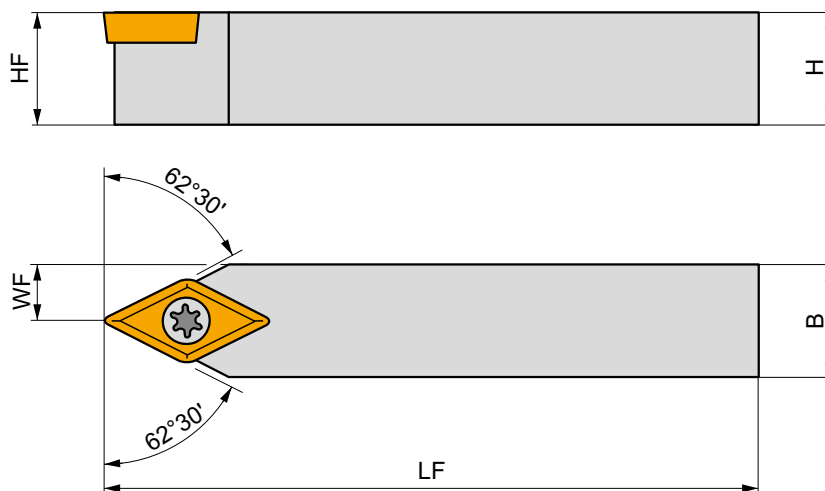
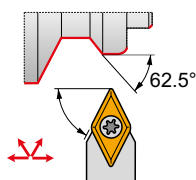


PRAMET

S

Utvendig verktøyholder med 62,5° skjærevinkel for DC .. Skjær

Utvendig nøytral verktøyholder med 62,5° skjærevinkel for positiv DC .. 07 eller 11 skjær. Egnet for utvendig langsgående dreining uten skulder, form, konisk og fasing. Tilgjengelig med skaftstørrelse 08x08 opp til 25x25 mm. Behandlet for lengre levetid for verktøyet.



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

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

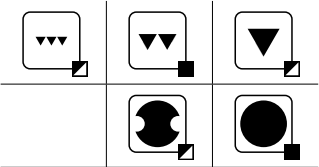
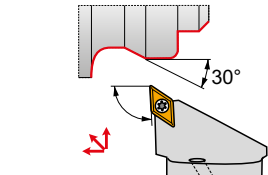
N

S

H

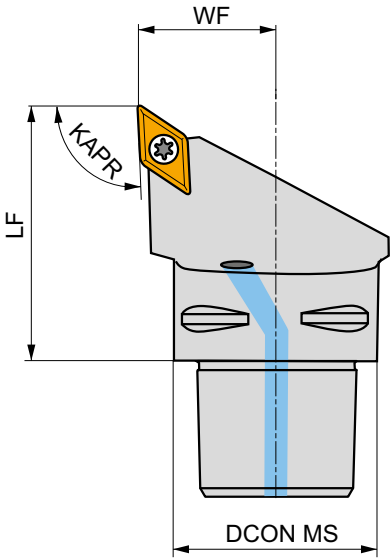
PRAMET

S



Utvendig PSC Quick Change dreieholder, 93 ° skjærevinkel for DC .. Skjær

Utvendig høyre/venstre hånd dreieholder, med innvendig kjøling, med 93 ° skjærevinkel for positiv DC ..07, 11 eller 15 skjærr. Passer for utvendig langsgående dreiging med skulder, kopi, konisk og fasing. Tilgjengelig med PSC (Polygon Shank Coupling) størrelse C3 opp til C5. Behandlet for lengre levetid.



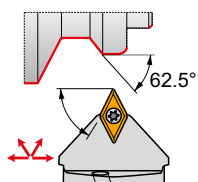
Product	DCON MS	WF	LF	KAPR	LAMS	GAMO		kg		
	(mm)	(mm)	(mm)	(°)	(°)	(°)				
R	C3-SDJCR-22040-11	32	22	40	93	0	0	✓	0.21	GI012 C-SD11V-1
	C4-SDJCR-27050-11	40	27	50	93	0	0	✓	0.38	GI012 C-SD11V-1
	C5-SDJCR-35060-11	50	35	60	93	0	0	✓	0.69	GI012 C-SD11V-2
L	C3-SDJCL-22040-11	32	22	40	93	0	0	✓	0.21	GI012 C-SD11V-1
	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..	
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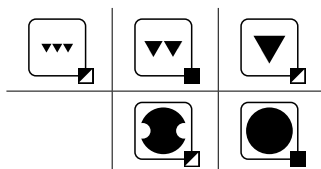
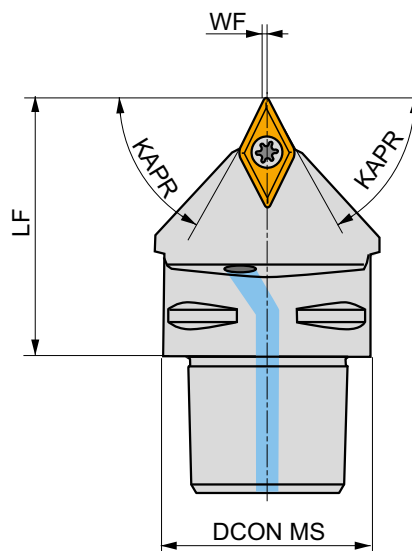
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C-SD11V-2	US 2001-T15P	3.0	M 3.5	12.1	SDS 263-01	MS 9001	FLAG T15P/3,5	CN 034-02

NEW**C.-SDNCN EXT**

PRAMET

S**Utvendig PSC Quick Change dreieholder, 62,5 ° skjærevinkel, DC .. Skjær**

Utvendig høyre/venstre hånd dreieholder, med innvendig kjøling, med 62,5 ° skjærevinkel for positiv DC .. 11 skjærr. Passer for utvendig langsgående dreining uten skulder, kopi, konisk og fasing. Tilgjengelig med PSC (Polygon Shank Coupling) størrelse C4 og C5. Behandlet for lengre levetid.



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..

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



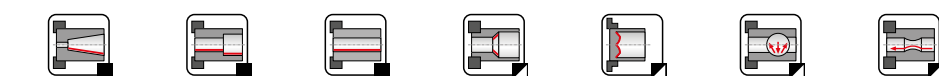
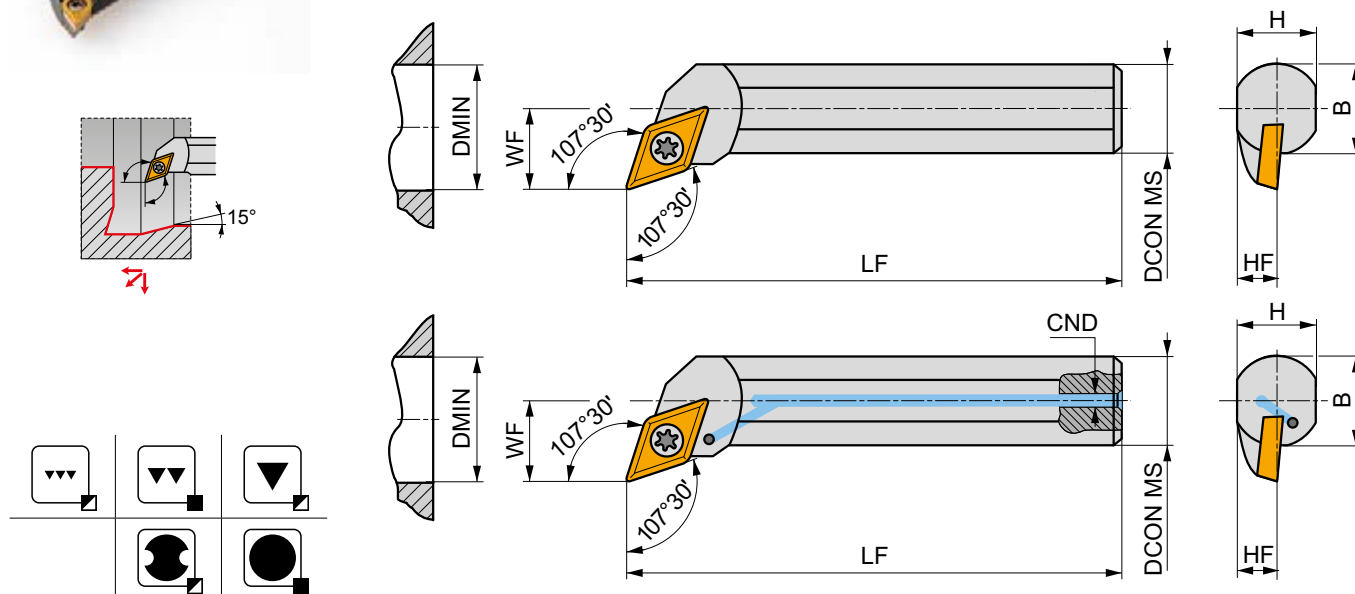
PRAMET

S



Innvendig dreiebom med 107,5° skjærevinkel for DC .. Skjør

Innvendig høyre/venstre dreiebom, tilgjengelig med innvendig kjøling, 107,5° skjærevinkel for DC .. 07 eller 11 skjær. Minimum innvendig dreiediameter Ø13 mm. For innvendig langsgående dreining med skulder, koning, kopiering og fasing. Ø10 til Ø32 mm skaft tilgjengelig. Behandlet for lengre levetid.



Product	DCON MS	DMIN	WF	H	B	LF	CND	LAMS	GAMO		kg		
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)				
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..

SD10	US 3510-T15P	3.0	M 3.5	10.6	SDN 110304	MS 3510	FLAG T15P	HXX 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



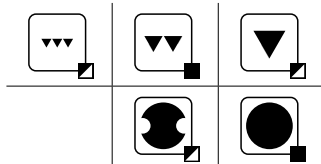
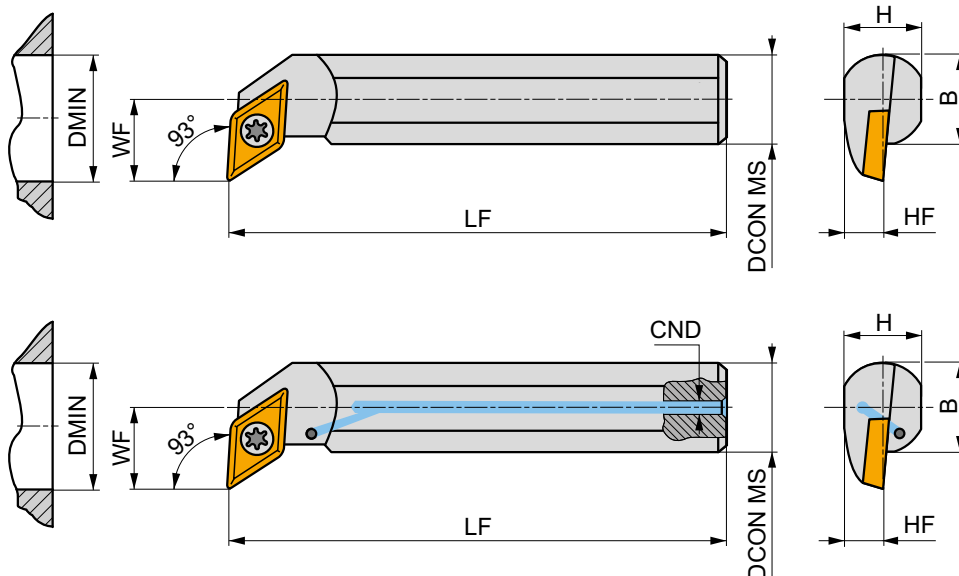
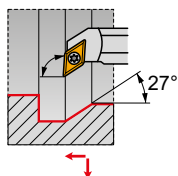
PRAMET

S



Innendig dreiebom med 93° skjærevinkel for DC.. skjær

Innendig høyre/venstre dreiebom, tilgjengelig med innvendig kjøling, 93° skjærevinkel for DC .. 07 eller 11 skjær. Minimum innvendig dreiediameter Ø13 mm. For innvendig langsgående dreining med skulder, koning, kopiering og fasing. Ø10 opp til Ø32 mm skaft tilgjengelig. Behandlet for lengre levetid.



Product		DCON MS	DMIN	WF	H	B	LF	CND	LAMS	GAMO		kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)				
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..



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

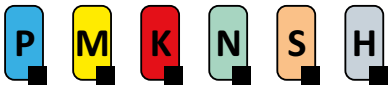
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FLAG T15P

—

SDUC(RL)-E INT



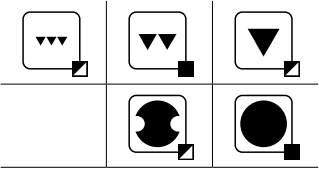
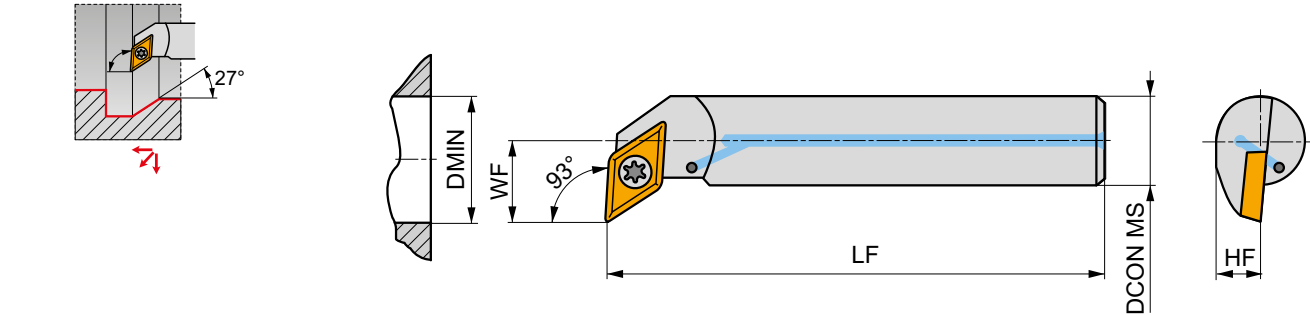
PRAMET

S



Innvendig hardmetall dreiebom med 93 ° skjærevinkel for DC ..Skjær

Innvendig høyre/venstre dreiebom, med innvendig kjøling, 93° skjærevinkel for positiv DC .. 07 skjær. Minimum innvendig dreiediameter Ø15 mm. For innvendig langsgående dreieing med skulder, koning, kopiering og fasing. Ø10 opp til Ø16 mm skaft tilgjengelig. For verktøyoverheng> 3xD.



Product	DCON MS	DMIN	WF	HF	LF	LAMS	GAMO		kg		
	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)				
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

100

SDZC(RL) INT

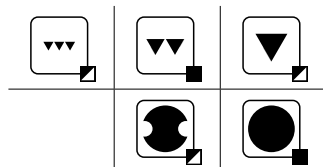
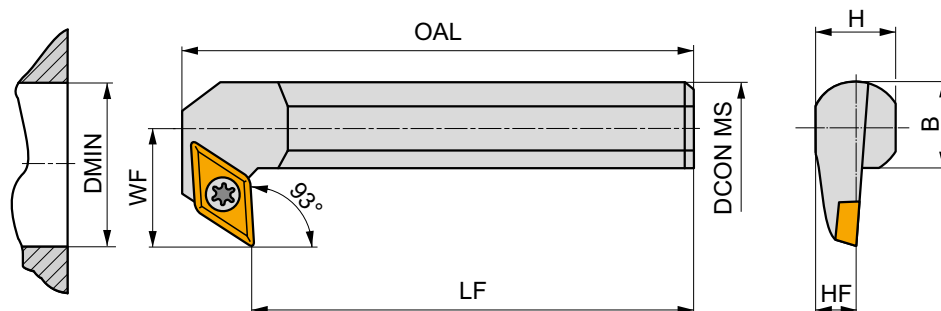
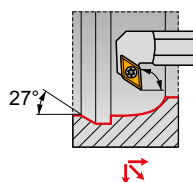


PRAMET

S

**Innvendig dreiebom med 93 ° skjærevinkel for DC .. Skjær**

Innvendig høyre/venstre dreiebom med 93° skjærevinkel for DC .. 07 eller 11 skjær. Minimum innvendig dreiediameter Ø27 mm. Passer for innvendig langsgående bakfasning med skulder, konisk, kopiering og fasing. Finnes med skaftstørrelse Ø16 opp til Ø40 mm. Behandlet for lengre levetid.



	Product	DCON MS	DMIN	WF	H	B	LF	OAL	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
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..



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

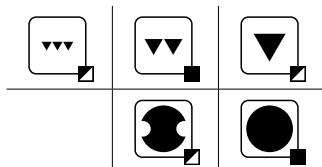
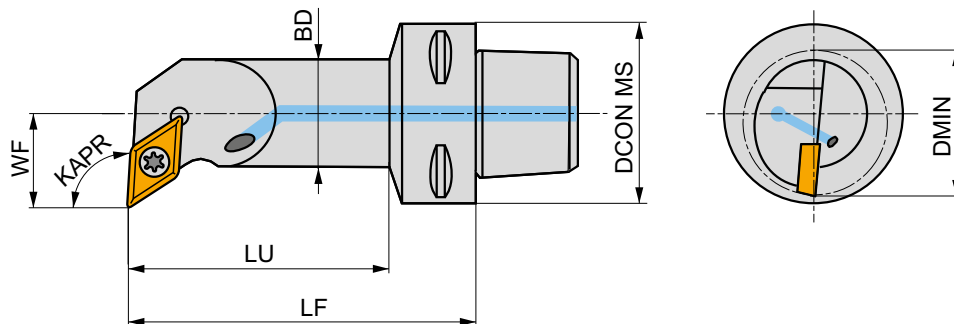
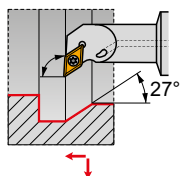
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NEW**C.-SDUC(RL) INT**

PRAMET

S**Innvendig PSC hurtig veksling dreieholder, 93° skjærevinkel for DC.. Skjær**

Innvendig høyre/venstre hånd dreiebom, med innvendig kjøling, med 93° skjærevinkel for DC.. 07 eller 11 skjær. Minimum innvendig dreiediameter Ø20 mm. Passer for et bredt spekter av innvendige dreieapplikasjoner. PSC-skaft (Polygon Shank Coupling) størrelse C3 opp til C5 med valg av lengder. Behandlet for lengre levetid.



Product	DCON MS	DMIN	WF	LF	LU	BD	KAPR	LAMS	GAMO				
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)	(°)				
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
L	C5-SDUCR-17090-11	50	32	17	90	67	25	93	-3.4	0	✓	0.68	GI012 SV16
	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..		

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

ECMT 060204E-FM2

Tool Holder

S08K-SEUCR 06

ISO DREIING – EKSTERN

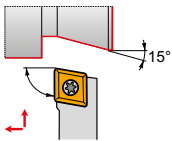
SEGC(RL) EXT

90°

EC..



08


 $\frac{12 \times 12}{16 \times 16}$

107

104 – 106

ISO DREIING – INTERN

SEUC(RL) INT

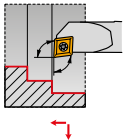
93°

EC..



06

08


 $\frac{11}{32}$

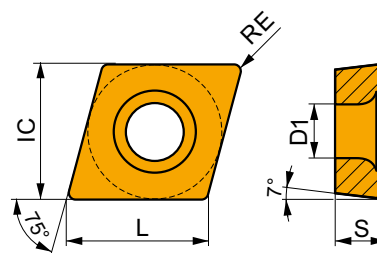
108

104 – 106

ECGT

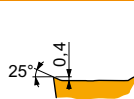


	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
0602	6.350	2.80	6.50	2.38
0602-SF3	6.350	2.80	6.50	2.58
0803	7.940	3.40	8.20	3.18
0803-SF3	7.940	3.40	8.20	3.43



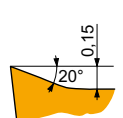
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

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)



SF2 geometri med svært positiv design for finbearbeiding og kontinuerlige kutt.

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	—	—	—



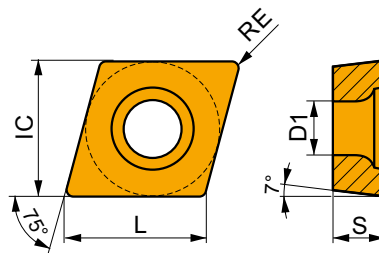
SF3-geometri med meget positiv design for finbearbeiding og kontinuerlige kutt.

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

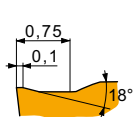


	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
0602	6.350	2.80	6.50	2.38
0803	7.940	3.40	8.20	3.18



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere 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)



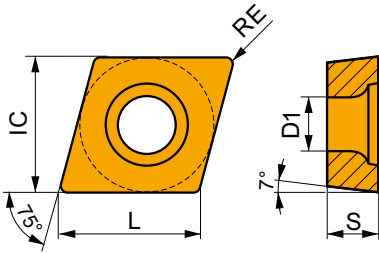
FM2 geometri for fin til middels bearbeiding, og kontinuerlig til avbrutt kutt.

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	—	—	—	—	—	—	—	—
ECMT 080308E-FM2	T9335	0.4	215	0.12	1.0	125	0.11	1.0	—	—	—	—	—	—	—	—	—	—	—
	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



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



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(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)



For fin til halv-grov bearbeiding og kontinuerlige til lett avbrutte kutt.

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



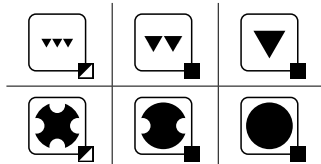
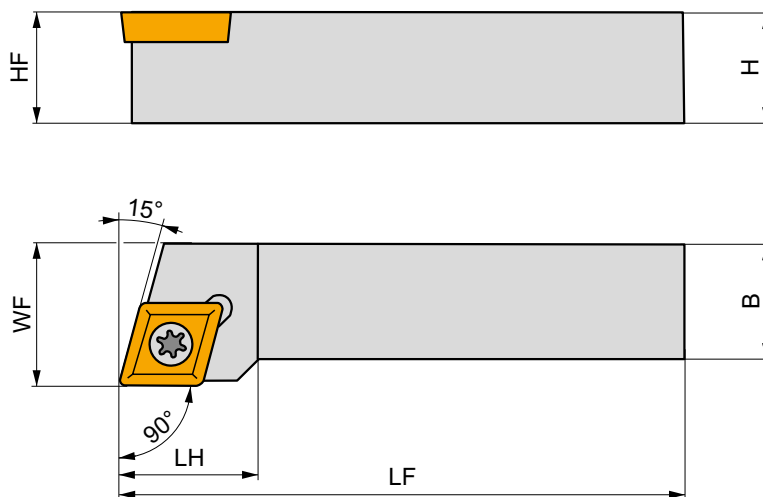
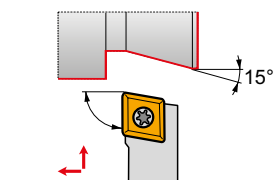
PRAMET

S



Utvendig dreieholder med 90° skjærevinkel for EC.. Skjær

Utvendig høyre/venstre hånd dreieholder med 90° skjærevinkel for positiv EC.. 08 skjær. Passer for utvendig overflate og langsgående dreining med skulder, koning, fasing og overflatedreining. Tilgjengelig med skaftstørrelse 12x12 og 16x16 mm. Behandlet for lengre levetid.



Product		H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
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

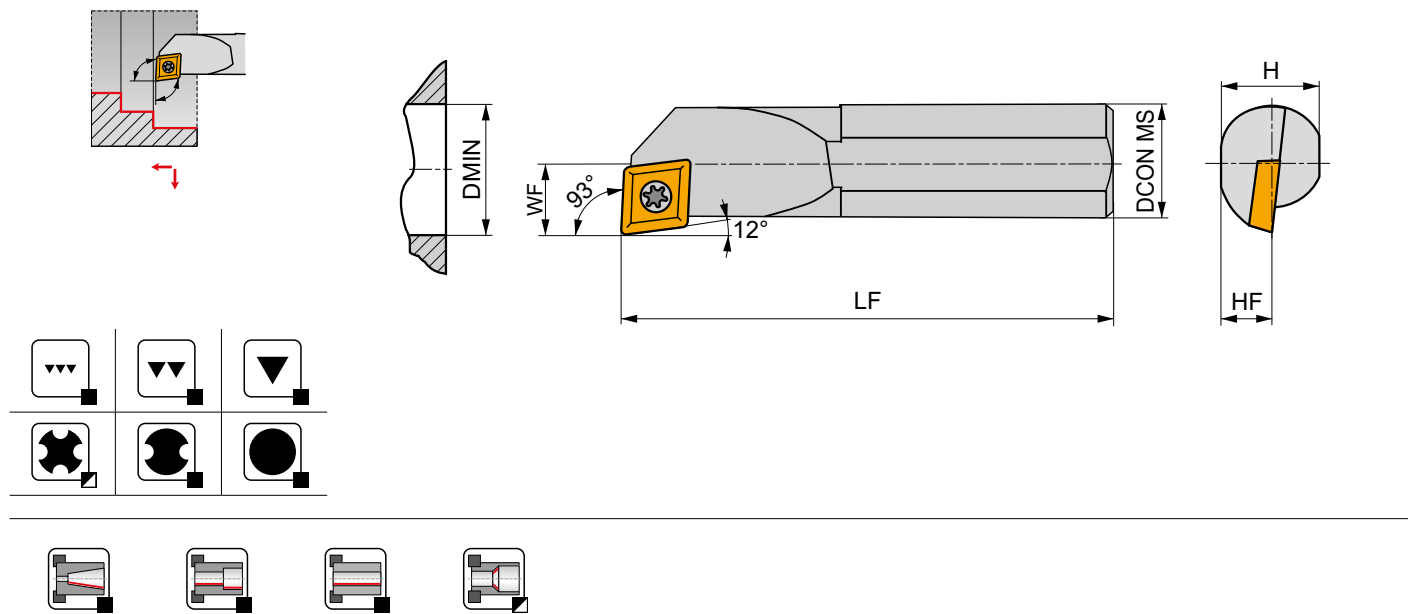
H

PRAMET

S



Innvendig dreiebom med 93 ° skjærevinkel for EC .. Skjær
 Innvendig høyre/venstre dreiebom med 93° skjærevinkel for EC .. 06 og 08 skjær. Minimum innvendig dreiediameter Ø11 mm. Passer for innvendig konisk og langsgående dreiling med skulder- og fasing. Finnes med skaftstørrelse Ø8 opp til Ø25 mm. Behandlet for lengre levetid.



Product		DCON MS	DMIN	WF	H	HF	LF	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
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
L	S25T-SEUCR 08	25	32	17	23	11.5	300	-4	0	1.06	GI210	SE24
	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..

					
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

EPGX 050202FR-JZ

Tool Holder

S0608H-SELPR 05

ISO DREIING – INTERN T

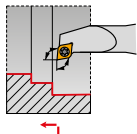
SELP(RL) INT

95°

EP..



05



111

8
16

110

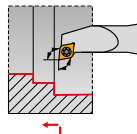
SELP(RL)-E INT

95°

EP..



05



112

8
16

110

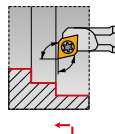
SEUP(RL) INT

93°

EP..



05



113

8,3

110

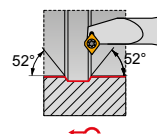
SEXP(RL) INT

52°30'

EP..



05



114

9,5
16

110

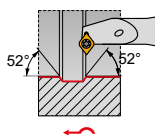
SEXP(RL)-E INT

52°30'

EP..



05



115

9,5
16

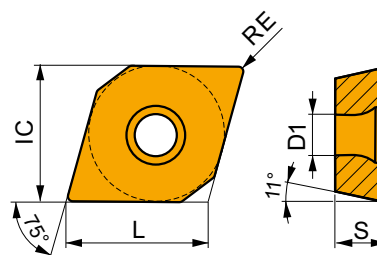
110

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
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EPGX

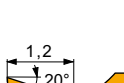
PRAMET

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



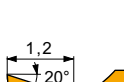
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

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)



FR-JZ geometri med positiv høyrehendt design for finbearbeiding og kontinuerlige kutt.

EPGX 050202FR-JZ	TT010	0.2	295	0.06	0.5	175	0.05	0.5	—	—	—	—	—	—	—	—	—	—	—
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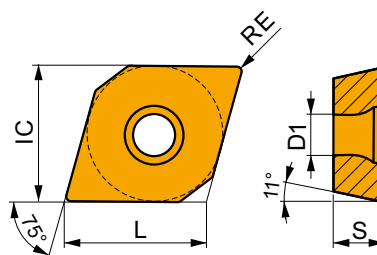
FL-JZ geometri med positiv venstrehendt design for finbearbeiding og kontinuerlige kutt.

EPGX 050202FL-JZ	TT010	0.2	295	0.06	0.5	175	0.05	0.5	—	—	—	—	—	—	—	—	—	—	—
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EPMT

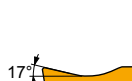
PRAMET

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



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere 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)



NF2-geometri med positiv design for finbehandling til middels bearbeiding og kontinuerlige kutt.

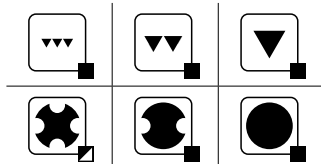
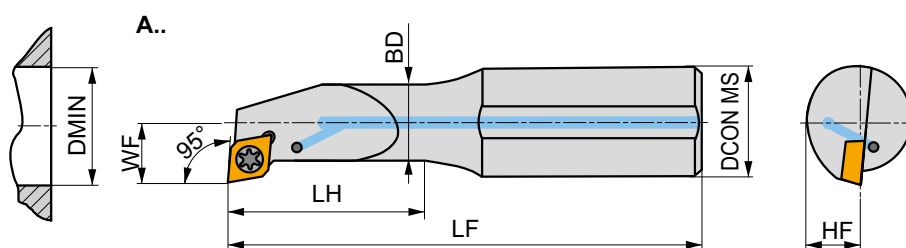
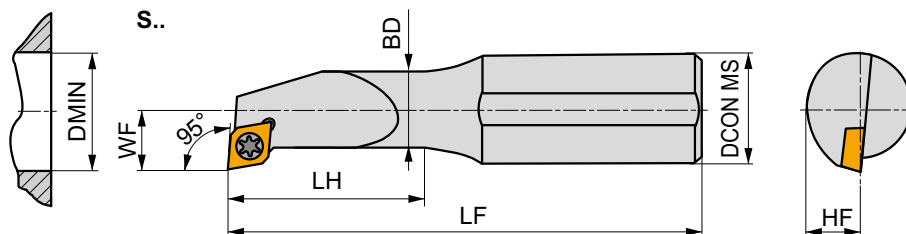
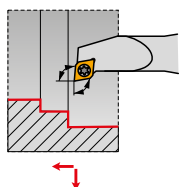
EPMT 050202E-NF2	H07	0.2	—	—	—	80	0.09	0.8	125	0.10	0.8	405	0.12	0.8	40	0.07	0.6	—	—	—
	T7325	0.2	215	0.07	0.8	165	0.06	0.8	—	—	—	—	—	—	65	0.06	0.6	—	—	—
	T7335	0.2	220	0.07	0.8	170	0.06	0.8	—	—	—	—	—	—	70	0.06	0.6	—	—	—
	T9315	0.2	390	0.05	0.8	—	—	—	370	0.05	0.8	—	—	—	—	—	—	—	—	—
	T9325	0.2	305	0.07	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

PRAMET

S**Innvendig dreiebom med 95° skjærevinkel for EP .. Skjær**

Innvendig høyre/venstre dreiebom, tilgjengelig med innvendig kjøling, med 95° skjærevinkel for EP .. 0502 skjær. Minimum innvendig dreiediameter Ø8 mm. Passer for innvendig konisk og langsgående dreining med skulder- og fasing. Ø8 opp til Ø16 mm skaft tilgjengelig. Behandlet for lengre levetid.



	Product	DCON MS	DMIN	BD	WF	LF	LH	LAMS	GAMO				
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)				
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..



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

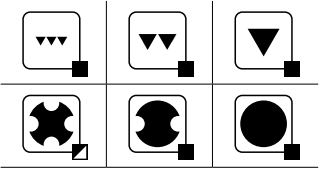
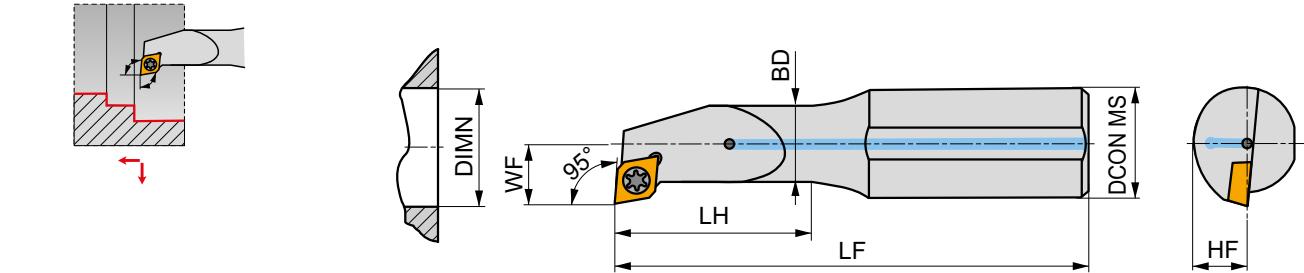
PRAMET

S



Innvendig hardmetall dreiebom med 95 ° skjærevinkel for EP .. Skjær

Innvendig høyre/venstre dreiebom, med innvendig kjøling, med 95° skjærevinkel for EP .. 0502 skjær. Minimum innvendig dreiediameter Ø8 mm. Passer for innvendig konisk og langsgående dreieing med skulder- og fasing. Finnes med skaftstørrelse Ø8 opp til Ø16 mm. For verktøyoverheng> 3xD.



Product		DCON MS	DMIN	BD	WF	LF	LH	LAMS	GAMO				
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)				
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..

SE22	28588	0.8	M 2.2	5.6	MA2-8304

SEUP(RL) INT



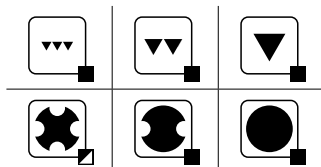
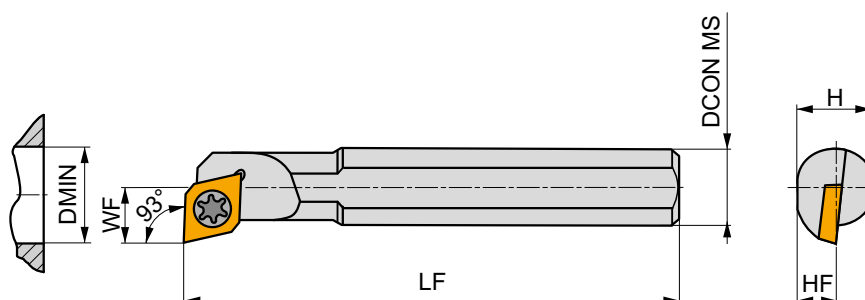
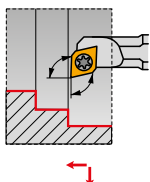
PRAMET

S



Innvendig dreiebom med 93° skjærevinkel for EP.. Skjær

Innvendig høyre/venstre dreiebom med 93° skjærevinkel for skruetype EP.. 0502 innsatser. Minimum innvendig snuddiameter Ø8,3 mm. Passer for innvendig konisk og langsgående dreining med skulder- og fasing. Finnes med skaftstørrelse Ø6 mm. Kroppsbehandlet for lengre levetid.



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



M 2.2

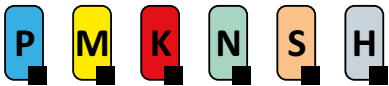


4.2



MA2-8304

SEXP(RL) INT



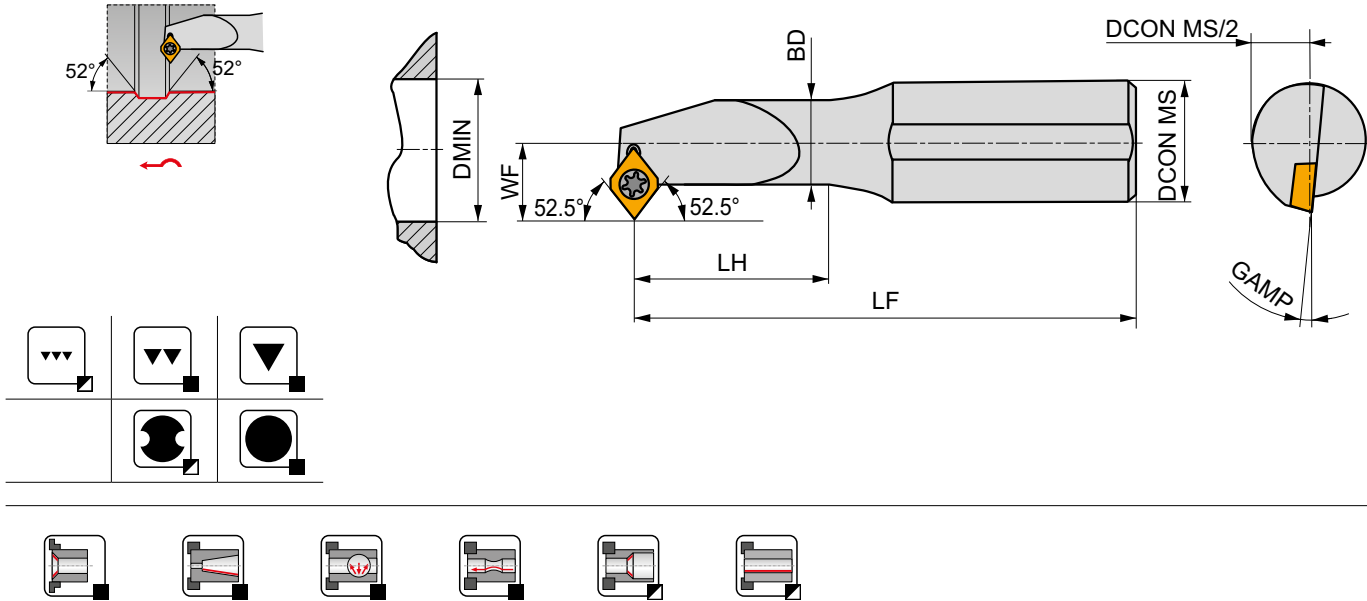
PRAMET

S



Innvendig dreiebom med 52,5° skjærevinkel for EP .. Skjær

Innvendig høyre/venstre dreiebom, 52,5° skjærevinkel for EP .. 0502 skjær. Minimum innvendig dreiediameter Ø9,5 mm. For innvendig bakfasning, konisk, Multi-dreieretninger, faset og langsgående dreining uten skulder. Tilgjengelig med skaftstørrelse Ø8 opp til Ø16mm. Behandlet for lengre levetid.



	Product	DCON MS	DMIN	BD	WF	LF	LH	GAMP	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)			
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..

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

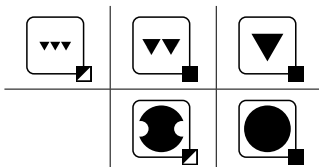
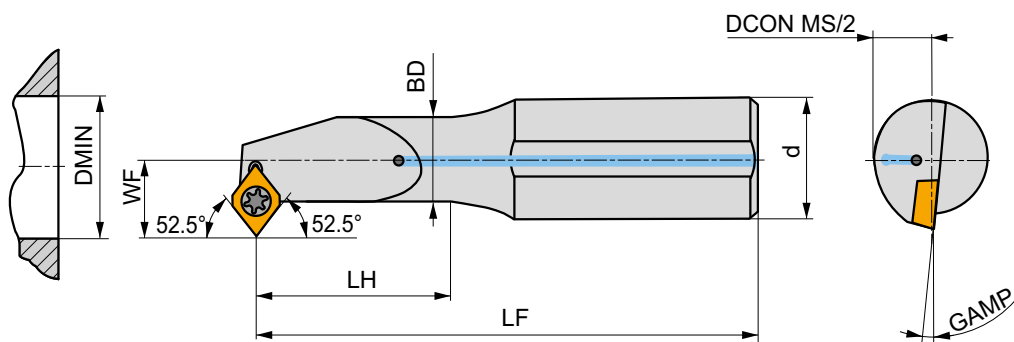
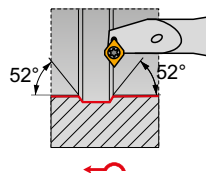


PRAMET

S

**Innvendig hardmetall dreiebom, 52,5° skjærevinkel for EP .. Skjær**

Innvendig høyre/venstre dreiebom, med innvendig kjøling, 52,5° skjærevinkel for EP .. 0502 skjær. Minimum innvendig snuddiameter Ø9,5 mm. For innvendig bakfasning, konisk, multi-dreieretninger, faset og langsgående dreining uten skulder. Ø8 til Ø16 mm skaft tilgjengelig. For overheng > 3xD.



Product	DCON MS	DMIN	BD	WF	LF	LH	GAMPA				
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)				
R	E0608H-SEXPR 05	8	9.5	6	5.5	100	-7	✓	0.07	GI212	SE21
	E0810J-SEXPR 05	10	11	8	6	110	-5	✓	0.11	GI212	SE22
	E1012K-SEXPR 05	12	13	10	7	125	-5	✓	0.16	GI212	SE22
	E1216M-SEXPR 05	16	16	12	9	150	-2	✓	0.32	GI212	SE22
L	E0608H-SEXPL 05	8	9.5	6	5.5	100	-7	✓	0.06	GI212	SE21



GI212



EP..0502..



SE21

28992
285880.8
0.8M 2.2
M 2.24.2
5.6MA2-8304
MA2-8304

RC

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

CARBIDE INSERTS

RCGT	RCMT	RCMW	RCMX
			
 118	 118	 120	 121

CER INSERTS

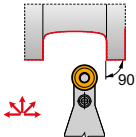
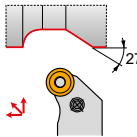
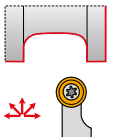
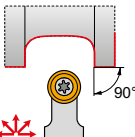
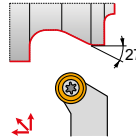
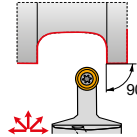
RCGX CER

 123

MATCH THE RIGHT SIZE (example)

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

ISO DREIING – EKSTERN

PRDCN EXT	PRSC(RL) EXT	SRDC(RL) EXT	SRDCN EXT
  40×40  50×50  124	  40×40  125	  20×20  32×25  126	  12×12  32×25  127
RC..  20 25 32  118 – 123	RC..  16 25  118 – 123	RC..  08  118 – 123	RC..  06 08 10 12 16  118 – 123
SRSC(RL) EXT	C.-SRDCN EXT NEW		
  12×12  32×25  128	  C4  C5  130		
RC..  06 08 10 12 16  118 – 123	RC..  10 12  118 – 123		

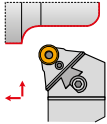
CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
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RC

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

ISO DREIING – TUNG GROVBEARBEIDING– EKSTERNT

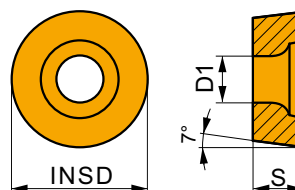
KHP-RSCR/L + DKH(RL)

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

RCGT

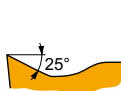


	INSD	D1	S
	(mm)	(mm)	(mm)
0803	8.0	3.40	3.18
1003	10.0	4.40	3.18



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere 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)



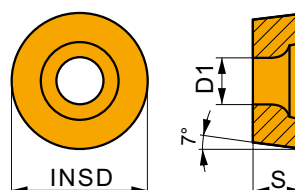
AL-geometri med svært positiv design for fin til grov bearbeiding, og kontinuerlige til lett avbrutte kutt.

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

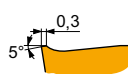


	INSD	D1	S
	(mm)	(mm)	(mm)
0602	6.0	2.80	2.38
0803	8.0	3.40	3.18
10T3	10.0	4.40	3.97
1204	12.0	4.40	4.76
1606	16.0	5.50	6.35
2006	20.0	6.50	6.35
2507	25.0	8.60	7.94



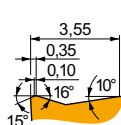
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

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)



Geometri 37 for halv-grov til tung-grov bearbeiding, og kontinuerlig til avbrutt kutt.

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	—	—	—	—	—	—	—	—



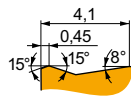
Geometri 371 for halv-grov til tung-grov bearbeiding, og kontinuerlig til avbrutt kutt.

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	—	—	—	—	—	—	—	—

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
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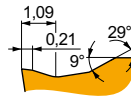
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(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)



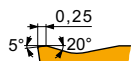
Geometri 372 for halv-grov til tung-grov maskinering, kontinuerlig til avbrutt kutt.

RCMT 2507M05-372	T9325	—	90	0.80	3.0	—	—	—	85	0.80	3.0	—	—	—	—	—	—	—	—	—
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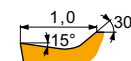
FM-geometri for fin til halv-grov bearbeiding, og kontinuerlige til lett avbrutte kutt.

RCMT 0602M0E-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 0803M0E-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 10T3M0E-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 1204M0E-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 for halv-grov til grov bearbeiding, og kontinuerlig til avbrutt kutt.

RCMT 0803M0E-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 1204M0E-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 1606M0E-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 2507M0E-RM3	H07	—	—	—	—	60	0.54	3.0	95	0.60	3.0	—	—	—	—	—	—	—	—	—



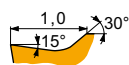
UR-geometri for finbearbeiding og kontinuerlige til lett avbrutte kutt.

RCMT 0602M0E-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	—	—	—	—	—	—	—	—	—

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
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Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product	RE (mm)	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)



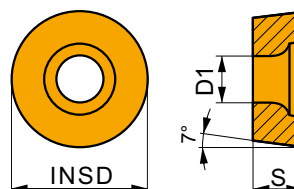
UR-geometri for finbearbeiding og kontinuerlige til lett avbrutte kutt.

RCMT 0803MOE-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 10T3MOE-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 1204MOE-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

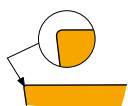


	INS D (mm)	D1 (mm)	S (mm)
0602	6.0	2.80	2.38
0803	8.0	3.40	3.18
10T3	10.0	4.40	3.97
1204	12.0	4.40	4.76



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product	RE (mm)	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)

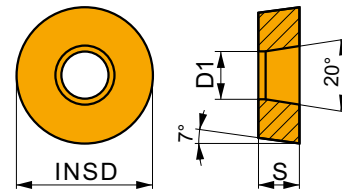


For fin til halv-grov bearbeiding og kontinuerlige til lett avbrutte kutt.

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

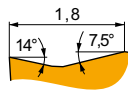
RCMX

	INSD	D1	S
	(mm)	(mm)	(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



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

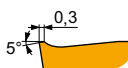
Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)



Geometri 31 for fin til halv-grov bearbeiding, og kontinuerlig til avbrutt kutt.

RCMX 1003M05-31

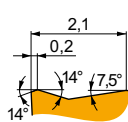
T9325	—	165	0.50	2.0	95	0.45	2.0	155	0.50	2.0	—	—	—	—	—	—	—	—	—
T9335	—	140	0.50	2.0	80	0.45	2.0	—	—	—	—	—	—	—	—	—	—	—	—



Geometri 37 for halv-grov til tung-grov bearbeiding, og kontinuerlig til avbrutt kutt.

RCMX 1606M05-37

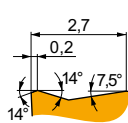
T9315	—	165	0.60	3.0	—	—	—	155	0.60	3.0	—	—	—	—	—	—	—	—	—
T9325	—	145	0.60	3.0	—	—	—	135	0.60	3.0	—	—	—	—	—	—	—	—	—



Geometri 321 for halv-grov til tung-grov bearbeiding, og kontinuerlig til avbrutt kutt.

RCMX 1204M05-321

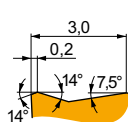
T9315	—	130	1.00	3.0	—	—	—	120	1.00	3.0	—	—	—	—	—	—	—	—	—
T9325	—	120	1.00	3.0	—	—	—	110	1.00	3.0	—	—	—	—	—	—	—	—	—
T9335	—	105	1.00	3.0	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—



Geometri 331 for halv-grov til tung-grov bearbeiding, og kontinuerlig til avbrutt kutt.

RCMX 1606M05-331

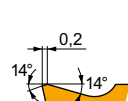
T9315	—	120	1.20	3.5	—	—	—	110	1.20	3.5	—	—	—	—	—	—	—	—	—
T9325	—	105	1.20	3.5	—	—	—	95	1.20	3.5	—	—	—	—	—	—	—	—	—
T9335	—	110	0.80	3.5	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—



Geometri 341 for halv-grov til tung-grov bearbeiding, og kontinuerlig til avbrutt kutt.

RCMX 2006M05-341

6640	—	90	1.00	3.5	—	—	—	85	1.00	3.5	—	—	—	—	—	—	—	—	—
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Geometri 351 for halv-grov til tung-grov bearbeiding, og kontinuerlig til avbrutt kutt.

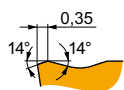
RCMX 2507M05-351

6640	—	60	1.00	3.5	—	—	—	55	1.00	3.5	—	—	—	—	—	—	—	—	—
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CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
----	----	----	----	----	----	----	----	----	----	----	----	----

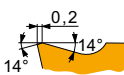
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(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)



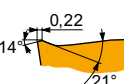
Geometri 361 for grov til tung-grov bearbeiding og kontinuerlig til kraftig avbrutt kutt.

RCMX 3209M0S-361	6640	—	50	1.40	4.5	—	—	—	45	1.40	4.5	—	—	—	—	—	—	—	—	—
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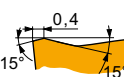
RF1 geometri for fin til halv-grov bearbeiding, og kontinuerlig til avbrutt kutt.

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	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—



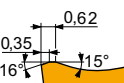
RM1 geometri for fin til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—



RM2 geometri for halv-grov til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—



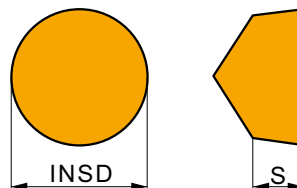
RR2-geometri for tung grovbearbeiding og kontinuerlige til avbrutte kutt.

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

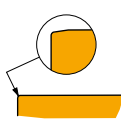


	INSD	S
	(mm)	(mm)
0606	6.350	6.35
0907	9.525	7.94
1207	12.700	7.94



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

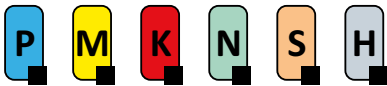
Product		RE (mm)	P			M			K			N			S			H		
			vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)



For maskinering med høye hastigheter og kontinuerlige kutt.

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

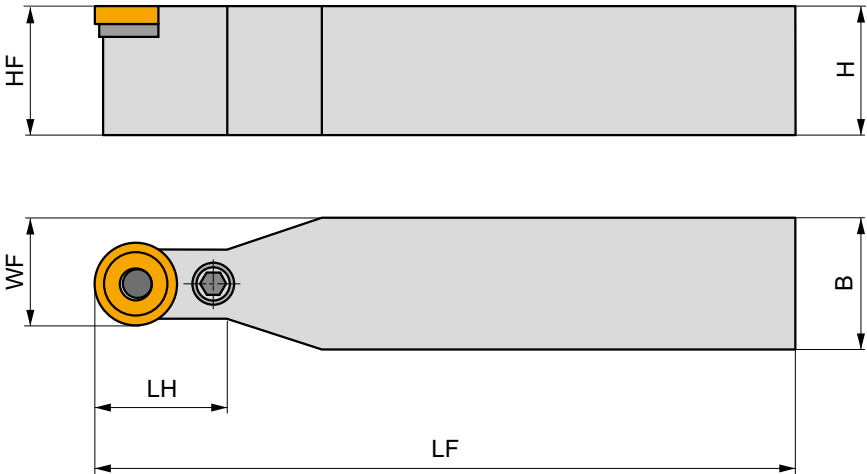
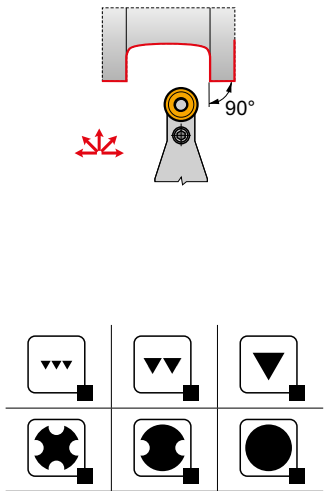


PRAMET



Utvendig verktøyholder for runde RC .. Skjær

Utvendig nøytral Verktøyholder for positive RC .. 16 opp til 32 skjær. Egnet for utvendig overflate og langsgående dreining uten skulder, form dreining opp til 90 °, konisk og fasing. Tilgjengelig med skaftstørrelse 32x25 opp til 50x50 mm. Behandlet for lengre levetid.



Product	H	B	HF	WF	LF	LH	LAMS	GAMO				
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)				
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 2006MO	
GI090		RCMX 1606MO	
GI096		RCMX 3209MO	
GI122		RCMX 2507MO	

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

PRSC(RL) EXT



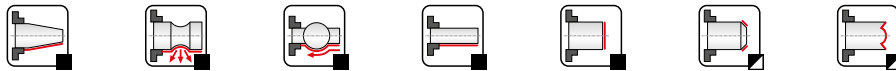
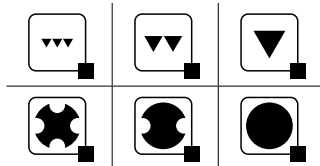
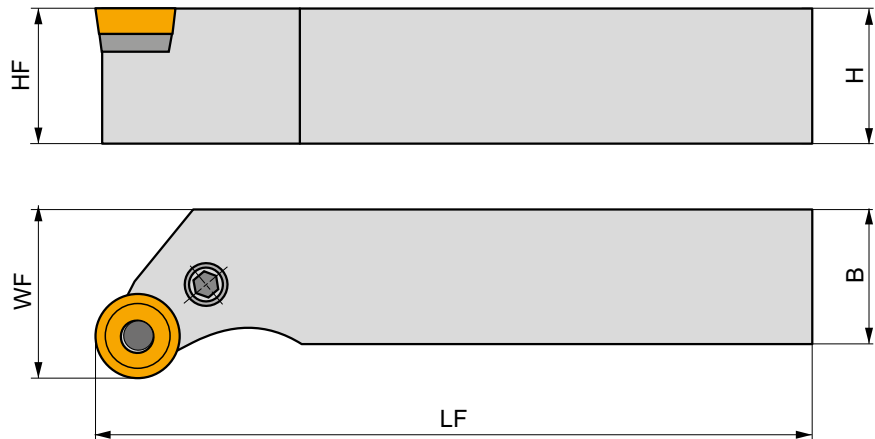
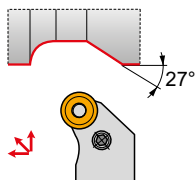
PRAMET

P



Utvendig dreieholder for rund RC .. Skjær

Utvendig høyre / venstre hånd dreieholder for positiv RC .. 16 opptil 25 skjær. Egnet for ytre overflate og langsgående dreining uten skulder, formdreining opp til 27°, konisk og fasing, inkludert overflateforming. Tilgjengelig med skaftstørrelse 32x25 opp til 40x40 mm. Behandlet for lengre levetid.

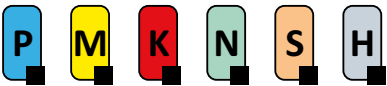


	Product	H	B	HF	WF	LF	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	PRSCR 3225 P 16	32	25	32	32	170	0	0	0.90	GI090	PRP70
	PRSCR 4040 R 16	40	40	40	50	200	0	0	2.38	GI090	PRP70
	PRSCR 3232 P 20	32	32	32	40	170	0	0	1.40	GI069	PRP90
	PRSCR 4040 S 25	40	40	40	50	250	0	0	3.40	GI122	PRP80
L	PRSCL 3225 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											
GI090											
GI122											

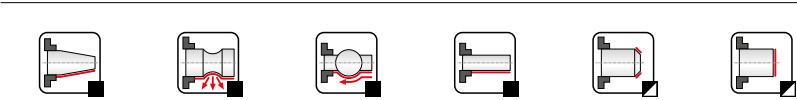
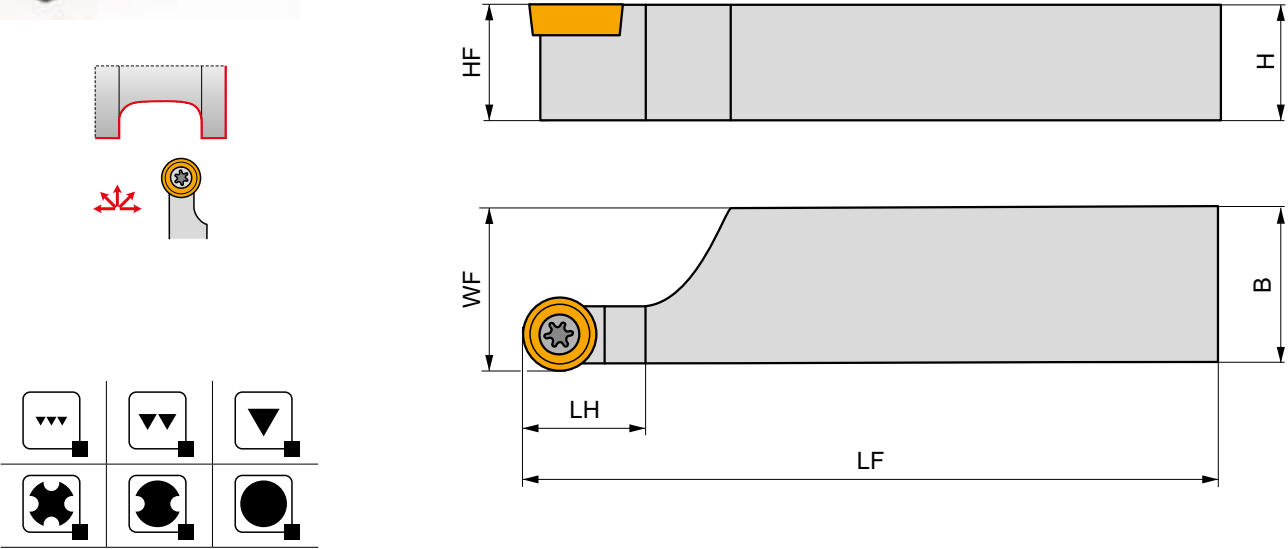
PRP70		RCU 160300		PU 07		US 36		6.0		M 8x1	
PRP80		RCU 250600		PU 08		US 38		8.0		M 10x1	
PRP90		RCU 200400		PU 09		US 36		6.0		M 8x1	

SRDC(RL) EXT



Utvendig dreieholder for rund RC .. Skjær

Utvendig høyre / venstre hånd dreieholder for positiv RC .. 08 skjær. Egnet for ytre overflate og langsgående dreining uten skulder-, konisk- og avfasings dreining. Tilgjengelig med skaftstørrelse 20x20 opp til 32x25 mm. Behandlet for lengre levetid for verktøyet.



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

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

SRDCN EXT



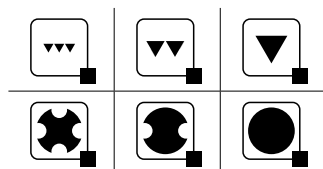
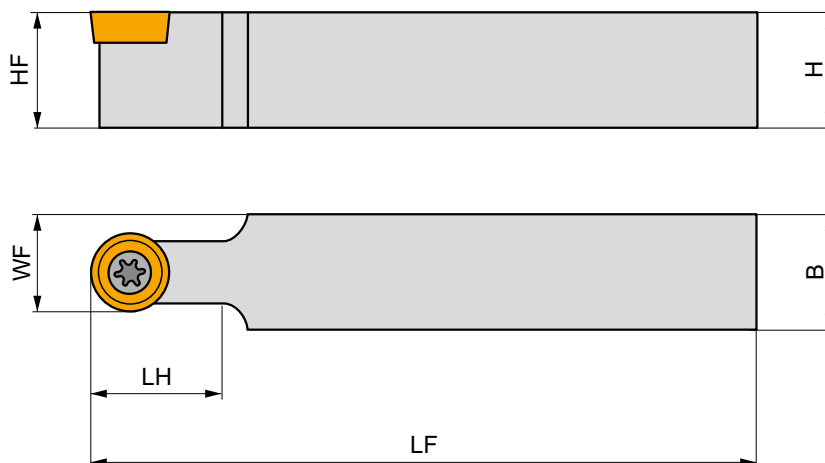
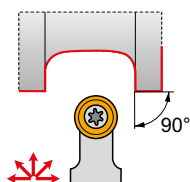
PRAMET

S



Utvendig verktøyholder for rund RC .. Skjær

Utvendig nøytral verktøyholder for positiv RC .. 06 opp til 16 skjær. Egnet for utvendig overflate og langsgående dreining uten skulder, form, konisk og fasing. Tilgjengelig med skaftstørrelse 12x12 opp til 32x25 mm. Behandlet for lengre levetid.



Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
N	SRDCN 1212 F 06	12	12	12	9	80	12	0	0	0.10	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.. 10T3MO
GI014	RC.. 1204MO
GI051	RC.. 0803MO
GI054	RC.. 0602MO
GI064	RC.. 1003MO
GI161	RC.. 1606MO

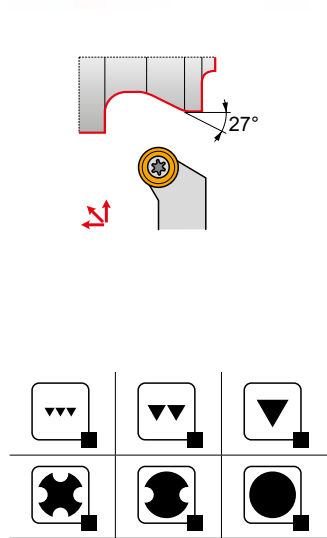


S01	US 2506-T07P	0.9	M 2.5	6.3	—	—	FLAG T07P	—
S03	US 3007-T09P	2.0	M 3	7.3	—	—	FLAG T09P	—
SR10	US 3510-T15P	3.0	M 3.5	10.6	SRN 100300	MS 3510	FLAG T15P	HXX 3.5
SR12	US 3510-T15P	3.0	M 3.5	10.6	SRN 120300	MS 3510	FLAG T15P	HXX 3.5
SR16	US 5018-T20P	5.0	M 5	18.2	SRN 16T3MO	MS 5015	FLAG T20P	HXX 5

SRSC(RL) EXT

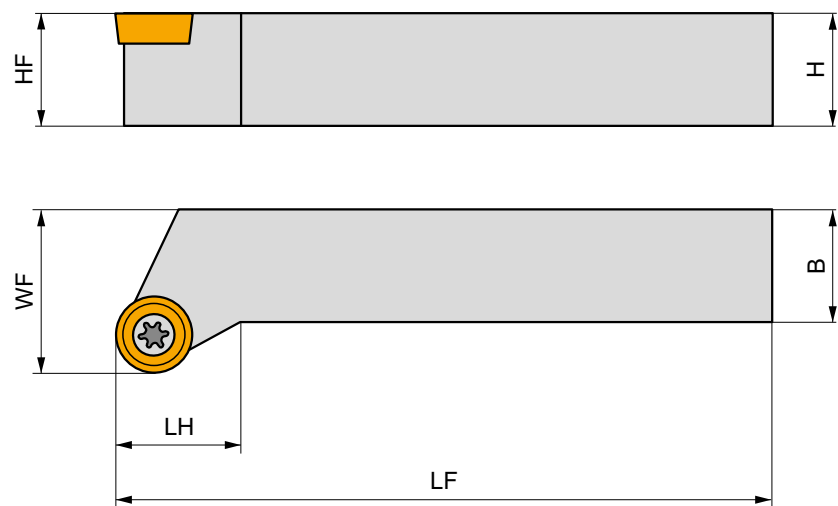


PRAMET



Utvendig dreieholder for rund RC .. Skjør

Utvendig høyre / venstre hånd dreieholder for positiv RC .. 06 inntil 16 skjær. Egnet for ytre overflte og langsgående dreining uten skulder, forming, konisk og fasing. Tilgjengelig med skaftstørrelse 12x12 opp til 32x25 mm. Behandlet for lengre levetid for verktøyet.



Product		H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	SRSCR 1212 F 06	12	12	12	16	80	12	0	0	0.09	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.. 10T3MO
GI014	RC.. 1204MO
GI051	RC.. 0803MO
GI054	RC.. 0602MO
GI161	RC.. 1606MO

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
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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 16T3MO	MS 5015	FLAG T20P	HXK 5

NEW

C.-SRDCN EXT



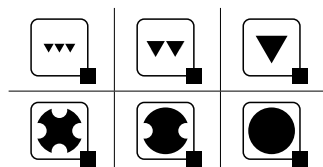
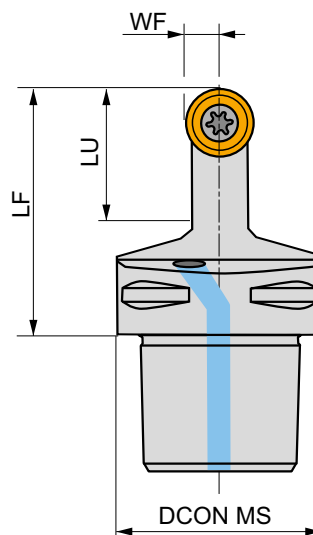
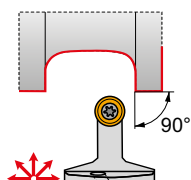
PRAMET

S



Utvendig PSC Hurtigvekslings dreieholder for RC .. Skjær

Utvendig nøytralt verktøy, innvendig kjølinge, for positiv RC .. 10 opp til 12 skjær. Egnet for ytre overflate og langsgående dreining uten skulder, form, konisk og fasing. Tilgjengelig med PSC (Polygon Shank Coupling) størrelse C4 og C5. Behandlet for lengre levetid.



Product	DCON MS	WF	LF	LU	LAMS	GAMO		kg		
	(mm)	(mm)	(mm)	(mm)	(°)	(°)				
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											
GI014											

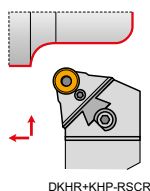
		 Nm						
C-SR10V	US 2010-T15P	3.0	M 3.5	10.1	SRS 110-01	MS 9001	FLAG T15P/3,5	CN 034-02
C-SR12V-1	US 2001-T15P	3.0	M 3.5	12.1	SRS 110-02	MS 9001	FLAG T15P/3,5	CN 034-01
C-SR12V-2	US 2001-T15P	3.0	M 3.5	12.1	SRS 110-02	MS 9001	FLAG T15P/3,5	CN 034-02

KHP-RSC(RL)

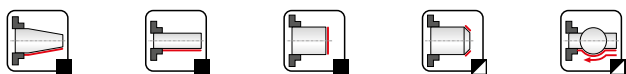
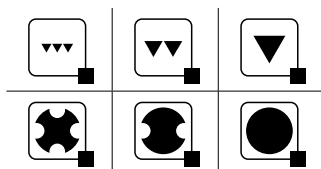
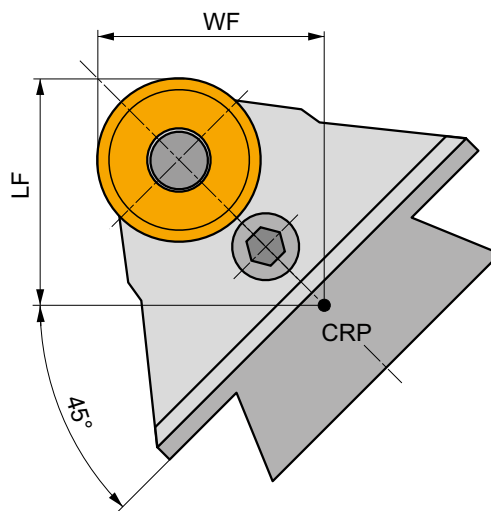
PRAMET

P**Modulær dreiepatron KHP låsespor for RC .. skjær**

Koblingshus høyre / venstre dreiepatron for montering på DKH verktøyholder. Egnet for kraftig langsgående dreining uten skulder, overflate dreining, konisk og fasing med positiv RC .. 20 opp til 32 skjær. Verktøyholder behandlet for lengre levetid.



DKHR+KHP-RSCR



Product	WF	LF	LAMS	GAMO	kg		
	(mm)	(mm)	(°)	(°)			
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									
GI096									
GI122									

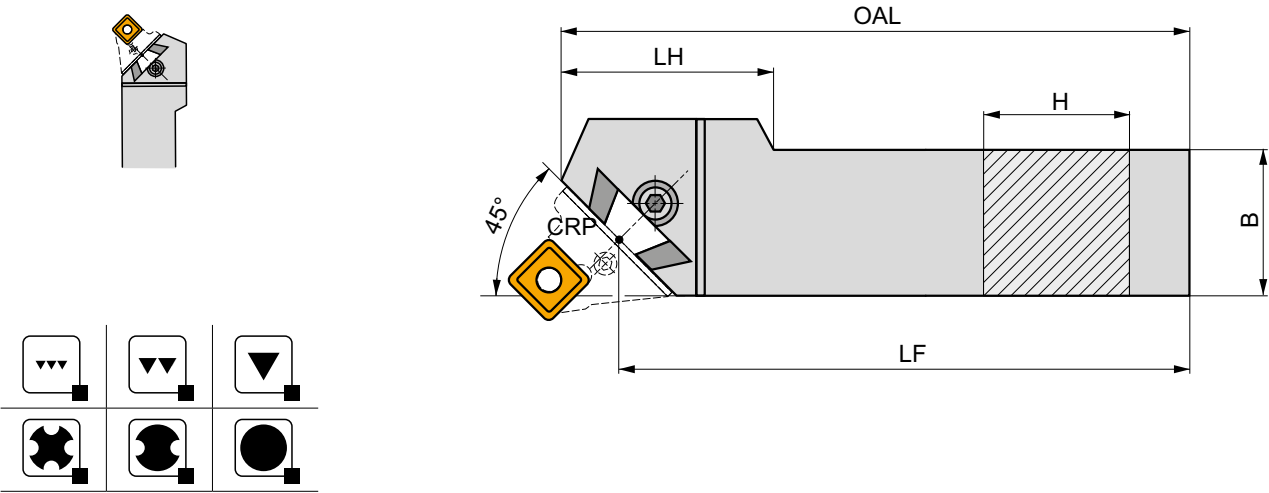
PRP32	RCU 320600	PU 10	US 47	8.0	M 12x1	36	NT 08	MT 08	HXX 5
PRP80	RCU 250600	PU 08	US 38	8.0	M 10x1	29	NT 06	MT 06	HXX 5
PRP90	RCU 200400	PU 09	US 36	6.0	M 8x1	26	NT 07	MT 07	HXX 4

DKH(RL)



Utvendig verktøyholderskaft for KHP / KHS Grove dreiepatroner

Koblingshus høyre / venstre hånds verktøyskaft for KHP / KHS-kassetter. Egnet for tunge dreie applikasjoner. Tilgjengelig med skaftstørrelse 40x50 opp til 60x80 mm. Behandlet for lengre levetid.



	Product	H	B	LF	OAL	LH	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)			
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

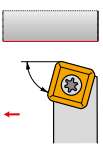
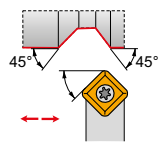
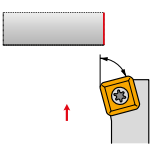
CARBIDE INSERTS

SCGT	SCMT	SCMW
		
 134	 135	 138

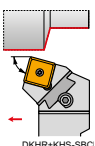
MATCH THE RIGHT SIZE (example)

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

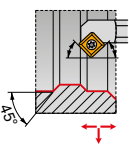
ISO DREIING – EKSTERN

SSBC(RL) EXT		SSDCN EXT		SSKC(RL) EXT	
75°	SC..	45°	SC..	75°	SC..
	 09 12 25 38		 09 12		 09 12
 12×12 60×60		 12×12 25×25		 12×12 25×25	
 139	 134 – 138	 140	 134 – 138	 141	 134 – 138

ISO DREIING – TUNG GROVBEARBEIDING – EKSTERNT

KHS-SBCR + DKH(RL)	
75°	SC..
	 25 38
 40×50 60×80	
 142, 143	 134 – 138

ISO DREIING – INTERNT

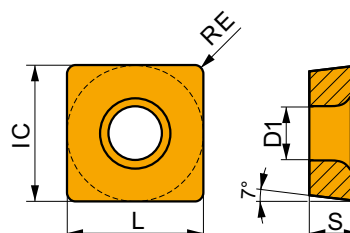
SSSC(RL) INT	
45°	SC..
	 09
 25 32	
 144	 134 – 138

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
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SCGT



	IC	D1	L	S
	(mm)	(mm)	(mm)	(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



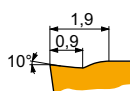
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

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)



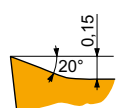
AL-geometri med svært positiv design for fin til grov bearbeiding, og kontinuerlige til lett avbrutte kutt.

SCGT 120408F-AL	HF7	0.8	—	—	—	—	—	—	—	—	315	0.48	2.0	—	—	—	—	—	—
	T0315	0.8	—	—	—	—	—	—	—	—	465	0.48	2.0	—	—	—	—	—	—



NF1-geometri med positiv design for finbearbeiding til middels bearbeiding og kontinuerlige kutt.

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 positiv design for finbearbeiding og kontinuerlige kutt.

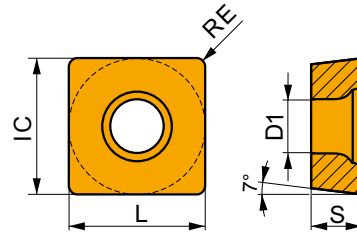
SCGT 09T304E-SF3	H07	0.4	—	—	—	95	0.09	1.0	155	0.10	1.0	495	0.12	1.0	50	0.07	0.8	—	—
	T6310	0.4	185	0.10	1.0	130	0.09	1.0	145	0.10	1.0	555	0.12	1.0	55	0.07	0.8	35	0.15
	T8315	0.4	200	0.10	1.0	120	0.09	1.0	190	0.10	1.0	600	0.12	1.0	50	0.07	0.8	40	0.15
SCGT 09T308E-SF3	T6310	0.8	210	0.12	1.0	150	0.12	1.0	165	0.12	1.0	630	0.14	1.0	60	0.11	0.8	40	0.15
	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

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
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SCMT

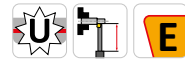
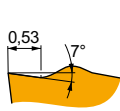


	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
09T3	9.525	4.40	9.53	3.97
1204	12.700	5.50	12.70	4.76
2509	25.400	8.70	25.40	9.53
3809	38.100	8.70	38.10	9.53



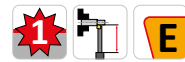
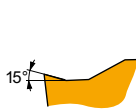
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

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)



FF2-geometri med positiv design for fin til ferdig bearbeiding, og kontinuerlige til lett avbrutte kutt.

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	—	—	—	—	—	—	—	—



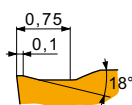
FM-geometri for fin til halv-grov bearbeiding, og kontinuerlige til lett avbrutte kutt.

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	—	—	—	—	—	—	—	—
	T7325	0.8	225	0.20	1.2	175	0.18	1.2	—	—	—	—	—	—	—	—	—	—	—
SCMT 09T308E-FM	T7335	0.8	215	0.20	1.2	165	0.18	1.2	—	—	—	—	—	—	—	—	—	—	—
	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	—	—	—	—	—	—	—	—
	T7325	0.4	195	0.15	1.6	150	0.15	1.6	—	—	—	—	—	—	—	—	—	—	—
SCMT 120404E-FM	T8315	0.4	185	0.15	1.6	110	0.14	1.6	175	0.15	1.6	555	0.18	1.6	—	—	—	—	—
	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	—	—	—	—	—	—	—	—
	T7325	0.8	215	0.20	1.6	165	0.18	1.6	—	—	—	—	—	—	—	—	—	—	—
SCMT 120408E-FM	T7335	0.8	210	0.20	1.6	160	0.18	1.6	—	—	—	—	—	—	—	—	—	—	—
	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	—	—	—	—	—	—	—	—
	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	—	—	—	—	—
SCMT 120412E-FM	T8430	1.2	200	0.27	1.6	110	0.24	1.6	165	0.27	1.6	555	0.32	1.6	—	—	—	—	—
	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	—	—	—	—	—	—	—	—

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
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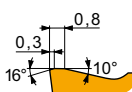
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

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



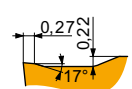
FM2 geometri for fin til middels bearbeiding, og kontinuerlig til avbrutt kutt.

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	—	—	—	—	—	—	—	—	—	—	—	—



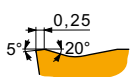
RF-geometri for halv-grov til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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 for halv-grov til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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	—	—	—	—	—	—



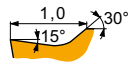
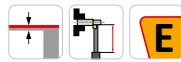
RM3-geometri for halv-grov til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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	—	—	—	—	—	—	—	—	—

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
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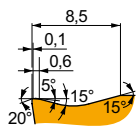
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	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)



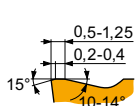
UR-geometri for finbearbeiding og kontinuerlige til lett avbrutte kutt.

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	—	—	—	—	—	—	—	—	—
SCMT 120408E-UR	TT310	0.8	270	0.20	1.2	160	0.18	1.2	—	—	—	—	—	—	—	—	—	—	—	—
	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	—	—	—	—	—	—	—	—	—
SCMT 120412E-UR	T9325	0.8	230	0.20	1.6	135	0.18	1.6	215	0.20	1.6	—	—	—	—	—	—	—	—	—
	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	—	—	—	—	—	—	—	—	—



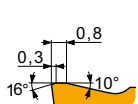
DR4-geometri for grov til tung-grov bearbeiding, og kontinuerlig til avbrutt kutt.

SCMT 380932E-DR4	T9335	3.2	50	1.33	16.0	30	1.20	16.0	—	—	—	—	—	—	—	—	—	—	—	—
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OR geometri for grov til tung grov bearbeiding, og kontinuerlig til avbrutt kutt.

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	—	—	—



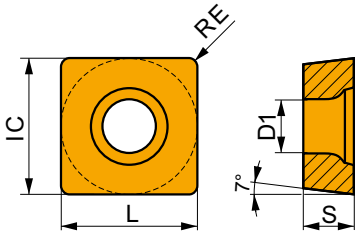
SR-geometri for grov til tung grov bearbeiding, og kontinuerlig til avbrutt kutt.

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



	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



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	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)



For fin til halv-grov bearbeiding og kontinuerlige til lett avbrutte kutt.

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



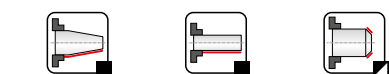
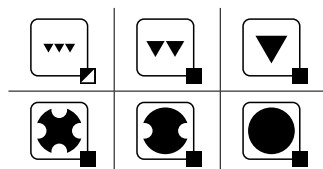
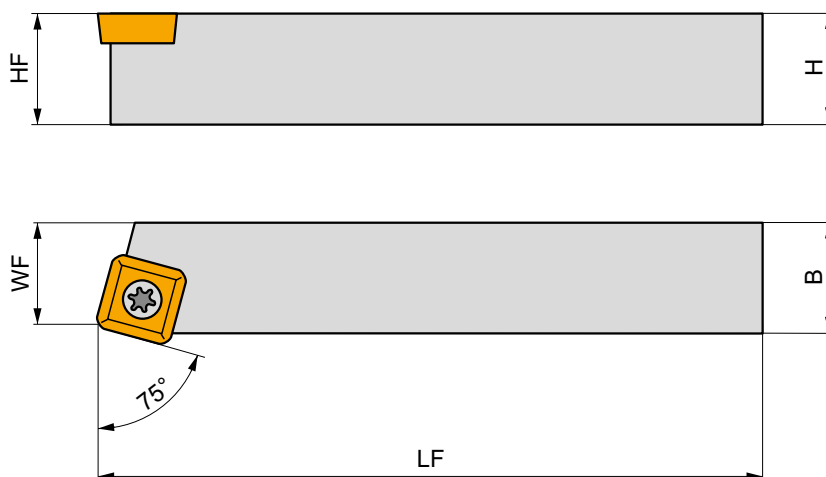
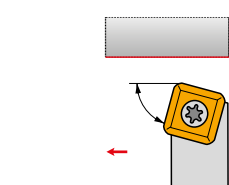
PRAMET

S



Utvendig dreieholder med 75° skjærevinkel for SC.. Skjær

Utvendig høyre/venstre hånd dreieholder for positiv SC.. 09 opptil 38 skjær. Passer for utvendig langsgående dreining uten skulder-, konisk- og fasedreining. Tilgjengelig med skaftstørrelse 12x12 opp til 60x60 mm. Behandlet for lengre levetid.

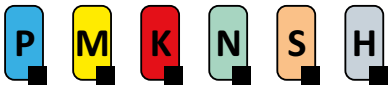


	Product	H	B	HF	WF	LF	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	SSBCR 1212 F 09	12	12	12	11	80	0	0	0.10	GI053	S08
	SSBCR 1616 H 09	16	16	16	13	100	0	0	0.20	GI053	S08
	SSBCR 2020 K 12-M-A	20	20	20	17	125	0	0	0.40	GI015	SS20
	SSBCR 2525 M 12-M-A	25	25	25	22	150	0	0	0.76	GI015	SS20
	SSBCR 4040 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
L	SSBCR 6060 V 38-A	60	60	60	53	400	0	0	11.10	GI164	SS38A
	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..									

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	HXX 5	—	—	—
SS25	US 8025-T30P	13.0	M 8	24.2	SSN 250620	MS 8020	—	HXX 5	SDRT30P	—	—
SS38A	US 8025-T30P	13.0	M 8	24.2	SSN 380920	MS 8020	—	HXX 5	SDRT30P	—	—

SSDCN EXT



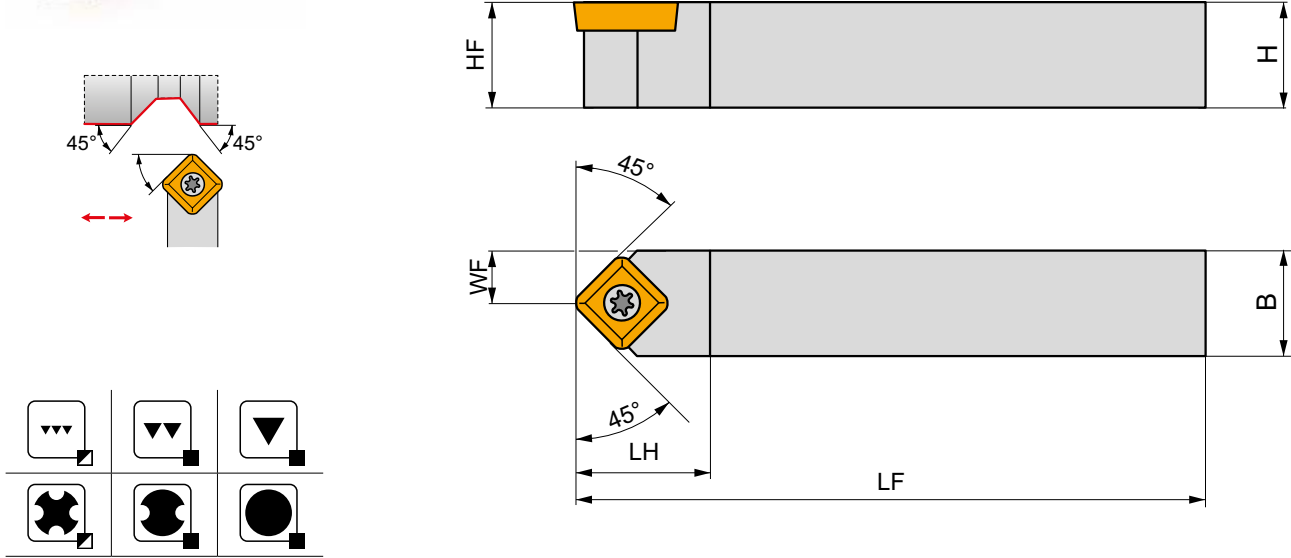
PRAMET

S



Utvendig verktøyholder med 45 ° skjærevinkel for SC .. Skjær

Utvendig nøytral verktøyholder for positive SC .. 09 eller 12 skjær. Egnet for utvendig langsgående dreiging uten skulder, form, konisk og fasing. Tilgjengelig med skaftstørrelse 12x12 opp til 25x25 mm. Behandlet for lengre levetid.



Product		H	B	HF	WF	LF	LH	LAMS	GAMO			
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
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..										

								
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

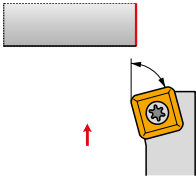
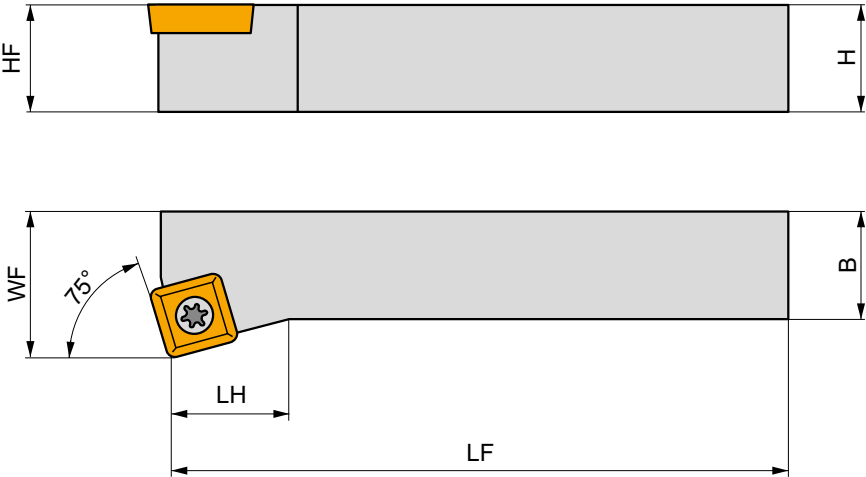
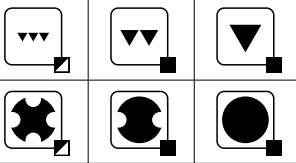
N

S

H

PRAMET

S


Product		H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	SSKCR 1212 F 09	12	12	12	16	80	32	0	0	0.10	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..

								
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)



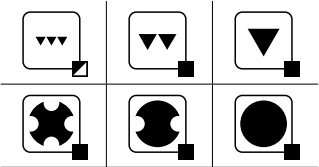
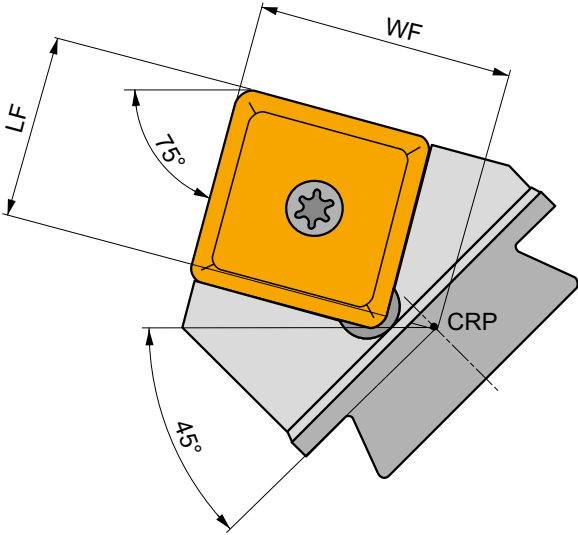
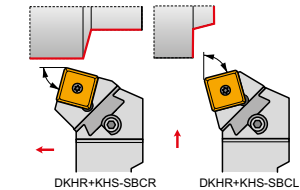
PRAMET

S



Modulær dreiepatron KHS låsespor med skruefeste, 75 ° skjærevinkel for SC .. Skjær

Koblingshus høyre / venstre dreiepatron, 75 ° skjæringsvinkel, for montering på DKH verktøyholder. Egnet for kraftig langsgående sving uten skulder, ansiktsvending, konisk og avfasing med positive SC .. 25 eller 38 skjær Verktøyholder behandlet for lengre levetid.



Product		WF	LF	LAMS	GAMO	kg		
		(mm)	(mm)	(°)	(°)			
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

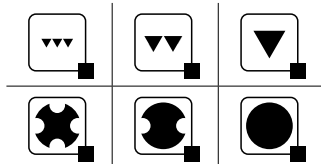
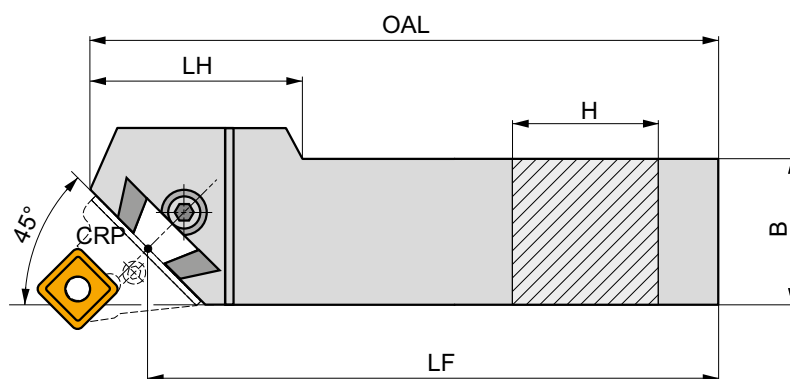
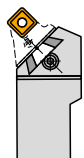
GI131	SC.. 2509..
GI164	SC.. 3809..

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)

**Utvendig verktøyholderskaff for KHP / KHS Grove dreiepatroner**

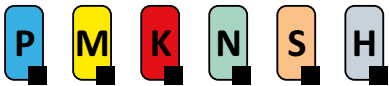
Koblingshus høyre / venstre hånds verktøyskaff for KHP / KHS-kassetter. Egnet for tunge dreie applikasjoner. Tilgjengelig med skaftstørrelse 40x50 opp til 60x80 mm. Behandlet for lengre levetid.



	Product	H	B	LF	OAL	LH	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)			
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	HXX 10

SSSC(RL) INT



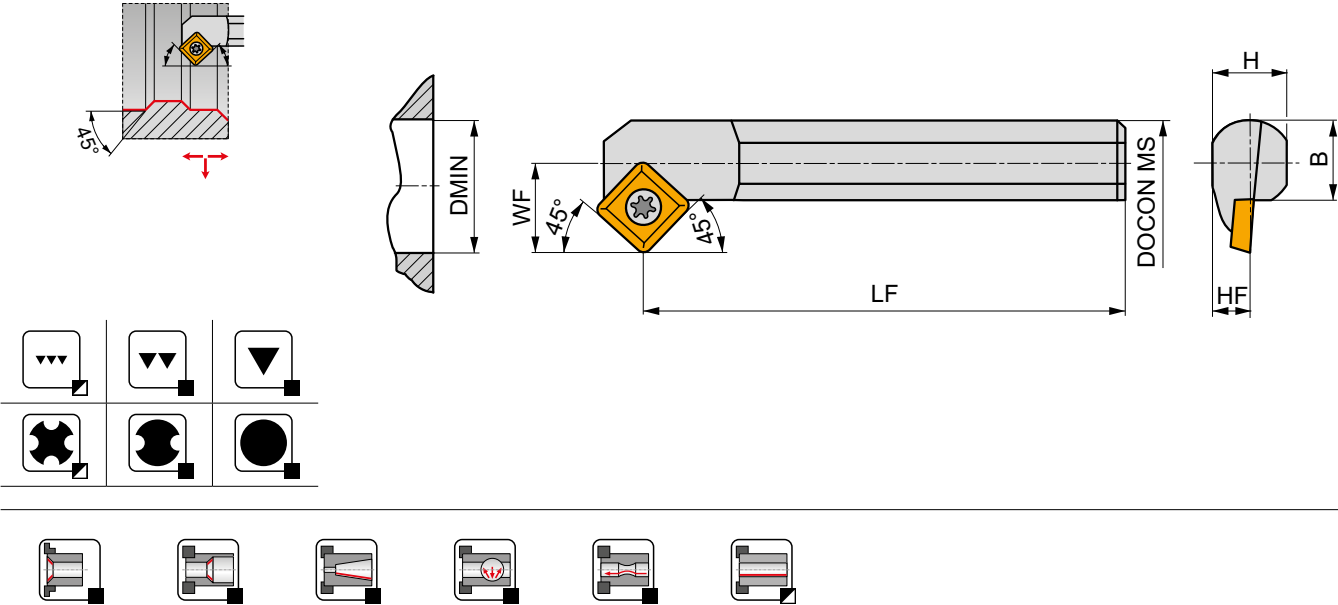
PRAMET

S



Innvendig dreiebom med 45 ° skjærevinkel for SC .. skjær

Innvendig høyre/venstre dreiebom med 45° skjærevinkel for SC .. 09 skjær. Minimum innvendig dreiediameter Ø25 mm. For innvendig bakfasning, konisk, multi-dreieretninger, faset og langsgående dreing uten skulder. Finnes med skaftstørrelse Ø20 opp til Ø25 mm. Behandlet for lengre levetid.



Product	DOCON MS	DMIN	WF	H	B	LF	LAMS	GAMO	kg		
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
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..
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S04	US 3510-T15P	3.0	M 3.5	10.6	FLAGT15P
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SP

09/ 12/ 15/ 19/ 25

CARBIDE INSERTS

SPMR



 146

SPUN



 146

CER INSERTS

SPGN CER

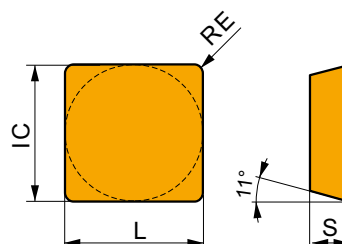


 147

SPMR

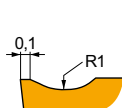


	IC (mm)	L (mm)	S (mm)
0903	9.525	9.53	3.18
1203	12.700	12.70	3.18



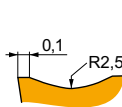
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product	RE (mm)	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)



Geometri 46 for finbearbeiding og kontinuerlig til avbrutt kutt.

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	—	—	—	—	—	—	—	—



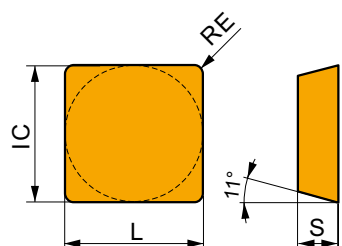
Geometri 48 for ferdig til halv-grov bearbeiding, og kontinuerlig til avbrutt kutt.

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

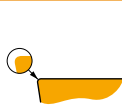


	IC (mm)	L (mm)	M (mm)	S (mm)
1203	12.700	12.70	2	3.18
1504	15.875	15.88	3	4.76
1904	19.050	19.05	3	4.76
2506	25.400	25.40	4	6.35



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product	RE (mm)	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)



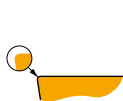
For fin til halv-grov bearbeiding og kontinuerlige til lett avbrutte kutt.

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	—	—	—	—	—	—	—	—

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
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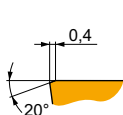
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	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)



For fin til halv-grov bearbeiding og kontinuerlige til lett avbrutte kutt.

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	■	—	—	—	—	—	—



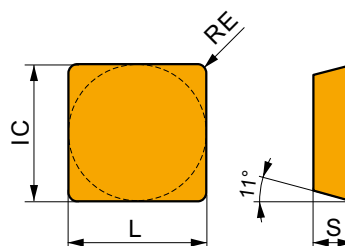
For fin til halv-grov bearbeiding og kontinuerlige til lett avbrutte kutt.

SPUN 250620S	6640	2.0	■	80	0.40	12.0	■	—	—	—	■	75	0.40	12.0	■	—	—	—	—	—	—
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SPGN CER

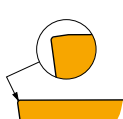
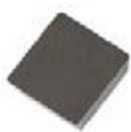


	IC (mm)	L (mm)	S (mm)
1203	12.700	12.70	3.18



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	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)



For maskinering med høye hastigheter og kontinuerlige kutt.

SPGN 120308 T01020	TC100	0.8	■	—	—	—	■	—	—	—	■	530	0.20	1.5	■	—	—	—	—	—	—
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TC

06/ 09/ 11/16

CARBIDE INSERTS

TCGT	TCMT	TCMW
		
 149	 150	 154

CBN INSERTS

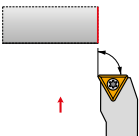
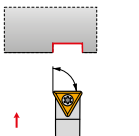
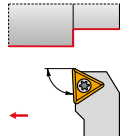
TCGW CBN

 154

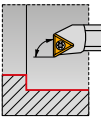
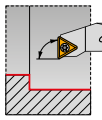
MATCH THE RIGHT SIZE (example)

Insert	Tool Holder
TCMT 110204E-FF2	STFCR 1616 H 11

ISO DREIING – EKSTERN

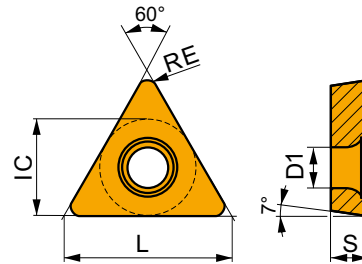
STFC(RL) EXT	STFC(RL)-A EXT	STJC(RL) EXT
90°   155	90°   156	93°   157
TC..  11 16  149 – 154	TC..  11  149 – 154	TC..  11 16  149 – 154
 16×16 25×25	 20×20	 16×16 25×25

ISO DREIING – INTERNT

STFC(RL) INT	STFC(RL)-E INT
90°   158	90°   160
TC..  06 09 11 16  149 – 154	TC..  06 09 11  149 – 154
 8,5 40	 8,5 20

TCGT

	IC	D1	L	S
	(mm)	(mm)	(mm)	(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



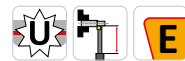
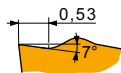
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

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)



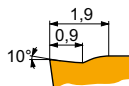
AL-geometri med svært positiv design for fin til grov bearbeiding, og kontinuerlige til lett avbrutte kutt.

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	—	—	—	—	—	—



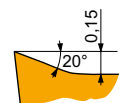
FF2-geometri med positiv design for fin til ferdig bearbeiding, og kontinuerlige til lett avbrutte kutt.

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	—	—	—	—	—	—	—	—
TCGT 090202E-FF2	TT010	0.2	295	0.05	0.5	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	TT010	0.2	295	0.05	0.5	—	—	—	—	—	—	—	—	—	—	—	—	—	—



NF1-geometri med positiv design for finbearbeiding til middels bearbeiding og kontinuerlige kutt.

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
	T7325	0.4	180	0.10	0.8	140	0.09	0.8	—	—	—	—	—	—	55	0.08	0.6	—	—



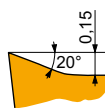
SF3-geometri med meget positiv design for finbearbeiding og kontinuerlige kutt.

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
	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
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
	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

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
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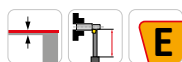
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product	RE (mm)	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(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)



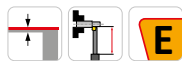
SF3-geometri med meget positiv design for finbearbeiding og kontinuerlige kutt.

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 positiv høyrehendt design for finbearbeiding og kontinuerlige kutt.

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	—	—	—



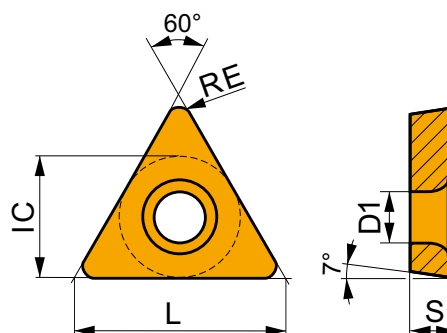
EL-SI geometri med positiv venstrehendt design for finbearbeiding og kontinuerlige kutt.

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

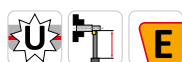
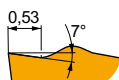
PRAMET

	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



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product	RE (mm)	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(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)



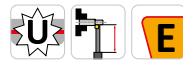
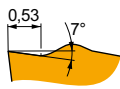
FF2-geometri med positiv design for fin til ferdig bearbeiding, og kontinuerlige til lett avbrutte kutt.

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	—	—	—	—	—	—	—	—

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
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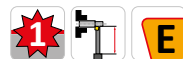
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

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)



FF2-geometri med positiv design for fin til ferdig bearbeiding, og kontinuerlige til lett avbrutte kutt.

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		–	–	–		–	–	–
TCMT 110204E-FF2	T9325	0.4	■	215	0.12	1.0		–	–	–	✓	200	0.12	1.0		–	–	–		–	–	–
	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		–	–	–		–	–	–
TCMT 110208E-FF2	T9325	0.4	■	220	0.12	0.8		–	–	–	✓	205	0.12	0.8		–	–	–		–	–	–
	T9335	0.4	■	185	0.12	0.8		–	–	–		–	–	–		–	–	–		–	–	–
	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		–	–	–		–	–	–
TCMT 16T304E-FF2	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		–	–	–		–	–	–
	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		–	–	–		–	–	–
TCMT 16T308E-FF2	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		–	–	–		–	–	–		–	–	–		–	–	–
	T7325	0.8	✓	180	0.17	0.8		–	–	–		–	–	–		–	–	–		–	–	–
TCMT 16T308E-FF2	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		–	–	–		–	–	–		–	–	–		–	–	–



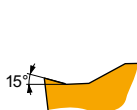
FM-geometri for fin til halv-grov bearbeiding, og kontinuerlige til lett avbrutte kutt.

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		–	–	–
TCMT 110204E-FM	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		–	–	–		–	–	–
	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		–	–	–
TCMT 110204E-FM	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		–	–	–		–	–	–

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
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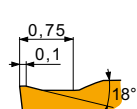
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(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)



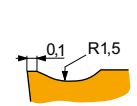
FM-geometri for fin til halv-grov bearbeiding, og kontinuerlige til lett avbrutte kutt.

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	—	—	—	—	—	—	—	—	—



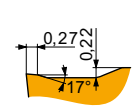
FM2 geometri for fin til middels bearbeiding, og kontinuerlig til avbrutt kutt.

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 for halv-grov til grov bearbeiding, og kontinuerlig til avbrutt kutt.

TCMT 16T308E-RF	T9325	0.8	175	0.20	1.5	105	0.18	1.5	165	0.20	1.5	—	—	—	—	—	—	—	—	—
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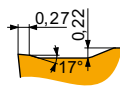
RM-geometri for halv-grov til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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	—	—	—	—	—	—

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
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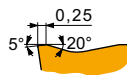
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

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



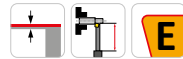
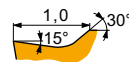
RM-geometri for halv-grov til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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 for halv-grov til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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 for finbearbeiding og kontinuerlige til lett avbrutte kutt.

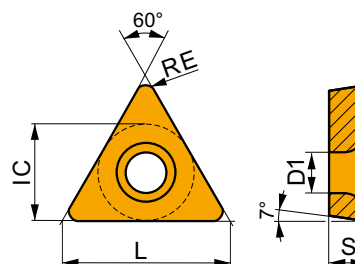
TCMT 110204E-UR	T7325	0.4	135	0.19	0.8	105	0.17	0.8	—	—	—	—	—	—	—	—	—	—	—	—
	T8330	0.4	135	0.12	0.8	80	0.11	0.8	125	0.12	0.8	—	—	—	—	—	—	—	—	—
	T8430	0.4	170	0.12	0.8	90	0.11	0.8	135	0.12	0.8	—	—	—	—	—	—	—	—	—
	T9315	0.4	235	0.12	0.8	—	—	—	220	0.12	0.8	—	—	—	—	—	—	—	—	—
	T9325	0.4	175	0.18	0.8	105	0.16	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	—	—	—	—	—	—	—	—	—

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
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TCMW

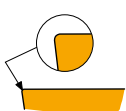
PRAMET

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



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere 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)



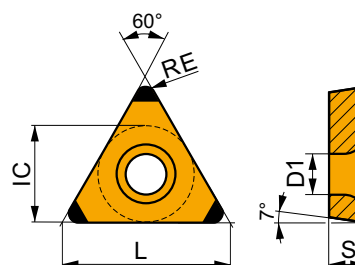
For fin til halv-grov bearbeiding og kontinuerlige til lett avbrutte kutt.

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

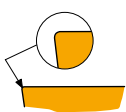
PRAMET

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



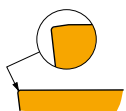
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

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)



For ferdig bearbeiding og kontinuerlige kutt.

TCGW 110204E-C	TB310	0.4	—	—	—	—	—	—	390	0.10	0.4	—	—	—	100	0.07	0.3	80	0.15	1.0
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For ferdig bearbeiding og kontinuerlige kutt.

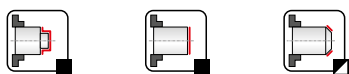
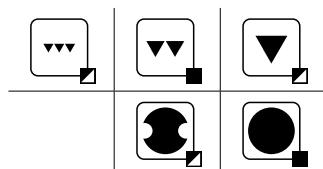
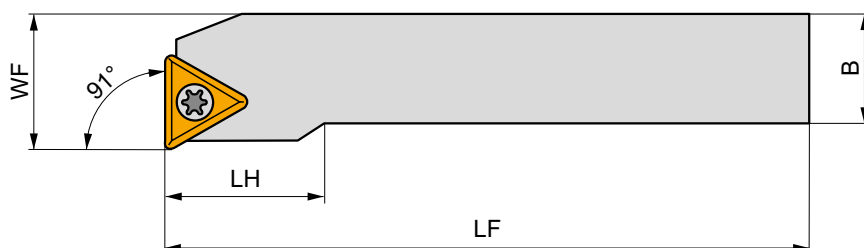
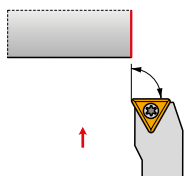
TCGW 110204S01020C	TB310	0.4	—	—	—	—	—	—	390	0.10	0.4	—	—	—	100	0.07	0.3	80	0.15	1.0
TCGW 110208S01020C	TB310	0.8	—	—	—	—	—	—	400	0.15	0.6	—	—	—	105	0.11	0.5	85	0.15	1.0

STFC(RL) EXT

PRAMET

S**Utv. dreieholder, 91° (overflatedreining) Skjærevinkel for TC .. Skjær**

Utvendig høyre/venstre hånd dreieholder for positiv TC .. 11 opptil 16 skjær. Passer for utvendig overflatedreining med skulder- og fasing. Tilgjengelig med skaftstørrelse 16x16 opp til 25x25 mm. Behandlet for lengre levetid.



Product		H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	STFCR 1616 H 11	16	16	16	20	100	18	0	0	0.20	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..



S01

US 2506-T07P

0.9

M 2.5

6.3

—

—

FLAGT07P

—

ST10

US 3510-T15P

3.0

M 3.5

10.6

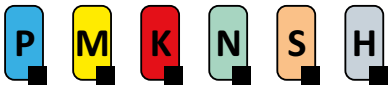
STN 160308

MS 3510

FLAGT15P

HXK 3.5

STFC(RL)-A EXT



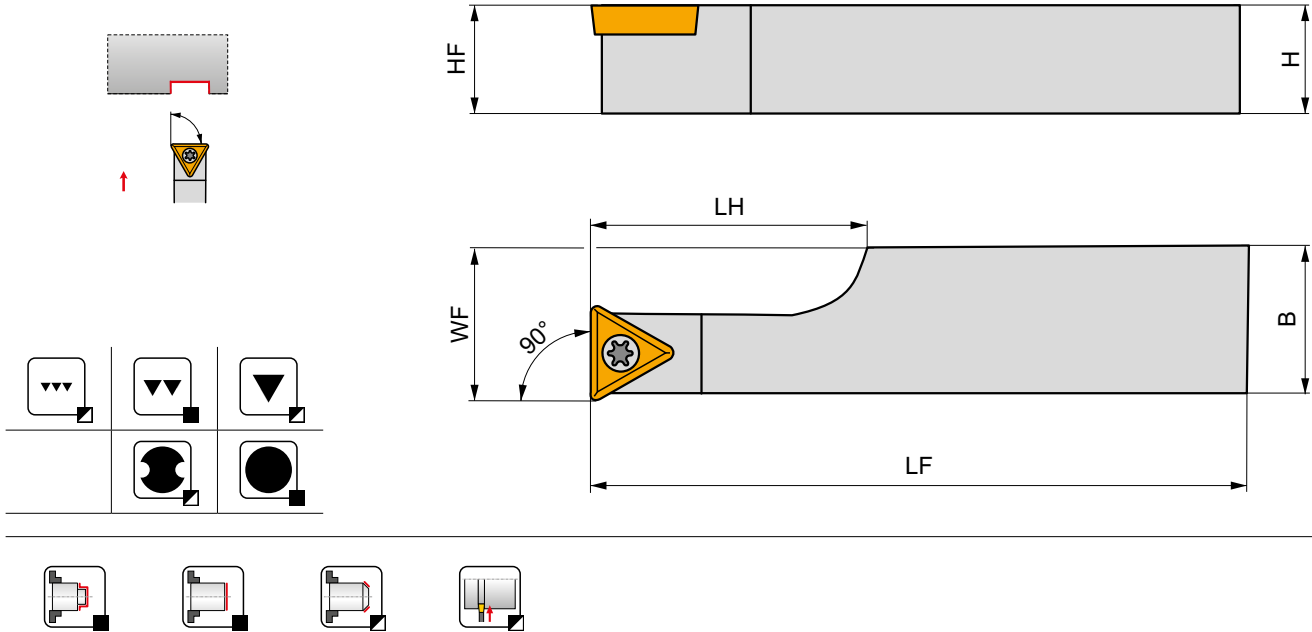
PRAMET

S



Utv. Dreieholder, 90 ° (overflatedreiging) Skjærevinkel for TC .. Skjær

Utvendig høyre/venstre hånd dreieholder for positiv TC .. 11 skjær. Passer for venstre- og høyresidig utvendig overflatedreiging med skulder- og fasing. Tilgjengelig med skaftstørrelse 20x20 mm. Behandlet for lengre levetid.



Product		H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
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..
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ST21	5513 020-03	0.8	M 2.5	6.5	PT-8001
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STJC(RL) EXT



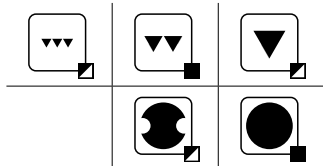
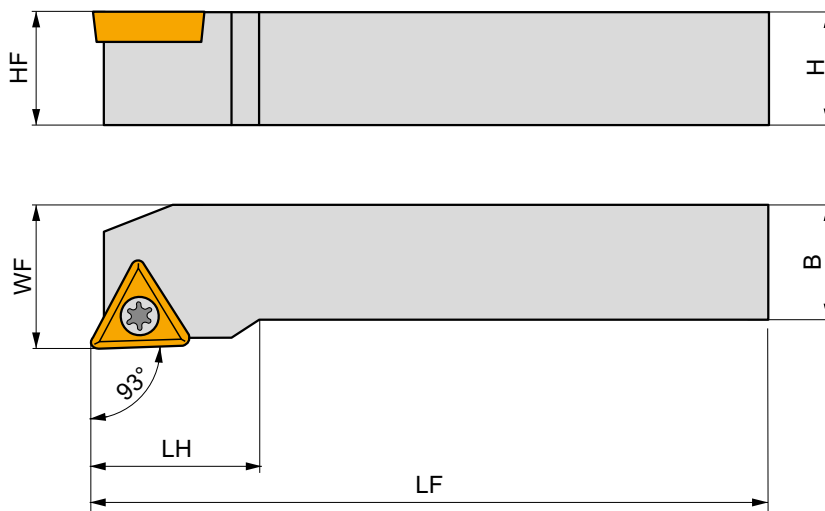
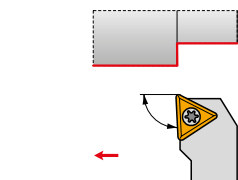
PRAMET

S



Utvendig dreieholder med 93° skjærevinkel for TC.. Skjær

Utvendig høyre/venstre hånd dreieholder for positiv TC.. 11 opptil 16 skjær. Passer for utvendig langsgående dreining med skulder-, konisk- og fasedreining. Tilgjengelig med skaftstørrelse 16x16 opp til 25x25 mm. Behandlet for lengre levetid.



Product		H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
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..	

STFC(RL) INT

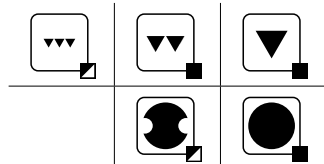
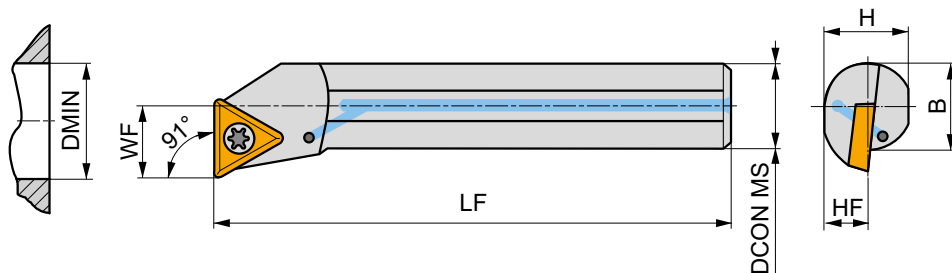
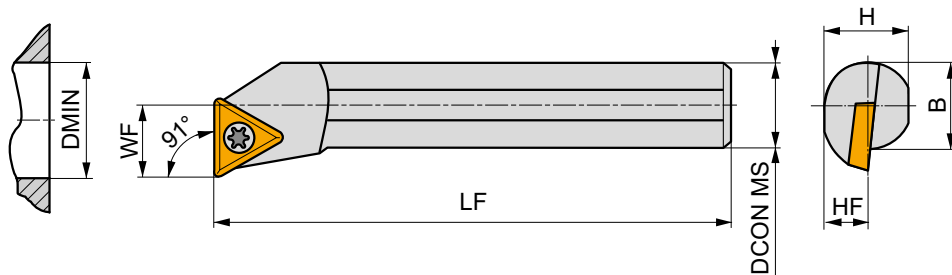
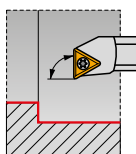


PRAMET

S

Innvendig dreiebom med 91° skjærevinkel for TC .. Skjær

Innvendig høyre/venstre dreiebom, tilgjengelig med innvendig kjøling, 91° skjærevinkel for TC .. 06 opptil 16 skjær. Minimum innvendig dreiediameter Ø8,5 mm. Passer for innvendig konisk og langsgående dreining med skulder- og fasing. Ø6 til Ø32 mm skaft tilgjengelig. Behandlet for lengre levetid.



Product	DCON MS	DMIN	WF	H	B	LF	LAMS	GAMO					
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)		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

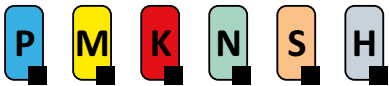
CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
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Product	DCON MS	D MIN	WF	H	B	LF	LAMS	GAMO				
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)		kg		
L	S25T-STFCL 16	25	32	17	23	23	300	-3	0	—	1.15	GI016 S08
	A32S-STFCL 16	32	40	22	30	30	250	-10	0	✓	1.36	GI016 ST10
	S32U-STFCL 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..

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	HXX 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



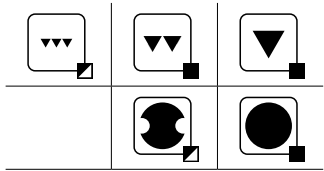
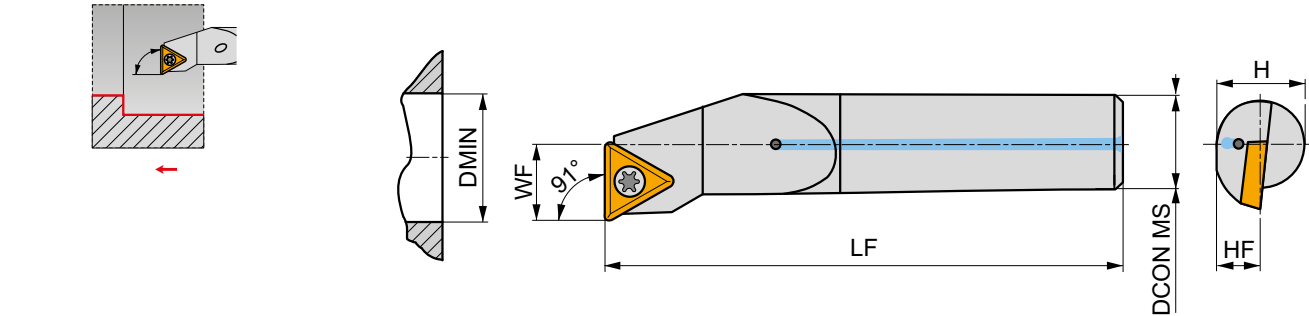
PRAMET

S



Innvendig hardmetall dreiebom med 91° skjærevinkel for TC ..skjær

Innvendig høyre/venstre dreiebom, med innvendig kjøling, med 91° skjærevinkel for TC .. 06 opptil 11 skjær. Minimum innvendig dreiediameter Ø8,5 mm. For innvendig konisk og langsgående dreiring med skulder- og fasing. Finnes med skaftstørrelse Ø6 opp til Ø16 mm. For verktøyoverheng> 3xD.



Product	DCON MS	DMIN	WF	H	HF	LF	LAMS	GAMO		kg		
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)				
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		GI217		GI218		TC.. 1102..		TC.. 06T1..		TC.. 0902..	
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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

CARBIDE INSERTS

TPGX	TPMR	TPUN
		
 162	 163	 164

CER INSERTS

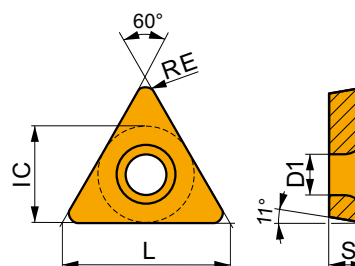
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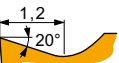
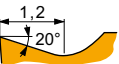
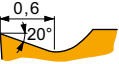
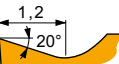
TPGX



	IC	D1	L	S
	(mm)	(mm)	(mm)	(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



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

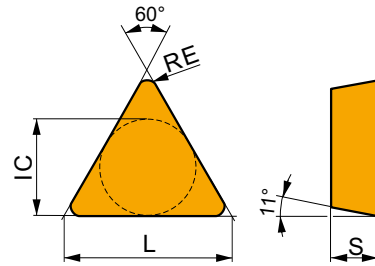
Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
																				
FR-JQ geometri med positiv høyrehendt design for finbearbeiding og kontinuerlige kutt.																				
TPGX 110204FR-JQ	TT010	0.4	 295	0.06	0.5	 175	0.05	0.5												
																				
FL-JQ geometri med positiv venstrehendt design for finbearbeiding, kontinuerlige kutt.																				
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 positiv venstrehendt design for finbearbeiding og kontinuerlige kutt.																				
TPGX 16T304FL-JR	TT010	0.4	 295	0.06	0.5	 175	0.05	0.5												
																				
FR-JZ geometri med positiv høyrehendt design for finbearbeiding og kontinuerlige kutt.																				
TPGX 090202FR-JZ	TT010	0.2	 280	0.06	0.5	 165	0.05	0.5												
																				
FL-JZ geometri med positiv venstrehendt design for finbearbeiding og kontinuerlige kutt.																				
TPGX 090202FL-JZ	TT010	0.2	 280	0.06	0.5	 165	0.05	0.5												

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
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TPMR

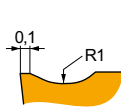


	IC (mm)	L (mm)	S (mm)
1103	6.350	11.00	3.18
1603	9.525	16.50	3.18



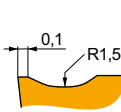
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product	RE (mm)	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)



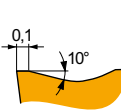
Geometri 46 for finbearbeiding og kontinuerlig til avbrutt kutt.

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	—	—	—	—	—	—	—	—	—	—	—



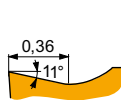
Geometri 47 for fin til halv-grov bearbeiding, og kontinuerlig til avbrutt kutt.

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 for ferdigbearbeiding med moderat mating og skjæredybde, og kontinuerlige til avbrutte kutt.

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	—	—	—	—	—	—	—	—	—	—	—



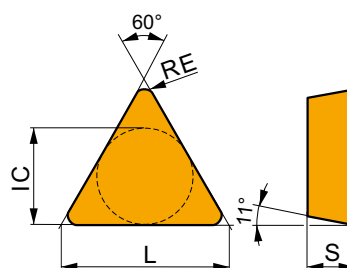
PF2-geometri for finbearbeiding og kontinuerlige kutt.

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

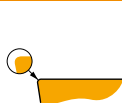


	IC (mm)	L (mm)	S (mm)
1103	6.350	11.00	3.18
1603	9.525	16.50	3.18
2204	12.700	22.00	4.76
2706	15.875	27.50	6.35
3306	19.050	33.00	6.35



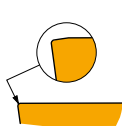
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

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)



For fin til halv-grov bearbeiding og kontinuerlige til lett avbrutte kutt.

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	—	—	—	—	—	—



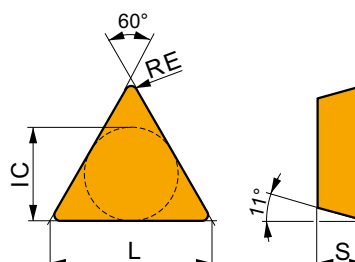
For fin til halv-grov bearbeiding og kontinuerlige til lett avbrutte kutt.

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

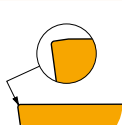


	IC (mm)	L (mm)	S (mm)
1103	6.350	11.00	3.18
1603	9.525	16.50	3.18



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere 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)



For maskinering med høye hastigheter og kontinuerlige kutt.

TPGN 110304 T01020	TC100	0.4	—	—	—	—	—	—	460	0.10	1.5	—	—	—	—	—	—
TPGN 110308 T01020	TC100	0.8	—	—	—	—	—	—	425	0.20	1.5	—	—	—	—	—	—

Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	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)



For maskinering med høye hastigheter og kontinuerlige kutt.

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

11/ 16

CARBIDE INSERTS

VBMT



168

CBN INSERTS

VBGW CBN



171

MATCH THE RIGHT SIZE (example)

Insert

Tool Holder

VBMT 160408E-FM

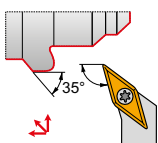
SVHCR 2020 K 16-M-A

ISO DREIING – EKSTERN

SVHB(C)(RL) EXT

107°30′

VB, VC..

11
16
 16×16
25×25

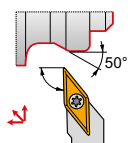
172

 168 – 171
186 – 192

SVJB(C)(RL) EXT

93°

VB, VC..

11
13
16
 12×12
32×25

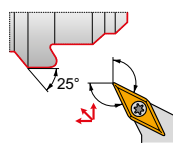
173

 168 – 171
186 – 192

SVPB(C)(RL) EXT

117°30′

VB, VC..

11
16
 16×16
32×25

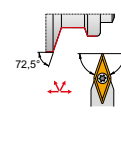
174

 168 – 171
186 – 192

SVVB(C)N EXT

72°30′

VB, VC..

11
13
16
 12×12
32×25

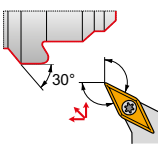
175

 168 – 171
186 – 192

SVXB(C)(RL) EXT

98°

VB, VC..

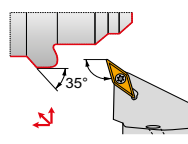
11
13
16
 12×12
32×25

176

 168 – 171
186 – 192
C.-SVHB(RL) EXT **NEW**

107°30′

VB, VC..



16

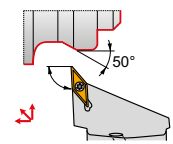
 C4
C6

177

 168 – 171
186 – 192
C.-SVJB(RL) EXT **NEW**

93°

VB, VC..

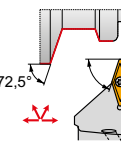
11
16
 C3
C6

178

 168 – 171
186 – 192
C.-SVVB(N) EXT **NEW**

72°30′

VB, VC..



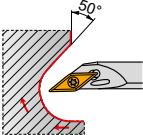
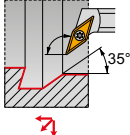
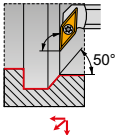
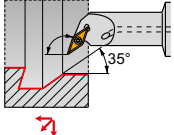
16

 C4
C6

179

 168 – 171
186 – 192

ISO DREIING – INTERNT

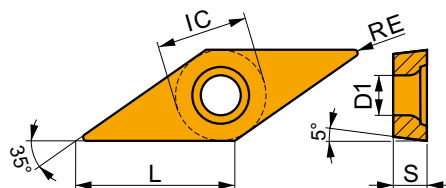
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93°	VB, VC..	107°30´	VB, VC..	93°	VB, VC..	108°	VB, VC..
	 11		 11 13 16		 11 13 16		 16
 ØDmin 25 32		 ØDmin 20 50		 ØDmin 20 50		 ØDmin 33	
 180	 168 – 171 186 – 192	 181	 168 – 171 186 – 192	 182	 168 – 171 186 – 192	 183	 168 – 171 186 – 192

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
----	----	----	----	----	----	----	----	----	----	----	----	----

VBMT

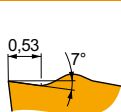


	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1102	6.350	2.80	11.10	2.38
1103	6.350	2.80	11.10	3.18
1604	9.525	4.40	16.60	4.76



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere 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)



FF2-geometri med positiv design for fin til ferdig bearbeiding, og kontinuerlige til lett avbrutte kutt.

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	—	—	—	—	—	—	—	—	—	—	—	—	—	—



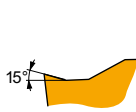
FM-geometri for fin til halv-grov bearbeiding, og kontinuerlige til lett avbrutte kutt.

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	—	—	—	—	—	—	—	—
	T9335	0.2	175	0.10	0.8	105	0.09	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	—	—	—	—	—	—	—	—
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	—	—	—	—	—	—	—	—
	T9335	0.8	175	0.17	0.8	105	0.15	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	—	—	—	—	—	—	—	—
	T9335	0.2	175	0.10	1.2	105	0.09	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	—	—	—	—	—	—	—	—
	T9335	0.4	175	0.19	1.2	105	0.17	1.2	—	—	—	—	—	—	—	—	—	—	—
	T9335	0.4	175	0.19	1.2	105	0.17	1.2	—	—	—	—	—	—	—	—	—	—	—

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
----	----	----	----	----	----	----	----	----	----	----	----	----

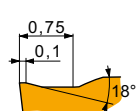
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	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)



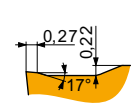
FM-geometri for fin til halv-grov bearbeiding, og kontinuerlige til lett avbrutte kutt.

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 for fin til middels bearbeiding, og kontinuerlig til avbrutt kutt.

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	—	—	—	—	—	—	—	—	—
VBMT 160408E-FM2	T9335	0.4	155	0.12	1.2	90	0.11	1.2	—	—	—	—	—	—	—	—	—	—	—	—
	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	—	—	—	—	—	—	—	—	—
VBMT 160412E-FM2	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	—	—	—	—	—	—	—	—	—	—	—	—
	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	—	—	—	—	—	—	—	—	—



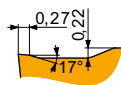
RM-geometri for halv-grov til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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	—	—	—

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
----	----	----	----	----	----	----	----	----	----	----	----	----

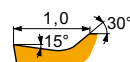
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

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



RM-geometri for halv-grov til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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	—	—	—



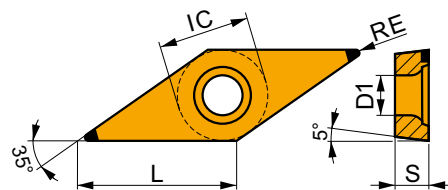
UR-geometri for finbearbeiding og kontinuerlige til lett avbrutte kutt.

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	—	—	—	—	—	—	—	—	—
VBMT 160402E-UR	TT310	0.4	195	0.12	0.8	115	0.11	0.8	—	—	—	—	—	—	—	—	—	—	—	—
	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	—	—	—	—	—	—	—	—	—
	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	—	—	—	—	—	—	—	—	—	—	—	—
VBMT 160404E-UR	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	—	—	—	—	—	—	—	—	—	—	—	—
	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	—	—	—	—	—	—	—	—	—
VBMT 160408E-UR	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	—	—	—	—	—	—	—	—	—	—	—	—
	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	—	—	—	—	—	—	—	—	—
VBMT 160412E-UR	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

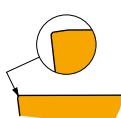


	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1604	9.525	4.50	16.00	4.76



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

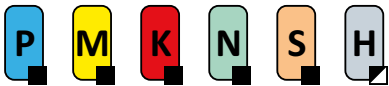
Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)



For ferdig bearbeiding og kontinuerlige kutt.

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



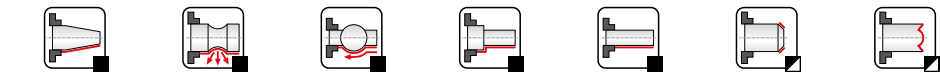
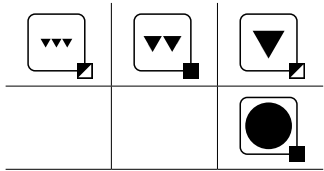
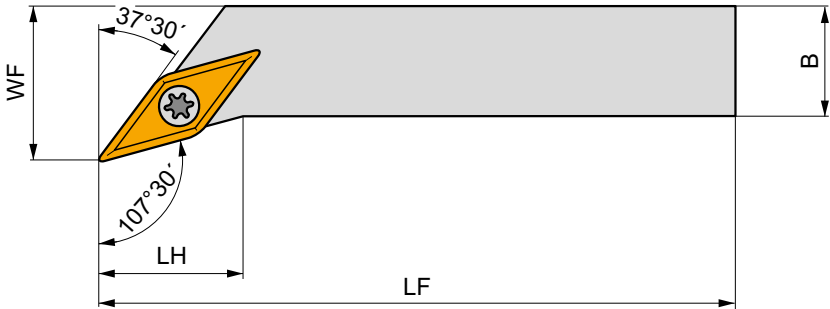
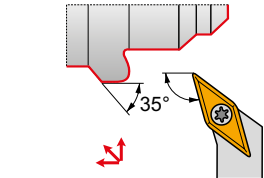
PRAMET

S



Utv. dreieholder med 107,5 ° skjærevinkel for VB/VC .. Skjær

Utvendig høyre/venstre hånd dreieholder for positiv VB .. 11 eller 16 og VC .. 11 eller 16 skjær. Passer for utvendig oerflate og langsgående dreieing med skulder-, konisk-, overflate- og langsgående kopi som dreier opp til 35 ° og fasing. Tilgjengelig med skaftstørrelse 16x16 opp til 25x25 mm. Behandlet for lengre levetid.



Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
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..			

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



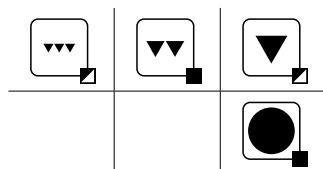
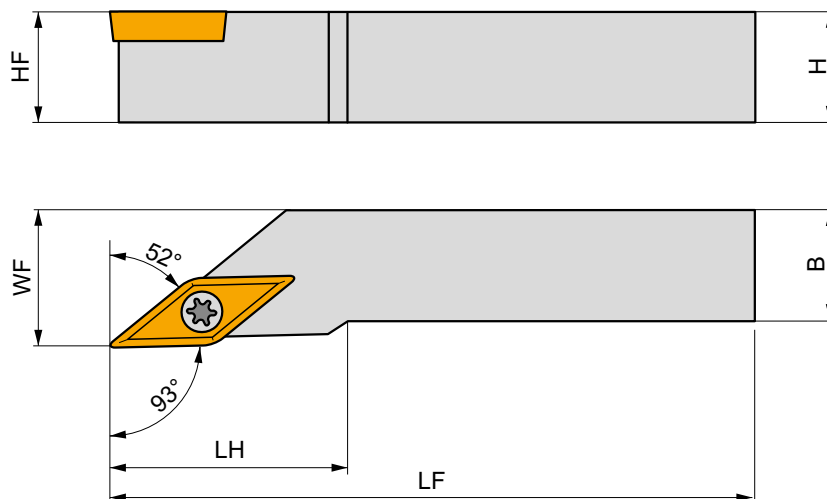
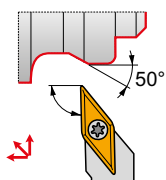
PRAMET

S



Utvendig dreieholder med 93° skjærevinkel for VB/VC .. Skjær

Utvendig høyre/venstre hånd dreieholder for positiv VB .. 11 eller 16 og VC .. 11 opptil 16 skjær. Passer for utvendig langsgående dreining med skulder, konisk, kopidreining opp til 50° og fasing. Tilgjengelig med skaftstørrelse 12x12 opp til 32x25 mm. Behandlet for lengre levetid.



Product		H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
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
L	SVJCR 3225 P 16-M-A	32	25	32	32	170	32	0	0	0.99	GI017	SV10
	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
GI194
GI211

VB.. 1604..
VB.. 1103..
—

VC.. 1604..
VC.. 1103..
VC.. 1303..



S01
SV10
SV21
SV22

US 2506-T07P
US 3512-T15P
5513 020-24
DVF 0573

0.9
3.0
1.5
1.5

M 2.5
M 3.5
M 3
M 3

6.3
12.6
8.5
10.3

—
SVN 160304
—
DAP 0331

—
MS 3510
—
DVT 0332

FLAG T07P
FLAG T15P
PT-8002
PT-8002

—
HXK 3.5
—
174.1-870

SVPB(C)(RL) EXT

P

M

K

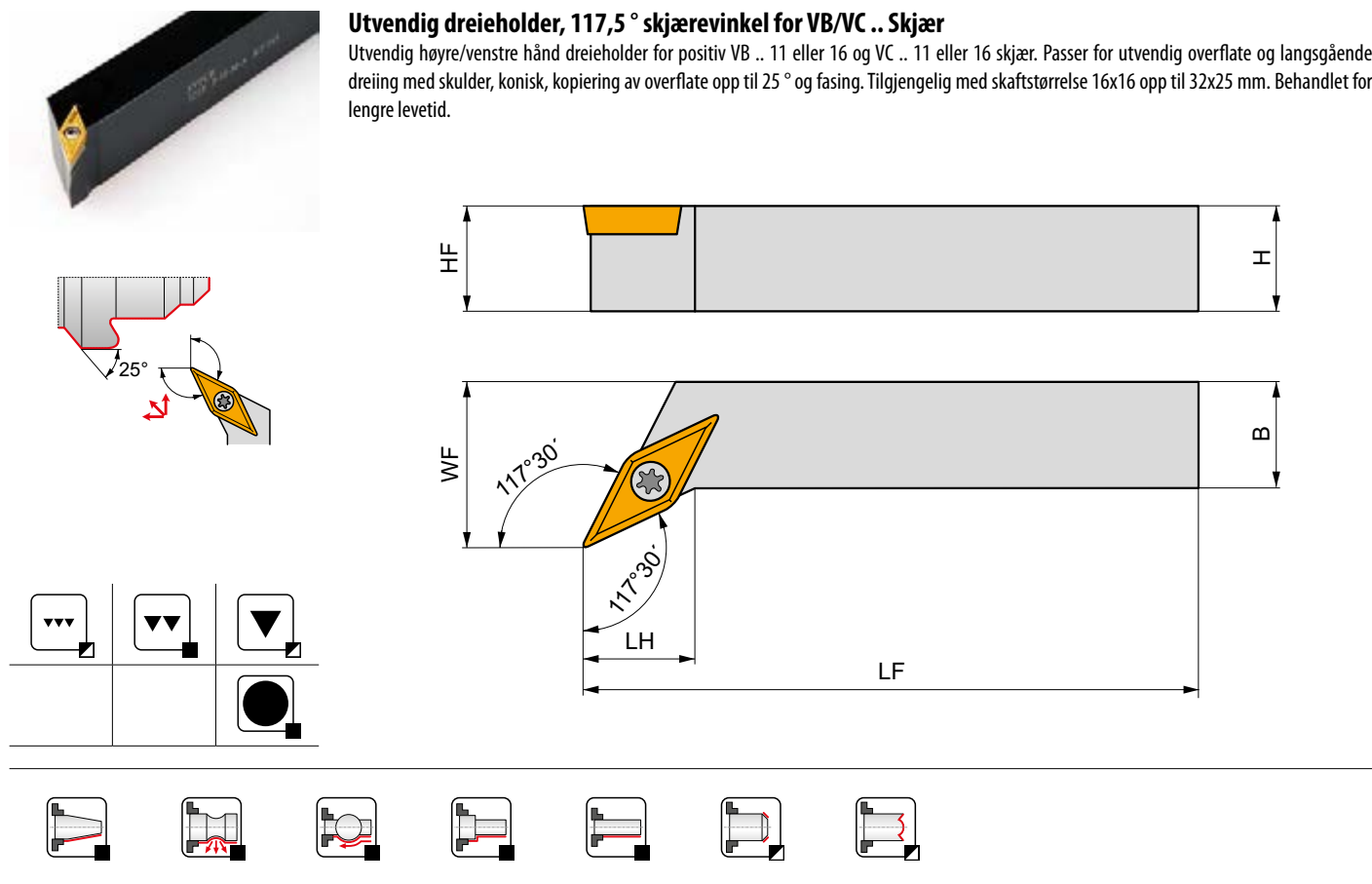
N

S

H

PRAMET

S



	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
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..			

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



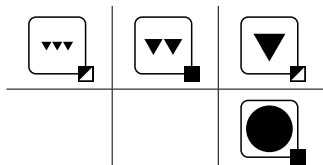
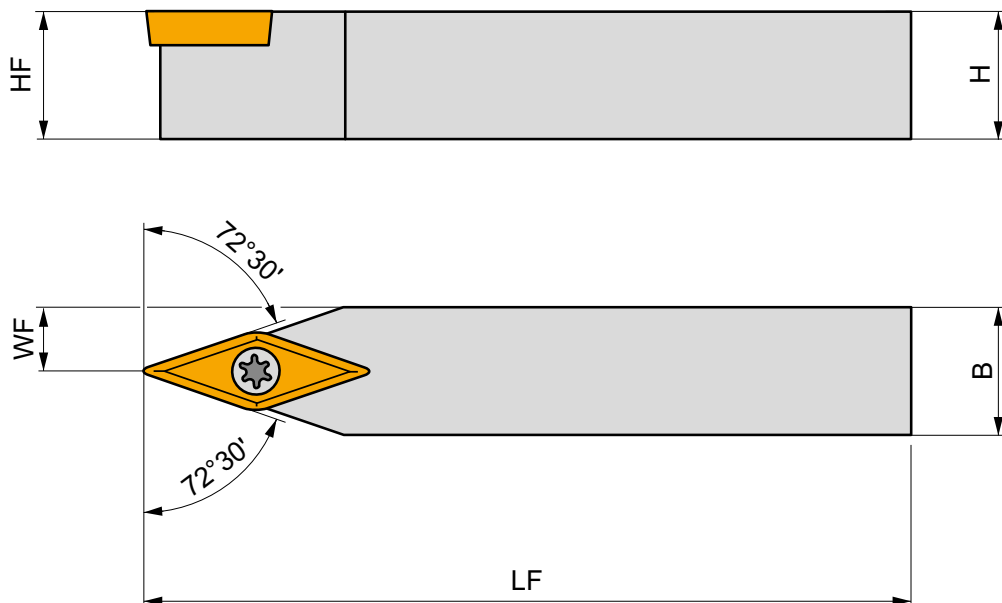
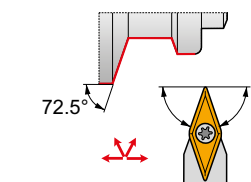
PRAMET

S



Utvendig verktøyholder, 72,5 ° skjærevinkel for VB / VC .. Skjær

Utvendig nøytral verktøyholder for positiv VB .. 11 eller 16 og VC .. 11 opp til 16 skjær. Egnet for utvendig langsgående dreining uten skulder, konisk, formdreining opp til 72,5 ° og fasing. Tilgjengelig med skaftstørrelse 12x12 opp til 32x25 mm. Behandlet for lengre levetid.



Product	H	B	HF	WF	LF	LH	LAMS	GAMO				
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)				
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..

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

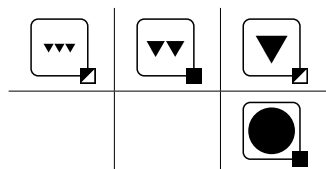
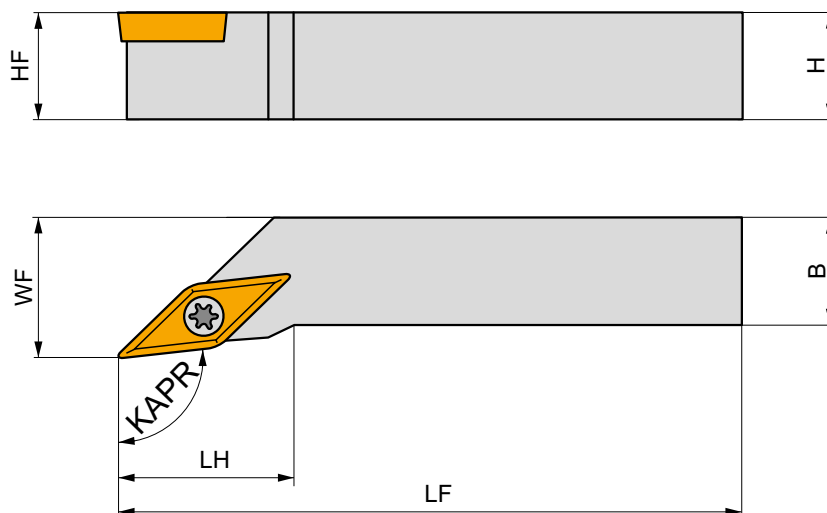
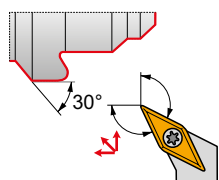


PRAMET

S

Utvendig dreieholder 98/113 ° skjærevinkel for VB/VC .. Skjær

Utvendig høyre/venstre hånd dreieholder for positiv VB .. 11 eller 16 og VC .. 11 opptil 16 skjær. Passer for utvendig langsgående dreining med skulder, konisk, kopidreining opp til 30 ° og fasing. Tilgjengelig med skaftstørrelse 12x12 opp til 32x25 mm. Behandlet for lengre levetid.



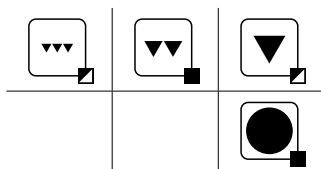
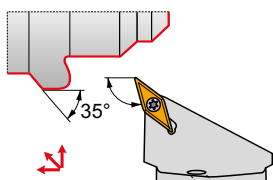
Product		H	B	HF	WF	LF	LH	KAPR	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)	(°)			
R	SVXBR 1212 F 11	12	12	12	16	80	20	98	0	0	0.09	GI194	S01
	SVXBR 1616 H 11	16	16	16	20	100	14	98	0	0	0.19	GI194	S01
	SVXCR 2020 K 13	20	20	20	25	125	12	113	0	0	0.38	GI211	SV22
	SVXCR 2020 K 16-M-A	20	20	20	25	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	S01
	SVXBL 1616 H 11	16	16	16	20	100	14	98	0	0	0.19	GI194	S01
	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..	

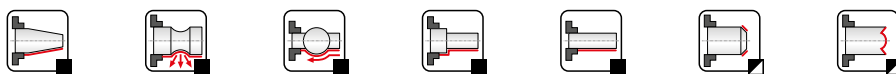
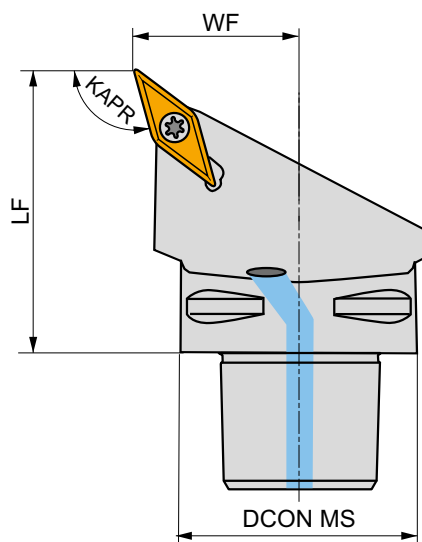
S01	US 2506-T07P	0.9	M 2.5	6.3	—	—	FLAG T07P	—	—
SV10	US 3512-T15P	3.0	M 3.5	12.6	SVN 160304	MS 3510	FLAG T15P	HXX 3.5	—
SV22	DVF 0573	1.5	M 3	10.3	DAP 0331	DVT 0332	PT-8002	174.1-870	—

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

PRAMET

S**Utv. PSC Quick Change dreieholder, 107,5° skjærevinkel, VB/VC .. Skjær**

Utvednig høyre/venstre hånd dreieholder, med innvendig kjøling, for positiv VB .. 16 og VC .. 16 skjær. Passer for utvendig langsgående dreining med skulder, konisk, kopidreining opp til 35° og fasing. Tilgjengelig med PSC (Polygon Shank Coupling) størrelse C4 opp til C6. Behandlet for lengre levetid.



	Product	DCON MS	WF	LF	KAPR	LAMS	GAMO		kg		
		(mm)	(mm)	(mm)	(°)	(°)	(°)				
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..	

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

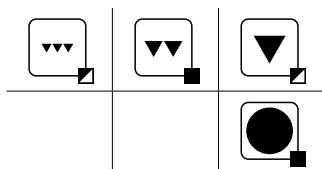
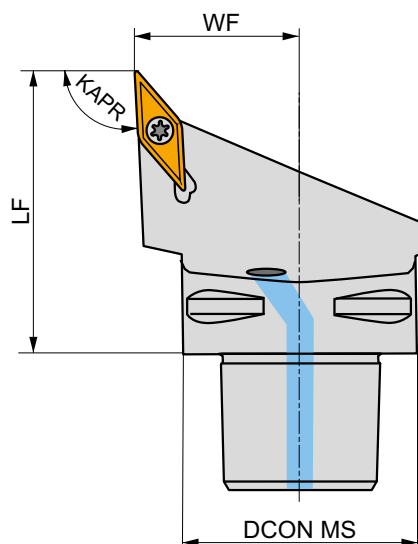
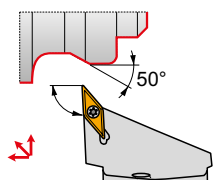
NEW

C.-SVJB(RL) EXT



PRAMET

S



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

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

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

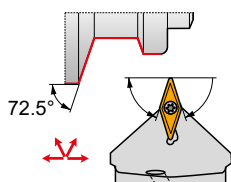
NEW

C-SVBN EXT



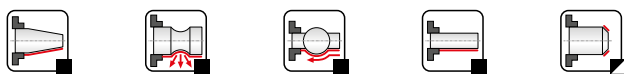
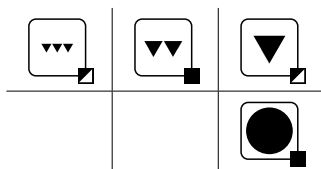
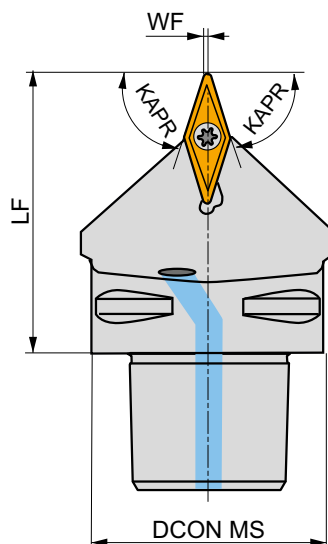
PRAMET

S



Utv. PSC hurtigvekslings holder, 72,5° skjærevinkel, VB / VC .. Skjær

Utvendig nøytral holder, Innvendig kjøling, for positive VB .. 16 og VC .. 16 skjær. Egnet for utvendig langsgående dreining uten skulder, konisk, formdreining på 72,5° og fasing. Tilgjengelig med PSC (Polygon Shank Coupling) størrelse C4 opp til C6. Behandlet for lengre levetid for verktøyet.

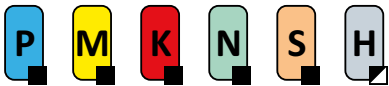


Product	DCON MS (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg		
N C4-SVBN-00050-16	40	0.6	50	72.5	0	0	✓	0.32	GI017	C-SV16S-1
C5-SVBN-00060-16	50	0.6	60	72.5	0	0	✓	0.56	GI017	C-SV16S-2
C6-SVBN-00065-16	63	0.6	65	72.5	0	0	✓	0.99	GI017	C-SV16S-2

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

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



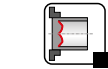
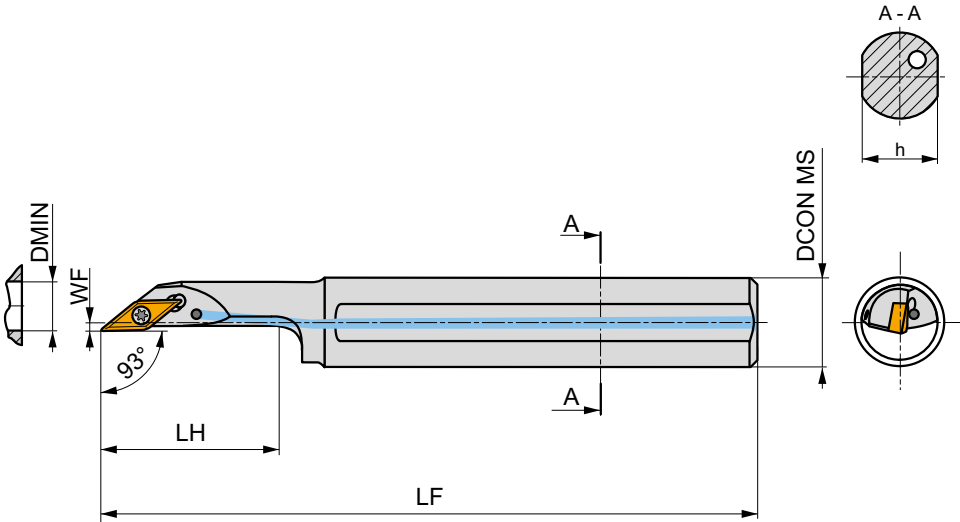
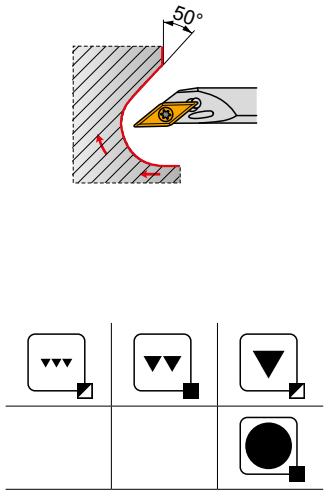
PRAMET

S



Innvendig dreiebom med 93 ° skjærevinkel for VB/VC .. skjær

Innvendig høyre/venstre dreiebom, med innvendig kjøling, med 93° skjærevinkel for VB .. 11 og VC .. 11 skjær. Minimum innvendig dreiediameter Ø25 mm. Passer for overflatekopi som skal dreies under 50°. Finnes med skaftstørrelse Ø20 og Ø25 mm. Behandlet for lengre levetid.



Product	DCON MS	DMIN	WF	H	LF	LH	LAMS	GAMO				
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)		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	M 2.5	6.3	FLAG T07P

SVQB(C)(RL) INT

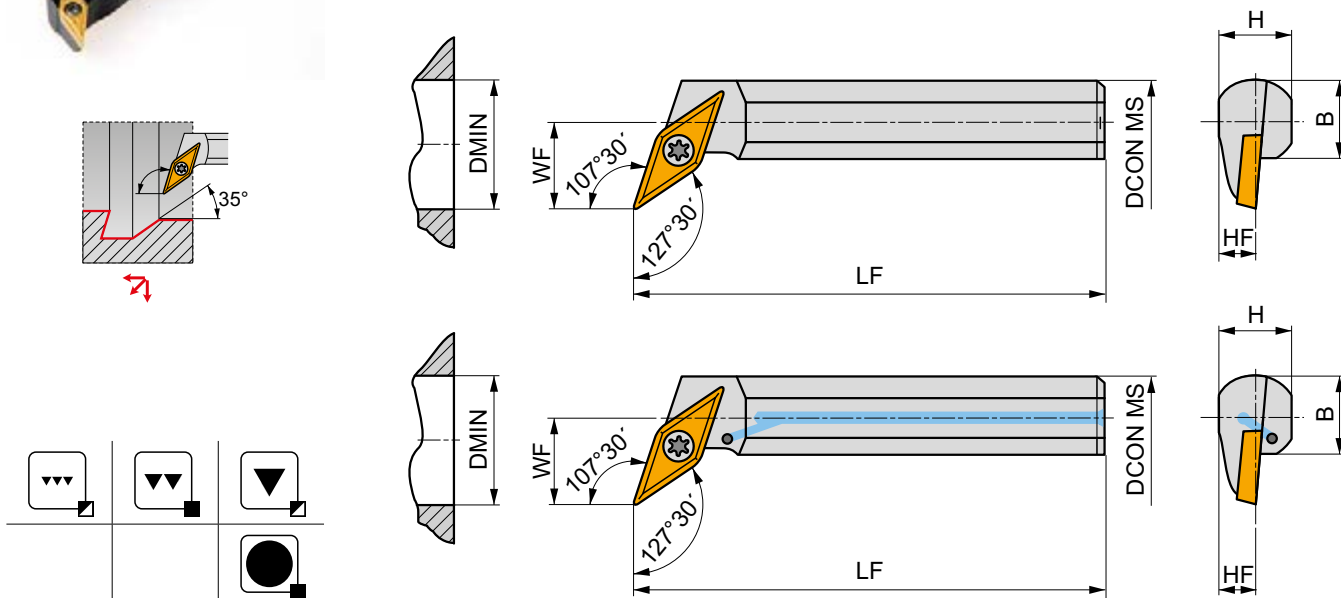


PRAMET

S

**Innvendig dreiebom med 107,5° skjærevinkel for VB/VC .. skjær**

Innvendig høyre/venstre dreiebom, tilgjengelig med innvendig kjøling, med 107,5° skjærevinkel for VB ../ VC .. 11 og 16 skjær. Minimum innvendig dreiediameter Ø20 mm. Passer for et bredt spekter av innvendige dreieoperasjoner. Finnes med skaftstørrelse Ø16 opp til Ø40 mm.



	Product	DCON MS	DMIN	WF	H	B	LF	LAMS	GAMO		kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)				
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..			

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



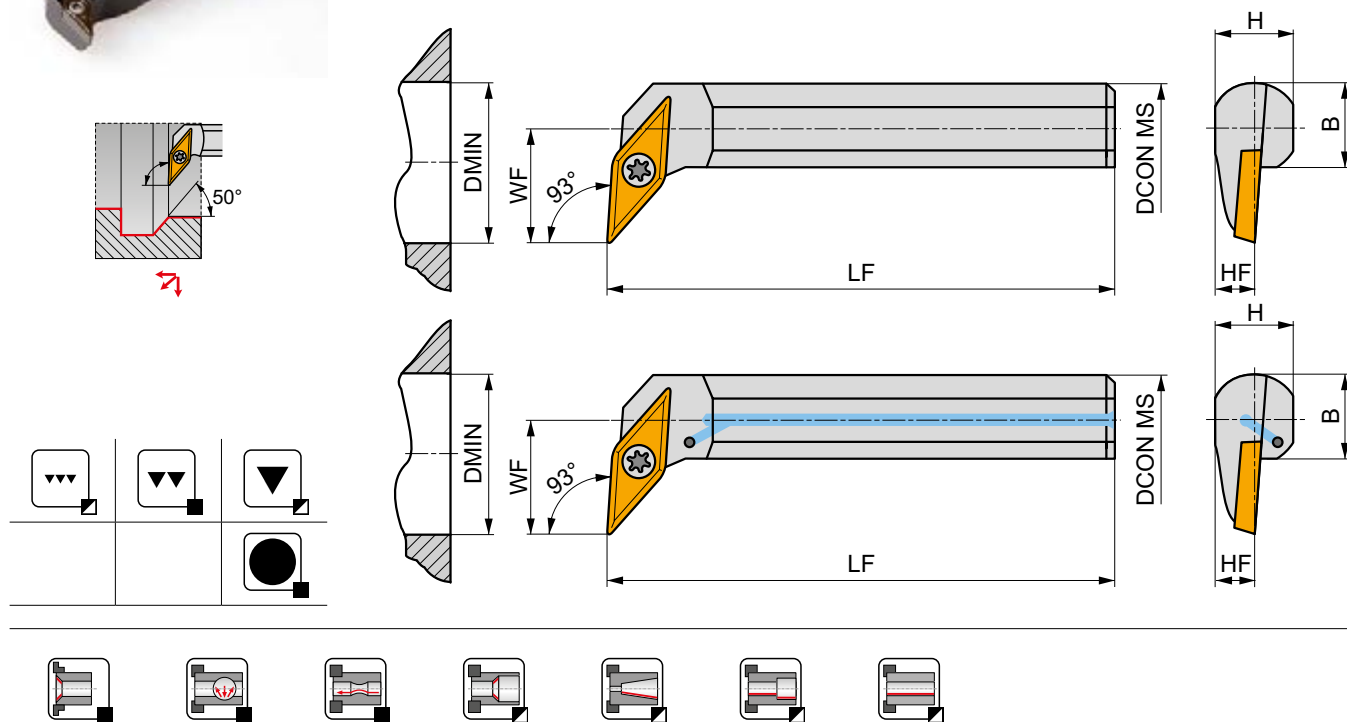
PRAMET

S



Innvendig dreiebom med 93 ° skjærevinkel for VB/VC .. Skjær

Innvendig høyre/venstre dreiebom, tilgjengelig med innvendig kjøling, med 93° skjærevinkel for VB ../VC .. 11 og 16 skjær. Minimum innvendig dreiediameter Ø20 mm. For et bredt spekter av innvendige dreieoperasjoner og kopiering under 50°. Ø16 opp til Ø40 mm skaft tilgjengelig. Behandlet for lengre levetid.



Product	DCON MS	DMIN	WF	H	B	LF	LAMS	GAMO		kg		
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)				
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..			

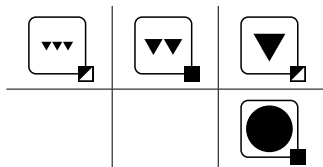
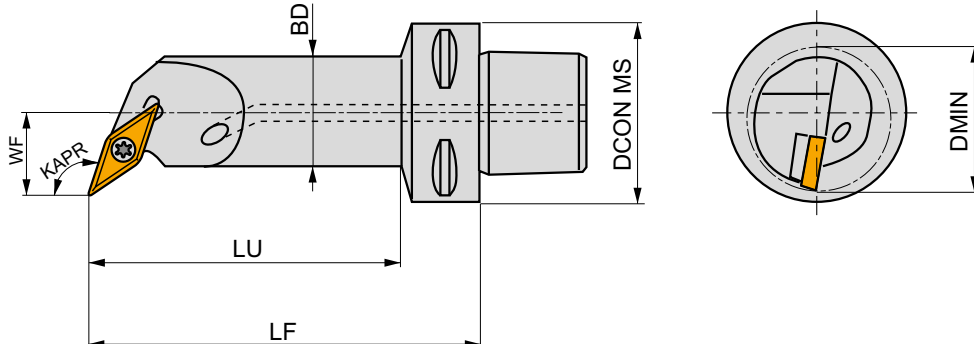
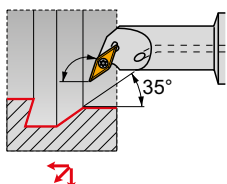
S01	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–				
S08	US 3510-T15P	3.0	M 3.5	10.6	–	–	FLAG T15P	–				
SV10	US 3512-T15P	3.0	M 3.5	12.6	SVN 160304	MS 3510	FLAG T15P	HXX 3.5				
SV21	5513 020-24	1.5	M 3	8.5	–	–	PT-8002	–				
SV22	DVF 0573	1.5	M 3	10.3	DAP 0331	DVT 0332	PT-8002	174.1-870				

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

PRAMET

S**Innv. PSC hurtig veksling dreieholder, 107,5° skjærevinkel, VB/VC .. Skjær**

Innvendig høyre/venstre hånd dreiebom, med innvendig kjøling, med 107,5° skjærevinkel for VB .. 16 eller VC .. 16 skjær. Minimum innvendig dreiediameter Ø33 mm. Passer for et bredt spekter av intnvendig dreieoperasjoner. PSC -skaft (Polygon Shank Coupling) størrelse C4 og C5 med valg av lengder. Behandlet for lengre levetid.



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



GI017



VB.. 1604..



VC.. 1604..



SV16



US 2010-T15P



3.0



M 3.5



10.1



FLAG T15P/3,5

VC

07/ 11/ 13/ 16

CARBIDE INSERTS

VC GT	VC GW	VC GX	VC MT	VC MW
				
 186	 189	 189	 190	 191

PCD INSERTS

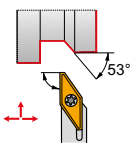
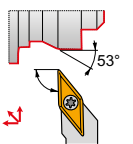
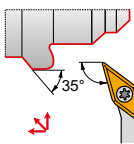
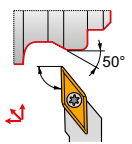
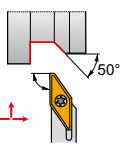
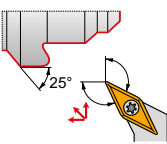
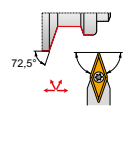
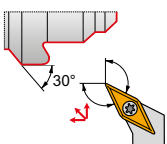
VC MW PCD

 192

MATCH THE RIGHT SIZE (example)

Insert	Tool Holder
VC GT 070204E-FF2	SVGCR 1010 M 07

ISO DREIING – EKSTERN

SVAC(RL)-DC EXT	SVGC(RL) EXT	SVHB(C)(RL) EXT	SVJB(C)(RL) EXT
90°	90°	107°30'	93°
VC..	VC..	VB, VC..	VB, VC..
			
13	07	11 16	11 13 16
 10×10 25×25	 08×08 16×16	 16×16 25×25	 12×12 32×25
 193	 194	 195	 196
 186 – 192	 186 – 192	 168 – 171 186 – 192	 168 – 171 186 – 192
SVJC(RL)-DC EXT	SVPB(C)(RL) EXT	SVVB(C)N EXT	SVXB(C)(RL) EXT
93°	117°30'	72°30'	98°
VC..	VB, VC..	VB, VC..	VB, VC..
			
13	11 16	11 13 16	11 13 16
 10×10 25×25	 16×16 32×25	 12×12 32×25	 12×12 32×25
 197	 198	 199	 200
 186 – 192	 168 – 171 186 – 192	 168 – 171 186 – 192	 168 – 171 186 – 192

VC

07/ 11/ 13/ 16

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

107°30'	VB, VC..
	16
	$\frac{C4}{C6}$
201	168 – 171 186 – 192

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

93°	VB, VC..
	11 16
	$\frac{C3}{C6}$
202	168 – 171 186 – 192

C.-SVVBN EXT **NEW**

72°30'	VB, VC..
	16
	$\frac{C4}{C6}$
203	168 – 171 186 – 192

ISO DREIING – INTERNT

SVJB(RL) INT

93°	VB, VC..
	11
	$\frac{25}{32}$
204	168 – 171 186 – 192

SVLC(RL) INT

95°	VC..
	13
	$\frac{27}{43}$
205	186 – 192

SVQB(C)(RL) INT

107°30'	VB, VC..
	11 13 16
	$\frac{20}{50}$
206	168 – 171 186 – 192

SVUB(C)(RL) INT

93°	VB, VC..
	11 13 16
	$\frac{20}{50}$
207	168 – 171 186 – 192

SVXC(RL) INT

113°	VC..
	07
	$\frac{12,5}{17,5}$
208	186 – 192

SVXC(RL)-E INT

113°	VC..
	07
	$\frac{12,5}{17,5}$
209	186 – 192

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

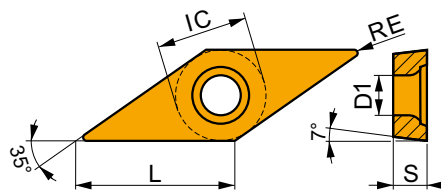
108°	VB, VC..
	16
	33
210	168 – 171 186 – 192

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
----	----	----	----	----	----	----	----	----	----	----	----	----

VCGT

PRAMET

	IC	D1	L	S
	(mm)	(mm)	(mm)	(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



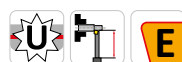
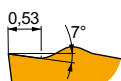
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

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)



AL-geometri med svært positiv design for fin til grov bearbeiding, og kontinuerlige til lett avbrutte kutt.

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	—	—	—	—	—	—



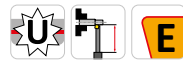
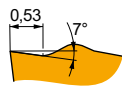
FF2-geometri med positiv design for fin til ferdig bearbeiding, og kontinuerlige til lett avbrutte kutt.

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	—	—	—	—	—	—	—	—	—	—	—	—	—	—

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
----	----	----	----	----	----	----	----	----	----	----	----	----

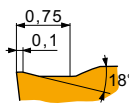
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(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)



FF2-geometri med positiv design for fin til ferdig bearbeiding, og kontinuerlige til lett avbrutte kutt.

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	—	—	—	—	—	—	—	—	—
VCGT 130308E-FF2	TT010	0.4	245	0.06	0.5	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	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	—	—	—	—	—	—	—	—	—
VCGT 130308E-FF2	TT010	0.8	245	0.10	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—



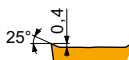
FM2 geometri for fin til middels bearbeiding, og kontinuerlig til avbrutt kutt.

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 positiv design for finbehandling til middels bearbeiding og kontinuerlige kutt.

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	—	—	—	—	—	—	—	—	—	—	—	—



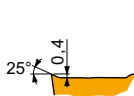
SF2 geometri med svært positiv design for finbearbeiding og kontinuerlige kutt.

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	—	—	—

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
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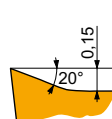
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(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)



SF2 geometri med svært positiv design for finbearbeiding og kontinuerlige kutt.

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 positiv design for finbearbeiding og kontinuerlige kutt.

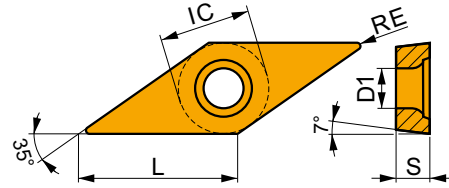
VCGT 070202E-SF3	H07	0.2	–	–	–	80	0.05	0.8	130	0.05	0.8	415	0.06	0.8	40	0.04	0.6	–	–	–
	T6310	0.2	145	0.05	0.8	100	0.05	0.8	115	0.05	0.8	435	0.06	0.8	40	0.04	0.6	25	0.15	1.0
VCGT 070204E-SF3	T6310	0.4	125	0.10	0.8	90	0.09	0.8	100	0.10	0.8	375	0.12	0.8	35	0.07	0.6	25	0.15	1.0
VCGT 110201E-SF3	T6310	0.1	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

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
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VCGW

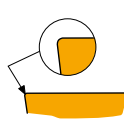


	IC	D1	L	S
(mm)	(mm)	(mm)	(mm)	(mm)
1303	7.940	3.40	13.80	3.18



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere 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)



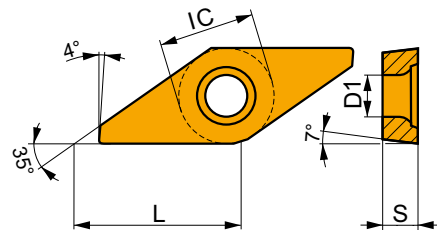
For fin til halv-grov bearbeiding og kontinuerlige til lett avbrutte kutt.

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

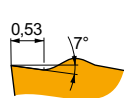


	IC	D1	L	S
(mm)	(mm)	(mm)	(mm)	(mm)
1303	7.940	3.40	13.80	3.18



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere 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)



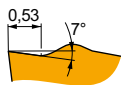
FR-FF2 geometri med positiv høyrehendt design for fin til ferdig bearbeiding og kontinuerlige kutt.

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	—	—	—	—	—	—	—	—	—	—	—	—	—	—

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
----	----	----	----	----	----	----	----	----	----	----	----	----

Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(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)



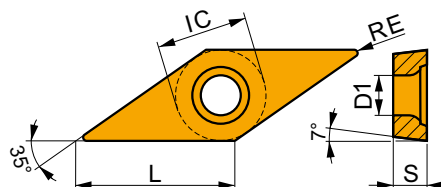
FL-FF2 geometri med positiv venstrehendt design for fin til ferdig bearbeiding og kontinuerlige kutt.

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

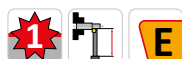
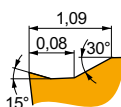
PRAMET

	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



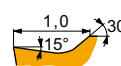
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(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)



FM-geometri for fin til halv-grov bearbeiding, og kontinuerlige til lett avbrutte kutt.

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	—	—	—	—	—	—	—	—	—



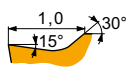
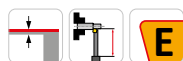
UR-geometri for finbearbeiding og kontinuerlige til lett avbrutte kutt.

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	—	—	—	—	—	—	—	—	—

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
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Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(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)



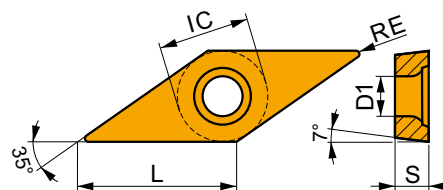
UR-geometri for finbearbeiding og kontinuerlige til lett avbrutte kutt.

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

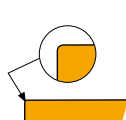
PRAMET

	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



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(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)



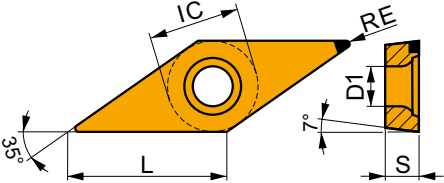
For fin til halv-grov bearbeiding og kontinuerlige til lett avbrutte kutt.

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

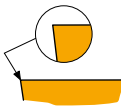


	IC	D1	L	S
(mm)	(mm)	(mm)	(mm)	(mm)
1604	9.525	4.40	16.60	4.76



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	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)



PCD belagt for ferdig til middels bearbeiding, høye hastigheter og stabile skjæreforhold.

VCMW 160404FN	PD1	0.4	—	—	—	—	—	—	—	—	—	900	0.12	0.5	—	—	—	—	—	—
VCMW 160408FN	PD1	0.8	—	—	—	—	—	—	—	—	—	1050	0.12	1.0	—	—	—	—	—	—

SVAC(RL)-DC EXT



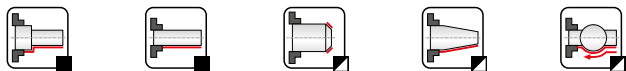
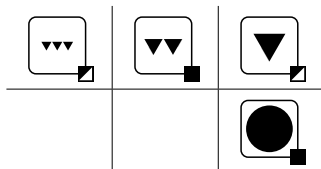
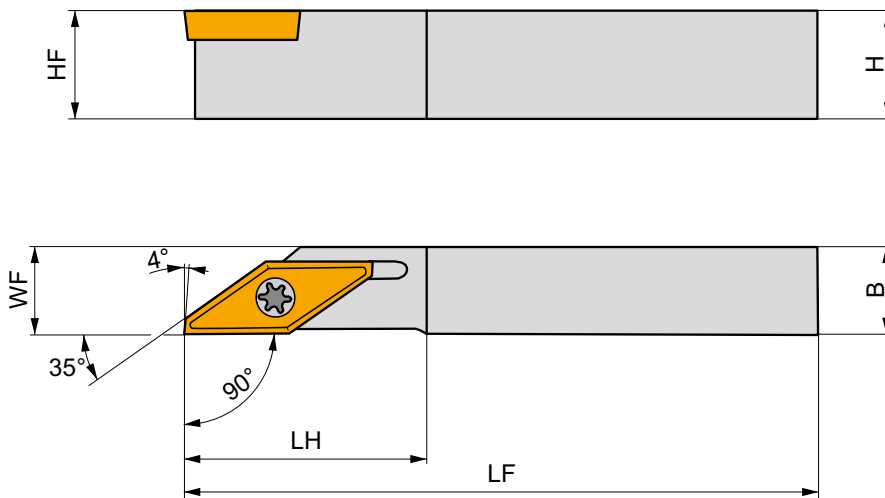
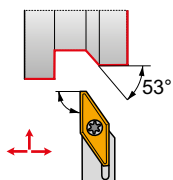
PRAMET

S



Utv. Swiss Style dreieholder, 90 ° skjærevinkel for VCGX 13 skjær

Utvendig høyre/venstre hånd dreieholder for positive VCGX 13 sveitsiske skjærtyper. Passer for utvendig overflate og langsgående dreining med skulder, konisk, kopidreining opp til 53 ° og fasing. Tilgjengelig med skaftstørrelse 10x10 opp til 25x25mm. Behandlet for lengre levetid.



	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
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..



SV20



5513 020-24



1.5



M 3

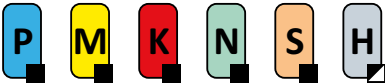


8.5



PT-8002

SVGCR(L) EXT



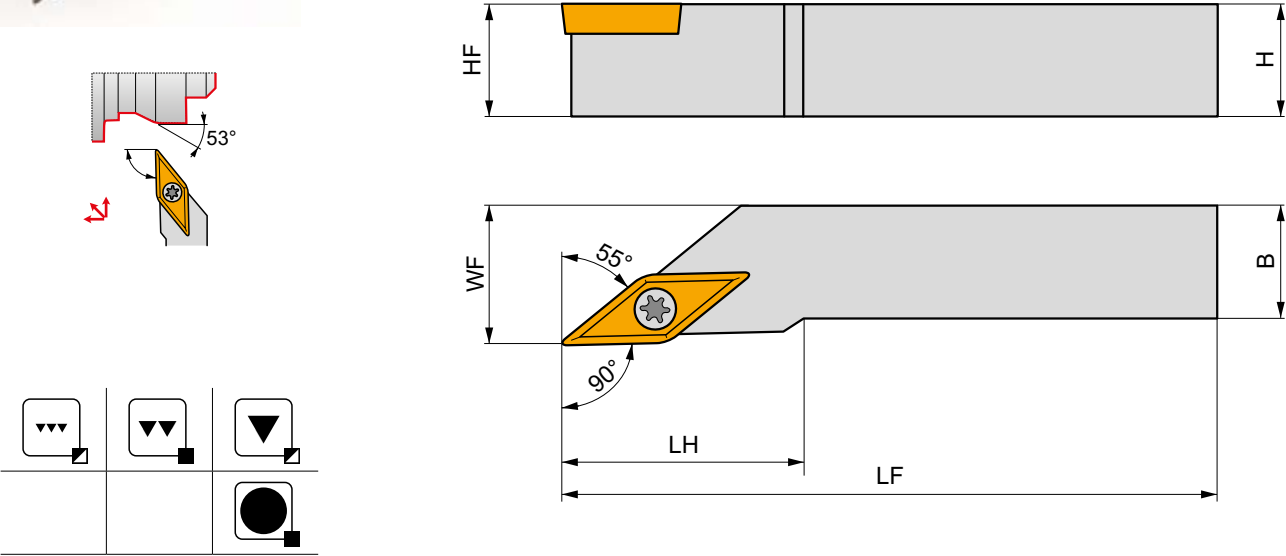
PRAMET

S



Utvendig dreieholder med 90 ° skjærevinkel for VC .. Skjær

Utvendig høyre/venstre hånd dreieholder for positiv VC .. 07 skjær. Passer for utvendig langsgående dreiling med skulder, konisk, kopidreiling opp til 53 ° og fasing. Tilgjengelig med skaftstørrelse 08x08 opp til 16x16 mm. Behandlet for lengre levetid.



	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
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..
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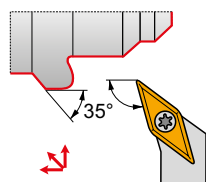
SV23	DVF 3584	0.6	M 2	5.5	DMD 1650
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SVHB(C)(RL) EXT

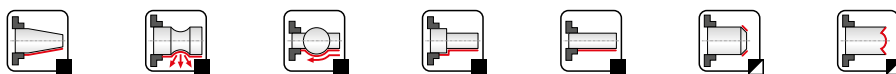
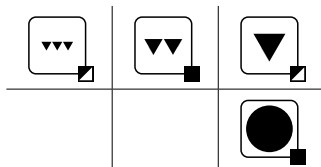
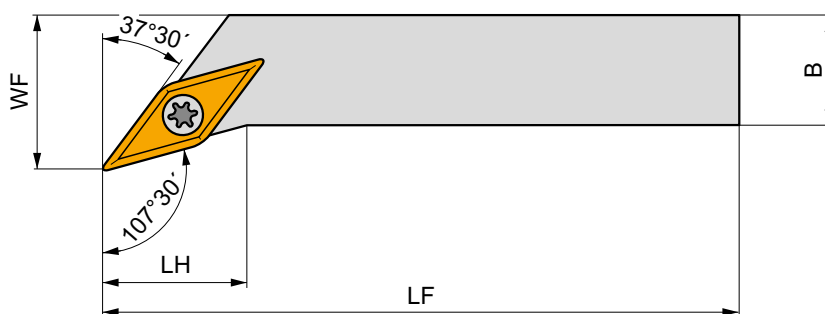


PRAMET

S

**Utv. dreieholder med 107,5° skjærevinkel for VB/VC .. Skjær**

Utvendig høyre/venstre hånd dreieholder for positiv VB .. 11 eller 16 og VC .. 11 eller 16 skjær. Passer for utvendig overflate og langsgående dreining med skulder-, konisk-, overflate- og langsgående kopi som dreier opp til 35° og fasing. Tilgjengelig med skaftstørrelse 16x16 opp til 25x25 mm. Behandlet for lengre levetid.



	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
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												
GI194												

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



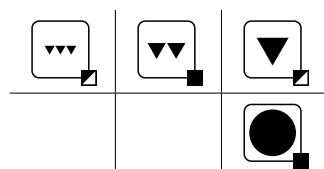
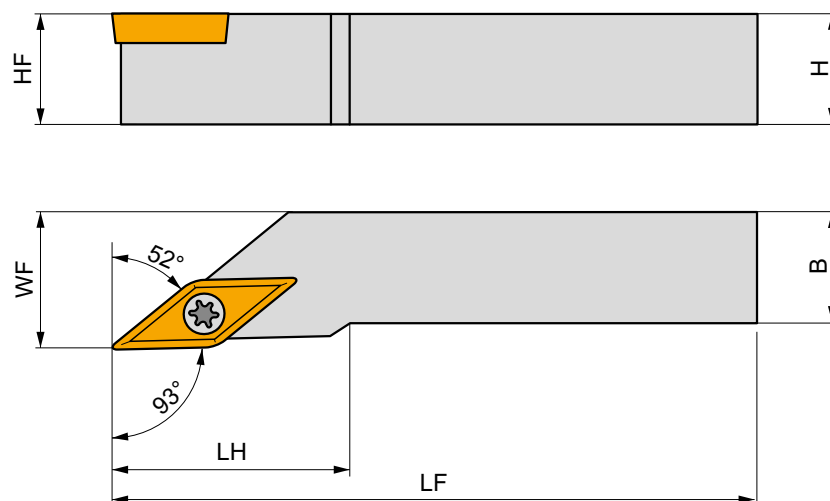
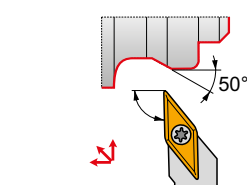
PRAMET

S



Utvendig dreieholder med 93° skjærevinkel for VB/VC.. Skjær

Utvendig høyre/venstre hånd dreieholder for positiv VB .. 11 eller 16 og VC .. 11 opptil 16 skjær. Passer for utvendig langsgående dreining med skulder, konisk, kopidreining opp til 50° og fasing. Tilgjengelig med skaftstørrelse 12x12 opp til 32x25 mm. Behandlet for lengre levetid.



	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
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
L	SVJCR 3225 P 16-M-A	32	25	32	32	170	32	0	0	0.99	GI017	SV10
	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..			

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



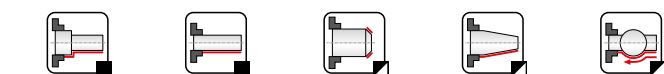
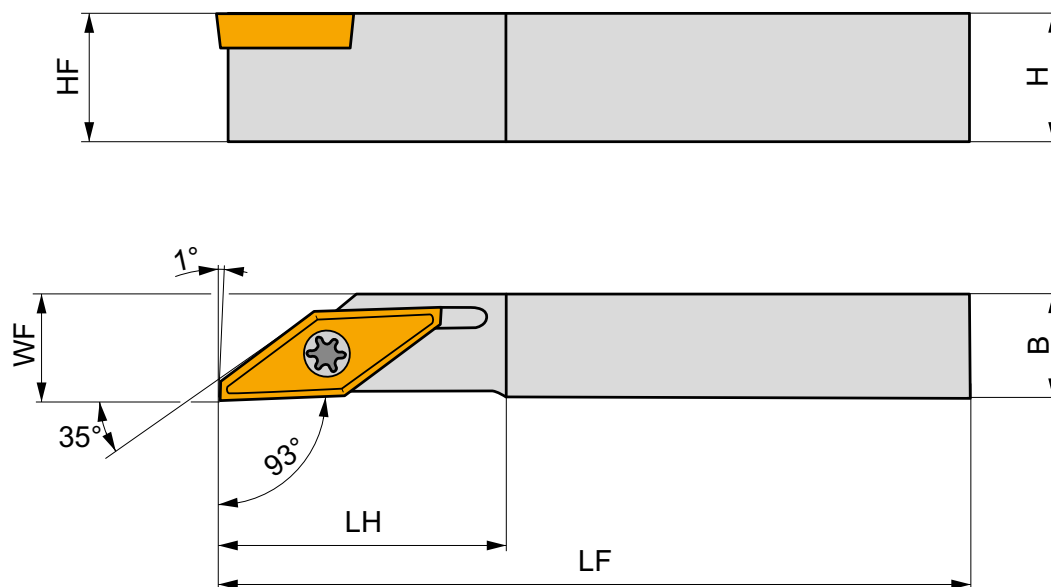
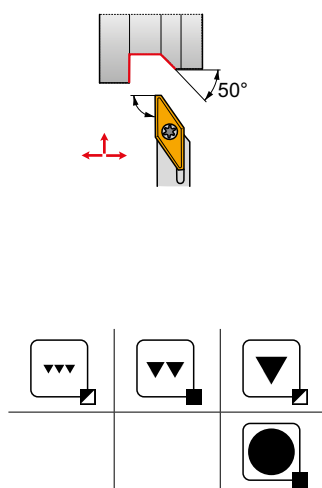
PRAMET

S



Utv. Swiss Style dreieholder, 93 ° skjærevinkel for VCGX 13 skjær

Utvendig høyre/venstre hånd dreieholder for positive VCGX 13 sveitsiske skjærtyper. Passer for utvendig overflate og langsgående dreining med skulder, konisk, kopidreining opp til 50 ° og fasing. Tilgjengelig med skaftstørrelse 10x10 opp til 25x25 mm. Behandlet for lengre levetid.



Product		H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
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..
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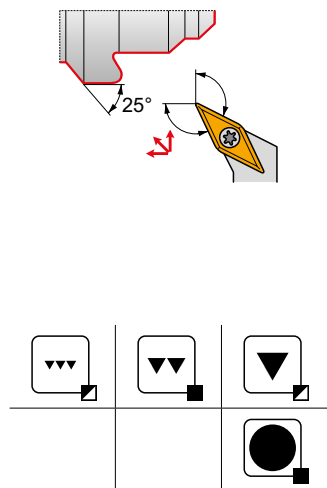
SV20	5513 020-24	1.5	M 3	8.5	PT-8002
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SVPB(C)(RL) EXT



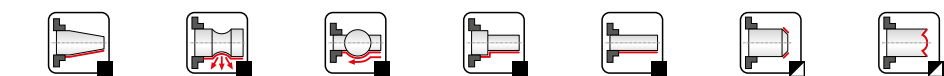
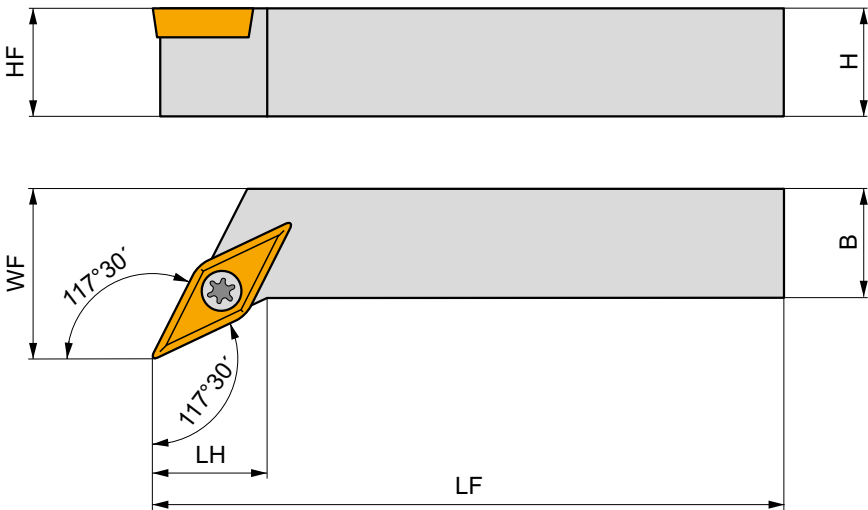
PRAMET

S



Utvendig dreieholder, 117,5° skjærevinkel for VB/VC .. Skjær

Utvendig høyre/venstre hånd dreieholder for positiv VB .. 11 eller 16 og VC .. 11 eller 16 skjær. Passer for utvendig overflate og langsgående dreining med skulder, konisk, kopiering av overflate opp til 25° og fasing. Tilgjengelig med skaftstørrelse 16x16 opp til 32x25 mm. Behandlet for lengre levetid.



	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
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..			

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



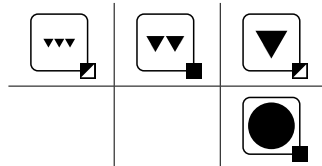
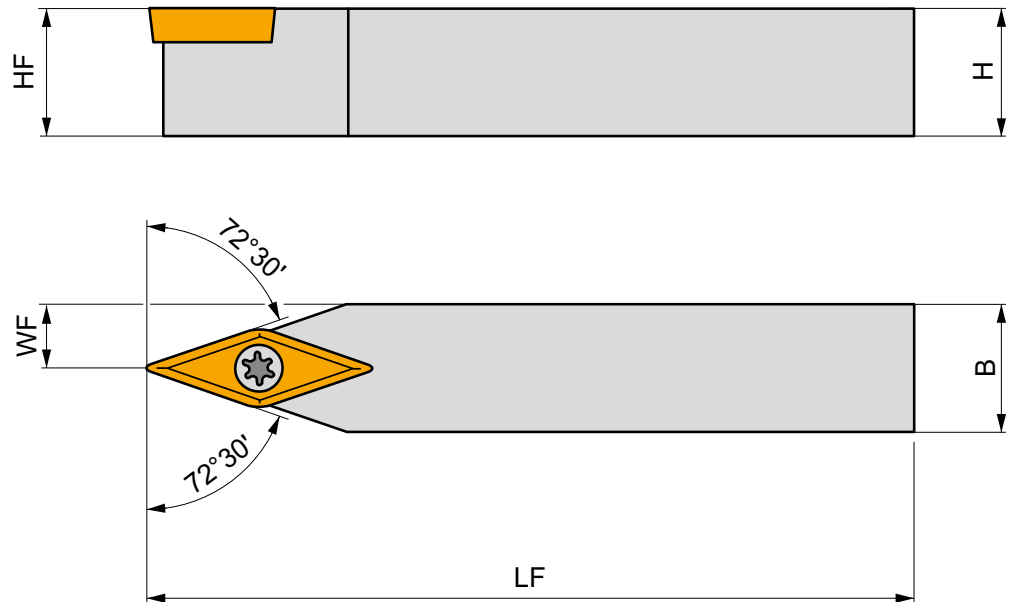
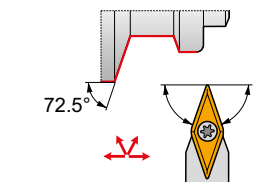
PRAMET

S



Utvendig verktøyholder, 72,5 ° skjærevinkel for VB / VC .. Skjær

Utvendig nøytral verktøyholder for positiv VB .. 11 eller 16 og VC .. 11 opp til 16 skjær. Egnet for utvendig langsgående dreining uten skulder, konisk, formdreining opp til 72,5 ° og fasing. Tilgjengelig med skaftstørrelse 12x12 opp til 32x25 mm. Behandlet for lengre levetid.



Product	H	B	HF	WF	LF	LH	LAMS	GAMO				
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)				
N	SVVBN 1212 F 11	12	12	12	6	80	—	0	0	0.11	GI194	SV01
	SVVBN 1616 H 11	16	16	16	8	100	—	0	0	0.18	GI194	SV01
	SVVBN 2020 K 11	20	20	20	10	125	—	0	0	0.38	GI194	SV01
	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

GI	VB..	VC..
GI017	VB.. 1604..	VC.. 1604..
GI194	VB.. 1103..	VC.. 1103..
GI211	—	VC.. 1303..

SV	US	Nm	M	6.3	SVN	MS	FLAG	—
SV01	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	HXX 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

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
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SVXB(C)(RL) EXT



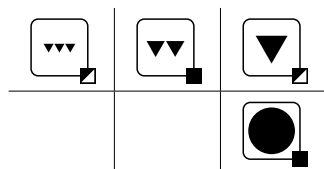
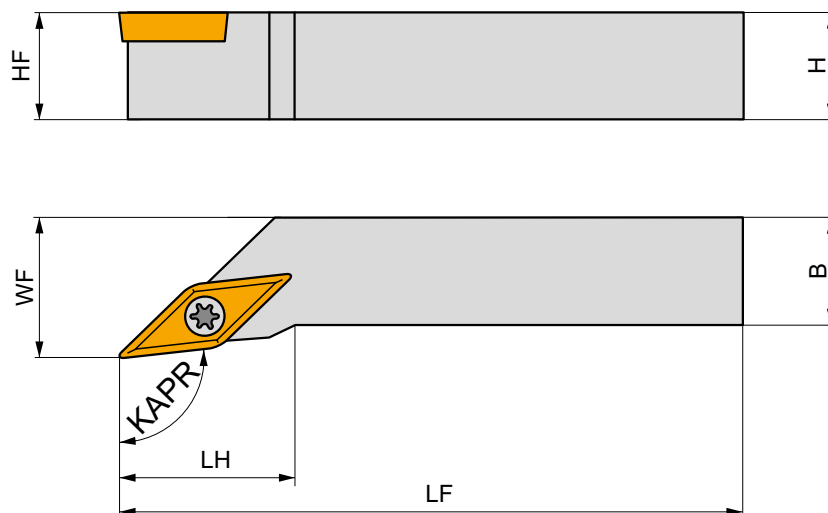
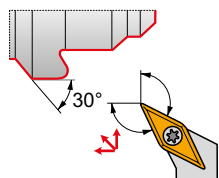
PRAMET

S



Utvendig dreieholder 98/113 ° skjærevinkel for VB/VC .. Skjær

Utvendig høyre/venstre hånd dreieholder for positiv VB .. 11 eller 16 og VC .. 11 opptil 16 skjær. Passer for utvendig langsgående dreining med skulder, konisk, kopidreining opp til 30 ° og fasing. Tilgjengelig med skaftstørrelse 12x12 opp til 32x25 mm. Behandlet for lengre levetid.



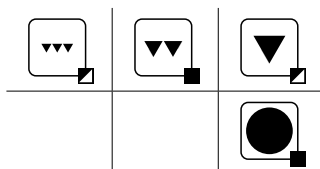
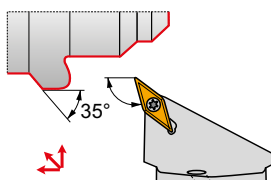
	Product	H	B	HF	WF	LF	LH	KAPR	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)	(°)			
R	SVXBR 1212 F 11	12	12	12	16	80	20	98	0	0	0.09	GI194	S01
	SVXBR 1616 H 11	16	16	16	20	100	14	98	0	0	0.19	GI194	S01
	SVXCR 2020 K 13	20	20	20	25	125	12	113	0	0	0.38	GI211	SV22
	SVXCR 2020 K 16-M-A	20	20	20	25	125	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	S01
	SVXBL 1616 H 11	16	16	16	20	100	14	98	0	0	0.19	GI194	S01
	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..

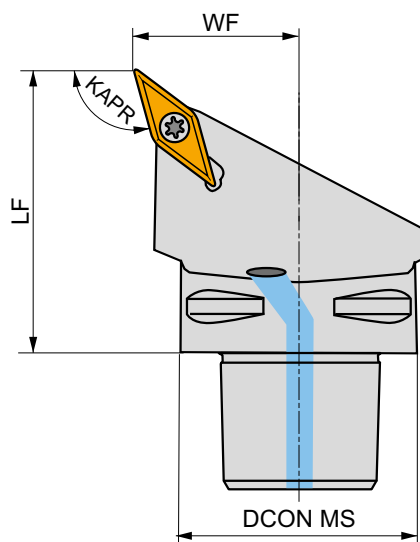
S01	US 2506-T07P	0.9	M 2.5	6.3	—	—	FLAG T07P	—
SV10	US 3512-T15P	3.0	M 3.5	12.6	SVN 160304	MS 3510	FLAG T15P	HXK 3.5
SV22	DVF 0573	1.5	M 3	10.3	DAP 0331	DVT 0332	PT-8002	174.1-870

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

PRAMET

S**Utv. PSC Quick Change dreieholder, 107,5° skjærevinkel, VB/VC .. Skjær**

Utvednig høyre/venstre hånd dreieholder, med innvendig kjøling, for positiv VB .. 16 og VC .. 16 skjær. Passer for utvendig langsgående dreining med skulder, konisk, kopidreining opp til 35° og fasing. Tilgjengelig med PSC (Polygon Shank Coupling) størrelse C4 opp til C6. Behandlet for lengre levetid.



Product	DCON MS (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)				
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

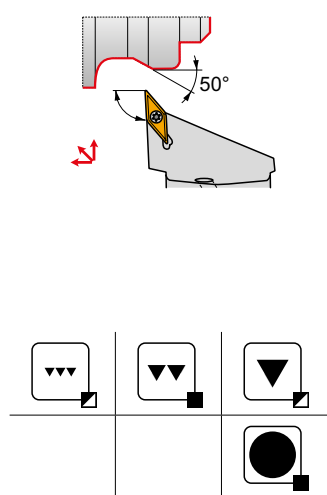
NEW

C.-SVJB(RL) EXT



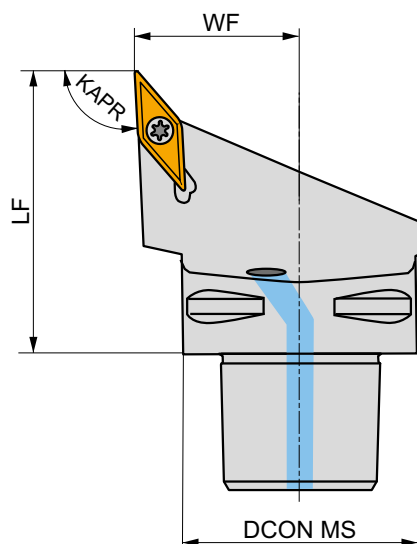
PRAMET

S



Utv. PSC Quick Change dreieholder, 93 ° skjærevinkel for VB/VC .. Skjær

Utvendig høyre/venstre hånd dreieholder, med innvendig kjøling, for positiv VB .. 11 eller 16 og VC .. 11 opptil 16 skjær. Passer for utvendig langsgående dreieing med skulder, konisk, kopidreig opp til 50 ° og fasing. Tilgjengelig med PSC (Polygon Shank Coupling) størrelse C3 opp til C6. Behandlet for lengre levetid.



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

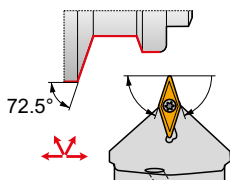
NEW

C-SVBN EXT



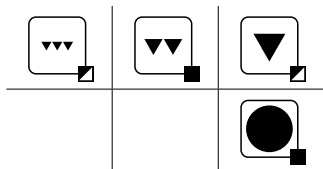
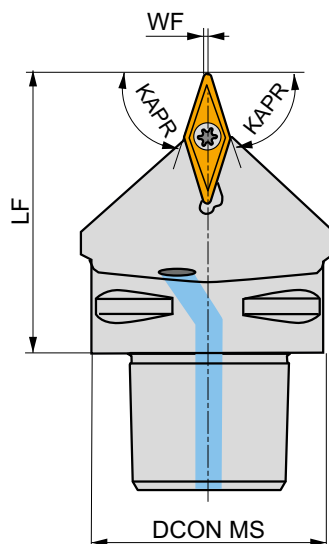
PRAMET

S



Utv. PSC hurtigvekslings holder, 72,5 ° skjærevinkel, VB / VC .. Skjær

Utvendig nøytral holder, Innvendig kjøling, for positive VB .. 16 og VC .. 16 skjær. Egnet for utvendig langsgående dreining uten skulder, konisk, formdreining på 72,5 ° og fasing. Tilgjengelig med PSC (Polygon Shank Coupling) størrelse C4 opp til C6. Behandlet for lengre levetid for verktøyet.

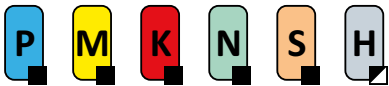


Product	DCON MS	WF	LF	KAPR	LAMS	GAMO		kg		
	(mm)	(mm)	(mm)	(°)	(°)	(°)				
N	C4-SVBN-00050-16	40	0.6	50	72.5	0	0	✓	0.32	GI017 C-SV16S-1
	C5-SVBN-00060-16	50	0.6	60	72.5	0	0	✓	0.56	GI017 C-SV16S-2
	C6-SVBN-00065-16	63	0.6	65	72.5	0	0	✓	0.99	GI017 C-SV16S-2

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

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



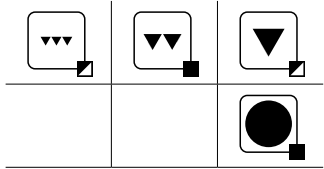
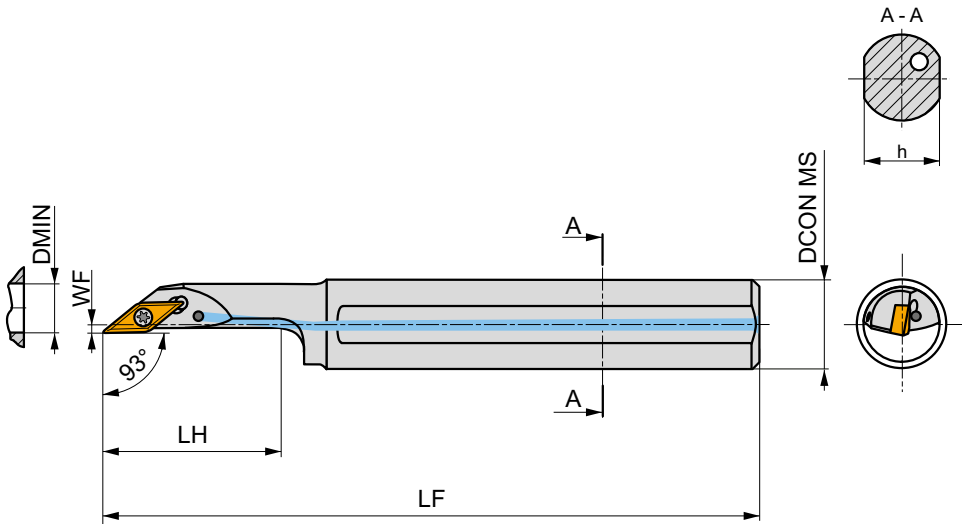
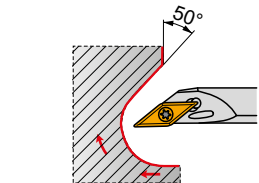
PRAMET

S



Innvendig dreiebom med 93 ° skjærevinkel for VB/VC .. skjær

Innvendig høyre/venstre dreiebom, med innvendig kjøling, med 93° skjærevinkel for VB .. 11 og VC .. 11 skjær. Minimum innvendig dreiediameter Ø25 mm. Passer for overflatekopi som skal dreies under 50°. Finnes med skaftstørrelse Ø20 og Ø25 mm. Behandlet for lengre levetid.



Product		DCON MS	DMIN	WF	H	LF	LH	LAMS	GAMO		kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)				
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	M 2.5	6.3	FLAG T07P

SVLC(RL) INT

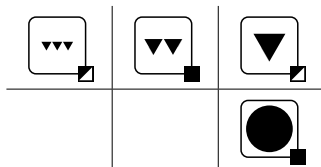
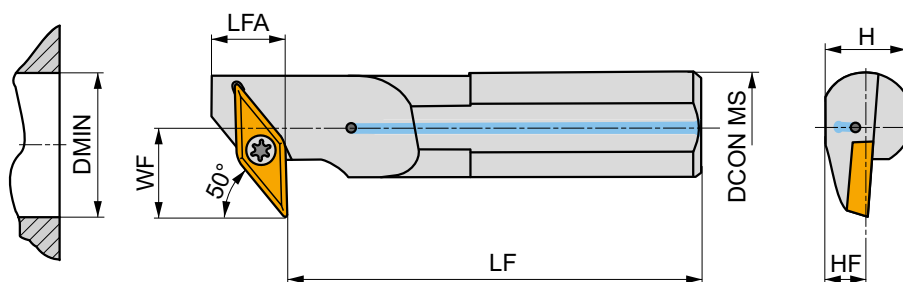
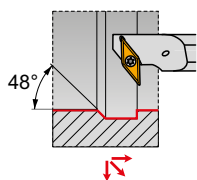


PRAMET

S

**Innvendig dreiebom med 50° skjærevinkel for VC.. Skjær**

Innvendig høyre/venstre dreiebom, med innvendig kjøling, med 50° skjærevinkel for VC .. 13 skjær. Minimum innvendig dreiediameter Ø27 mm. Passer for et bredt spekter av innvendige trekk -dreieoperasjoner og kopiering under 48°. Finnes med skaftstørrelse Ø20 opp til Ø32 mm. Behandlet for lengre levetid.



	Product	DCON MS	DMIN	WF	H	LF	HF	LFA	LAMS	GAMO		kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)				
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-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	✓	0.05	GI211	SV22
	A32T-SVLCR 13-X	32	43	25	30	300	15	18	-1	-2	✓	1.75	GI211	SV22



GI211



VC.. 1303..



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



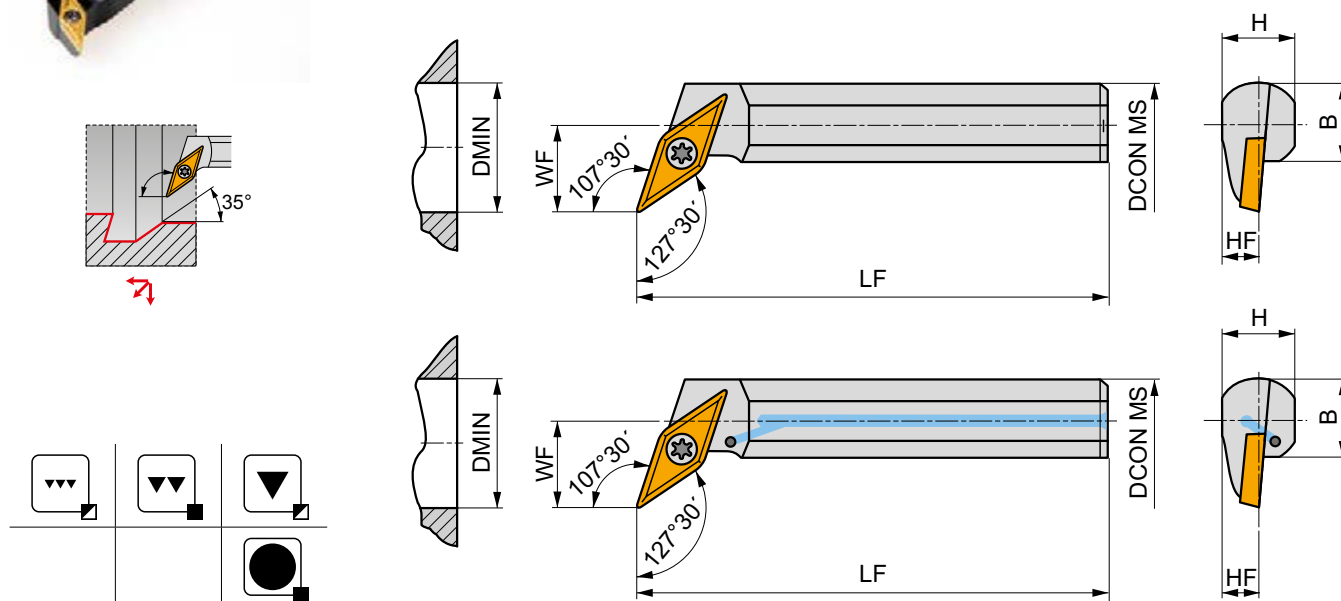
PRAMET

S



Innvendig dreiebom med 107,5° skjærevinkel for VB/VC .. skjær

Innvendig høyre/venstre dreiebom, tilgjengelig med innvendig kjøling, med 107,5° skjærevinkel for VB ../ VC .. 11 og 16 skjær. Minimum innvendig dreiediameter Ø20 mm. Passer for et bredt spekter av innvendige dreieoperasjoner. Finnes med skaftstørrelse Ø16 opp til Ø40 mm.



Product	DCON MS	DMIN	WF	H	B	LF	LAMS	GAMO		kg		
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)				
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..		

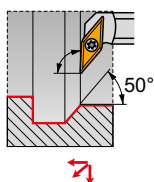
S01	US 2506-T07P	0.9	M 2.5	6.3	—	—	FLAG T07P	—				
S08	US 3510-T15P	3.0	M 3.5	10.6	—	—	FLAG T15P	—				
SV10	US 3512-T15P	3.0	M 3.5	12.6	SVN 160304	MS 3510	FLAG T15P	HXX 3.5				
SV21	5513 020-24	1.5	M 3	8.5	—	—	PT-8002	—				

SVUB(C)(RL) INT

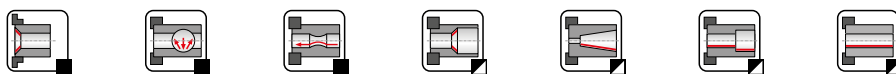
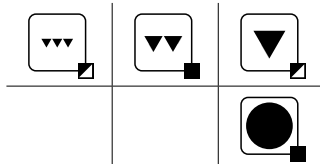
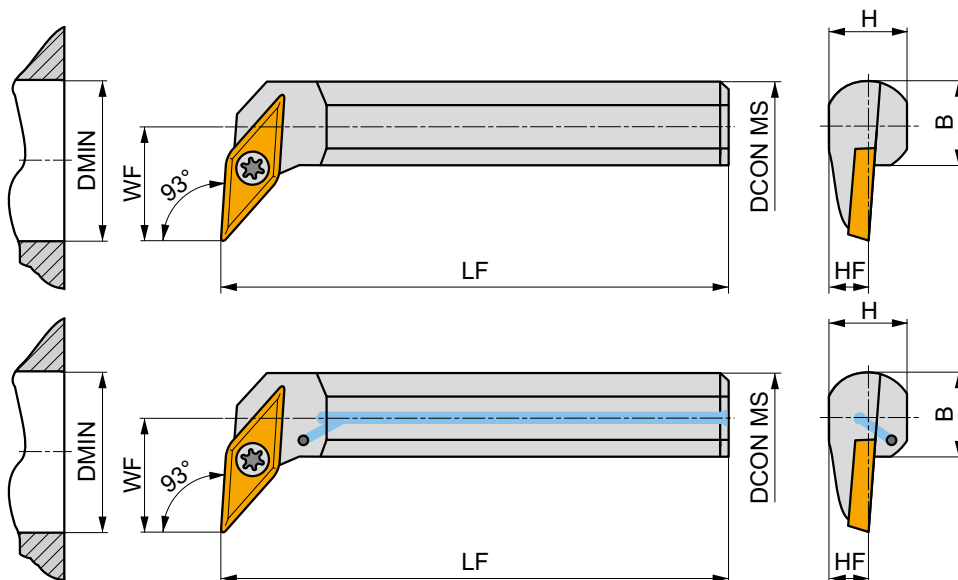


PRAMET

S

**Innvendig dreiebom med 93° skjærevinkel for VB/VC.. Skjær**

Innvendig høyre/venstre dreiebom, tilgjengelig med innvendig kjøling, med 93° skjærevinkel for VB../VC.. 11 og 16 skjær. Minimum innvendig dreiediameter Ø20 mm. For et bredt spekter av innvendige dreieoperasjoner og kopiering under 50°. Ø16 opp til Ø40 mm skaft tilgjengelig. Behandlet for lengre levetid.



	Product	DCON MS	DMIN	WF	H	B	LF	LAMS	GAMO		kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)				
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
GI194
GI211VB.. 1604..
VB.. 1103..
–VC.. 1604..
VC.. 1103..
VC.. 1303..

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

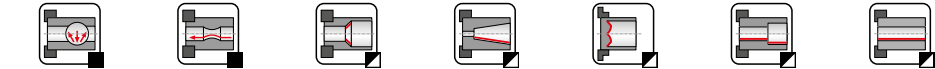
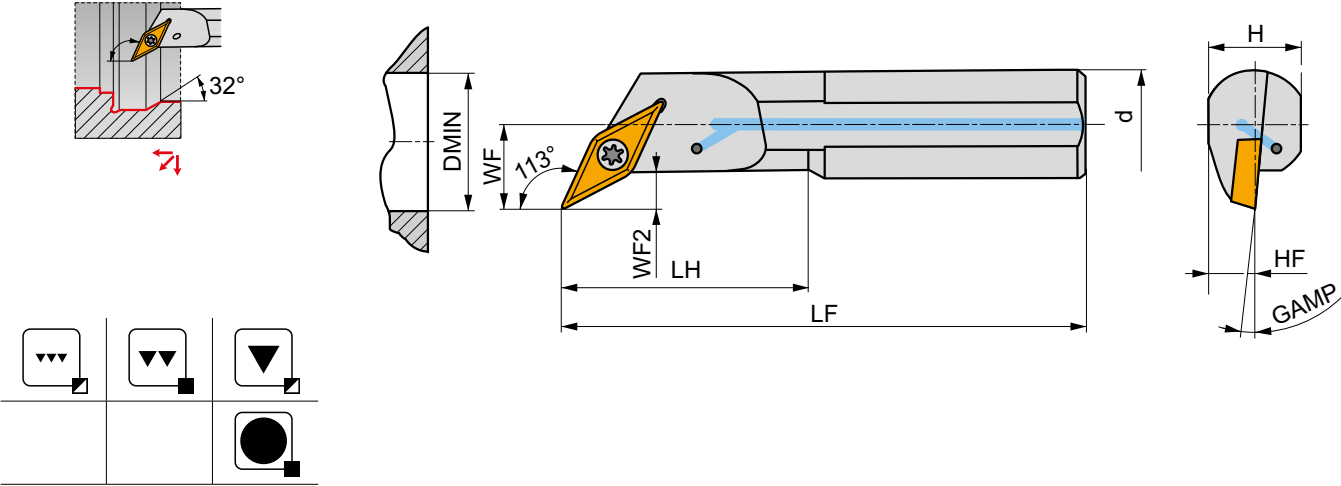
PRAMET

S



Innvendig dreiebom med 113 ° skjærevinkel for VC .. skjær

Innvendig høyre/venstre dreiebom, med innvendig kjøling, med 113° skjærevinkel for VC .. 07 skjær. Minimum innvendig dreiediameter Ø12,5 mm. Passer for et bredt spekter av interne dreieoperasjoner og kopiering under 32° . Finnes med skaftstørrelse Ø10 opp til Ø16 mm. Behandlet for lengre levetid.



Product		DCON MS	DMIN	WF	H	LF	HF	LH	WF2	GAMP		kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)				
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

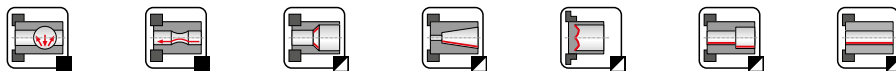
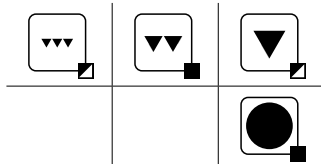
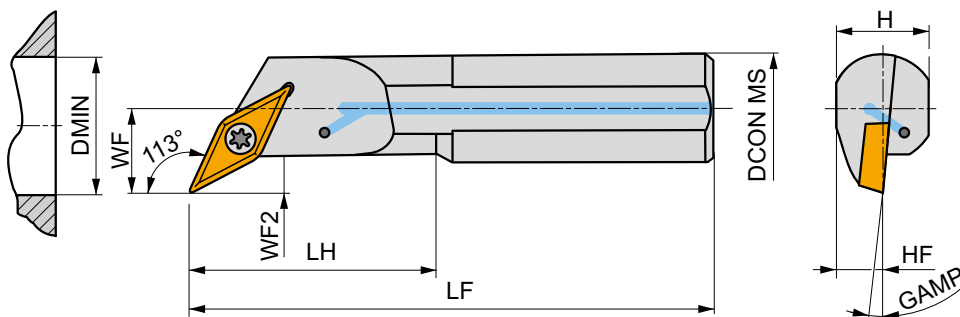
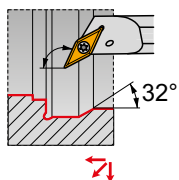


PRAMET

S

**Innvendig hardmetall dreiebom, 113° skjærevinkel for VC .. Skjær**

Innvendig høyre/venstre dreiebom, med innvendig kjøling, med 113° skjærevinkel for VC .. 07 skjær. Minimum innvendig dreiediameter Ø12,5 mm. Passer for et bredt spekter av innvendige dreieoperasjoner og kopiering under 32°. Finnes med skaftstørrelse Ø10 opp til Ø16 mm. For verktøyoverheng > 3xD.



Product		DCON MS	DMIN	WF	H	HF	LF	LH	WF2	GAMP		kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)				
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



M 2



5.5



DMD 1650

NEW

C.-SVQB(RL) INT



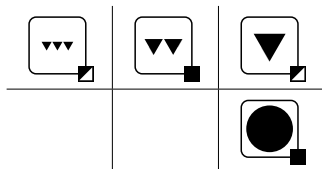
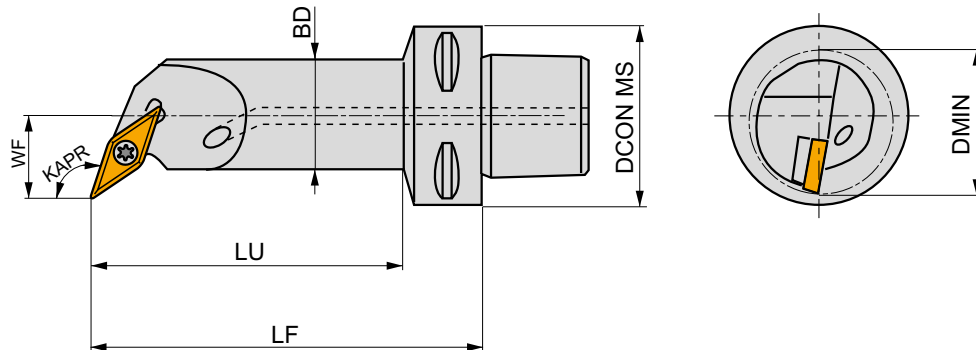
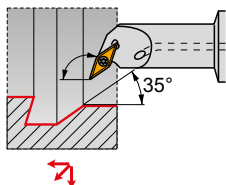
PRAMET

S



Innv. PSC hurtig veksling dreieholder, 107,5 ° skjærevinkel, VB/VC .. Skjær

Innvendig høyre/venstre hånd dreiebom, med innvendig kjøling, med 107,5° skjærevinkel for VB .. 16 eller VC .. 16 skjær. Minimum innvendig dreiediameter Ø33 mm. Passer for et bredt spekter av intrvendig dreieoperasjoner. PSC -skaft (Polygon Shank Coupling) størrelse C4 og C5 med valg av lengder. Behandlet for lengre levetid.



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

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

SV16	US 2010-T15P	3.0	M 3.5	10.1	FLAGT15P/3,5

WC

02/ 06/ 08/ 16

CARBIDE INSERTS

WCGT



212

WCGX



213

WCMT



213

MATCH THE RIGHT SIZE (example)

Insert

WCGT 020102E-FF2

Tool Holder

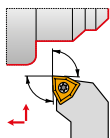
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ISO DREIING – EKSTERN

SWLC(RL) EXT

95°

WC..

06
0816×16
25×25

215

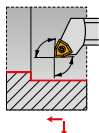
212 – 214

ISO DREIING – INTERNT

SWLC(RL) INT

95°

WC..

06
0825
40

216

212 – 214

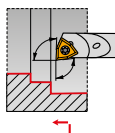
SWUC(RL) INT

93°

WC..



02

5,8
7,8

217

212 – 214

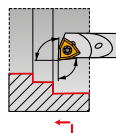
SWUC(RL)-E INT

93°

WC..



02

5,8
7,8

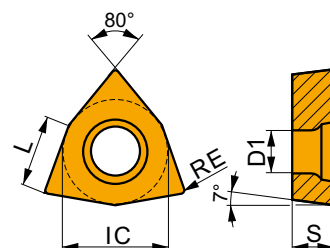
218

212 – 214

WCGT

PRAMET

	IC	D1	L	S
(mm)	(mm)	(mm)	(mm)	(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



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(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)

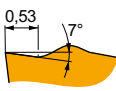






AL-geometri med svært positiv design for fin til grov bearbeiding, og kontinuerlige til lett avbrutte kutt.

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		—	—	—		—	—	—





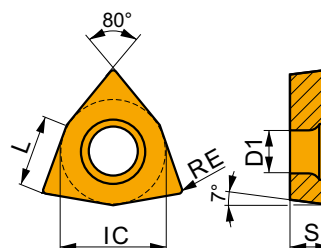
FF2-geometri med positiv design for fin til ferdig bearbeiding, og kontinuerlige til lett avbrutte kutt.

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

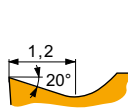


	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
0201	3.970	2.20	2.70	1.59



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere 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)



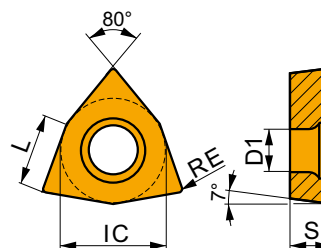
JZ-geometri med venstrehendt design for finbearbeiding og kontinuerlige kutt.

WCGX 020102FL-JZ	TT010	0.2	■	330	0.06	0.5	■	195	0.05	0.5	■	—	—	—	■	—	—	—	■	—	—	—
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WCMT

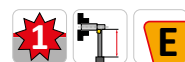


	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
06T3	9.525	4.40	6.50	3.97
0804	12.700	5.50	8.70	4.76



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere 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)



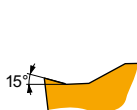
FM-geometri for fin til halv-grov bearbeiding, og kontinuerlige til lett avbrutte kutt.

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	■	—	—	—	■	—	—	—

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
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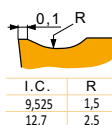
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(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)



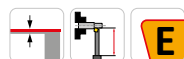
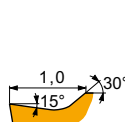
FM-geometri for fin til halv-grov bearbeiding, og kontinuerlige til lett avbrutte kutt.

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	—	—	—	—	—	—	—	—	—
WCMT 080412E-FM	T9325	0.8	250	0.20	1.7	150	0.18	1.7	235	0.20	1.7	—	—	—	—	—	—	—	—	—
	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	—	—	—	—	—	—	—	—	—



RF-geometri for halv-grov til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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 for finbearbeiding og kontinuerlige til lett avbrutte kutt.

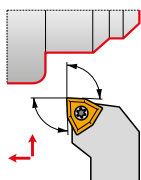
WCMT 06T308E-UR	T7325	0.8	185	0.20	1.2	140	0.18	1.2	—	—	—	—	—	—	—	—	—	—	—	—
	T9315	0.8	250	0.20	1.2	—	—	—	235	0.20	1.2	—	—	—	—	—	—	—	—	—
	T9325	0.8	225	0.20	1.2	135	0.18	1.2	210	0.20	1.2	—	—	—	—	—	—	—	—	—

SWLC(RL) EXT



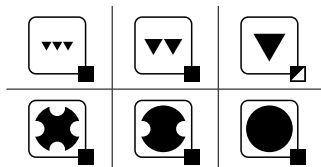
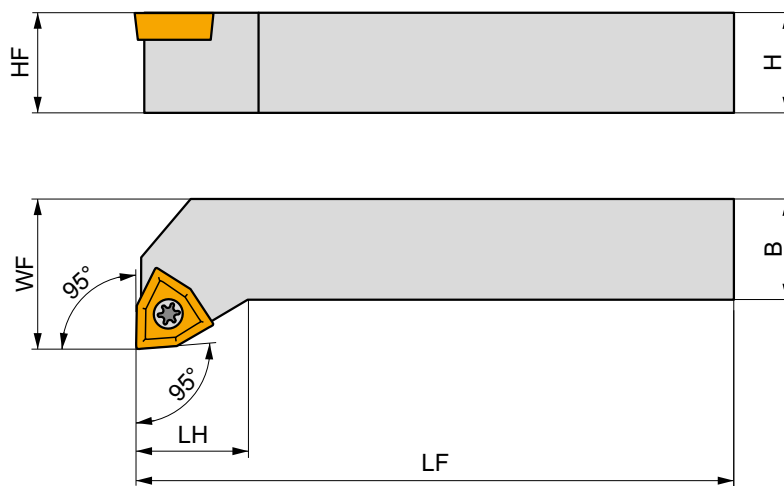
PRAMET

S



Utvendig dreieholder med 95° skjærevinkel for WC .. Skjær

Utvendig høyre/venstre hånd dreieholder for positiv WC .. 06 eller 08 skjær. Passer for overflate og langsgående dreiring med skulder-, konisk- og avfasningsdreiring. Tilgjengelig med skaftstørrelse 16x16 opp til 25x25 mm. Behandlet for lengre levetid.



Product		H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	SWLCR 1616 H 06	16	16	16	20	100	15	0	0	0.24	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..



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

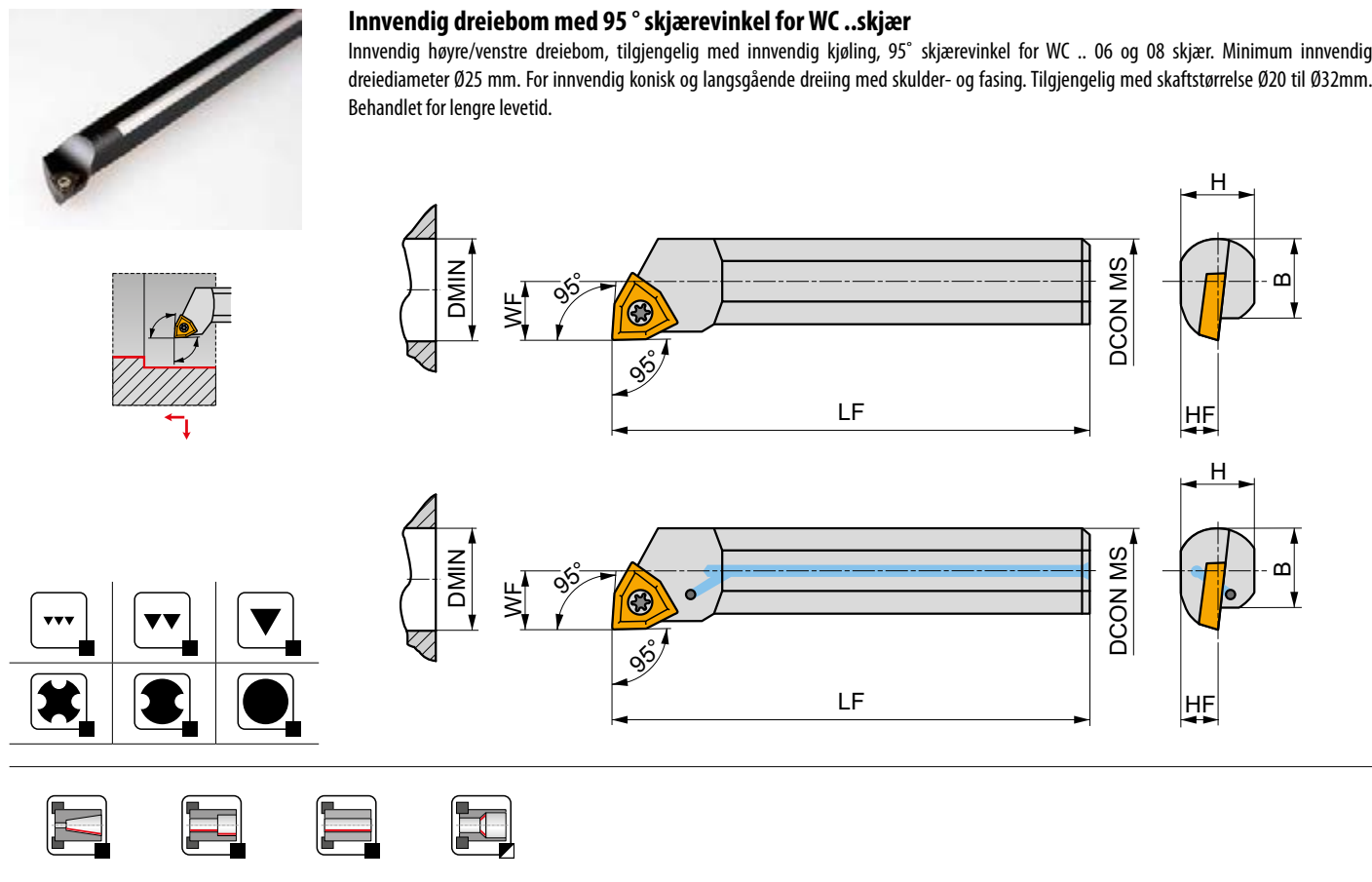
N

S

H

PRAMET

S



Product		DCON MS	DMIN	WF	H	B	LF	LAMS	GAMO		kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)				
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-SWLC L 06	20	25	13	18	18.5	180	-7	0	✓	0.00	GI055	S04
	S20S-SWLC L 06	20	25	13	18	18.5	250	-7	0	–	0.60	GI055	S04
	A25R-SWLC L 06	25	32	17	23	23	200	-7	0	✓	0.70	GI055	S04
	S25T-SWLC L 06	25	32	17	23	23	300	-7	0	–	1.15	GI055	S04
	A25R-SWLC L 08	25	32	17	23	23	200	-7	0	✓	0.70	GI049	S04
	A32S-SWLC L 08	32	40	22	30	30	250	-5	0	✓	1.32	GI049	S09
	S32U-SWLC L 08	32	40	22	30	30	350	-5	0	–	4.10	GI049	S09

GI049													
GI055													

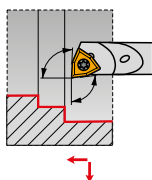
S04		US 3510-T15P		3.0		M 3.5		10.6		FLAGT15P			
S09		US 4512-T15P		5.0		M 4.5		12.2		FLAGT15P			

SWUC(RL) INT

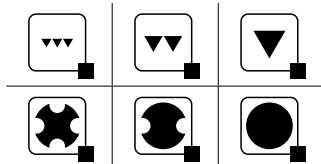
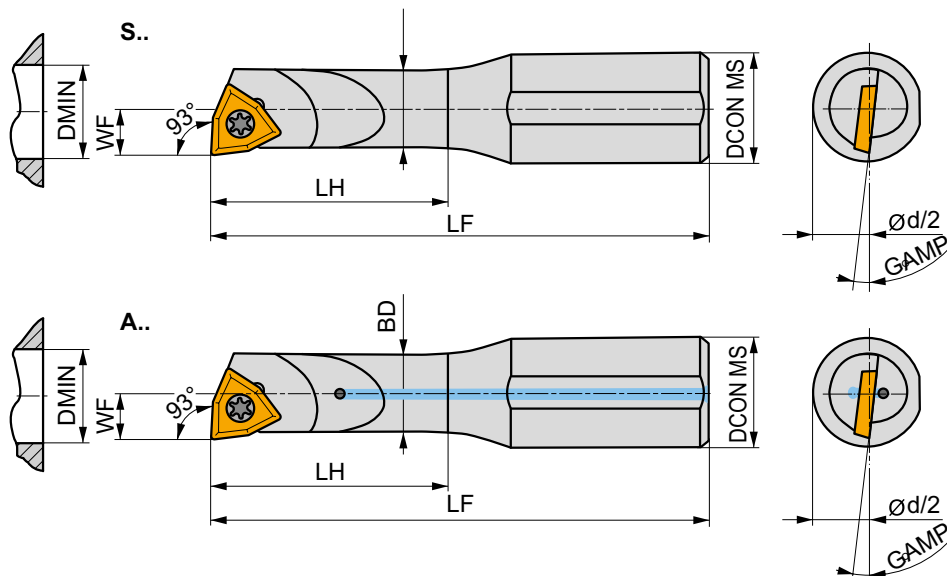


PRAMET

S

**Innendig dreiebom med 93° skjærevinkel for WC.. Skjær**

Innendig høyre/venstre dreiebom, tilgjengelig med innvendig kjøling, 93° skjærevinkel for WC.. 0201 skjær. Minimum innvendig dreiediameter Ø5,8 mm. Passer for innvendig konisk og langsgående dreining med skulder- og fasing. Finnes kun med skaftstørrelse Ø8 mm. Behandlet for lengre levetid.



Product	DCON MS	DMIN	BD	WF	LF	LH	GAMP				
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)				
R	A0508H-SWUCR 02	8	5.8	5	2.9	100	-17	✓	0.09	GI221	SW21
	S0508H-SWUCR 02	8	5.8	5	2.9	100	-17	—	0.04	GI221	SW21
	A0608H-SWUCR 02	8	7.8	6	3.9	100	-12	✓	0.04	GI221	SW21
	S0608H-SWUCR 02	8	7.8	6	3.9	100	-12	—	0.04	GI221	SW21
L	A0508H-SWUCL 02	8	5.8	5	2.9	100	-17	✓	0.04	GI221	SW21
	S0508H-SWUCL 02	8	5.8	5	2.9	100	-17	—	0.04	GI221	SW21
	A0608H-SWUCL 02	8	7.8	6	3.9	100	-12	✓	0.04	GI221	SW21
	S0608H-SWUCL 02	8	7.8	6	3.9	100	-12	—	0.04	GI221	SW21



GI221



WC.. 0201..



SW21



T20.037



0.6



M 2



3.7



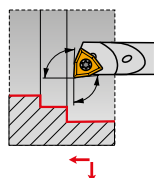
DMD 1650

SWUC(RL)-E INT

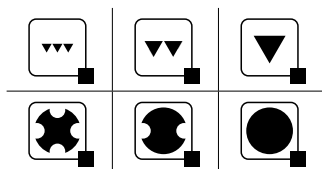
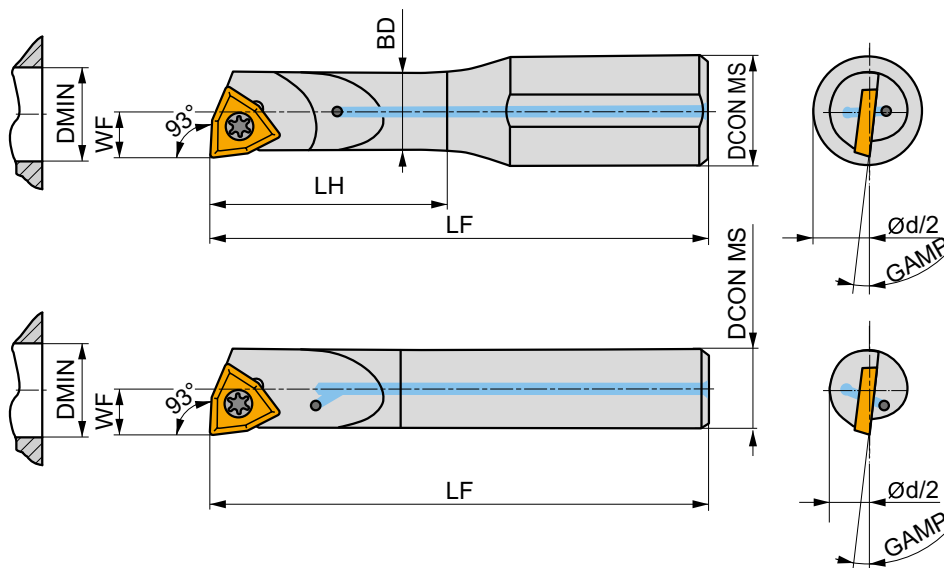


PRAMET

S

**Innvendig hardmetall dreiebom med 93° skjærevinkel for WC.. Skjær**

Innvendig høyre/venstre dreiebom, med innvendig kjøling, med 93° skjærevinkel for WC .. 0201 skjær. Minimum innvendig dreiediameter Ø5,8 mm. Passer for innvendig konisk og langsgående dreining med skulder- og fasing. Finnes med skaftstørrelse Ø5 opp til Ø8 mm. For verktøyoverheng > 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



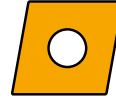
222

CNMG



223

CNMM



234

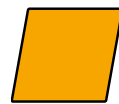
CER AND CBN INSERTS

CNGA CER



238

CNGN CER



238

CNGA CBN



239

MATCH THE RIGHT SIZE (example)

Insert

CNMM 120412E-OR

Tool Holder

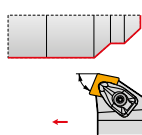
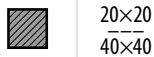
DCBNR 2525 M 12

ISO DREIING – EKSTERN

DCBN(RL) EXT

75°

CN..


12
16
19

20×20
40×40

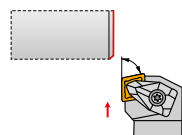
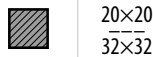
240

222 – 239

DCKN(RL) EXT

75°

CN..


12
16

20×20
32×32

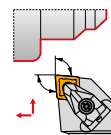
242

222 – 239

DCLN(RL) EXT

95°

CN..


09
12
16
19

16×16
40×40

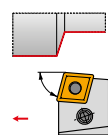
243

222 – 239

PCBN(RL) EXT

75°

CN..


12
16
19
25

20×20
50×50

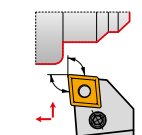
245

222 – 239

PCLN(RL) EXT

95°

CN..


12
16
19
25

20×20
50×50

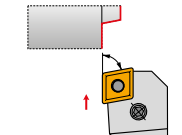
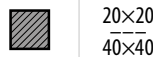
247

222 – 239

PCKN(RL) EXT

75°

CN..


12
16
19

20×20
40×40

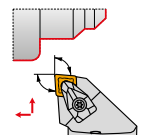
246

222 – 239

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

95°

CN..


12
16
19

C3
C8

249

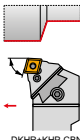
222 – 239

CN

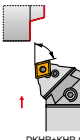
09/ 12/ 16/ 19/ 25

ISO DREIING – TUNG GROVBEARBEIDING– EKSTERNT

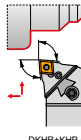
KHP-CBNR + DKH(RL)

75°		CN..
		25
		
	40×50 60×80	
	251, 253	 222 – 239

KHP-CBNL + DKH(RL)

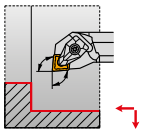
75°		CN..
		25
		
	40×50 60×80	
	251, 253	 222 – 239

KHP-CLNR/L + DKH(RL)

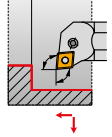
95°		CN..
		19 25
		
	40×50 60×80	
	252, 253	 222 – 239

ISO DREIING – INTERNT

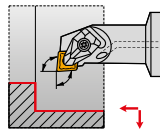
DCLN(RL) INT

95°		CN..
		09 12
	32 50	
	254	 222 – 239

PCLN(RL) INT

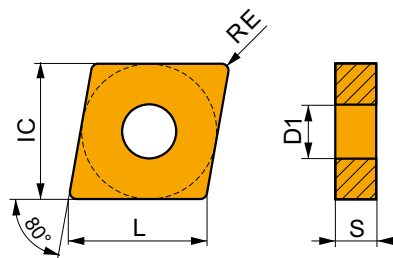
95°		CN..
		09 12 16 19
	20 80	
	255	 222 – 239

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

95°		CN..
		09 12 16
	25 50	
	257	 222 – 239

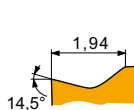
CNGG

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



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere 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)

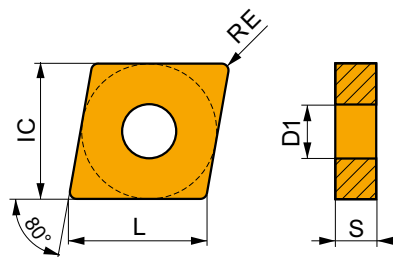


SF-geometri med positiv design for finbearbeiding av tynne vegger i kontinuerlige kutt.

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

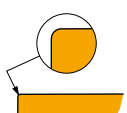
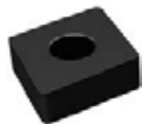
CNMA

	IC	D1	L	S
	(mm)	(mm)	(mm)	(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



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere 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)



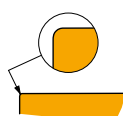
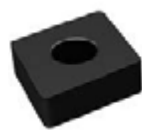
For fin til halv-grov bearbeiding og kontinuerlige til lett avbrutte kutt.

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
CNMA 120412	T6310	0.8	—	—	—	—	—	—	100	0.20	4.0	—	—	—	—	—	—	25	0.15	1.0
	T5305	1.2	—	—	—	—	—	—	195	0.30	4.0	—	—	—	—	—	—	40	0.15	1.0
CNMA 120416	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

CN	DN	KN	LN	RN	SN	TN	VN	WN
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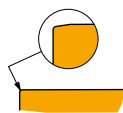
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	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)



For fin til halv-grov bearbeiding og kontinuerlige til lett avbrutte kutt.

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



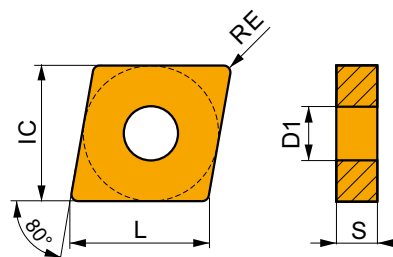
For fin til halv-grov bearbeiding og kontinuerlige til lett avbrutte kutt.

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

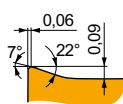
PRAMET

	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



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	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)



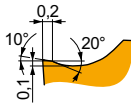
FF-geometri med meget positiv design for finbearbeiding og kontinuerlige til lett avbrutte kutt.

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	—	—	—	—	—	—	—	—	—

CN	DN	KN	LN	RN	SN	TN	VN	WN
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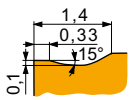
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(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)



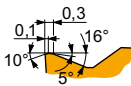
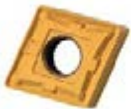
FM-geometri med positiv design for fin til halv-grov bearbeiding, og kontinuerlige til lett avbrutte kutt.

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	—	—	—	—	—	—	—	—	—	—	—	—
	T7325	0.8	220	0.20	2.1	170	0.18	2.1	—	—	—	—	—	—	70	0.16	1.7	—	—	—
CNMG 120408E-FM	T7335	0.8	215	0.20	2.1	165	0.18	2.1	—	—	—	—	—	—	65	0.16	1.7	—	—	—
	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	—	—	—	—	—	—	—	—	—	—	—	—
	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	—	—	—	—	—	—	—	—	—
CNMG 120412E-FM	T9325	1.2	255	0.27	2.1	150	0.24	2.1	240	0.27	2.1	—	—	—	55	0.19	1.7	—	—	—



KR-geometri for middels til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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



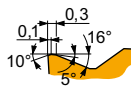
M geometri for fin til middels bearbeiding, og kontinuerlig til avbrutt kutt.

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	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—

CN	DN	KN	LN	RN	SN	TN	VN	WN
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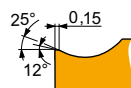
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

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)



M geometri for fin til middels bearbeiding, og kontinuerlig til avbrutt kutt.

CNMG 120408E-M	6640	0.8	■	165	0.32	2.1	■	—	—	—	■	155	0.32	2.1	■	—	—	—	■	55	0.15	1.0
	T5305	0.8	■	280	0.32	2.1	■	—	—	—	■	265	0.32	2.1	■	—	—	—	■	50	0.15	1.0
	T5315	0.8	■	250	0.32	2.1	■	—	—	—	■	235	0.32	2.1	■	—	—	—	■	30	0.15	1.0
	T8330	0.8	■	155	0.32	2.1	■	—	—	—	■	145	0.32	2.1	■	—	—	—	■	25	0.15	1.0
	T8430	0.8	■	170	0.32	2.1	■	—	—	—	■	135	0.32	2.1	■	—	—	—	■	45	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	■	—	—	—	■	—	—	—
	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	■	—	—	—	■	40	0.15	1.0
	T9315	1.2	■	220	0.40	2.1	■	—	—	—	■	205	0.40	2.1	■	—	—	—	■	—	—	—
	T9325	1.2	■	195	0.40	2.1	■	—	—	—	■	185	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	■	—	—	—	■	—	—	—	■	—	—	—	■	—	—	—



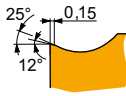
NF-geometri med meget positiv design for finbearbeiding til middels bearbeiding og kontinuerlige kutt.

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	■	—	—	—

CN	DN	KN	LN	RN	SN	TN	VN	WN
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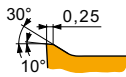
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

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



NF-geometri med meget positiv design for finbearbeiding til middels bearbeiding og kontinuerlige kutt.

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	—	—	—



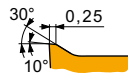
NM-geometri med meget positiv design for finbearbeiding, middels og grov bearbeiding, med kontinuerlige kutt.

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	—	—	—

CN	DN	KN	LN	RN	SN	TN	VN	WN
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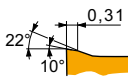
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(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)



NM-geometri med meget positiv design for finbearbeiding, middels og grov bearbeiding, med kontinuerlige kutt.

CNMG 160612E-NM	T7325	1.2	✓	205	0.30	3.6	■	155	0.27	3.6	—	—	—	—	—	—	—	—	—	—		
	T7335	1.2	✓	200	0.30	3.6	■	155	0.27	3.6	—	—	—	—	—	—	—	—	—	—		
	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	



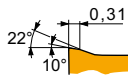
NMR-geometri med positiv design for middels til grov bearbeiding og kontinuerlige kutt.

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
	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
	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
	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

CN	DN	KN	LN	RN	SN	TN	VN	WN
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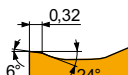
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(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)



NRM-geometri med positiv design for middels til grov bearbeiding og kontinuerlige kutt.

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	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
CNMG 190608E-NMR	T9325	1.6	180	0.45	4.0	105	0.41	4.0	—	—	—	—	—	—	40	0.32	3.2	—	—	—
	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	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
CNMG 190612E-NMR	T9325	0.8	180	0.35	5.2	105	0.32	5.2	—	—	—	—	—	—	40	0.25	4.2	—	—	—
	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	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
CNMG 190616E-NMR	T9325	1.2	180	0.40	5.2	105	0.36	5.2	—	—	—	—	—	—	40	0.28	4.2	—	—	—
	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	—	—	—



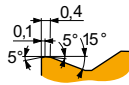
NRM-geometri med positiv design for middels til grov bearbeiding, og kontinuerlig til moderat avbrutt kutt.

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	—	—	—	—	—	—	—	—	—

CN	DN	KN	LN	RN	SN	TN	VN	WN
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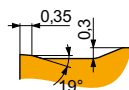
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

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)



R-geometri for halv-grov til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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		—	—	—		—	—	—		—	—	—		—	—	—



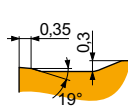
RM-geometri for halv-grov til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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	—	—	—	—	—	—	—	—	—	—

CN	DN	KN	LN	RN	SN	TN	VN	WN
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Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

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



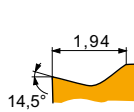
RM-geometri for halv-grov til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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	—	—	—	—	—	—
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	—	—	—	—	—	—
CNMG 160616E-RM	T9335	1.2		165	0.45	6.0		95	0.41	6.0	—	—	—	—	—	—	—	—	—	—
	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	—	—	—	—	—	—
CNMG 190608E-RM	T9335	1.6		165	0.50	6.0		95	0.45	6.0	—	—	—	—	—	—	—	—	—	—
	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	—	—	—	—	—	—	—	—	—	—

CN	DN	KN	LN	RN	SN	TN	VN	WN
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Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(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	—	—	—	—	—	—	—	—	—	—	—	—



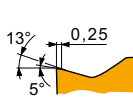
SF-geometri med positiv design for finbearbeiding av tynne vegger og kontinuerlige kutt.

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

CN	DN	KN	LN	RN	SN	TN	VN	WN
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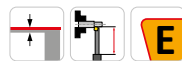
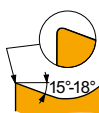
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

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)



SM-geometri med positiv design for middels bearbeiding og kontinuerlige til avbrutte kutt.

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	—	—	—



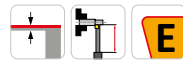
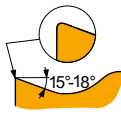
ER-SI geometri med positiv høyrehendt design for fin til halv-grov bearbeiding og kontinuerlige kutt.

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	—	—	—
CNMG 120412ER-SI	T9325	0.8	255	0.35	1.7	150	0.32	1.7	—	—	—	—	—	—	55	0.25	1.4	—	—	—
	T8430	1.2	225	0.35	1.7	120	0.32	1.7	—	—	—	615	0.42	1.7	45	0.25	1.4	—	—	—

CN	DN	KN	LN	RN	SN	TN	VN	WN
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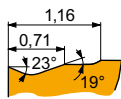
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(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)



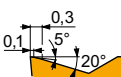
EL-SI geometri med positiv venstrehendt design for fin til halv-grov bearbeiding og kontinuerlige kutt.

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



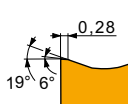
W-F Wipergeometri for finbearbeiding med økt mating og forbedret overflate.

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	■	—	—	—	—	—	—



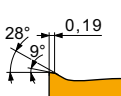
W-M wipergeometri for halv-grov til grov bearbeiding med økt mating og forbedret overflate.

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-MR wipergeometri for fin til grov bearbeiding med økt mating og forbedret overflate.

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	■	—	—	—	—	—	—



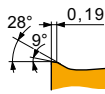
W-NM-wipergeometri for fin til grov bearbeiding med økt mating og forbedret overflate.

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	—	—	—

CN	DN	KN	LN	RN	SN	TN	VN	WN
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Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(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)



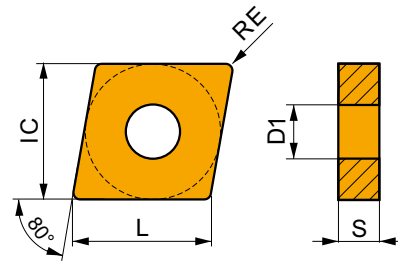
W-NM-wiperergeometri for fin til grov bearbeiding med økt mating og forbedret overflate.

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

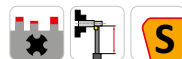
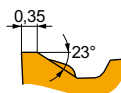


	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.90	4.76
1606	15.875	6.35	16.10	6.35
1906	19.050	7.94	19.30	6.35
2509	25.400	9.12	25.80	9.53



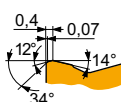
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(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)



DR-geometri for middels til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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	—	—	—	—	—	—	—	—	—	—	—	—



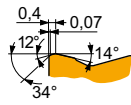
HR-geometri for grov til tung-grov bearbeiding, og kontinuerlig til avbrutt kutt.

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	—	—	—	—	—	—	—	—	—	—	—	—

CN	DN	KN	LN	RN	SN	TN	VN	WN
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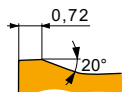
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

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)



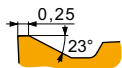
HR-geometri for grov til tung-grov bearbeiding, og kontinuerlig til avbrutt kutt.

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	—	—	—	—	—	—	—	—	—	—



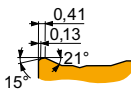
HR2-geometri for grov til tung-grov bearbeiding, og kontinuerlig til avbrutt kutt.

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 for medium til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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
	T8430	0.8	■	165	0.40	3.0	■	90	0.36	3.0	■	135	0.40	3.0	—	—	—	■	35	0.28
	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
	T9335	0.8	■	175	0.40	3.0	■	135	0.36	3.0	—	—	—	—	■	60	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
	T8430	1.2	■	170	0.40	3.0	■	90	0.36	3.0	■	135	0.40	3.0	—	—	—	■	35	0.28
	T9325	1.2	■	205	0.40	3.0	■	120	0.36	3.0	■	190	0.40	3.0	—	—	—	■	45	0.28



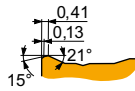
NR2 geometri for middels til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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
	T8430	0.8	■	150	0.40	5.0	■	80	0.36	5.0	■	125	0.40	5.0	—	—	—	■	30	0.28
	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
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
	T8430	1.2	■	150	0.45	5.0	■	80	0.41	5.0	■	125	0.45	5.0	—	—	—	■	30	0.32
	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
CNMM 160608E-NR2	T8330	0.8	■	145	0.40	6.0	■	85	0.36	6.0	■	135	0.40	6.0	—	—	—	■	35	0.32
	T8430	0.8	■	150	0.40	6.0	■	80	0.36	6.0	■	125	0.40	6.0	—	—	—	■	30	0.32
	T9325	0.8	■	180	0.40	6.0	■	105	0.36	6.0	■	170	0.40	6.0	—	—	—	■	40	0.32

CN	DN	KN	LN	RN	SN	TN	VN	WN
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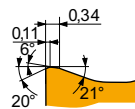
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(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)



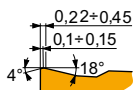
NR2 geometri for middels til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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	—	—	—
CNMM 190616E-NR2	T9325	1.2	175	0.45	9.0	105	0.41	9.0	165	0.45	9.0	—	—	—	35	0.36	7.2	—	—	—
	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	—	—	—	—	—	—	—	—	—
CNMM 190624E-NR2	T9325	1.6	175	0.50	9.0	105	0.45	9.0	165	0.50	9.0	—	—	—	35	0.40	7.2	—	—	—
	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 positiv design for middels til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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	—	—	—	—	—	—	—	—	—



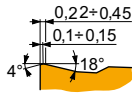
OR geometri for middels til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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	—	—	—

CN	DN	KN	LN	RN	SN	TN	VN	WN
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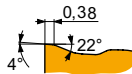
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	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)



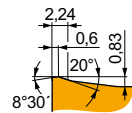
OR geometri for middels til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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
CNMM 190616E-OR	T9335	1.2	■	150	0.45	9.0	■	90	0.41	9.0	■	—	—	—		—	—	—	■	30	0.36	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
	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 for middels til tung-grov bearbeiding, og kontinuerlig til avbrutt kutt.

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



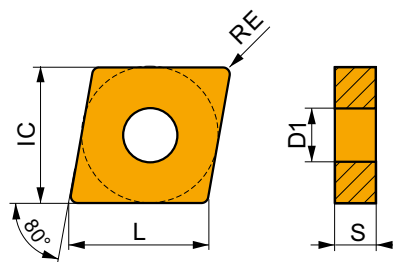
Geometri 923 for halv-grov til tung-grov bearbeiding, og kontinuerlig til kraftig avbrutt kutt.

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

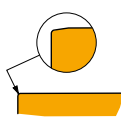
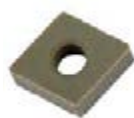


	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1204	12.700	5.16	12.90	4.76



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere 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)



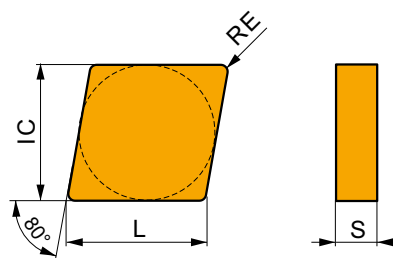
For maskinering med høye hastigheter og kontinuerlige kutt.

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

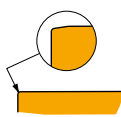


	IC	L	S
	(mm)	(mm)	(mm)
1204	12.700	12.90	4.76
1207	12.700	12.90	7.94



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere 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)

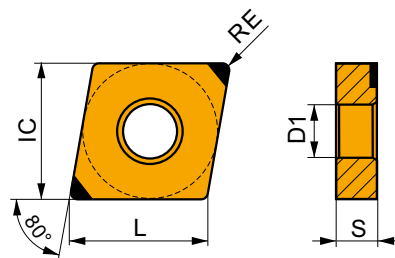


For maskinering med høye hastigheter og kontinuerlige kutt.

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	—	—	—	—	—	—	—	—

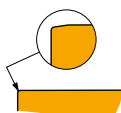
CNGA CBN

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



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere 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)



For ferdig bearbeiding og kontinuerlige kutt.

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



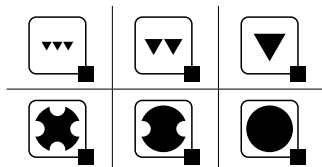
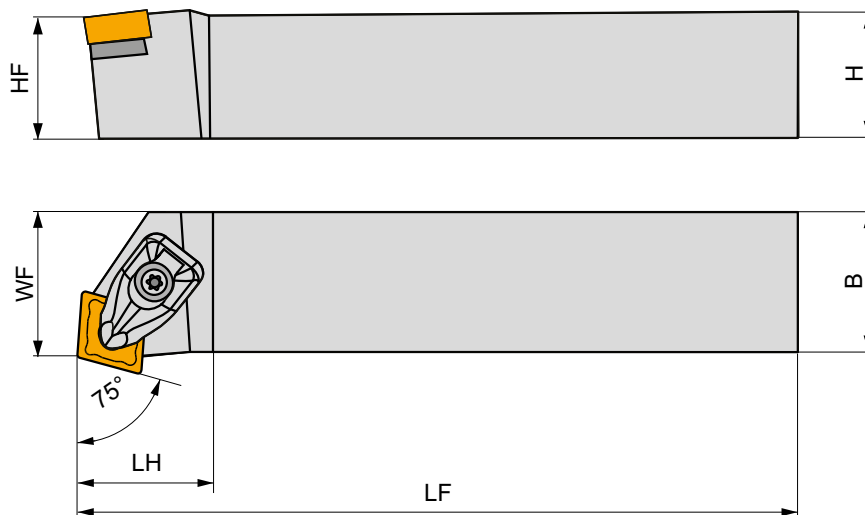
PRAMET

D



Utvendig dreieholder med klemhode 75 ° skjærevinkel for CN .. Skjær

Utvendig høyre / venstre dreieholder med klemhode, 75 ° holder. Passer til langsgående og overflatedreining uten skulder og avfasning med negativ CN .. 12 inntil 19 skjærstørrelse. Tilgjengelig med skaft 20x20 opp til 40x40 mm. Behandlet for lengre levetid.



	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg			
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)				
R	DCBNR 2020 K 12	20	20	20	17	125	34.2	-6	-6	0.43	GI043	DC12	AT001
	DCBNR 2525 M 12	25	25	25	22	150	34.6	-6	-6	0.76	GI043	DC12	AT001
	DCBNR 3225 P 12	32	25	32	22	170	34.6	-6	-6	1.09	GI043	DC12	AT001
	DCBNR 2525 M 16	25	25	25	22	150	41.5	-6	-6	0.80	GI050	DC16	AT005
	DCBNR 3225 P 16	32	25	32	22	170	32	-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..



DC12

DCS 12

3.9

DCS 234-01

US 2002-T15P

FLAGT15P/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



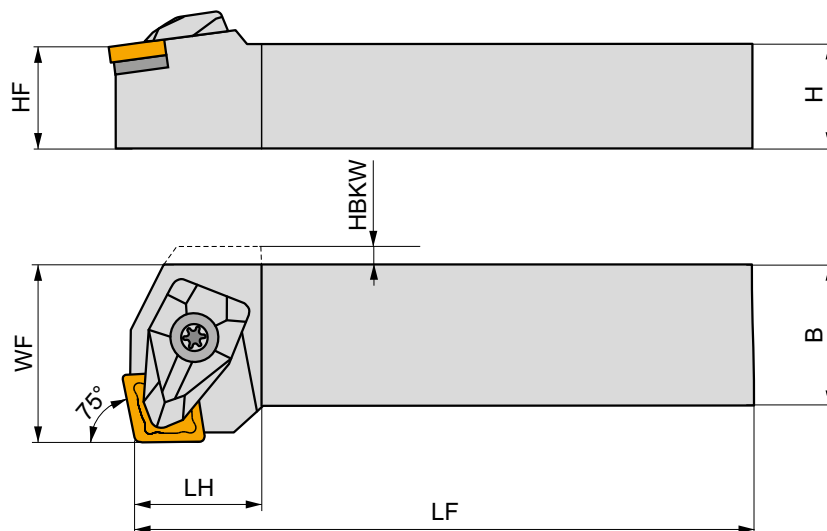
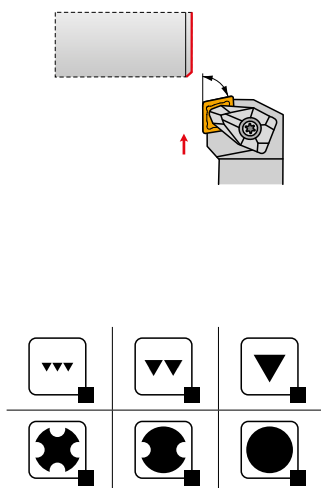
PRAMET

D



Utvendig dreieholder med klemhode, 75 ° (overflate) skjærevinkel for CN .. Skjær

Utvendig høyre / venstre klemhode 75 ° dreieholder. Egnet for overflatedreining og av og til fasing med negative CN .. 12 eller 16 skjærstørrelse. Tilgjengelig med skaft 20x20 opp til 32x32 mm. Behandlet for lengre 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

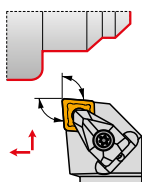
AT001a	CN.. 1207..	—	DCS 234-02
AT005a	CN.. 1607..	—	DCS 234-04
AT001b	CER CN.N 1204..	DCS 12C4	—
AT001c	CER CN.A 1204..	DCS 12C2	—
AT005b	CER CN.N 1606..	DCS 16C4	—
AT005c	CER CN.A 1606..	DCS 16C2	—

DCLN(RL) EXT



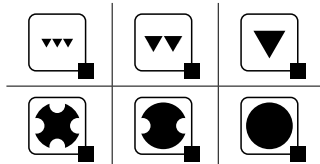
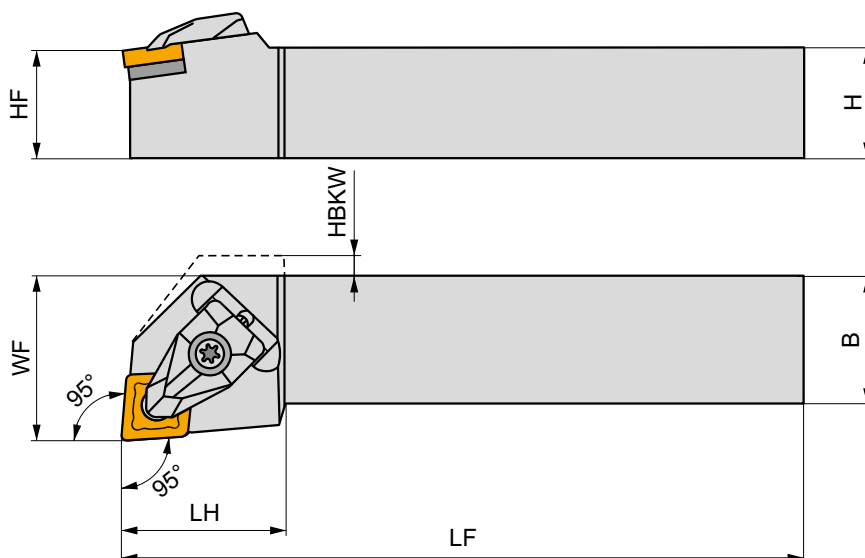
PRAMET

D



Utvendig dreieholder med klemhode 95 ° skjærevinkel for CN .. Skjær

Utvendig høyre / venstredreieholder med klemhode, 95 ° dreieholder. Passer for langsgående dreining, fasing og skulderfasing ved bruk av negative CN .. 09 inntil 19 skjærestørrelse og tilgjengelig i 16x16 opp til 40x40 mm skaft. Behandlet for lengre levetid for verktøyet.



	Product	H	B	HF	WF	LF	LH	HBKW	LAMS	GAMO	kg			
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)				
R	DCLNR 1616 H 09	16	16	16	20	100	25	—	-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	DC12	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	—
L	DCLNR 4040 S 19	40	40	40	50	250	43.4	—	-6	-6	3.26	GI042	DC19	—
	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	DC12	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
DC112	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



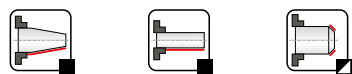
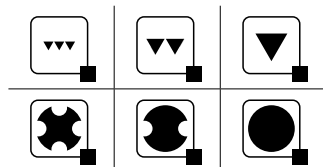
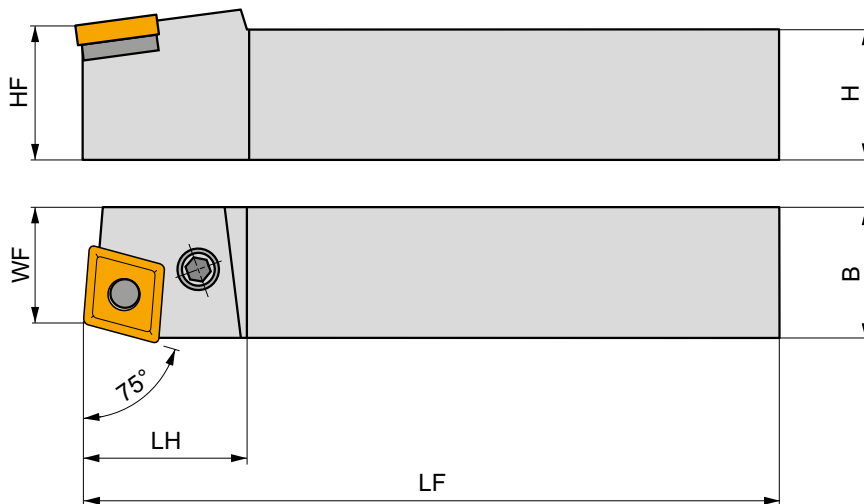
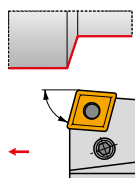
PRAMET

P



Utvendig dreieholder med 75° skjærevinkel for CN .. Skjær

Utvendig høyre / venstre hånd dreieholder 75°. Egnet for utvendig fasing, konisk og langsgående dreiging uten skulder, ved bruk av negative CN .. 12, 16, 19 eller 25 skjærstørrelse. Tilgjengelig i 20x20 opptil 50x50 mm skaft. Behandlet for lengre levetid.



	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
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..



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

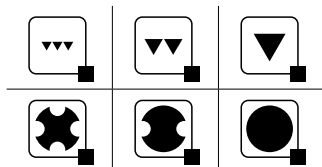
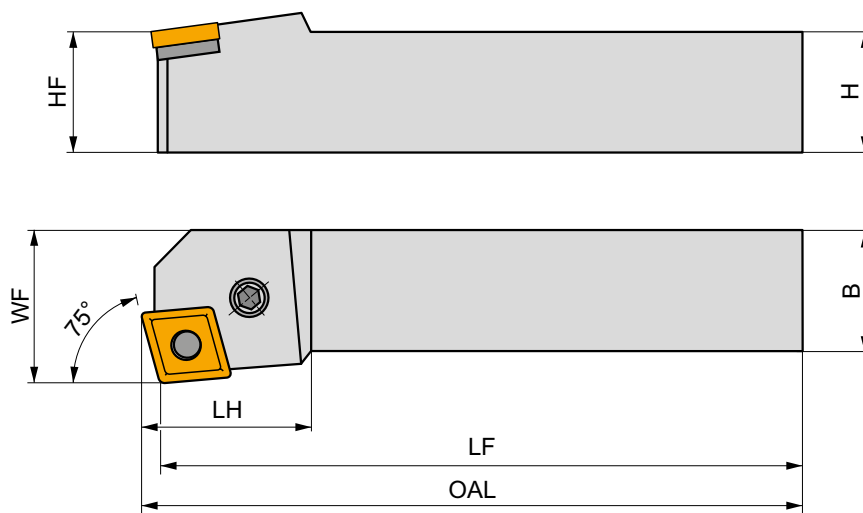
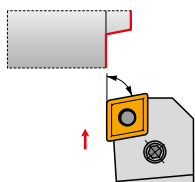


PRAMET

P

**Utvendig dreieholder, 75 ° (Overflate dreining) Skjærevinkel for CN .. Skjær**

Utvendig høyre / venstre hånd dreieholder 75 °. Egnet for utvendig fasing og overflatedreining med skulder ved bruk av negative CN .. 12, 16 eller 19 skjærstørrelse. Tilgjengelig i 20x20 opptil 40x40 mm skaft. Behandlet for lengre levetid.



	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	PCKNR 2020 K 12	20	20	20	25	125	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..



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

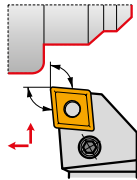
HXK 5

PCLN(RL) EXT

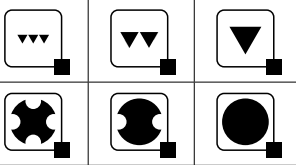
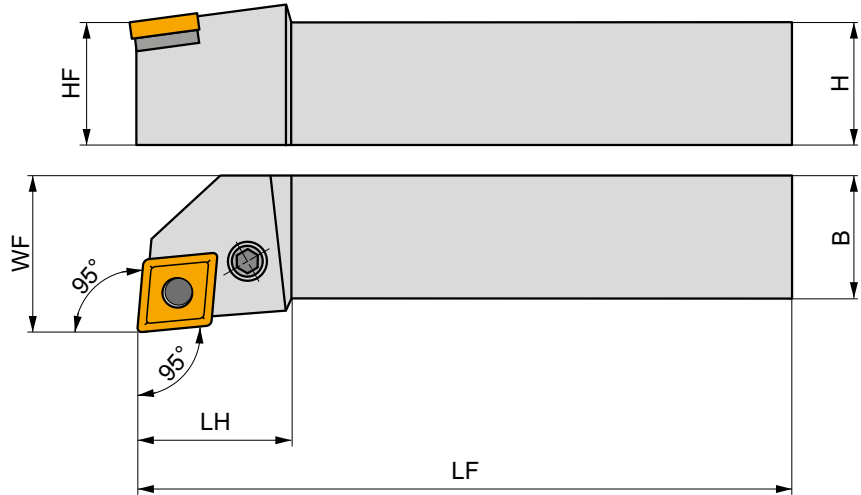


PRAMET

P

**Utvendig dreieholder med 95° skjærvinkel for CN .. Skjær**

Utvendig høyre / venstre hånd dreieholder 95°. Egnert for utvendig konisk dreining, overflate, langsgående med skulderdreining og fasing med negative CN .. 12, 16, 19 eller 25 skjærstørrelse. Tilgjengelig i 20x20 opptil 50x50 mm skaft. Behandlet for lengre levetid.



Product		H	B	HF	WF	LF	LH	LAMS	GAMO	kg	GI	PC
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
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
L	PCLNL 5050 T 25	50	50	50	60	300	50	-6	-6	5.90	GI062	PC60
	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..

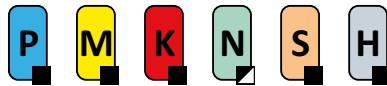
GI050

CN.. 1606..

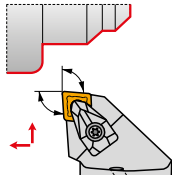
GI062

CN.. 2509..

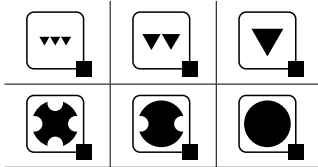
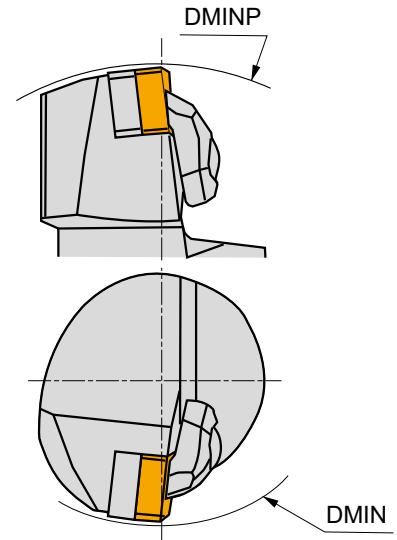
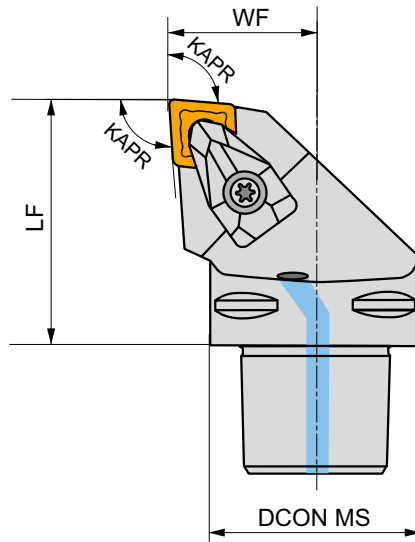
				 Nm					
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PC22	CNU 120312	PU 02	US 42	6.0	M 8x1	21	NT 05	MT 05	HXX 4
PC40	CNU 150312	PU 04	US 36	6.0	M 8x1	26	NT 07	MT 07	HXX 4
PC50	CNU 190416	PU 05	US 38	8.0	M 10x1	29	NT 06	MT 06	HXX 5
PC60	CNU 250620	PU 06	US 39	8.0	M 10x1	33	NT 08	MT 08	HXX 5

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

PRAMET

D**Utv. PSC hurtigveksling dreieholder, klemhode, 95° skjærevinkel for CN .. Skjær**

Utvendig høyre / venstre hånds dreieholder med klemhode, innvendig kjøling, med 95° skjærevinkel for langsgående dreining, fasing og overflatedreining med skulder, ved bruk av negative CN .. 12 inntil 19 skjærstørrelse. Tilgjengelig med PSC (Polygon Shank Coupling) C3 opp til C8. Behandlet for lengre levetid.



	Product	DCON MS	DMIN	DMINP	WF	LF	KAPR	LAMS	GAMO					
		(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)	(°)					
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	—
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)

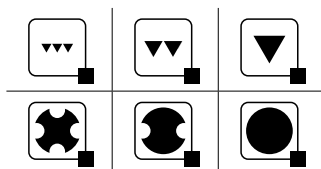
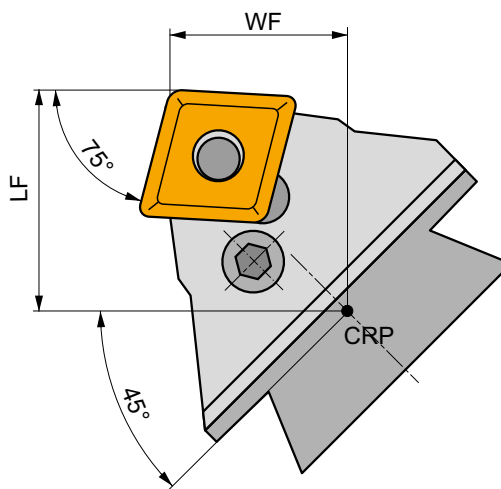
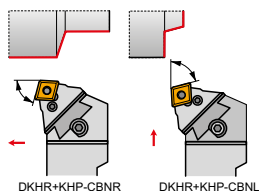


PRAMET

P

**Modulær dreiepatron KHP låsespor, 75 ° skjærevinkel for CN .. Skjær**

Koblingshus høyre / venstre dreiepatron, 75 ° skjærevinkel, for montering på DKH verktøyholder. Egnet for tung langsgående sving uten skulder, ansiktsvending, konisk og fasing med negativ CN .. 25 skjær. Verktøyholder behandlet for lengre levetid.



Product		WF	LF	LAMS	GAMO	kg		
		(mm)	(mm)	(°)	(°)			
R	KHP-CBNR 25	32	47	-6	-6	1.54	GI062	PC60
L	KHP-CBNL 25	32	47	-6	-6	1.56	GI062	PC60



GI062



CN.. 2509..



PC60



CNU 250620



PU 06



US 39



8.0



M 10x1



33



NT 08



MT 08



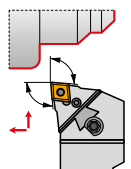
HXK 5

KHP-CLN(RL)



PRAMET

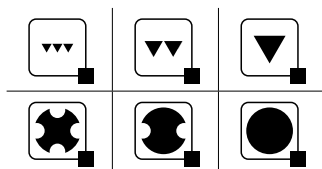
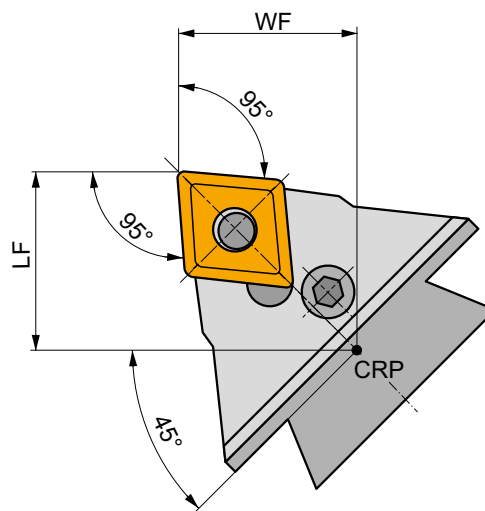
P



DKHR+KHP-CLNR

Modulær dreiepatron KHP låsespor, 95 ° skjærevinkel for CN .. Skjær

Koblingshus høyre / venstre dreiepatron, 95 ° skjærevinkel, for montering på DKH verktøyholder. Egnet for kraftig langsgående dreining med skulder, ansiktssving med skulder, konisk og fasing med negativ CN .. 19 eller 25 skjær. Verktøyholder behandlet for lengre levetid.



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

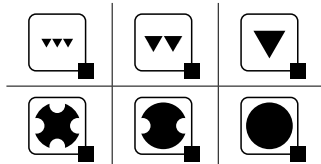
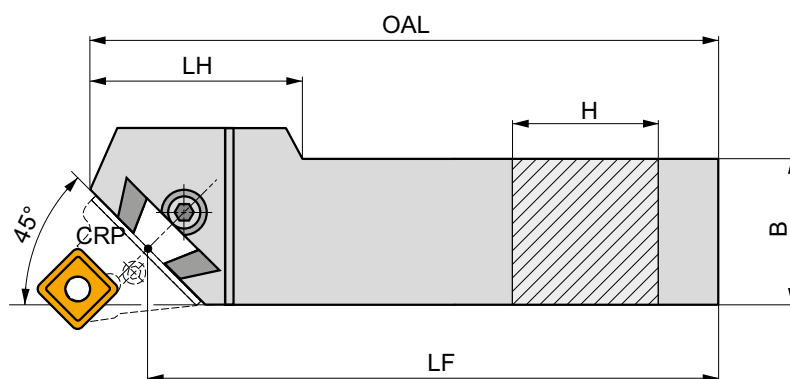
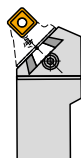
GI042							
GI062							

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)

**Utvendig verktøyholderskaff for KHP / KHS Grove dreiepatroner**

Koblingshus høyre / venstre hånds verktøyskaff for KHP / KHS-kassetter. Egnet for tunge dreie applikasjoner. Tilgjengelig med skaftstørrelse 40x50 opp til 60x80 mm. Behandlet for lengre levetid.



Product		H	B	LF	OAL	LH	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)			
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	HXX 10

DCLN(RL) INT

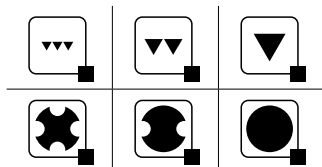
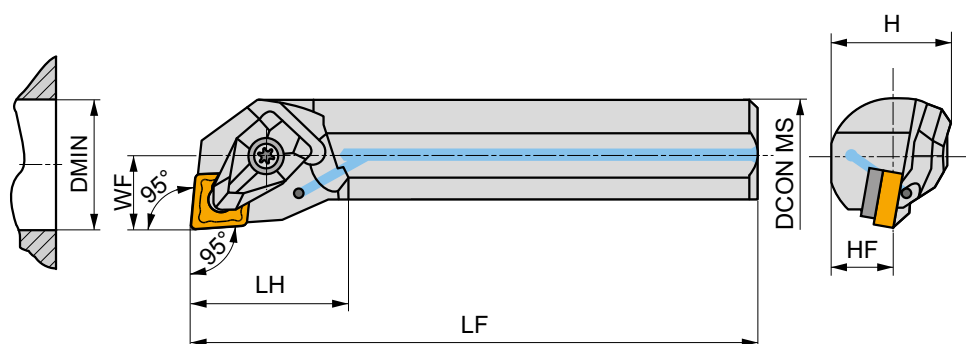
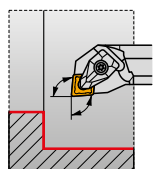


PRAMET

D

**Innvendig dreiebom med klemhode og 95° skjærevinkel for CN .. Skjær**

Innvendig høyre/venstre dreiebom med toppklemming, med innvendig kjøling, 95° skjærevinkel for CN .. 09 og 12 skjær. Minimum innvendig dreiediameter Ø32 mm. For innvendig konisk og langsgående dreieing med skulder- og fasing. Finnes med skaftstørrelse Ø25 opp til Ø40 mm. Behandlet for lengre levetid.



Product	DCON MS	DMIN	WF	H	HF	LF	LH	LAMS	GAMO				
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)		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 DC12
	A32T-DCLNR 12	32	40	22	30	15	300	30	-10	-6	✓	1.68	GI043 DC12
	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 DC12
	A32T-DCLNL 12	32	40	22	30	15	300	30	-10	-6	✓	1.68	GI043 DC12
	A40T-DCLNL 12	40	50	27	37	18.5	300	32	-15	-6	✓	2.56	GI043 DC12



GI043

CN.. 1204..

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

DC112

DCS 12

3.9

DCS 236-03

US 2002-T15P

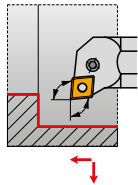
FLAG T15P/3,5

PCLN(RL) INT

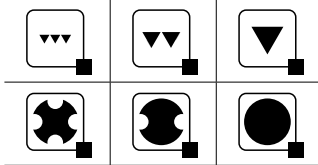
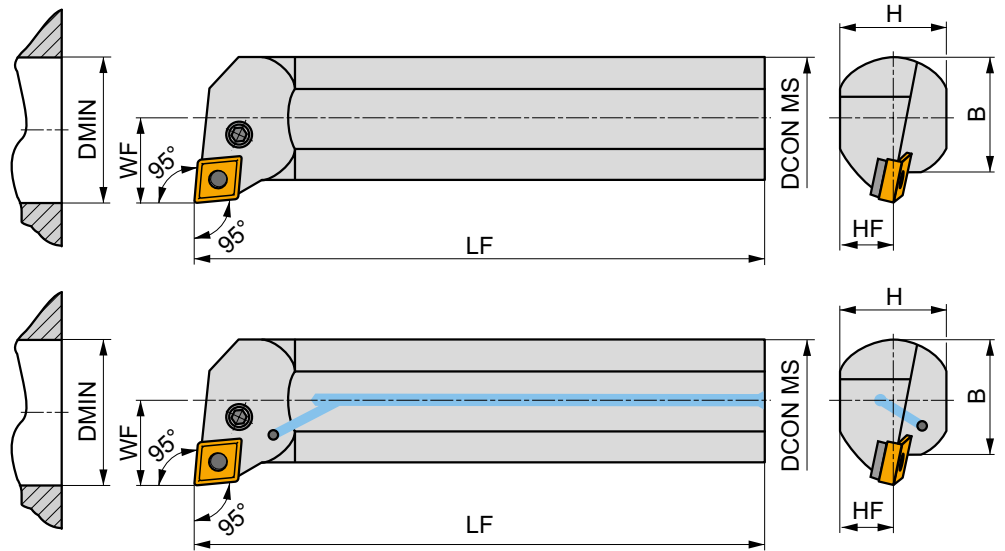


PRAMET

P

**Innvendig dreiebom med 95° skjærevinkel for CN .. Skjær**

Innvendig høyre/venstre hånd dreiebom, tilgjengelig med innvendig kjøling, 95° skjærevinkel for CN .. 09, 12, 16 og 19 iskjær. Minimum innvendig dreiediameter Ø20 mm. For innvendig konisk og langsgående dreieing med skulder- og fasing. Ø16 til Ø60 mm skaft tilgjengelig. behandlet for lengre levetidB



	Product	DCON MS	DMIN	WF	H	B	LF	LAMS	GAMO				
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)				
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
	A16M-PCLNL 09	16	20	11	15	15	150	-13.5	-5	✓	0.20	GI133	PC09
L	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
GI043



CN.. 1906..
CN.. 1204..

								
GI050	CN.. 1606..							
GI133	CN.. 0903..							

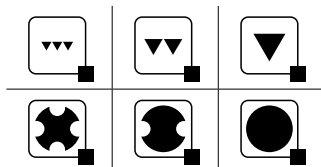
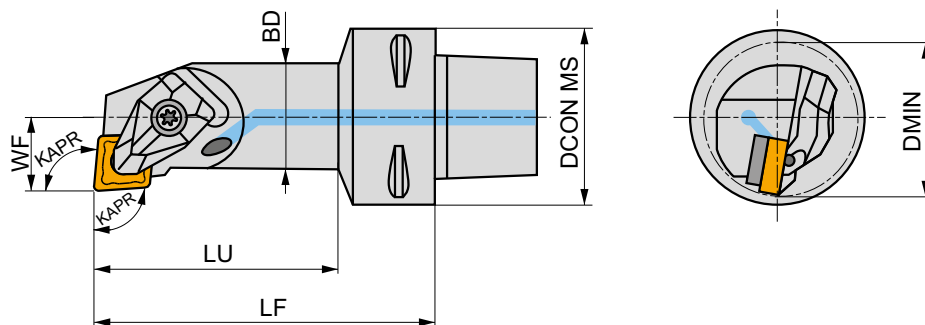
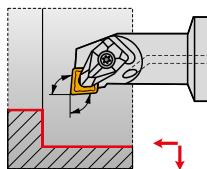
									
PC09	—	PU 8451	PS 8290	2.0	M 5	12	—	—	HXX 2
PC20	CNU 120312	PU 02	US 35	6.0	M 8x1	22.5	NT 05	MT 05	HXX 4
PC21	CNU 120312	PU 02	US 41	6.0	M 8x1	17	NT 05	MT 05	HXX 4
PC25	—	PU 32	US 46	5.0	M 6x0.75	13.2	—	—	HXX 3
PC40	CNU 150312	PU 04	US 36	6.0	M 8x1	26	NT 07	MT 07	HXX 4
PC41	CNU 150312	PU 04	US 40	6.0	M 8x1	20.5	NT 07	MT 07	HXX 4
PC50	CNU 190416	PU 05	US 38	8.0	M 10x1	29	NT 06	MT 06	HXX 5

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

PRAMET

D**Innv. PSC hurtig veksling dreieholder, klemhode, 95 ° skjærevinkel for CN .. skjær**

Innvendig høyre/venstre hånd dreieholder med klemhode, med innvendig kjøling, med 95° skjærevinkel for negative CN .. 09 opp til 16 skjær, egnet for et bredt spekter av innvendige dreieapplikasjoner, minimum diameter Ø25mm. PSC-skaft (Polygon Shank Coupling) størrelse C4 opp til C6 med valg av lengder. Behandlet for lengre levetid.



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	DC112
	C5-DCLNR-17090-12	50	32	17	90	66	25	95	-12	-6	✓	0.72	GI043	DC112
	C6-DCLNR-17100-12	63	32	17	100	72	25	95	-12	-6	✓	1.15	GI043	DC112
	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	DC112
	C5-DCLNL-17090-12	50	32	17	90	66	25	95	-12	-6	✓	0.72	GI043	DC112



GI043	CN.. 1204..
GI050	CN.. 1606..
GI133	CN.. 0903..



DC09	DCS 09	1.7	DCS 236-04	US 2004-T09P	FLAG T09P	—
DC16	DCS 16	6.4	DCS 234-03	US 2007-T20P	—	LKT20P
DC112	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

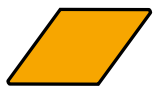
CER AND CBN INSERTS

DNGA CER



271

DNGN CER



271

DNGA CBN



272

MATCH THE RIGHT SIZE (example)

Insert

DNMG 150404E-SF

Tool Holder

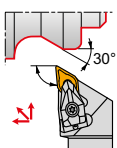
DDJNL 2020 K 15

ISO DREIING – EKSTERN

DDJN(RL) EXT

93°

DN..


 20×20
32×32

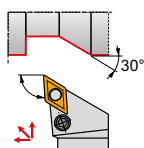
273

260 – 272

PDJN(RL) EXT

93°

DN..


 20×20
32×32

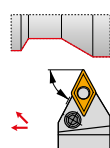
274

260 – 272

PDNN(RL) EXT

62°30'

DN..


 20×20
32×25

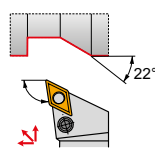
275

260 – 272

PDXN(RL) EXT

98°

DN..


 20×20
32×25

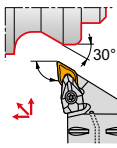
276

260 – 272

C.-DDJN(RL) EXT **NEW**

93°

DN..


 C4
C6

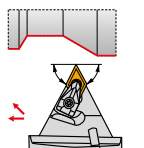
277

260 – 272

C.-DDNNN EXT **NEW**

62,5°

DN..


 C5
C6

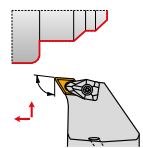
278

260 – 272

C.-DDUN(RL) EXT **NEW**

93°

DN..


 C5
C6

279

260 – 272

DN

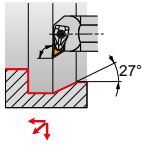
11/ 15

ISO DREIING – INTERNT

DDUN(RL) INT

93°

DN..

11
1525
50

280

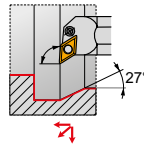


260 – 272

PDUN(RL) INT

93°

DN..

11
1525
60

281



260 – 272

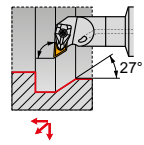
C.-DDUN(RL) INT **NEW**

93°

DN..



11



12



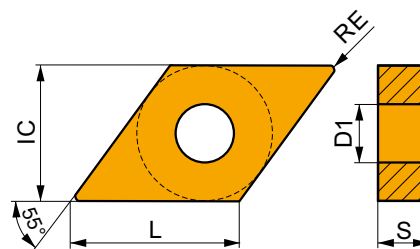
282



260 – 272

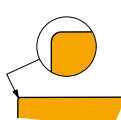
DNMA

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



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere 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)

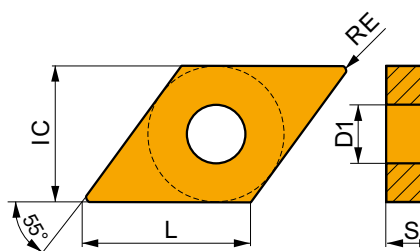


For fin til halv-grov bearbeiding og kontinuerlige til lett avbrutte kutt.

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

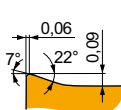
DNMG

	IC	D1	L	S
	(mm)	(mm)	(mm)	(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



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere 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)



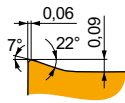
FF-geometri med meget positiv design for finbearbeiding og kontinuerlige til lett avbrutte kutt.

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	—	—	—	—	—	—	—	—

CN	DN	KN	LN	RN	SN	TN	VN	WN
----	----	----	----	----	----	----	----	----

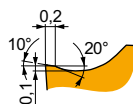
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(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)



FF-geometri med meget positiv design for finbearbeiding og kontinuerlige til lett avbrutte kutt.

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	—	—	—	—	—	—	—	—	—	—
DNMG 150608E-FF	T8315	0.4	✓	175	0.12	1.0	■	105	0.11	1.0	✓	165	0.12	1.0	—	—	—	—	—	—
	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	—	—	—	—	—	—



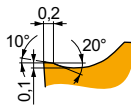
FM-geometri med positiv design for fin til halv-grov bearbeiding, og kontinuerlige til lett avbrutte kutt.

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	—	—	—

CN	DN	KN	LN	RN	SN	TN	VN	WN
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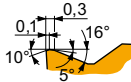
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(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)



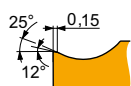
FM-geometri med positiv design for fin til halv-grov bearbeiding, og kontinuerlige til lett avbrutte kutt.

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 for fin til middels bearbeiding, og kontinuerlig til avbrutt kutt.

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	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—



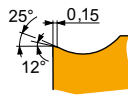
NF-geometri med meget positiv design for finbearbeiding til middels bearbeiding og kontinuerlige kutt.

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	—	—	—

CN	DN	KN	LN	RN	SN	TN	VN	WN
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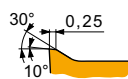
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	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 positiv design for finbearbeiding til middels bearbeiding og kontinuerlige kutt.

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	—	—	—
DNMG 150608E-NF	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	—	—	—
	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	—	—	—
DNMG 150612E-NF	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	—	—	—
	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	—	—	—



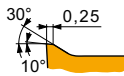
NM-geometri med meget positiv design for finbearbeiding, middels til grov bearbeiding og kontinuerlige kutt.

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		—	—	—

CN	DN	KN	LN	RN	SN	TN	VN	WN
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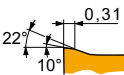
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(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)



NM-geometri med meget positiv design for finbearbeiding, middels til grov bearbeiding og kontinuerlige kutt.

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	—	—	—
	T7325	0.4	160	0.20	1.9	120	0.18	1.9	—	—	—	—	—	—	50	0.20	1.5	—	—	—
DNMG 150604E-NM	T7335	0.4	150	0.20	1.9	115	0.18	1.9	—	—	—	—	—	—	45	0.20	1.5	—	—	—
	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	—	—	—
	T7325	0.8	175	0.25	1.9	135	0.23	1.9	—	—	—	—	—	—	55	0.20	1.5	—	—	—
DNMG 150608E-NM	T7335	0.8	170	0.25	1.9	130	0.23	1.9	—	—	—	—	—	—	55	0.20	1.5	—	—	—
	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	—	—	—
	T7325	1.2	175	0.30	1.9	135	0.27	1.9	—	—	—	—	—	—	55	0.24	1.5	—	—	—
DNMG 150612E-NM	T7335	1.2	170	0.30	1.9	130	0.27	1.9	—	—	—	—	—	—	55	0.24	1.5	—	—	—
	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	—	—	—



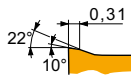
NMR-geometri med positiv design for middels til grov bearbeiding og kontinuerlige kutt.

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	—	—	—
	T7325	0.4	140	0.20	1.9	105	0.18	1.9	—	—	—	—	—	—	45	0.18	1.5	—	—	—
DNMG 150604E-NMR	T7335	0.4	130	0.20	1.9	100	0.18	1.9	—	—	—	—	—	—	40	0.18	1.5	—	—	—
	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	—	—	—

CN	DN	KN	LN	RN	SN	TN	VN	WN
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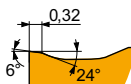
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(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)



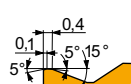
NMR-geometri med positiv design for middels til grov bearbeiding og kontinuerlige kutt.

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	—	—	—



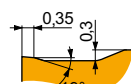
NRM-geometri med positiv design for middels til grov bearbeiding, og kontinuerlig til moderat avbrutt kutt.

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 for halv-grov til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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	■	—	—	—	■	—	—	—
	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
DNMG 150612E-R	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	■	—	—	—	■	—	—	—
	T9325	1.6	■	155	0.40	3.0	■	—	—	—	▣	145	0.40	3.0	■	—	—	—	■	—	—	—



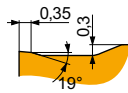
RM-geometri for halv-grov til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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	■	—	—	—	■	—	—	—

CN	DN	KN	LN	RN	SN	TN	VN	WN
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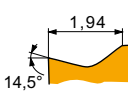
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

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



RM-geometri for halv-grov til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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	—	—	—	—	—	—	—	—	—
DNMG 150608E-RM	T9335	1.2	150	0.40	3.0	90	0.36	3.0	—	—	—	—	—	—	—	—	—	—	—	—
	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	—	—	—	—	—	—	—	—	—
DNMG 150612E-RM	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	—	—	—	—	—	—	—	—	—
DNMG 150616E-RM	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	—	—	—	—	—	—	—	—	—
DNMG 150612E-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 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	—	—	—	—	—	—	—	—	—	—	—	—
DNMG 150612E-RM	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	—	—	—	—	—	—	—	—	—
DNMG 150612E-RM	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	—	—	—	—	—	—	—	—	—
DNMG 150612E-RM	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	—	—	—	—	—	—	—	—	—
DNMG 150616E-RM	T9335	1.6	155	0.40	3.0	90	0.36	3.0	—	—	—	—	—	—	—	—	—	—	—	—



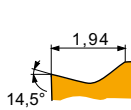
SF-geometri med positiv design for finbearbeiding av tynne vegger og kontinuerlige kutt.

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
DNMG 110408E-SF	T8430	0.4	180	0.15	0.8	95	0.14	0.8	145	0.15	0.8	495	0.18	0.8	35	0.12	0.6	30	0.15	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	—	—	—
DNMG 150404E-SF	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
DNMG 150404E-SF	T9325	0.4	195	0.17	1.5	115	0.15	1.5	185	0.17	1.5	—	—	—	40	0.15	1.2	—	—	—

CN	DN	KN	LN	RN	SN	TN	VN	WN
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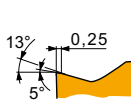
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(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)



SF-geometri med positiv design for finbearbeiding av tynne vegger og kontinuerlige kutt.

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



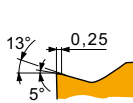
SM-geometri med positiv design for middels bearbeiding og kontinuerlige til avbrutte kutt.

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	■	—	—	—

CN	DN	KN	LN	RN	SN	TN	VN	WN
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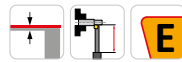
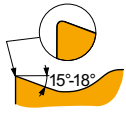
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(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)



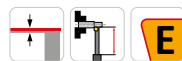
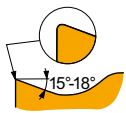
SM-geometri med positiv design for middels bearbeiding og kontinuerlige til avbrutte kutt.

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 positiv høyrehendt design for fin til halv-grov bearbeiding og kontinuerlige kutt.

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	—	—	—



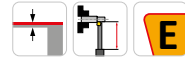
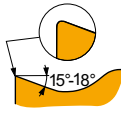
EL-SI-geometri med positiv venstrehendt design for fin til halv-grov bearbeiding og kontinuerlige kutt.

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	—	—	—

CN	DN	KN	LN	RN	SN	TN	VN	WN
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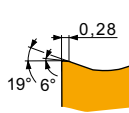
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

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)



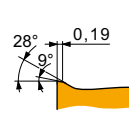
EL-SI-geometri med positiv venstrehendt design for fin til halv-grov bearbeiding og kontinuerlige kutt.

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	—	—	—	
	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-MR wipergeometri for fin til grov bearbeiding med økt mating og forbedret overflate.

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	■	—	—	—	—	—	—

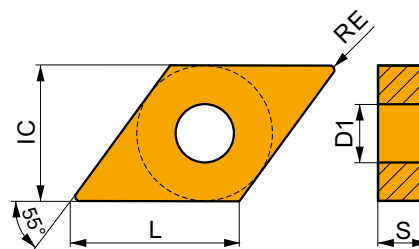


W-NM-wiperergeometri for fin til grov bearbeiding med økt mating og forbedret overflate.

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	—	—	—

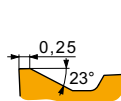
DNMM

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



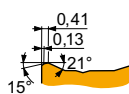
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

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)



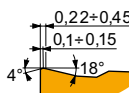
NR-geometri for medium til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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 for middels til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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	—	—	—
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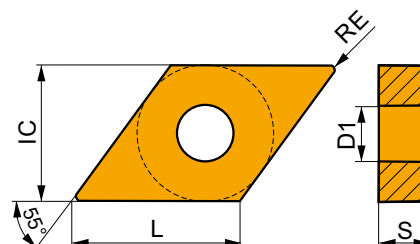
OR geometri for middels til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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



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



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere 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)



For maskinering med høye hastigheter og kontinuerlige kutt.

DNGA 150408 S02020	TC100	0.8	—	—	—	—	—	—	450	0.20	1.5	—	—	—	—	—	—	—	—	—
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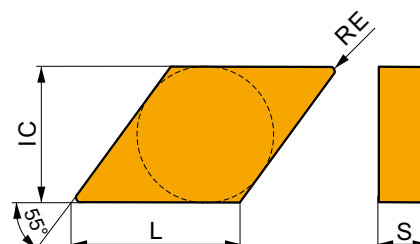
For maskinering med høye hastigheter og kontinuerlige kutt.

DNGA 150404 T01020	TC100	0.4	—	—	—	—	—	—	475	0.10	1.5	—	—	—	—	—	—	—	—	—
DNGA 150408 T00520	TC100	0.8	—	—	—	—	—	—	450	0.20	1.5	—	—	—	—	—	—	—	—	—

DNGN CER



	IC	L	S
	(mm)	(mm)	(mm)
1504	12.700	15.50	4.76



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere 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)

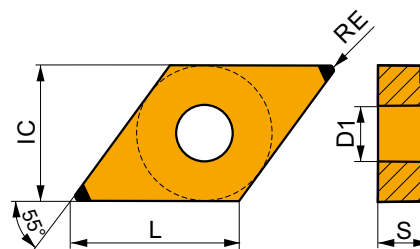


For maskinering med høye hastigheter og kontinuerlige kutt.

DNGN 150408 T01020	TC100	0.8	—	—	—	—	—	—	450	0.20	1.5	—	—	—	—	—	—	—	—	—
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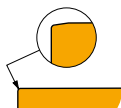
DNGA CBN

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



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere 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)



For ferdig bearbeiding og kontinuerlige kutt.

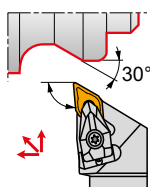
DNGA 150608S01020B	TB310	0.8	—	—	—	—	—	—	420	0.15	0.6	—	—	—	110	0.11	0.5	85	0.15	1.0
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DDJN(RL) EXT



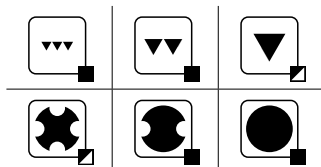
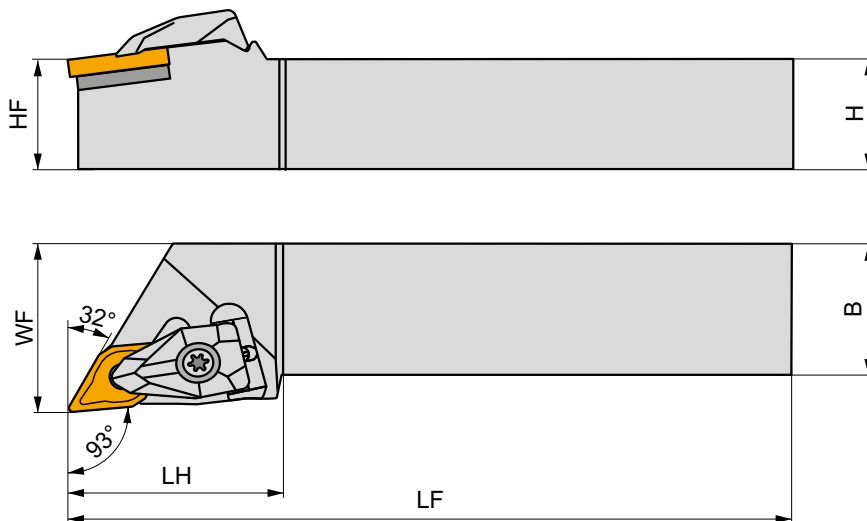
PRAMET

D



Utvendig dreieholder med klemhode 93 ° skjærevinkel for DN .. Skjær

Utvendig høyre / venstre dreieholder med klemhode skjærevinkel på 93 °. Passer for langsgående dreiging med skulder, forming, fasing og overflate med negative DN .. 11 eller 15 skjærstørrelse. Tilgjengelig med skaftstørrelse 20x20 opp til 32x32 mm. Behandlet for lengre levetid.



Product		H	B	HF	WF	LH	LF	LAMS	GAMO	kg			
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)				
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..



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



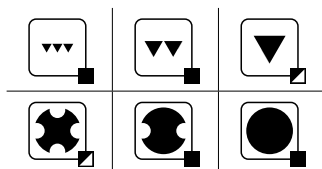
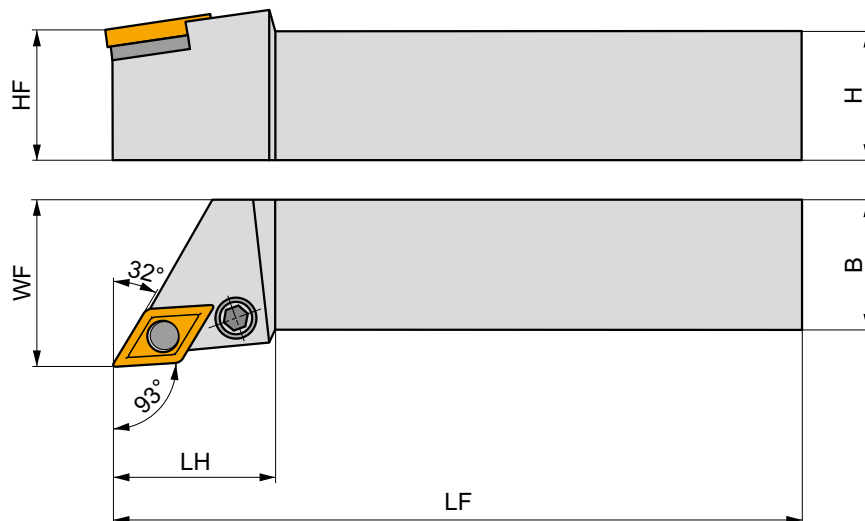
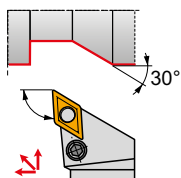
PRAMET

P



Utvendig dreieholder med 93° skjærevinkel for DN .. Skjær

Utvendig høyre / venstre hånd dreieholder med 93° skjærevinkel. Passer for langsgående dreining med skulder, forming opp til 30° og avfasning med negative DN .. 11 og 15 skjærstørrelse. Tilgjengelig med skaftstørrelse 20x20 opp til 32x32 mm. Behandlet for lengre levetid.



	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
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
L	PDJNR 3232 P 15	32	32	32	40	170	40	-6	-6	1.30	GI044	PD30
	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..



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

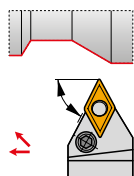
HXK 2.5

PDNN(RL) EXT



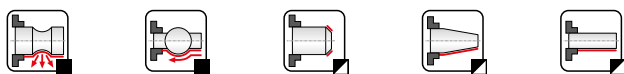
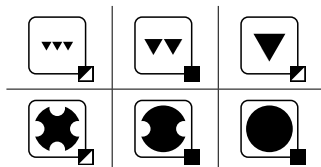
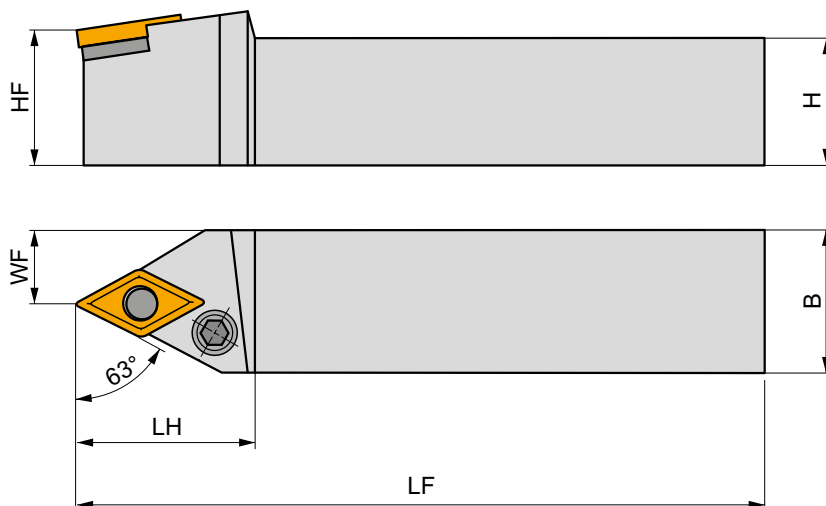
PRAMET

P



Utvendig dreieholder med 63° skjærevinkel for DN .. Skjær

Utvendig høyre / venstre hånd dreieholder 63° (nøytral). Passer til langsgående dreiging uten skulder, konisk dreiging, form og avfasing med negativ DN .. 15 skjærstørrelse Tilgjengelig med skaftstørrelse 20x20 opp til 32x25 mm. Behandlet for lengre levetid.



Product		H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
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..



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

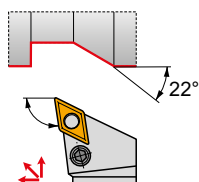
HXK 2.5

PDXN(RL) EXT



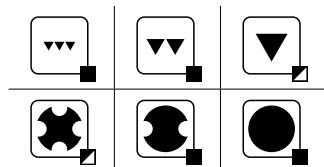
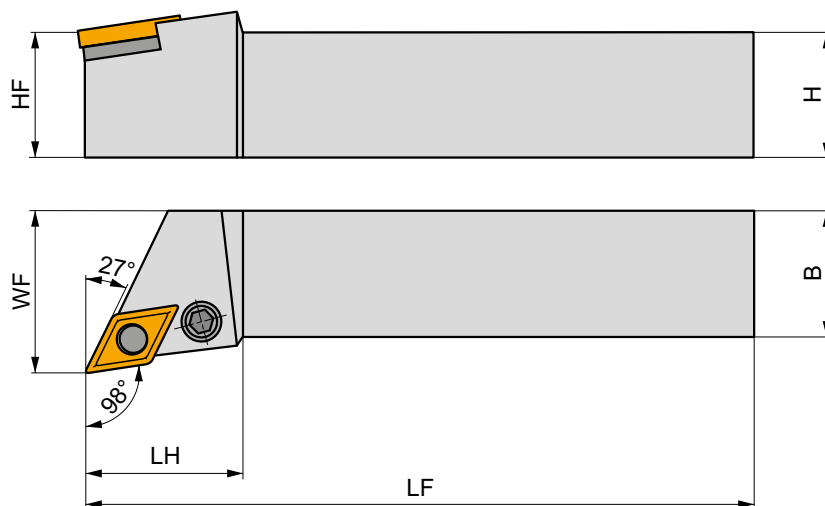
PRAMET

P



Utvendig dreieholder med 98° skjæresvinkel for DN .. Skjær

Utvendig høyre / venstre hånd dreieholder med skjærevinkel på 98°. Passer til konisk dreieing, langsgående dreieing med skulder, formdreieing opp til 22° og fasing med negativ DN .. 15 stjørstørrelse. Tilgjengelig i 20x20 opptil 32x25 mm skaft. Behandlet for lengre levetid.



Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
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



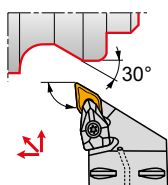
GI044

DN.. 1506..

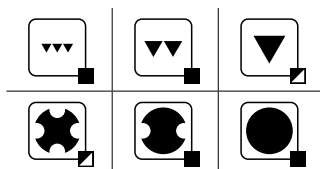
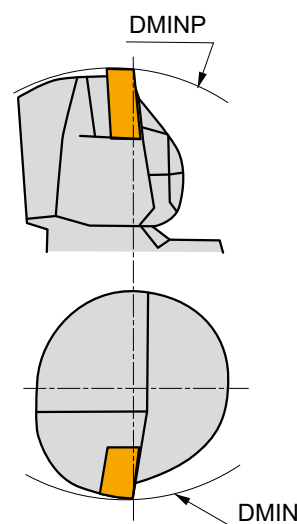
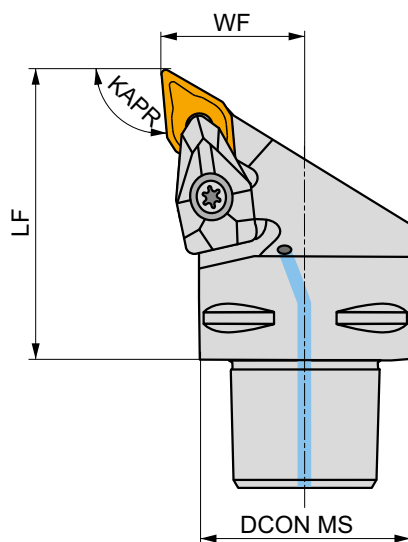
				Nm					
PD30	DNU 150308	PU 03	US 36	6.0	M 8x1	26	NT 05	MT 05	HXX 4
PD31	DNU 150308	PU 03	US 40	6.0	M 8x1	20.5	NT 05	MT 05	HXX 4

NEW**C.-DDJN(RL) EXT**

PRAMET

D**Utv. PSC hurtigveksling dreieholder, klemhode, 93 ° skjærevinkel for DN .. Skjær**

Utvendig høyre / venstre hånd dreieholder med klemhode, innvendig kjøling, med 93 ° skjærevinkel for konisk og langsgående dreining med skulder, form og fasing med negative DN .. 11 eller 15 skjærestørrelse. Tilgjengelig med PSC (Polygon Shank Coupling) C4 opp til C6 kobling. Behandlet for lengre levetid.



	Product	DCON MS	DMIN	DMINP	WF	LF	KAPR	LAMS	GAMO		kg			
		(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)	(°)					
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
	C4-DDJNL-27050-11	40	60	140	27	50	93	-7	-6	✓	0.39	GI046	C-DD11	—
L	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
GI046DN.. 1506..
DN.. 1104..

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



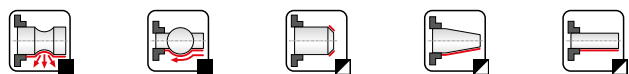
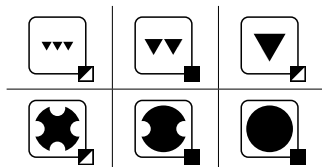
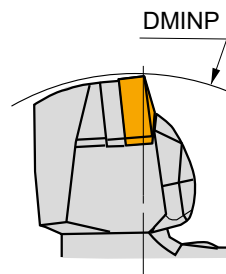
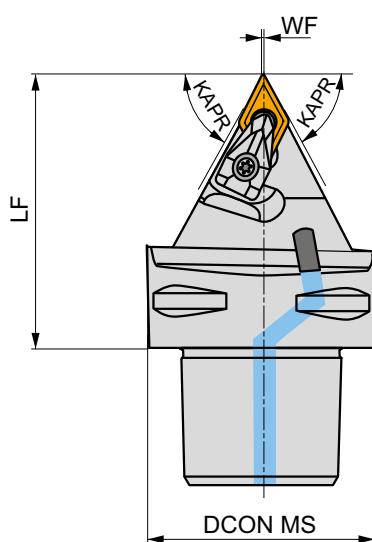
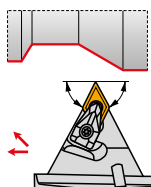
AT002a	DN.. 1504..	—	DDS 266-01
AT002b	CER DN.N 1506..	DCS 12C4	—
AT002c	CER DN.A 1506..	DCS 12C2	—
AT002d	CER DN.N 1504..	DCS 12C4	DDS 266-01
AT002e	CER DN.A 1504..	DCS 12C2	DDS 266-01

NEW**C.-DDNNN EXT**

PRAMET

D**Utv. PSC hurtigveksling dreieholder, klemhode, 62,5 ° skjærevinkel for DN .. Skjær**

Utvendig høyre / venstre hånd dreieholder med klemhode, innvendig kjøling, med 62,5 ° skjærevinkel for konisk og langsgående dreining uten skulder, form og fasing med negative DN .. 15 skjærstørrelse. Tilgjengelig med PSC (Polygon Shank Coupling) C5 og C6 kobling. Kroppsbehandlet for lengre 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

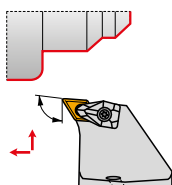
GI044	DN.. 1506..

C-DD154-2	DCS 12	3.9	DDS 266-02	US 2002-T15P	FLAG T15P/3,5	CN 045-01

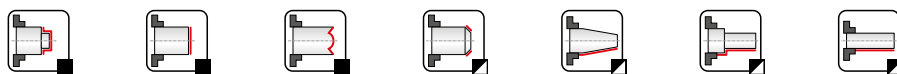
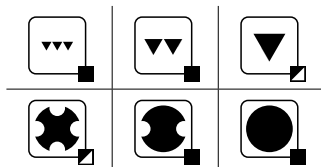
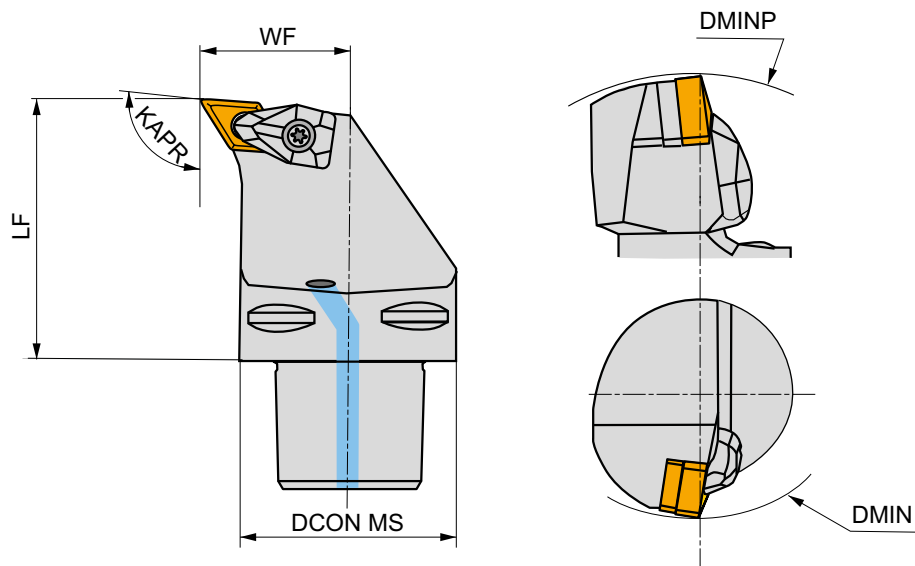
AT002a	DN.. 1504..	—	DDS 266-01
AT002b	CER DN.N 1506..	DCS 12C4	—
AT002c	CER DN.A 1506..	DCS 12C2	—
AT002d	CER DN.N 1504..	DCS 12C4	DDS 266-01
AT002e	CER DN.A 1504..	DCS 12C2	DDS 266-01

NEW**C-DDUN(RL) EXT**

PRAMET

D**Utv. PSC hurtigveskling dreieholder, klemhode, 93 ° (overflate) skjærevinkel, DN .. Skjær**

Utvendig høyre / venstre hånd dreieholder med klemhode, innvendig kjøling, med 93 ° skjærevinkel for formdreining med skulder, overflatedreining, konisk dreining, langsgående dreining og fasing med negative DN .. 15 skjærestørrelseg. Tilgjengelig med PSC (Polygon Shank Coupling) C5 og C6 kobling. Behandlet for lengre levetid.



Product		DCON MS (mm)	DMIN (mm)	DMINP (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)					
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

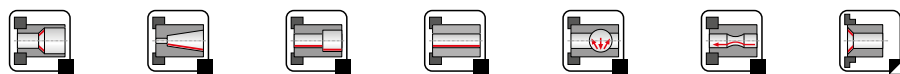
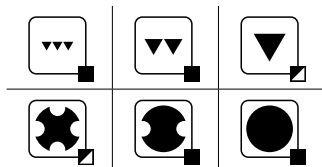
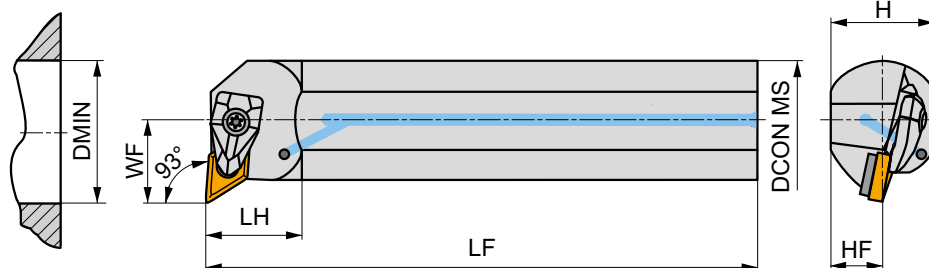
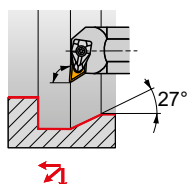


PRAMET

D

**Innvendig dreiebom med klemhode og 93° skjærevinkel for DN .. Skjær**

Innvendig høyre/venstre dreiebom med toppklemming, med innvendig kjøling, 93° skjærevinkel for DN .. 11 og 15 skjær. Minimum innvendig dreiediameter Ø32 mm. Passer for et bredt spekter av interne dreieprogrammer, kopiering opp til 27°. Finnes med skaftstørrelse Ø25 opp til Ø50 mm. Behandlet for lengre levetid.



Product		DCON MS	DMIN	WF	H	HF	LF	LH	LAMS	GAMO					
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)					
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..	

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



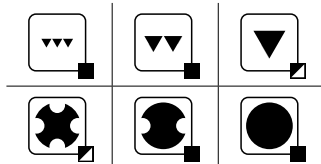
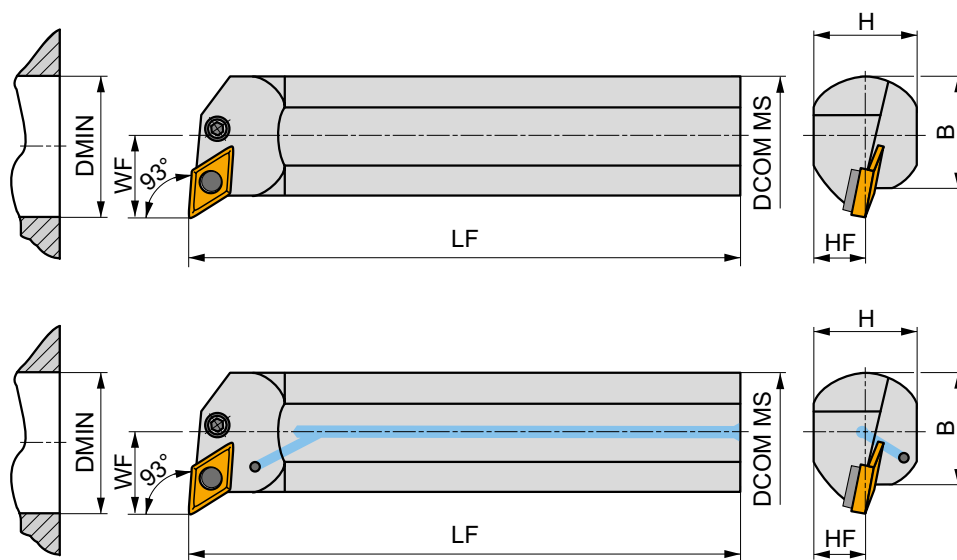
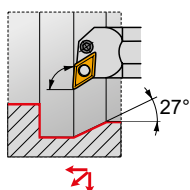
PRAMET

P



Innvendig dreiebom med 93° skjærevinkel for DN .. Skjær

Innvendig høyre/venstre hånd dreiebom, tilgjengelig med innvendig kjøling, 93° skjærevinkel for DN .. 11 og 15 skjær. Minimum innvendig dreiediameter Ø32 mm. For et bredt spekter av innvendig dreieprogrammer, formdreieing opp til 27°. Finnes med skaftstørrelse Ø25 opp til Ø60 mm. Behandlet for lengre levetid.



Product		DCOM 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..



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

–

–

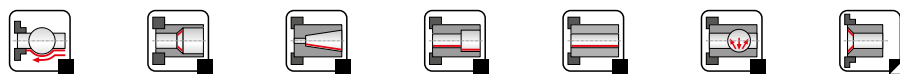
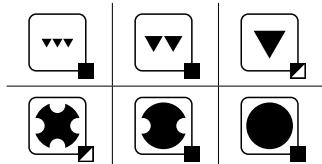
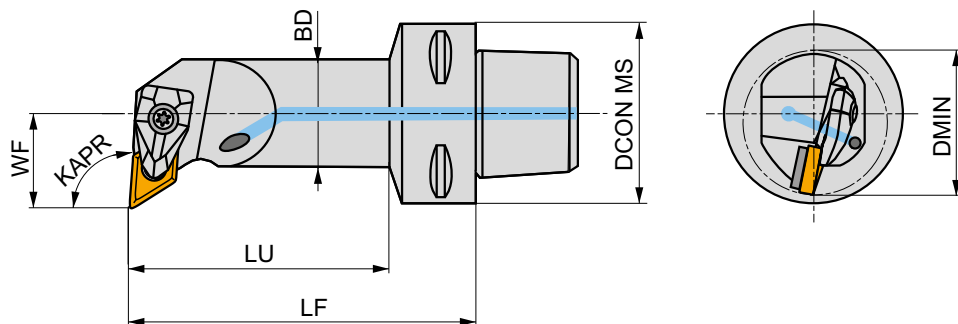
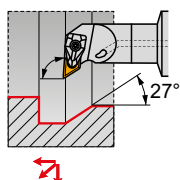
HXK 2

NEW**C-DDUN(RL) INT**

PRAMET

D**Innv. PSC hurtig veksling dreieholder, klemhode, 93° skjærevinkel for DN .. skjær**

Innvendig høyre/venstre hånd dreieholder med klemhode, med innvendig kjøling, med 93° skjærevinkel for innvendige dreieplikasjoner, inkludert kopidreining opp til 27° med DN .. 11 skjær, minimum innvendig diameter Ø32mm. PSC -skaft (Polygon Shank Coupling) størrelse C4 med dreielengde på 68 mm. Behandlet for lengre levetid.



Product	DCON MS (mm)	DMIN (mm)	WF (mm)	LF (mm)	LU (mm)	BD (mm)	KAPR (°)	LAMS (°)	GAMO (°)				
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

KNUX 160405L-22

Tool Holder

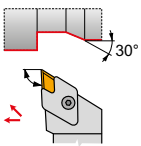
CKJNR 2020 K 16

ISO DREIING – EKSTERN

CKJN(RL) EXT

93°

KN..



16

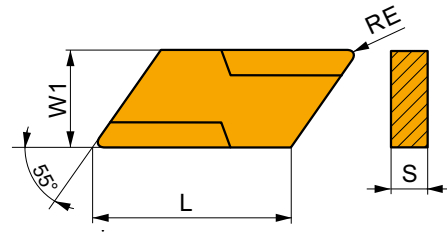

20×20
32×25

287

284 – 286

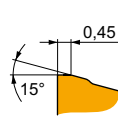
KNUX

	W1	L	S
	(mm)	(mm)	(mm)
1604	9.525	19.50	4.76



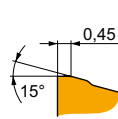
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

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)



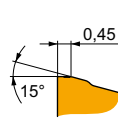
L-22 geometri med venstrehendt design for etterbehandling til middels bearbeiding og kontinuerlige kutt.

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	—	—	—	—	—	—	—	—	—



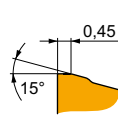
R-22 geometri med høyrehendt design for fin til halv-grov bearbeiding og kontinuerlige kutt.

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	—	—	—	—	—	—	—	—	—



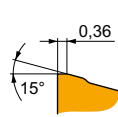
L-22 geometri med venstrehendt design for etterbehandling til middels bearbeiding og kontinuerlige kutt.

KNUX 160410L-22	T9335	1.0	155	0.32	2.7	90	0.29	2.7	—	—	—	—	—	—	—	—	—
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R-22 geometri med høyrehendt design for fin til halv-grov bearbeiding og kontinuerlige kutt.

KNUX 160410R-22	T9335	1.0	155	0.32	2.7	90	0.29	2.7	—	—	—	—	—	—	—	—	—
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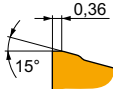
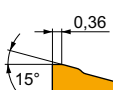
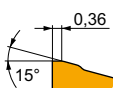
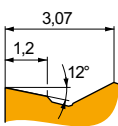
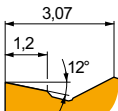
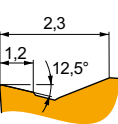
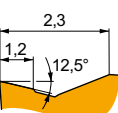
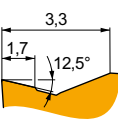


L-32 geometri med venstrehendt design for fin til middels bearbeiding og kontinuerlige kutt.

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	—	—	—	—	—	—	—	—	—

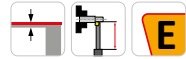
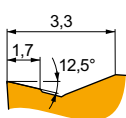
CN	DN	KN	LN	RN	SN	TN	VN	WN
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Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	P			M			K			N			S			H					
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap			
			(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)			
			 			R-32 geometri med høyrehendt design for fin til halv-grov bearbeiding og kontinuerlige kutt.																	
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	—	—	—	—	—	—	—	—	—	—	—				
			 			L-32 geometri med venstrehendt design for fin til middels bearbeiding og kontinuerlige kutt.																	
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	—	—	—	—	—	—	—	—	—	—	—				
			 			R-32 geometri med høyrehendt design for fin til halv-grov bearbeiding og kontinuerlige kutt.																	
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	—	—	—	—	—	—	—	—	—	—	—				
			 			ER-72 geometri med høyrehendt design for finbearbeiding og kontinuerlige kutt.																	
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	—	—				
			 			EL-72 geometri med venstrehendt design for finbearbeiding og kontinuerlige kutt.																	
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	—	—				
			 			ER-73 geometri med høyrehendt design for fin til halv-grov bearbeiding og kontinuerlige kutt.																	
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	—	—	—	—	—	—	—	—				
			 			EL-73 geometri med venstrehendt design for fin til halv-grov bearbeiding og kontinuerlige kutt.																	
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	—	—	—	—	—	—	—	—				
			 			ER-74 geometri med høyrehendt design for fin til grov bearbeiding og kontinuerlige kutt.																	
KNUX 160415SR-74	6640	1.5	155	0.45	3.0	90	0.41	3.0	145	0.45	3.0	—	—	—	—	—	—	—	—				

Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(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)



EL-74 geometri med venstrehendt design for fin til grov bearbeiding og kontinuerlige kutt.

KNUX 160415SL-74	6640	1.5		155	0.45	3.0		90	0.41	3.0		145	0.45	3.0		—	—	—		—	—	—		—	—	—
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CKJN(RL) EXT



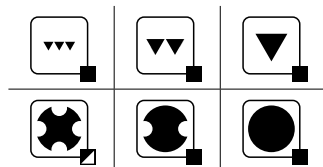
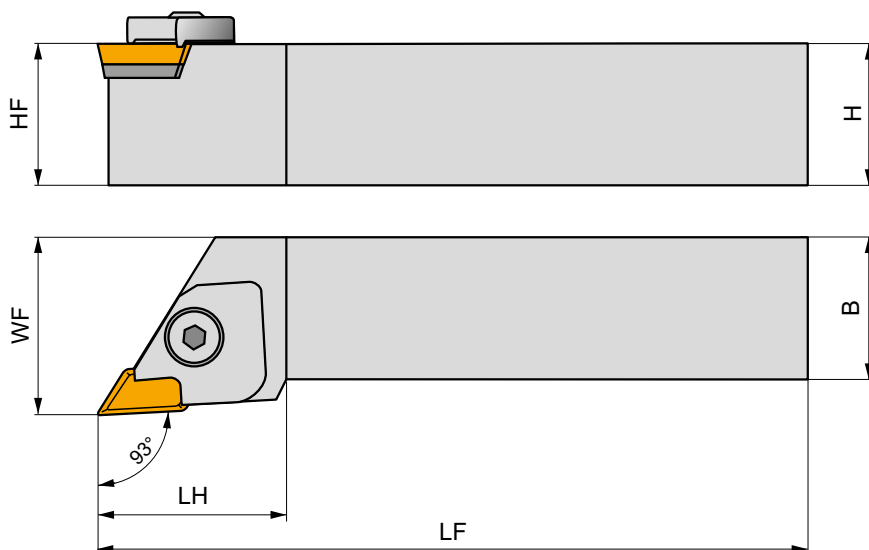
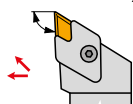
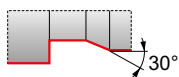
PRAMET

C



Utvendig toppklemme dreieholder med 93 ° skjærevinkel for KN .. 16 Skjær

Utvendig høyre/venstre toppklemme dreieholder med 93 ° skjærevinkel. Passer for konisk, langsgående dreieing med skulder, kopiereing opp til 30 ° og fasing med negative KN .. 16 skjærstørrelse. Tilgjengelig i 20x20 opptil 32x25 mm skaft. Behandlet for lengre levetid.



	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	CKJNR 2020 K 16	20	20	20	30	125	34	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



L	KNN 190412L	NT 03	—	UP 26	US 83	6.0	PR 07	K 23	HXX 4
L1	KNN 190412L	NT 03	—	UP 26	US 83	6.0	PR 07	K 22	HXX 4
R	KNN 190412R	NT 03	UP 25	—	US 83	6.0	PR 07	K 23	HXX 4
R1	KNN 190412R	NT 03	UP 25	—	US 83	6.0	PR 07	K 22	HXX 4

CARBIDE INSERTS

LNUX 40, LN.X 50



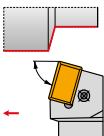
289

MATCH THE RIGHT SIZE (example)

Insert	Tool Holder
LNUX 40-1129003	KHP-LBNR 40-A

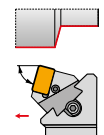
ISO DREIING – EKSTERN

PLBN(RL) EXT

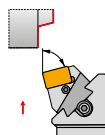
75°	LN..
	
	40
	50
 60×60	
 290	 289

ISO DREIING – TUNG GROVBEARBEIDING– EKSTERNT

KHP-LBNR + DKH(RL)

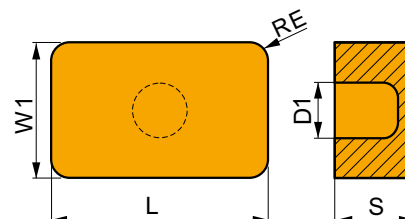
75°	LN..
	
	40
 40×50 60×80	
 291, 292	 289

KHP-LBNL + DKH(RL)

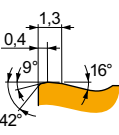
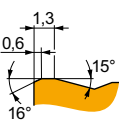
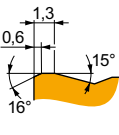
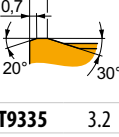
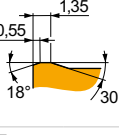
75°	LN..
	
	40
 40×50 60×80	
 291, 292	 289

LNUX 40, LN.X 50

	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



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product	RE (mm)	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)
 																			
 																			
 																			
 																			
 																			

PLBN(RL) EXT

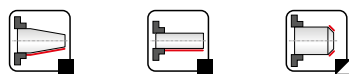
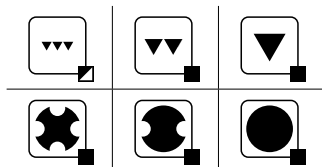
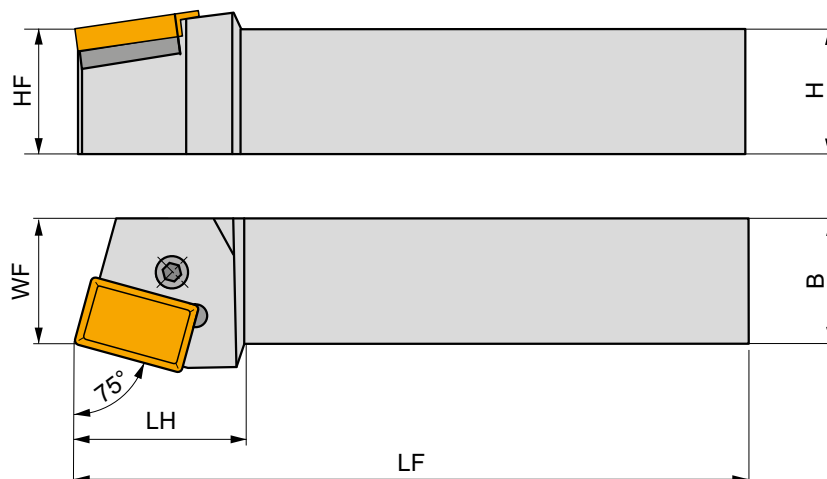
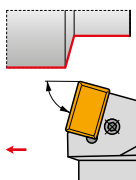


PRAMET

P

**Utvendig dreieholder, grov dreieing, skjærevinkel på 75 ° for LNUX-skjær**

Utvendig høyre / venstre hånd dreieholder med skjærevinkel på 75 ° for tung dreieing. Egnet for langsgående dreieing uten skulder, konisk og avfasing med negativ LN .. 40 og 50 skjærstørrelse. Tilgjengelig i 60x60 mm skaft. Behandlet for lengre levetid.



	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
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....										

											
PL71	LNX 400632	PU 06	PS 12040	8.0	M 12x1	40	NT 08	MT 08	HXK 5	—	—
PL72	LNX 500632	PU 06	PS 12040	8.0	M 12x1	40	NT 08	MT 08	HXK 5	—	—
PL73	LNX 500432P	—	—	—	—	—	—	—	—	UP 1515A-T15P	SDRT15P

KHP-LBN(RL)

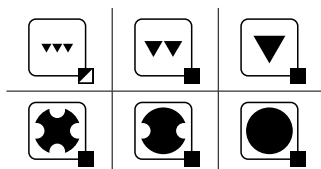
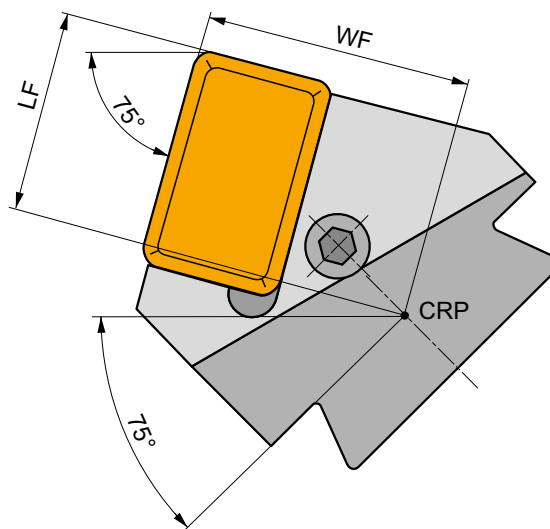
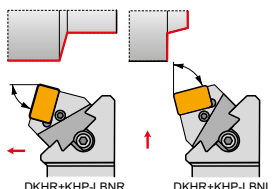


PRAMET

P

**Modulær dreiepatron KHP Låsespor, 75 ° skjæringsvinkel for LNUX-skjær**

Koblingshus høyre / venstre dreiepatron, 75 ° skjærevinkel, for montering på DKH verktøyholder. Egnet for kraftig langsgående dreining uten skulder, avsmalning og avfasing med negative LNUX 40 skjær. Verktøyholder behandlet for lengre levetid.



Product	WF	LF	LAMS	GAMO	kg		
	(mm)	(mm)	(°)	(°)			
L	KHP-LBNR 40-A	48	36	-6	-6	1.50	GI102
	KHP-LBNL 40-A	48	36	-6	-6	1.47	GI102



GI102



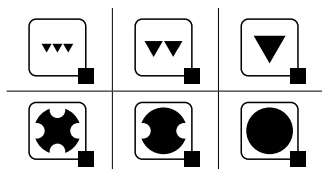
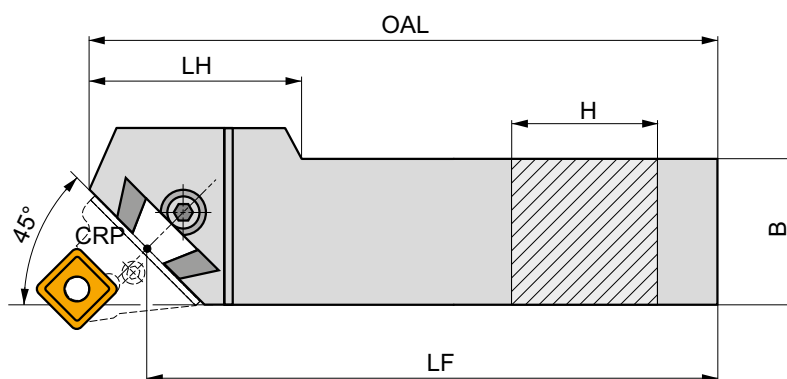
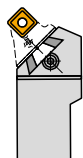
LNUX 40....

PL71	LNK 400632	PU 06	PS 12040	8.0	M 12x1	40	NT 08	MT 08
								HXK 5

DKH(RL)

**Utvendig verktøyholderskaft for KHP / KHS Grove dreiepatroner**

Koblingshus høyre / venstre hånds verktøyskaft for KHP / KHS-kassetter. Egnet for tunge dreie applikasjoner. Tilgjengelig med skaftstørrelse 40x50 opp til 60x80 mm. Behandlet for lengre levetid.



	Product	H	B	LF	OAL	LH	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)			
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

RNMG 120400E-08

Tool Holder

DRSNR 2525 M 12

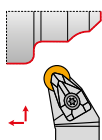
ISO DREIING – EKSTERN

DRSN(RL) EXT

RN..



12



25x25

295

294

PRSN(RL) EXT

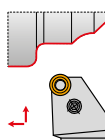
RN..



12

15

19

25x25
40x40

296

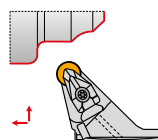
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C.-DRSN(RL) EXT **NEW**

RN..



12



C6

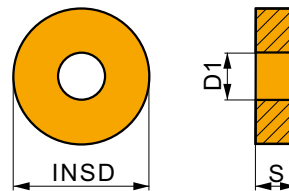
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294

RNMG

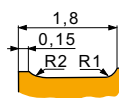


	INSD	D1	S
	(mm)	(mm)	(mm)
1204	12.700	5.16	4.76
1506	15.875	6.35	6.35
1906	19.050	7.94	6.35
2509	25.400	9.12	9.53



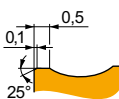
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

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)



Geometri 08 for halv-grov til tung-grov bearbeiding, og kontinuerlig til avbrutt kutt.

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	—	—	—	—	—	—	—	—	—



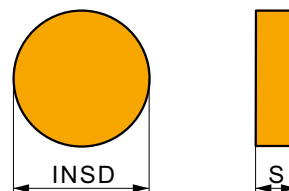
Geometri 081 for grov til tung grov bearbeiding, og kontinuerlig til avbrutt kutt.

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

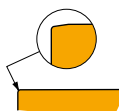


	INSD	S
	(mm)	(mm)
0903	9.525	3.18
1204	12.700	4.76
1207	12.700	7.94



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere 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)



For maskinering med høye hastigheter og kontinuerlige kutt.

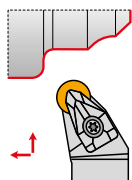
RNGN 090300 T01020	TC100	—	—	—	—	—	—	460	0.20	1.2	—	—	—	—	—	—	—	—	—
RNGN 120400 T01020	TC100	—	—	—	—	—	—	455	0.20	1.5	—	—	—	—	—	—	—	—	—
RNGN 120700 T01020	TC100	—	—	—	—	—	—	455	0.20	1.5	—	—	—	—	—	—	—	—	—
RNGN 120700 T15015	TC100	—	—	—	—	—	—	455	0.20	1.5	—	—	—	—	—	—	—	—	—

DRSN(RL) EXT

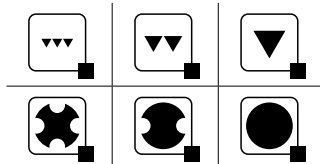
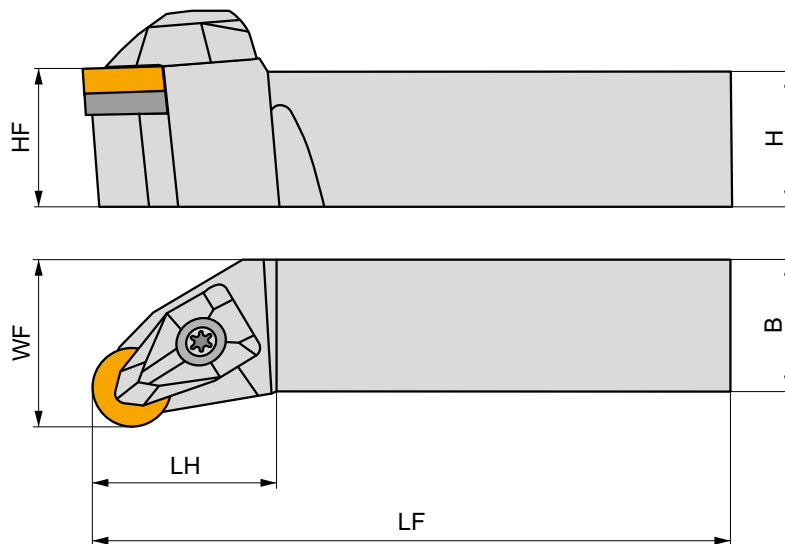


PRAMET

D

**Utvendig dreieholder med klemhode for RN .. Skjær**

Utvendig høyre / venstre dreieholder med klemhode. Egnet for langsgående dreining uten skulder, forming, konisk og fasing med negativ rund RN .. 12 størrelse skjær. Tilgjengelig i 25x25 mm skaft. Behandlet for lengre levetid.



Product		H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
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



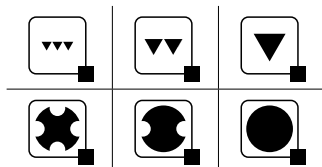
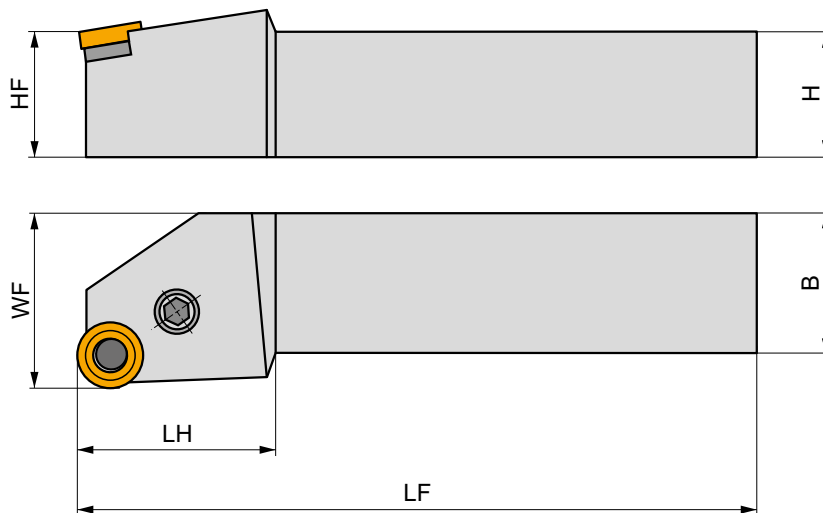
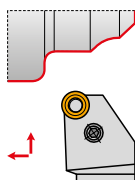
PRAMET

P



Utvendig drieholder for RN .. Skjær

Utvendig høyre / venstre hånd freieholder. Egnet for langsgående dreining, kformdreining opp til 90°, konisk og fasing med negativ runde RN .. 12, 15 og 19 skjærstørrelse. Tilgjengelig i 25x25 opp til 40x40 mm skaft. Behandlet for lengre levetid.



	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
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													
GI105													
GI106													

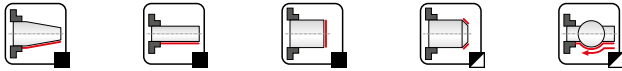
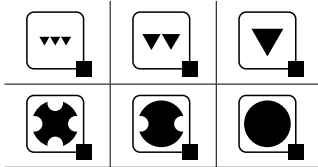
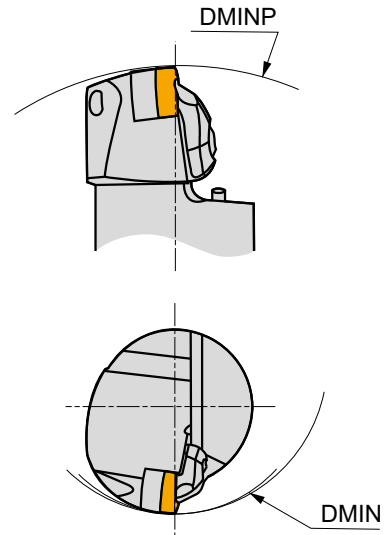
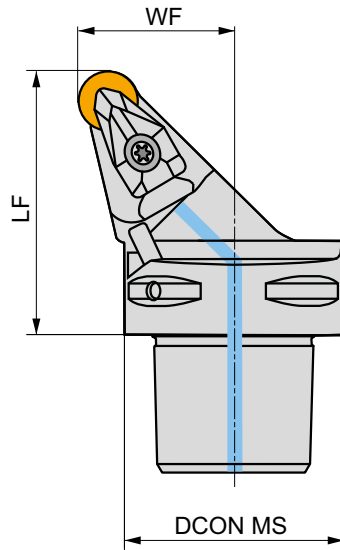
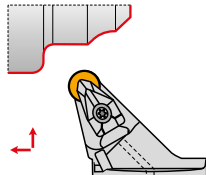
PR20		RNU 120300	PU 02	US 35	6.0	M 8x1	22.5	NT 05	MT 05	HXK 4			
PR40		RNU 150300	PU 04	US 36	6.0	M 8x1	26	NT 07	MT 07	HXK 4			
PR50		RNU 190400	PU 05	US 38	8.0	M 10x1	29	NT 06	MT 06	HXK 5			

NEW**C.-DRSN(RL) EXT**

PRAMET

D**Utvendig PSC hurtigveksling dreieholder, klemhode for RN .. Skjær**

Utvendig høyre / venstre hånd dreieholder med klemhode, innvendig kjøling, for langsgående dreining uten skulder, formdreining, konisk og fasing med negativ rund RN .. 12 skjærstørrelse. Tilgjengelig med PSC (Polygon Shank Coupling) C6-skaft. Behandlet for lengre levetid.



Product		DCON MS (mm)	DMIN (mm)	DMINP (mm)	WF (mm)	LF (mm)	LAMS (°)	GAMO (°)					
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



DRS 155-02



US 2002-T15P



FLAG T15P/3,5

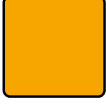


CN 045-01

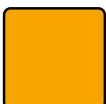
SN

09/ 12/ 15/ 19/ 25

CARBIDE INSERTS

SNMA	SNMG	SNMM	SNMX
			
 300	 301	 307	 311

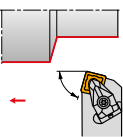
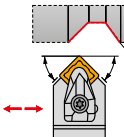
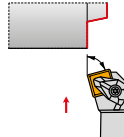
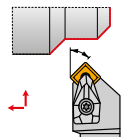
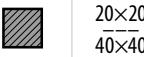
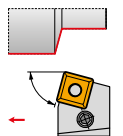
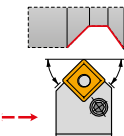
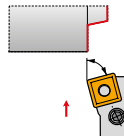
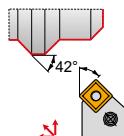
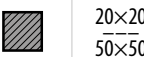
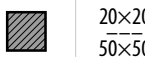
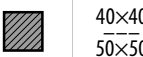
CER INSERTS

SNGA CER	SNGN CER
	
 311	 312

MATCH THE RIGHT SIZE (example)

Insert	Tool Holder
SNMG 190616E-RM	DSDNN 3232 P 19

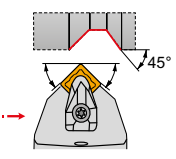
ISO DREIING – EKSTERN

DSBN(RL) EXT		DSDNN EXT		DSKN(RL) EXT		DSSN(RL) EXT	
75°	SN..	45°	SN..	75°	SN..	45°	SN..
							
12	12	12	12	12	12	12	12
15	15	15	15	15	15	15	15
19	19	19	19	19	19	19	19
	20×20 40×40		20×20 40×40		25×25 32×32		20×20 40×40
 313	 300 – 312	 315	 300 – 312	 316	 300 – 312	 317	 300 – 312
PSBN(RL) EXT		PSDNN EXT		PSKN(RL) EXT		PSSN(RL) EXT	
75°	SN..	45°	SN..	75°	SN..	45°	SN..
							
12	12	12	12	12	12	19	19
15	15	15	15	15	15	25	25
19	19	19	19	19	19		
25	25	25	25	25	25		
	20×20 50×50		20×20 50×50		20×20 50×50		40×40 50×50
 318	 300 – 312	 320	 300 – 312	 321	 300 – 312	 323	 300 – 312

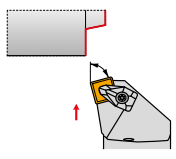
SN

09/ 12/ 15/ 19/ 25

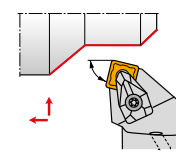
C.-DSDNN EXT NEW

45°		SN..
		 12 19
	$\frac{C4}{C6}$	
		 300 – 312
324		

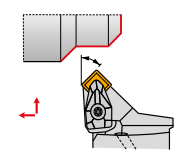
C.-DSKN(RL) EXT NEW

75°		SN..
		 12
	C4	
		 300 – 312
325		

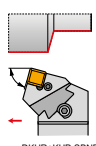
C.-DSRN(RL) EXT NEW

75°		SN..
		 12 19
	$\frac{C4}{C6}$	
		 300 – 312
326		

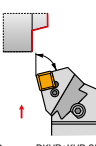
C.-DSSN(RL) EXT NEW

45°		SN..
		 12
	$\frac{C4}{C5}$	
		 300 – 312
327		

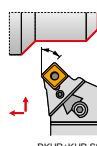
ISO DREIING – TUNG GROVBEARBEIDING– EKSTERNT**KHP-SBNR + DKH(RL)**

75°		SN..
		 25
		
$\frac{40 \times 50}{60 \times 80}$		
		 300 – 312
328, 330		

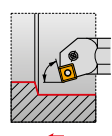
KHP-SBNL + DKH(RL)

75°		SN..
		 25
		
$\frac{40 \times 50}{60 \times 80}$		
		 300 – 312
328, 330		

KHP-SSNR/L + DKH(RL)

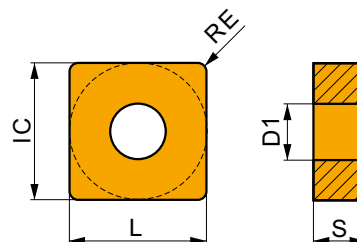
45°		SN..
		 19 25
		
$\frac{40 \times 50}{60 \times 80}$		
		 300 – 312
329, 330		

ISO DREIING – INTERNT**PSKN(RL) INT**

93°		SN..
		 11 15
		
$\frac{32}{80}$		
		 300 – 312
331		

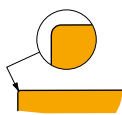
SNMA

	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



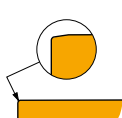
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	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)



For fin til halv-grov bearbeiding og kontinuerlige til lett avbrutte kutt.

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

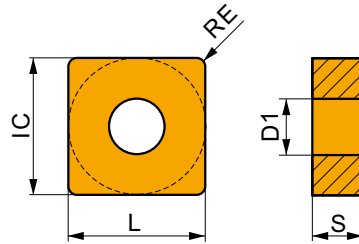


For fin til halv-grov bearbeiding og kontinuerlige til lett avbrutte kutt.

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

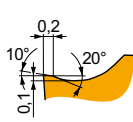
SNMG

	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



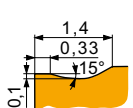
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	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)



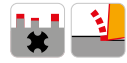
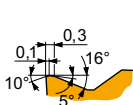
FM-geometri med positiv design for fin til halv-grov bearbeiding, og kontinuerlige til lett avbrutte kutt.

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 for middels til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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



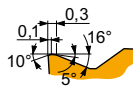
M geometri for fin til middels bearbeiding, og kontinuerlig til avbrutt kutt.

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	🟡	—	—	—	🟥	—	—	—	🟢	—	—	—	—	—	—	

CN	DN	KN	LN	RN	SN	TN	VN	WN
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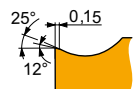
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

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



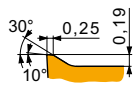
M geometri for fin til middels bearbeiding, og kontinuerlig til avbrutt kutt.

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 positiv design for finbearbeiding til middels bearbeiding og kontinuerlige kutt.

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	—	—	—
	T9335	0.4	240	0.19	1.7	185	0.17	1.7	—	—	—	—	—	—	75	0.15	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	—	—	—



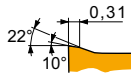
NM-geometri med meget positiv design for finbearbeiding, middels og grov bearbeiding, i kontinuerlige kutt.

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	—	—	—

CN	DN	KN	LN	RN	SN	TN	VN	WN
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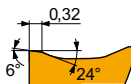
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

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)



NMR-geometri med positiv design for middels til grov bearbeiding og kontinuerlige kutt.

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	■	—	—	—	■	—	—	—	—	—	—	—	—	—	—
SNMG 120412E-NMR	T9325	0.8	■	200	0.35	2.6	■	120	0.32	2.6	■	—	—	—	▣	45	0.25	2.1	—	—	—
	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	■	—	—	—	■	—	—	—	—	—	—	—	—	—	—
SNMG 120416E-NMR	T9325	1.2	■	200	0.40	2.6	■	120	0.36	2.6	■	—	—	—	▣	45	0.28	2.1	—	—	—
	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	—	—	—
SNMG 150612E-NMR	T9325	1.6	■	200	0.45	2.6	■	120	0.41	2.6	■	—	—	—	▣	45	0.32	2.1	—	—	—
	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	■	—	—	—	■	—	—	—	—	—	—	—	—	—	—
SNMG 190612E-NMR	T9325	1.2	■	190	0.40	3.8	■	110	0.36	3.8	■	—	—	—	▣	40	0.28	3.0	—	—	—
	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	■	—	—	—	■	—	—	—	—	—	—	—	—	—	—
SNMG 190616E-NMR	T9325	1.2	■	185	0.40	5.2	■	110	0.36	5.2	■	—	—	—	▣	40	0.28	4.2	—	—	—
	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	—	—	—



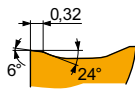
NRM-geometri med positiv design for middels til grov bearbeiding, og kontinuerlig til moderat avbrutt kutt.

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	■	—	—	—	—	—	—

CN	DN	KN	LN	RN	SN	TN	VN	WN
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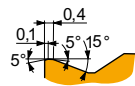
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(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)



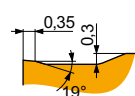
NRM-geometri med positiv design for middels til grov bearbeiding, og kontinuerlig til moderat avbrutt kutt.

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 for halv-grov til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—



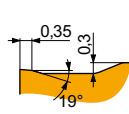
RM-geometri for halv-grov til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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	—	—	—	—	—	—	—	—	—	—	—	—

CN	DN	KN	LN	RN	SN	TN	VN	WN
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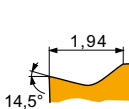
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

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



RM-geometri for halv-grov til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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	—	—	—	—	—	—	—	—	—
SNMG 150616E-RM	T9335	1.2	180	0.45	5.0	105	0.41	5.0	—	—	—	—	—	—	—	—	—	—	—	—
	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	—	—	—	—	—	—	—	—	—
SNMG 190612E-RM	T9335	1.6	180	0.50	5.0	105	0.45	5.0	—	—	—	—	—	—	—	—	—	—	—	—
	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	—	—	—	—	—	—	—	—	—
SNMG 190616E-RM	T9335	1.2	175	0.45	7.0	105	0.41	7.0	—	—	—	—	—	—	—	—	—	—	—	—
	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	—	—	—	—	—	—	—	—	—	—	—	—



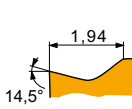
SF-geometri med positiv design for finbearbeiding av tynne vegger og kontinuerlige kutt.

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	—	—	—

CN	DN	KN	LN	RN	SN	TN	VN	WN
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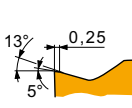
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(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)



SF-geometri med positiv design for finbearbeiding av tynne vegger og kontinuerlige kutt.

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

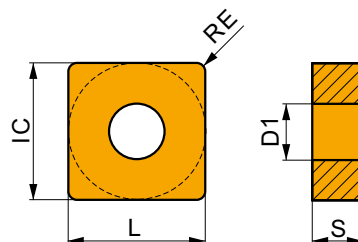


SM-geometri med positiv design for middels bearbeiding og kontinuerlige til avbrutte kutt.

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	—	—	—

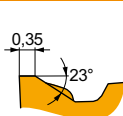
SNMM

	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



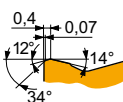
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	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)



DR-geometri for middels til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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	—	—	—	—	—	—	—	—	—	—	—	—



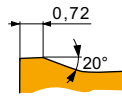
HR-geometri for grov til tung-grov bearbeiding, og kontinuerlig til avbrutt kutt.

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	—	—	—	—	—	—	—	—	—
SNMM 250716E-HR	T9335	2.4	90	0.65	9.0	50	0.59	9.0	—	—	—	—	—	—	—	—	—	—	—	—
	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	—	—	—	—	—	—	—	—	—
SNMM 250724E-HR	T9335	1.6	85	0.60	13.0	50	0.54	13.0	—	—	—	—	—	—	—	—	—	—	—	—
	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	—	—	—	—	—	—	—	—	—
SNMM 250732E-HR	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	—	—	—	—	—	—	—	—	—
SNMM 250932E-HR	T9335	2.4	85	0.65	13.0	50	0.59	13.0	—	—	—	—	—	—	—	—	—	—	—	—
	T9325	3.2	95	0.80	13.0	55	0.72	13.0	90	0.80	13.0	—	—	—	—	—	—	—	—	—

CN	DN	KN	LN	RN	SN	TN	VN	WN
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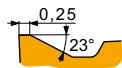
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product	RE (mm)	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)



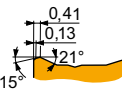
HR2-geometri for grov til tung-grov bearbeiding, og kontinuerlig til avbrutt kutt.

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 for medium til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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	—	—



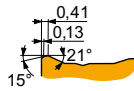
NR2 geometri for middels til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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	—	—	—	—	—	—	—	—
SNMM 190624E-NR2	T9325	1.6	185	0.50	8.0	110	0.45	8.0	175	0.50	8.0	—	—	—	40	0.40	6.4	—	—
	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	—	—

CN	DN	KN	LN	RN	SN	TN	VN	WN
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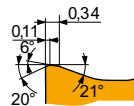
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	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)



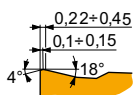
NR2 geometri for middels til grov bearbeiding, og kontinuerlig til avbrutt kutt.

SNMM 250724E-NR2	T7335	2.4	100	0.80	12.0	75	0.72	12.0	80	0.80	12.0	—	—	—	30	0.56	9.6	—	—	—
	T8330	2.4	85	0.80	12.0	50	0.72	12.0	70	0.80	12.0	—	—	—	20	0.56	9.6	—	—	—
	T8430	2.4	85	0.80	12.0	45	0.72	12.0	90	0.80	12.0	—	—	—	15	0.56	9.6	—	—	—
	T9226	2.4	95	0.80	12.0	55	0.72	12.0	110	0.80	12.0	—	—	—	20	0.56	9.6	—	—	—
	T9315	2.4	120	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 positiv design for middels til grov bearbeiding, og kontinuerlig til moderat avbrutt kutt.

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	—	—	—	—	—	—	—	—	—



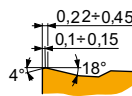
OR geometri for middels til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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	—	—	—
SNMM 190624E-OR	T9335	1.6	160	0.50	8.0	95	0.45	8.0	—	—	—	—	—	—	35	0.40	6.4	—	—	—
	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	—	—	—

CN	DN	KN	LN	RN	SN	TN	VN	WN
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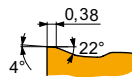
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(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)



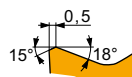
OR geometri for middels til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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	—	—	—



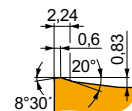
OR1 geometri for middels til tung-grov bearbeiding, og kontinuerlig til avbrutt kutt.

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 for grov til tung grov bearbeiding, og kontinuerlig til avbrutt kutt.

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	—	—	—	—	—	—	—	—	—	—	—	—



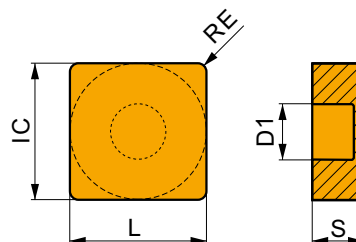
Geometri 923 for halv-grov til tung-grov bearbeiding, og kontinuerlig til kraftig avbrutt kutt.

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

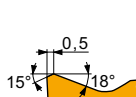


	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
2512	25.400	9.17	25.40	12.00



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere 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)



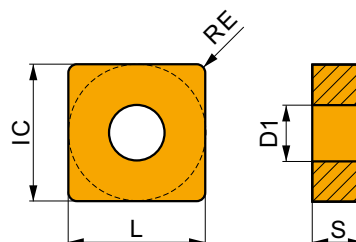
SR-geometri for grov til tung grov bearbeiding, og kontinuerlig til avbrutt kutt.

SNMX 2512245-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

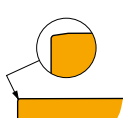


	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1204	12.700	5.16	12.70	4.76



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere 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)

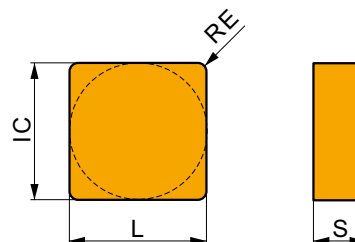


For maskinering med høye hastigheter og kontinuerlige kutt.

SNGA 120408 T01025	TC100	0.8	—	—	—	—	—	—	575	0.20	2.0	—	—	—	—	—	—	—	—
SNGA 120412 T01020	TC100	1.2	—	—	—	—	—	—	565	0.25	2.0	—	—	—	—	—	—	—	—

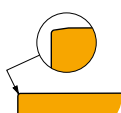
SNGN CER

	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



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product	RE (mm)	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)



For maskinering med høye hastigheter og kontinuerlige kutt.

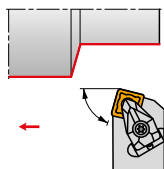
SNGN 090308 T01020	TC100	0.8	—	—	—	—	—	—	580	0.20	1.8	—	—	—	—	—	—	—	—
SNGN 090312 T01020	TC100	1.2	—	—	—	—	—	—	565	0.25	1.8	—	—	—	—	—	—	—	—
SNGN 120404 T01020	TC100	0.4	—	—	—	—	—	—	620	0.10	2.0	—	—	—	—	—	—	—	—
SNGN 120408 T01020	TC100	0.8	—	—	—	—	—	—	575	0.20	2.0	—	—	—	—	—	—	—	—
SNGN 120708 T01020	TC100	0.8	—	—	—	—	—	—	575	0.20	2.0	—	—	—	—	—	—	—	—
SNGN 120712 T01020	TC100	1.2	—	—	—	—	—	—	565	0.25	2.0	—	—	—	—	—	—	—	—

DSBN(RL) EXT



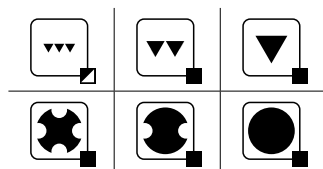
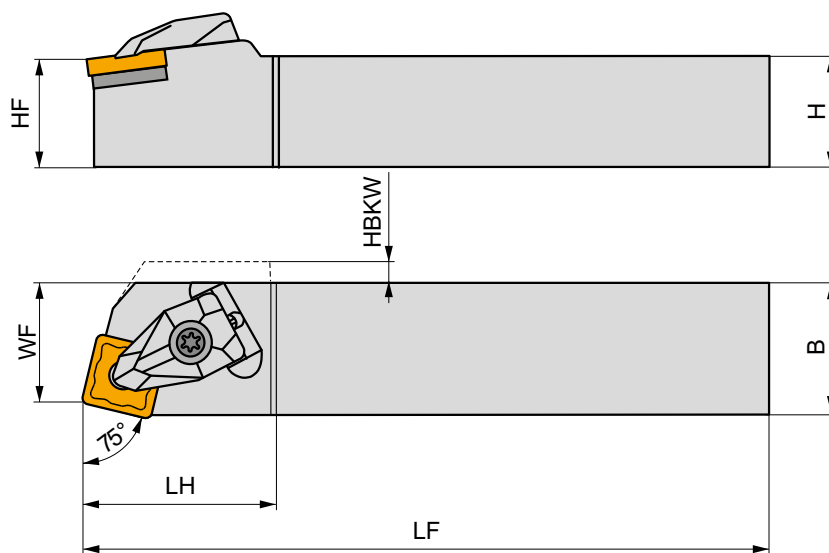
PRAMET

D



Utvendig dreieholder med klemhode 75 ° skjærevinkel for SN .. Skjær

Utvendig høyre / venstre dreieholder med klemhode, 75 ° skjærevinkel. Passer for langsgående dreieing uten skulder-, konisk- og fasedreieing med negative SN .. 12, 15 eller 19 skjærstørrelse. Tilgjengelig i 20x20 opptil 40x40 mm skaft. Kroppsbehandlet for lengre levetid for verktøyet.



Product		H	B	HF	WF	LF	LH	HBKW	LAMS	GAMO	kg			
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)				
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..



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

—

LKT20P

DS19

DCS 19

6.4

DSS 425-04

US 2007-T20P

—

LKT20P

			
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



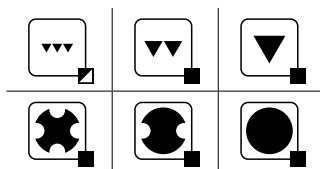
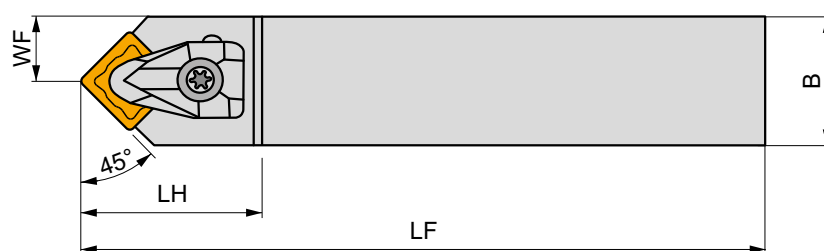
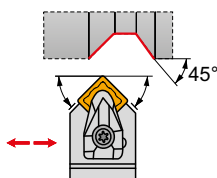
PRAMET

D



Utvendig dreieholder med klemhode 45 ° skjærevinkel for SN .. Skjær

Utvendig nøytral dobbelt klemmeverktøyholder med 45 ° skjæringsvinkel. Egnet for langsgående dreining uten skulder, form, konisk og fasing med negativ SN .. 12, 15, 19 eller 25 skjærstørrelse. Tilgjengelig i 25x25 opptil 40x40 mm skaft. Behandlet for lengre levetid.



Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg			
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)				
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..



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

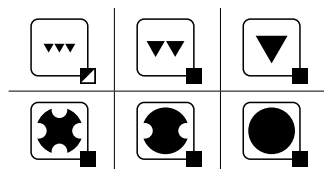
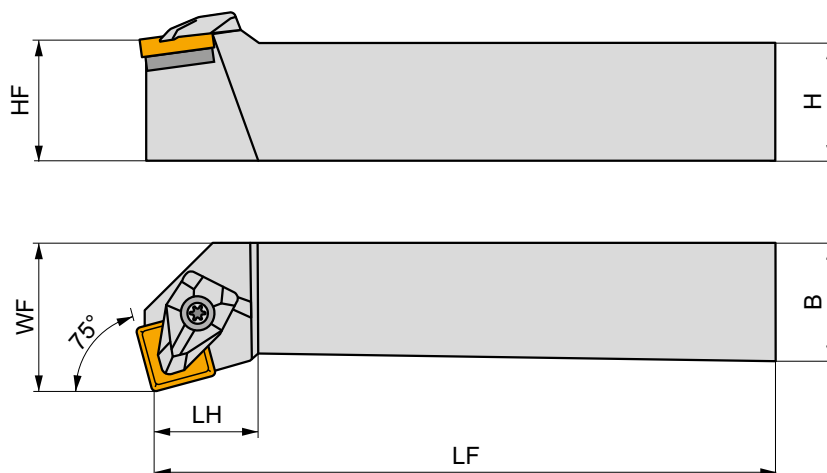
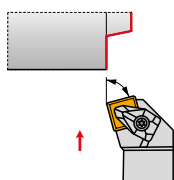


PRAMET

D

**Utvendig dreieholder med klemhode 75 ° (overflate) skjærevinkel for SN .. Skjær**

Utvendig høyre / venstre dreieholder medklemhode, 75 ° skjærevinkel. Egnet for overflatedreining uten skulder og fasing med SN .. 12 .. eller 19 .. skjærstørrelse. Tilgjengelig i 25x25 opp til 32x32 mm skaft. Behandlet for lengre levetid.



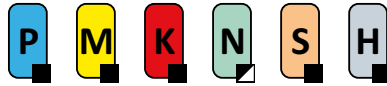
Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg			
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)				
R DSKNR 2525 M 12	25	25	25	32	150	23.6	-6	-6	0.79	GI029	DS12	AT003
DSKNR 3232 P 19	32	32	32	40	170	32.1	-6	-6	1.46	GI026	DS19	—
L DSKNL 2525 M 12	25	25	25	32	150	23.6	-6	-6	0.79	GI029	DS12	AT003
DSKNL 3232 P 19	32	32	32	40	170	32.1	-6	-6	1.46	GI026	DS19	—

GI026	SN.. 1906..
GI029	SN.. 1204..

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

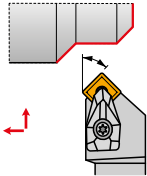
AT003a	SN.. 1207..	—	DSS 425-02
AT003b	CER SN.N 1204..	DCS 12C4	—
AT003c	CER SN.A 1204..	DCS 12C2	—

DSSN(RL) EXT

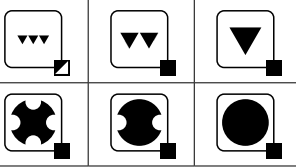
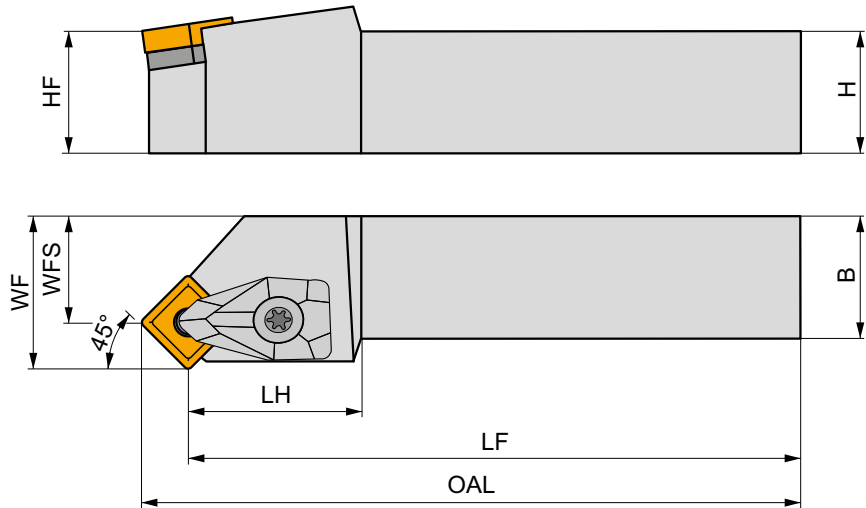


PRAMET

D

**Utvendig dreieholder med klemhode 45 ° skjærevinkel for SN .. Skjær**

Utvendig høyre / venstre Dreieholder med klemhode, 45 ° skjærevinkel. Passer for langsgående og overflatedreining uten skulder, konisk, formdreining og fasing med negative SN .. 12, 15 eller 19 skjærstørrelse. Tilgjengelig i 20x20 opp til 40x40 mm skaft. Behandlet for lengre levetid.



Product		H	B	HF	WF	WFS	LF	OAL	LH	LAMS	GAMO	kg			
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)				
R	DSSNR 2020 K 12	20	20	20	25	16.7	125	133.3	27.5	0	-8	0.45	GI029	DS12	AT003
	DSSNR 2525 M 12	25	25	25	32	23.7	150	158.3	27.5	0	-8	0.80	GI029	DS12	AT003
	DSSNR 2525 M 15	25	25	25	32	21.8	150	160.2	32	0	-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..



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

—

LKT20P

DS19

DCS 19

6.4

DSS 425-04

US 2007-T20P

—

LKT20P



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



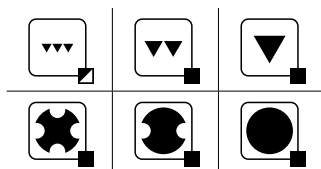
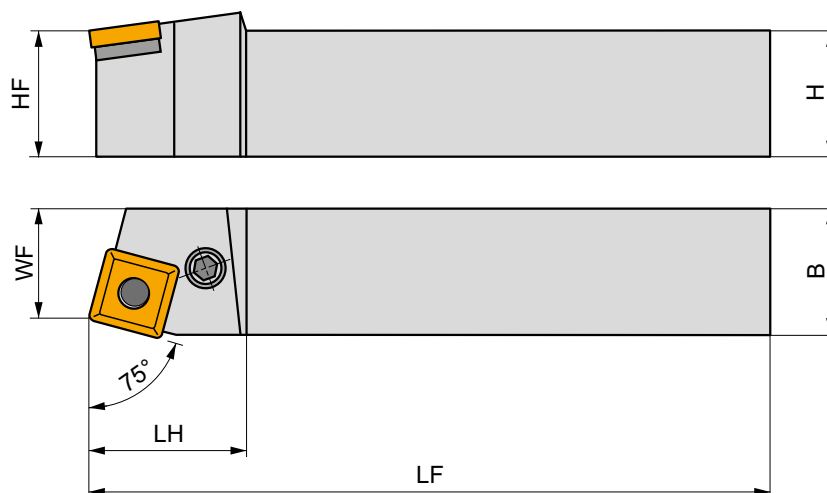
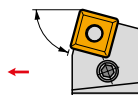
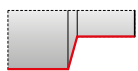
PRAMET

P



Utvendig dreieholder med 75° skjærevinkel for SN .. Skjær

Utvendig høyre / venstre hånd dreieholder med skjærevinkel på 75°. Egnet for langsgående dreining uten skulder, konisk dreining og fasing med negativ SN .. 12, 15, 19 eller 25 skjærstørrelse. Tilgjengelig i 20x20 opptil 50x50 mm skaft. Behandlet for lengre levetid.



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

CN	DN	KN	LN	RN	SN	TN	VN	WN
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Product	H	B	HF	WF	LF	LH	LAMS	GAMO			
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
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..

									
PS20	SNU 120312	PU 02	US 35	6.0	M 8x1	22.5	NT 05	MT 05	HXX 4
PS22	SNU 120312	PU 02	US 42	6.0	M 8x1	21	NT 05	MT 05	HXX 4
PS40	SNU 150312	PU 04	US 36	6.0	M 8x1	26	NT 07	MT 07	HXX 4
PS50	SNU 190416	PU 05	US 38	8.0	M 10x1	29	NT 06	MT 06	HXX 5
PS60	SNU 250624	PU 06	US 39	8.0	M 10x1	33	NT 08	MT 08	HXX 5
PS70	SNU 250624	PU 06	US 47	8.0	M 12x1	36	NT 08	MT 08	HXX 5
PS72	SNU 250624	PU 10-N	PS 12040	8.0	M 12x1	40	NT 08	MT 08	HXX 5

PSDNN EXT



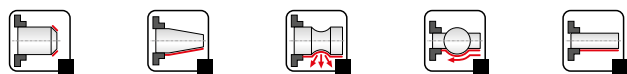
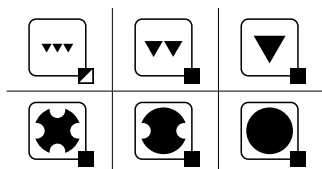
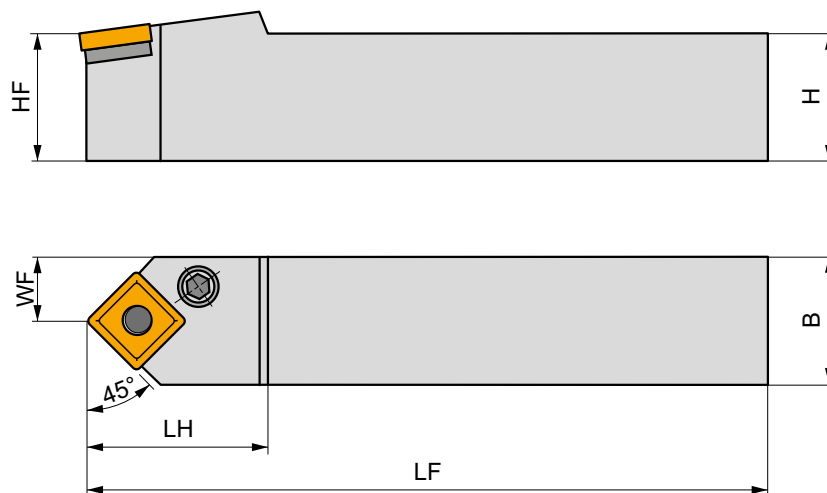
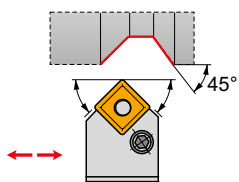
PRAMET

P



Utvendig verktøyholder med 45 ° skjærevinkel for SN .. Skjær

Utvendig nøytral verktøyholder med skjæringsvinkel på 45 °. Passer for langsgående dreining uten skulder, formdreining og konisk dreining og fasing med negative SN .. 12, 15, 19 eller 25 skjærestørrelse. Tilgjengelig i 20x20 opptil 50x50 mm skaft. Behandlet for lengre levetid.



Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
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..

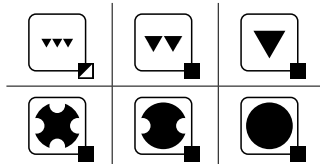
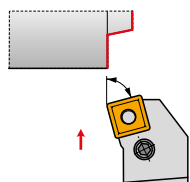
PS20	SNU 120312	PU 02	US 35	6.0	M 8x1	22.5	NT 05	MT 05	HXX 4
PS22	SNU 120312	PU 02	US 42	6.0	M 8x1	21	NT 05	MT 05	HXX 4
PS40	SNU 150312	PU 04	US 36	6.0	M 8x1	26	NT 07	MT 07	HXX 4
PS50	SNU 190416	PU 05	US 38	8.0	M 10x1	29	NT 06	MT 06	HXX 5
PS60	SNU 250624	PU 06	US 39	8.0	M 10x1	33	NT 08	MT 08	HXX 5

PSKN(RL) EXT

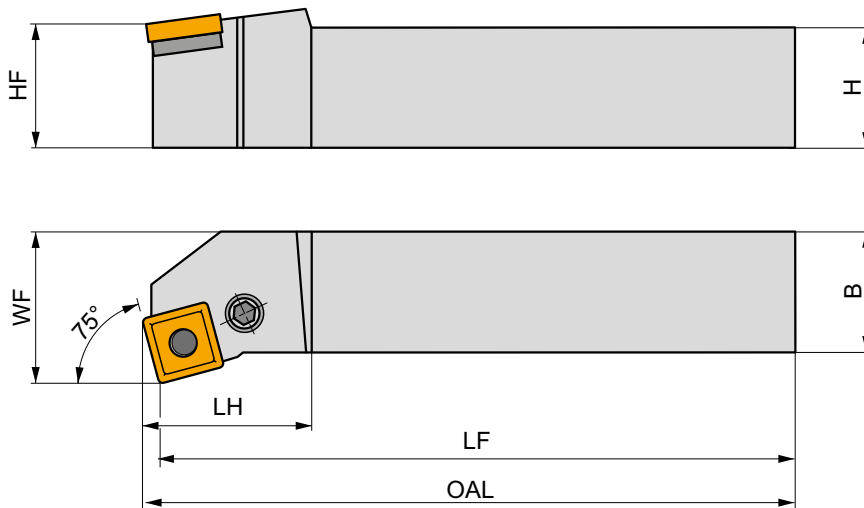


PRAMET

P

**Utvendig dreieholder, 75 ° (overflate dreining) Skjærevinkel for SN .. Skjær**

Utvendig høyre / venstre hånd dreieholder med skjærevinkel på 75 °. Egnet for overflatedreining uten skulder og avfasning med negativ SN .. 12, 15, 19 eller 25 skjærstørrelse. Tilgjengelig i 20x20 opptil 50x50 mm skaft. Behandlet for lengre levetid.



Product		H	B	HF	WF	LF	OAL	LH	LAMS	GAMO	kg	GI029	PS22
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
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
L	PSKNR 5050 T 2509	50	50	50	60	300	306.5	50	-6	-6	6.20	GI040	PS70
	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..

				 Nm					
PS20	SNU 120312	PU 02	US 35	6.0	M 8x1	22.5	NT 05	MT 05	HXX 4
PS22	SNU 120312	PU 02	US 42	6.0	M 8x1	21	NT 05	MT 05	HXX 4
PS40	SNU 150312	PU 04	US 36	6.0	M 8x1	26	NT 07	MT 07	HXX 4
PS50	SNU 190416	PU 05	US 38	8.0	M 10x1	29	NT 06	MT 06	HXX 5
PS60	SNU 250624	PU 06	US 39	8.0	M 10x1	33	NT 08	MT 08	HXX 5
PS70	SNU 250624	PU 06	US 47	8.0	M 12x1	36	NT 08	MT 08	HXX 5

PSSN(RL) EXT



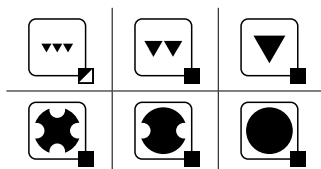
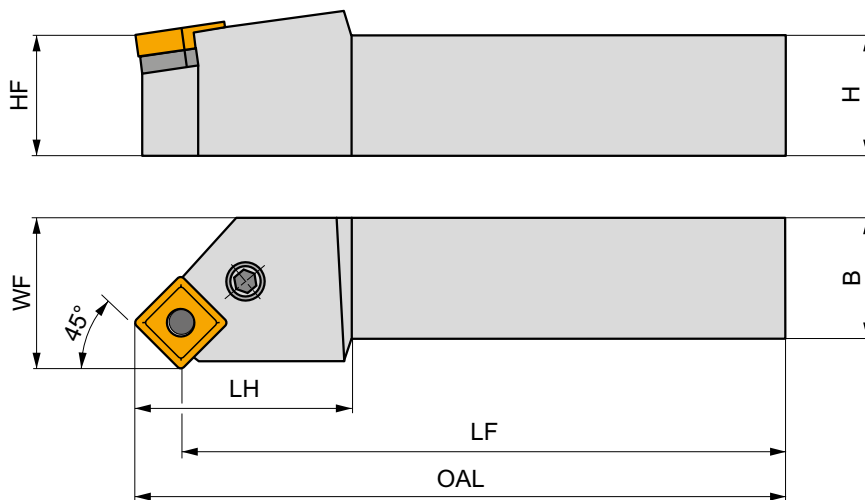
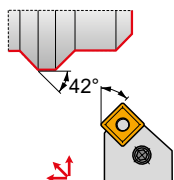
PRAMET

P



Utvendig dreieholder med 45° skjærevinkel for SN .. Skjær

Utvendig høyre / venstre hånd dreieholderr med skjærevinkel på 45°. Passer for langsgående og overflatedreining uten skulder, form og konisk dreining og fasing med negativ SN .. 12, 15, 19 eller 25 skjærstørrelse. Tilgjengelig i 20x20 opptil 50x50 mm skaft. Behandlet for lengre levetid.



Product		H	B	HF	WF	LF	OAL	HH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
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
L	PSSNR 5050 T 2509	50	50	50	60	300	316	50	0	-8	6.05	GI040	PS70
	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..



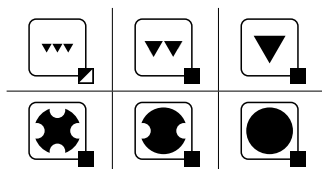
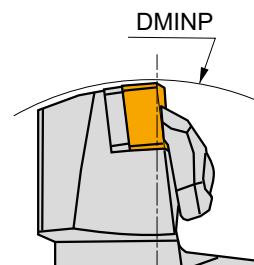
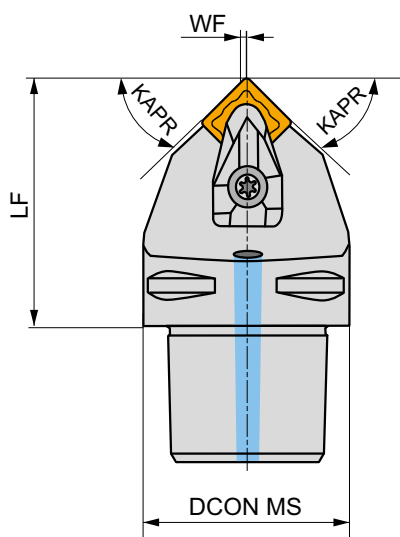
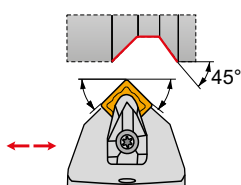
PS20	SNU 120312	PU 02	US 35	6.0	M 8x1	22.5	NT 05	MT 05	HXX 4
PS22	SNU 120312	PU 02	US 42	6.0	M 8x1	21	NT 05	MT 05	HXX 4
PS40	SNU 150312	PU 04	US 36	6.0	M 8x1	26	NT 07	MT 07	HXX 4
PS50	SNU 190416	PU 05	US 38	8.0	M 10x1	29	NT 06	MT 06	HXX 5
PS60	SNU 250624	PU 06	US 39	8.0	M 10x1	33	NT 08	MT 08	HXX 5
PS70	SNU 250624	PU 06	US 47	8.0	M 12x1	36	NT 08	MT 08	HXX 5

NEW**C.-DSDNN EXT**

PRAMET

D**Utvendig PSC hurtigvekslin dreieholder, klemhode, 45° skjærevinkel, SN .. Skjær**

Utvendig nøytralt dobbelt klemmeverktøy, gjennom kjølevæske, med 45° skjæringsvinkel for langsgående dreining uten skulder, formdreining, konisk dreining og avfasing med negativ SN .. 12 eller 19 skjærstørrelse. Tilgjengelig med PSC (Polygon Shank Coupling) C4 opp til C6 skaft. Behandlet for lengre levetid.

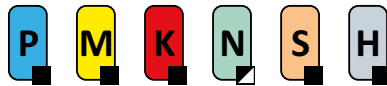


Product	DCON MS (mm)	DMINP (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg			
N C4-DSDNN-00050-12	40	140	0.3	50	45	-6	-6	✓	0.39	GI029	C-DS12-2	AT003
C5-DSDNN-00060-12	50	165	0.3	60	45	-6	-6	✓	0.69	GI029	C-DS12-2	AT003
C6-DSDNN-00070-19	63	195	0.5	70	45	-6	-6	✓	1.28	GI026	C-DS19	—

GI026	SN.. 1906..
GI029	SN.. 1204..

C-DS12-2	DCS 12	3.9	DSS 425-01	US 2002-T15P	FLAGT15P/3,5	—	CN 045-01
C-DS19	DCS 19	6.4	DSS 425-04	US 2007-T20P	—	LKT20P	CN 045-01

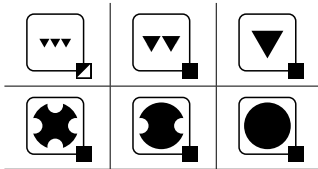
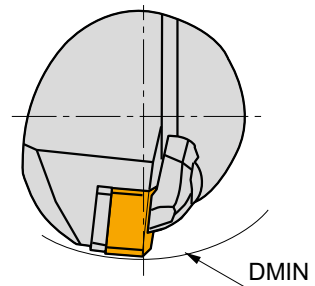
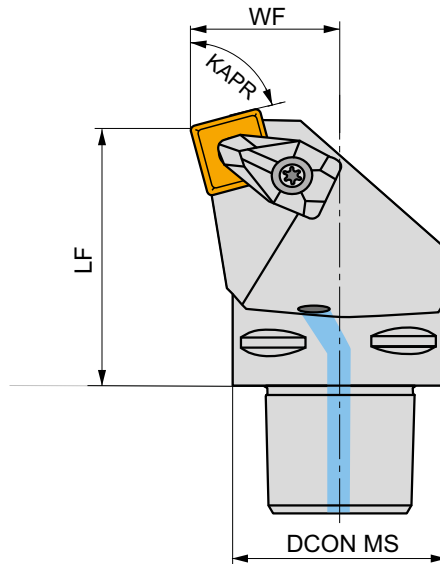
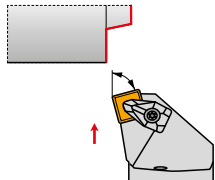
AT003a	SN.. 1207..	—	DSS 425-02
AT003b	CER SN.N 1204..	DCS 12C4	—
AT003c	CER SN.A 1204..	DCS 12C2	—

NEW**C.-DSKN(RL) EXT**

PRAMET

D**Utv. PSC hurtigveksling dreieholder, klemhode, 75 ° (overflate), Skjærevinkel SN ..Skjær**

Utvendig høyre / venstre hånd dreieholder med klemhode, innvendig kjøling, med 75° skjærevinkel for overflatedreining uten skulder og avfasning med negativ SN .. 12 .. skjærestørrelse. Tilgjengelig med PSC (Polygon Shank Coupling) C4. Behandlet for lengre levetid.



Product	DCON MS (mm)	DMIN (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)					
R C4-DSKNR-27050-12	40	110	27	50	75	-6	-6	✓	0.46	GI029	C-DS12-1	AT003
L C4-DSKNL-27050-12	40	110	27	50	75	-6	-6	✓	0.46	GI029	C-DS12-1	AT003



GI029



SN.. 1204..



C-DS12-1



DCS 12



3.9



DSS 425-01



US 2002-T15P



FLAG T15P/3,5



CN 034-01



AT003a



SN.. 1207..



-



DSS 425-02

AT003b

CER SN.N 1204..

DCS 12C4

AT003c

CER SN.A 1204..

DCS 12C2

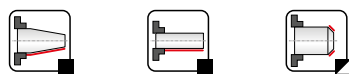
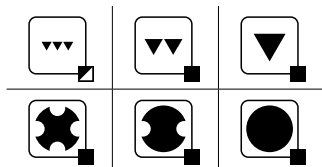
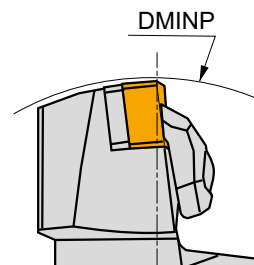
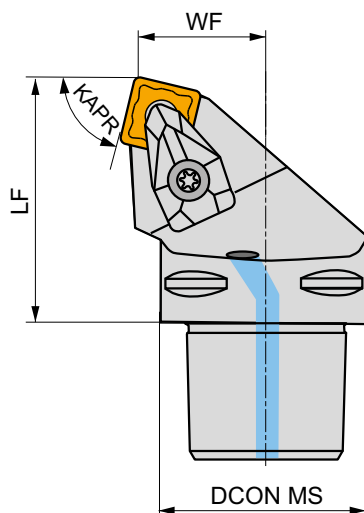
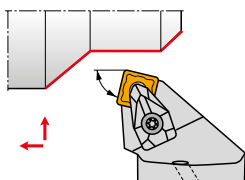
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NEW**C.-DSRN(RL) EXT**

PRAMET

D**Utvendig PSC hurtigveksling dreieholder, klemhode, 75 ° skjærevinkel, SN .. Skjær**

utvendig høyre / venstre hånd dreieholder med klemhode, innvendig kjøling, med 75° skjærevinkel for langsgående sving uten skulder, konisk dreining og fasing med negative SN .. 12 eller 19 skjærstørrelse. Tilgjengelig med PSC (Polygon Shank Coupling) C4 opp til C6 skaft. Behandlet for lengre 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	—

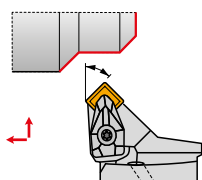
GI026	SN.. 1906..
GI029	SN.. 1204..

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

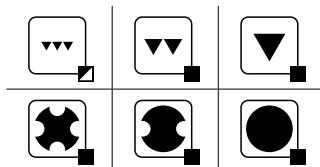
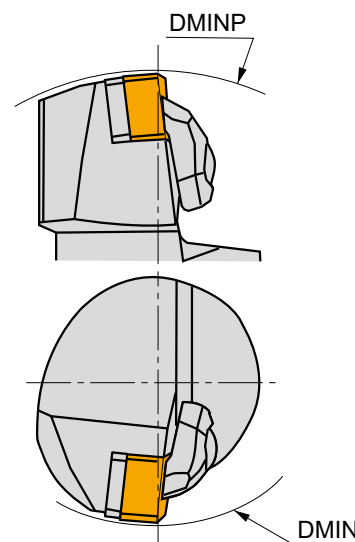
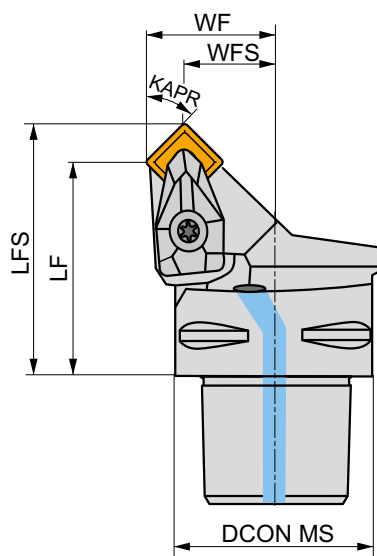
AT003a	SN.. 1207..	—	DSS 425-02
AT003b	CER SN.N 1204..	DCS 12C4	—
AT003c	CER SN.A 1204..	DCS 12C2	—

NEW**C.-DSSN(RL) EXT**

PRAMET

D**Utvendig PSC hurtigveksling dreieholder, klemhode, 45° skjærevinkel, SN .. Skjær**

Utvendig høyre / venstre hånd dreieholder med klemhode, innvendig kjøling, med 45° skjærevinkel for langsgående og overflate dreining uten skulder, konisk dreining, formdreining og fasing med negativ SN .. 12 skjærstørelse. Tilgjengelig med PSC (Polygon Shank Coupling) C4 og C5 skaft. Behandlet for lengre levetid.



Product		DCON MS	DMIN	DMINP	WF	WFS	LF	LFS	KAPR	LAMS	GAMO		kg			
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)	(°)					
R	C4-DSSNR-27042-12	40	110	140	27	18.7	42	50.3	45	0	-8	✓	0.38	GI029	C-DS12-1	AT003
	C5-DSSNR-35052-12	50	110	165	35	26.7	52	60.3	45	0	-8	✓	0.68	GI029	C-DS12-3	AT003
L	C4-DSSNL-27042-12	40	110	140	27	18.7	42	50.3	45	0	-8	✓	0.36	GI029	C-DS12-1	AT003
	C5-DSSNL-35052-12	50	110	165	35	26.7	52	60.3	45	0	-8	✓	0.69	GI029	C-DS12-3	AT003



GI029



SN.. 1204..



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)

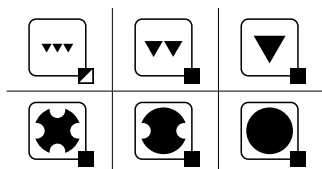
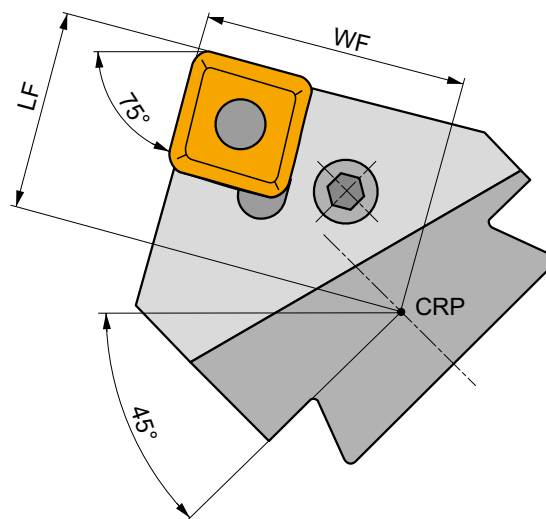
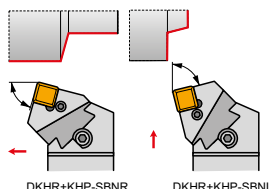


PRAMET

P

**Modulær dreiepatron KHP låsespor, 75 ° skjærevinkel for SN .. Skjær**

Koblingshus høyre / venstre dreiepatron, 75 ° skjærevinkel, for montering på DKH verktøyholder. Egnet for kraftig langsgående sving uten skulder, ansiktsvending, konisk og fasing med negativ SN .. 19 eller 25 skjær. Verktøyholder behandlet for lengre levetid.



	Product	WF	LF	LAMS	GAMO	kg		
		(mm)	(mm)	(°)	(°)			
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								
GI027								
GI040								
GI162								

PS50	SNU 190416	PU 05	US 38	8.0	M 10x1	29	NT 06	MT 06	HXX 5
PS60	SNU 250624	PU 06	US 39	8.0	M 10x1	33	NT 08	MT 08	HXX 5
PS70	SNU 250624	PU 06	US 47	8.0	M 12x1	36	NT 08	MT 08	HXX 5
PS72	SNU 250624	PU 10-N	PS 12040	8.0	M 12x1	40	NT 08	MT 08	HXX 5

KHP-SSN(RL)

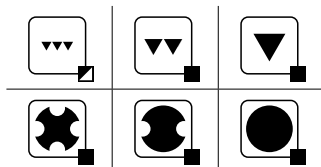
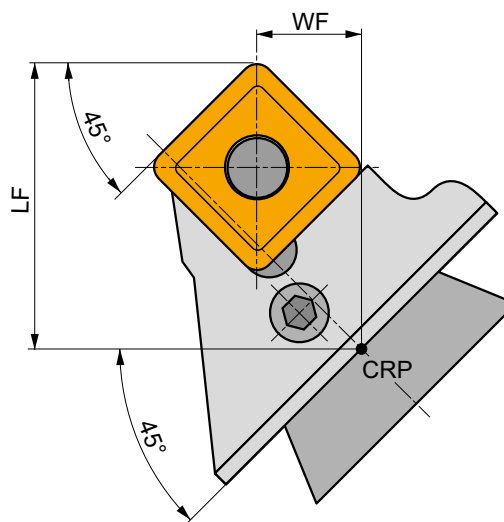
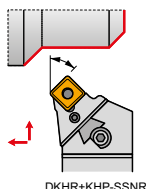


PRAMET

P

**Modulær dreiepatron KHP låsespor, 45 ° skjærevinkel for SN .. Skjær**

Koblingshus høyre / venstre dreiepatron, 45 ° skjærevinkel, for montering på DKH verktøyholder. Egnet for tung langsgående sving uten skulder, ansiktsvending, kopiering, konisk og fasing med negativ SN .. 19 eller 25 skjær. Verktøyholder behandlet for lengre levetid.



Product		WF	LF	LAMS	GAMO	kg		
		(mm)	(mm)	(°)	(°)			
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..



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

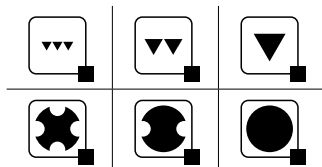
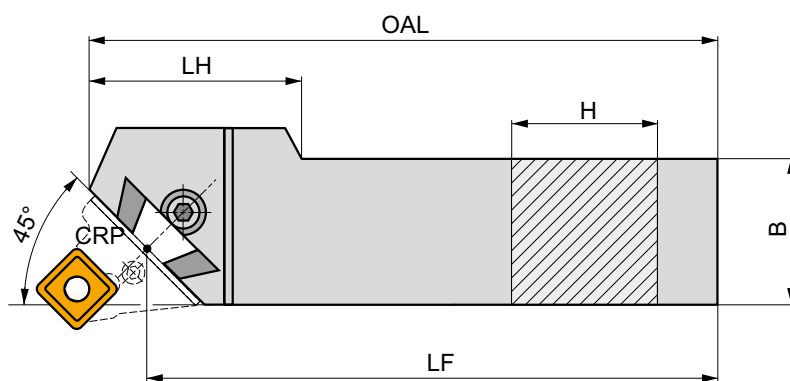
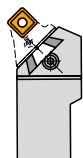
MT 08

HXK 5

DKH(RL)

**Utvendig verktøyholderskaft for KHP / KHS Grove dreiepatroner**

Koblingshus høyre / venstre hånds verktøyskaft for KHP / KHS-kassetter. Egnet for tunge dreie applikasjoner. Tilgjengelig med skaftstørrelse 40x50 opp til 60x80 mm. Behandlet for lengre levetid.



	Product	H	B	LF	OAL	LH	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)			
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

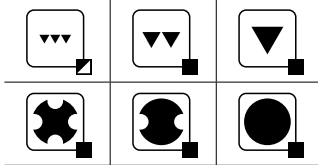
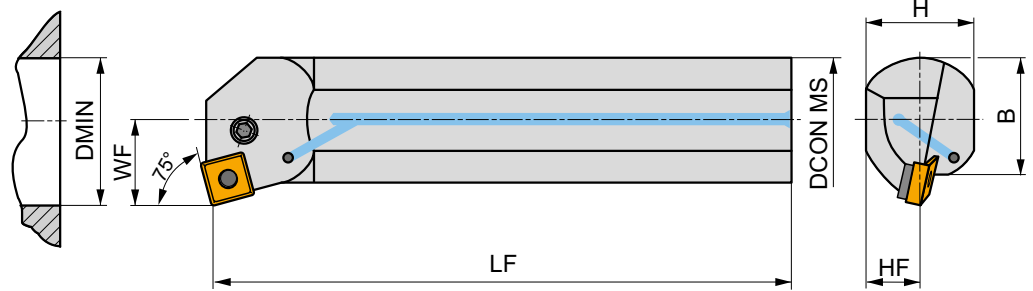
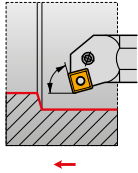


PRAMET

P

**Innvendig dreiebom med 75 ° skjærevinkel for SN .. Skjær**

Innvendig høyre/venstre hånd dreiebom, med innvendig kjøling, 75° skjærevinkel for SN .. 12, 15 og 19 skjær. Minimum innvendig dreiediameter Ø40 mm. For innvendig konisk og langsgående dreieing uten skulder- og avfasning. Finnes med skaftstørrelse Ø32 opp til Ø60 mm. Behandlet for lengre levetid.



Product		DCON MS	DMIN	WF	H	B	LF	LAMS	GAMO		kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)				
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..



PS21

SNU 120312

PU 02

US 41

6.0

M 8x1

17

NT 05

MT 05

HXX 4

PS40

SNU 150312

PU 04

US 36

6.0

M 8x1

26

NT 07

MT 07

HXX 4

PS41

SNU 150312

PU 04

US 40

6.0

M 8x1

20.5

NT 07

MT 07

HXX 4

PS50

SNU 190416

PU 05

US 38

8.0

M 10x1

29

NT 06

MT 06

HXX 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

TNMM 160412E-OR

Tool Holder

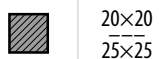
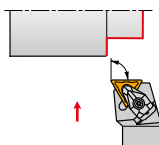
DTFNR 2525 M 16

ISO DREIING – EKSTERN

DTFN(RL) EXT

90°

TN..

16
22

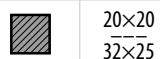
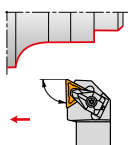
345

334 – 344

DTGN(RL) EXT

90°

TN..

16
22

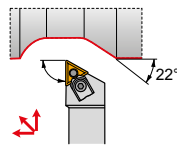
346

334 – 344

MTJN(RL) EXT

93°

TN..

16
22

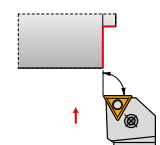
347

334 – 344

PTFN(RL) EXT

90°

TN..

16
22
27

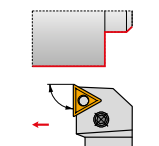
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334 – 344

PTGN(RL) EXT

90°

TN..

16
22
27

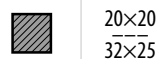
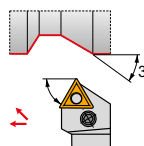
349

334 – 344

PTTN(RL) EXT

60°

TN..

16
22

350

334 – 344

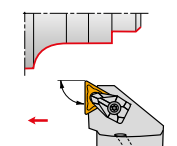
C.-DTJN(RL) EXT **NEW**

93°

TN..



16



351

334 – 344

TN

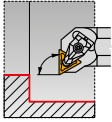
16/ 22/ 27/ 33

ISO DREIING – INTERNT

DTFN(RL) INT

90°

TN..

16
22
 $\frac{32}{50}$

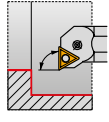
352

334 – 344

PTFN(RL) INT

90°

TN..

16
22
 $\frac{32}{50}$

353

334 – 344

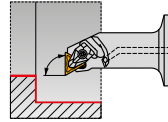
C.-DTFN(RL) INT **NEW**

91°

TN..



16



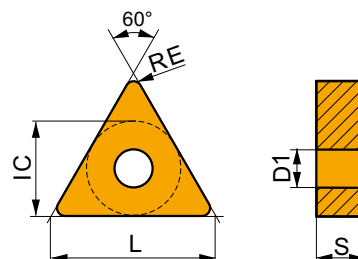
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354

334 – 344

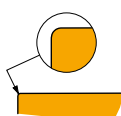
TNMA

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



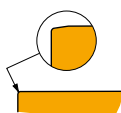
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

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)



For fin til halv-grov bearbeiding og kontinuerlige til lett avbrutte kutt.

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

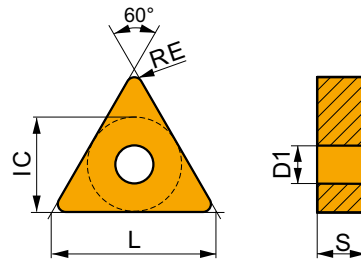


For fin til halv-grov bearbeiding og kontinuerlige til lett avbrutte kutt.

TNMA 160408S	T5305	0.8	—	—	—	—	—	—	205	0.20	1.5	—	—	—	—	—	40	0.15	1.0
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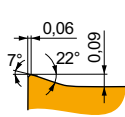
TNMG

	IC	D1	L	S
	(mm)	(mm)	(mm)	(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



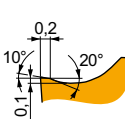
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

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)



FF-geometri med meget positiv design for finbearbeiding og kontinuerlige til lett avbrutte kutt.

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	—	—	—	—	—	—	—	—



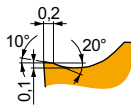
FM-geometri med positiv design for fin til halv-grov bearbeiding, og kontinuerlige til lett avbrutte kutt.

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	—	—	—	—	—	—	—	—	—	—	—
	T7325	0.8	195	0.20	1.7	150	0.18	1.7	—	—	—	—	—	60	0.16	1.4	—	—	—
TNMG 160408E-FM	T7335	0.8	190	0.20	1.7	145	0.18	1.7	—	—	—	—	—	60	0.16	1.4	—	—	—
	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	—	—	—	—	—	—	—	—	—	—	—
	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	—	—	—
TNMG 160412E-FM	T8430	1.2	185	0.25	1.7	100	0.23	1.7	150	0.25	1.7	—	—	40	0.18	1.4	—	—	—
	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	—	—	—
	T8330	0.4	145	0.20	1.7	85	0.18	1.7	135	0.20	1.7	—	—	35	0.20	1.4	—	—	—
TNMG 220404E-FM	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	—	—	—

CN	DN	KN	LN	RN	SN	TN	VN	WN
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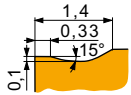
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(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)



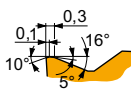
FM-geometri med positiv design for fin til halv-grov bearbeiding, og kontinuerlige til lett avbrutte kutt.

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	—	—	—



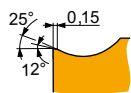
KR-geometri for middels til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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 for fin til middels bearbeiding, og kontinuerlig til avbrutt kutt.

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	—	—	—	—	—	—	—	—	—
TNMG 160412E-M	T9335	0.8	160	0.30	1.6	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	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	—	—	—	—	—	—	—	—	—
TNMG 220408E-M	T9335	1.2	145	0.40	1.6	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	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
TNMG 220412E-M	T9325	0.8	180	0.30	2.1	—	—	—	170	0.30	2.1	—	—	—	—	—	—	—	—	—
	T9335	0.8	155	0.30	2.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	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	—	—	—	—	—	—	—	—	—
TNMG 220412E-M	T9335	1.2	140	0.40	2.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—



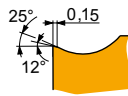
NF-geometri med meget positiv design for finbearbeiding til middels bearbeiding og kontinuerlige kutt.

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	—	—	—

CN	DN	KN	LN	RN	SN	TN	VN	WN
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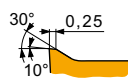
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	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)



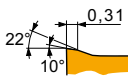
NF-geometri med meget positiv design for finbearbeiding til middels bearbeiding og kontinuerlige kutt.

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 positiv design for finbearbeiding, middels og grov bearbeiding, i kontinuerlige kutt.

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	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
TNMG 220408E-NM	T9325	0.8	225	0.25	1.9	135	0.23	1.9	—	—	—	—	—	—	50	0.20	1.5	—	—	—
	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	—	—	—
TNMG 220412E-NM	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	—	—	—
	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	—	—	—



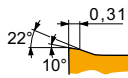
NMR-geometri med positiv design for middels til grov bearbeiding og kontinuerlige kutt.

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	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
TNMG 160408E-NMR	T9325	0.4	180	0.20	1.7	105	0.18	1.7	—	—	—	—	—	—	40	0.18	1.4	—	—	—
	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	—	—	—

CN	DN	KN	LN	RN	SN	TN	VN	WN
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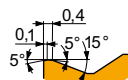
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(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)



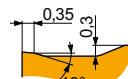
NMR-geometri med positiv design for middels til grov bearbeiding og kontinuerlige kutt.

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 for halv-grov til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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	—	—	—	—	—	—	—	—	—
TNMG 160412E-R	T9335	0.8	130	0.40	3.0	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	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	—	—	—	—	—	—	—	—	—
TNMG 220408E-R	T9335	1.2	140	0.40	3.0	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	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	—	—	—	—	—	—	—	—	—
TNMG 220412E-R	T9335	0.8	125	0.40	4.0	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	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	—	—	—
TNMG 220416E-R	T9325	1.2	155	0.40	4.0	—	—	—	145	0.40	4.0	—	—	—	—	—	—	—	—	—
	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	—	—	—	—	—	—	—	—	—



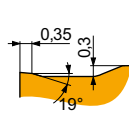
RM-geometri for halv-grov til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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		—	—	—		—	—	—		—	—	—		—	—	—

CN	DN	KN	LN	RN	SN	TN	VN	WN
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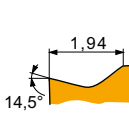
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

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)



RM-geometri for halv-grov til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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	—	—	—	—	—	—	—	—	—
TNMG 220408E-RM	T9335	1.2	160	0.40	3.0	95	0.36	3.0	—	—	—	—	—	—	—	—	—	—	—	—
	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	—	—	—	—	—	—	—	—	—
TNMG 220412E-RM	T9335	0.8	145	0.40	4.0	85	0.36	4.0	—	—	—	—	—	—	—	—	—	—	—	—
	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	—	—	—	—	—	—	—	—	—	—	—	—



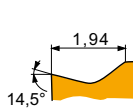
SF-geometri med positiv design for finbearbeiding av tynne vegger og kontinuerlige kutt.

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	—	—	—

CN	DN	KN	LN	RN	SN	TN	VN	WN
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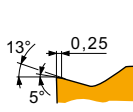
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(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)



SF-geometri med positiv design for finbearbeiding av tynne vegger og kontinuerlige kutt.

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	—	—	—
	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
TNMG 160412E-SF	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	—	—	—
	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
TNMG 220404E-SF	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	—	—	—
	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
TNMG 220408E-SF	T8315	0.8	180	0.17	1.7	105	0.15	1.7	170	0.17	1.7	540	0.20	1.7	45	0.15	1.4	35	0.15	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
	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
TNMG 220412E-SF	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	—	—	—



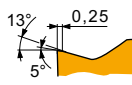
SM-geometri med positiv design for middels bearbeiding og kontinuerlige til avbrutte kutt.

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	—	—	—
	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
TNMG 160408E-SM	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	—	—	—
	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	—	—	—
TNMG 160412E-SM	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	—	—	—
	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	—	—	—
	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
TNMG 220404E-SM	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	—	—	—

CN	DN	KN	LN	RN	SN	TN	VN	WN
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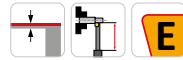
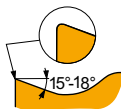
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(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)



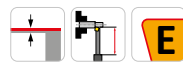
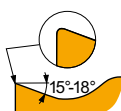
SM-geometri med positiv design for middels bearbeiding og kontinuerlige til avbrutte kutt.

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	—	—	—



ER-SI geometri med positiv høyrehendt design for fin til halv-grov bearbeiding og kontinuerlige kutt.

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	—	—	—
	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	—	—	—
	T9335	0.8	190	0.35	1.5	110	0.32	1.5	—	—	—	—	—	—	40	0.25	1.2	—	—	—

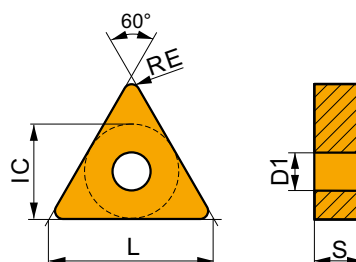


EL-SI geometri med positiv venstrehendt design for fin til halv-grov bearbeiding og kontinuerlige kutt.

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	—	—	—
	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	—	—	—
	T9335	0.8	190	0.35	1.5	110	0.32	1.5	—	—	—	—	—	—	40	0.25	1.2	—	—	—

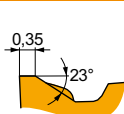
TNMM

	IC	D1	L	S
	(mm)	(mm)	(mm)	(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



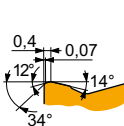
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

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)



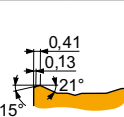
DR-geometri for middels til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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	—	—	—	—	—	—	—	—	—	—	—



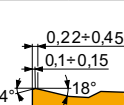
HR-geometri for grov til tung-grov bearbeiding, og kontinuerlig til avbrutt kutt.

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 for middels til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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	—	—

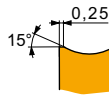


OR geometri for middels til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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	—	—

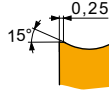
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	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 høyrehendt design for middels til halv-grov bearbeiding og kontinuerlige kutt.

TNMM 220412ER	T9335	1.2	190	0.35	2.1	110	0.32	2.1	—	—	—	—	—	—	40	0.25	1.7	—	—	—
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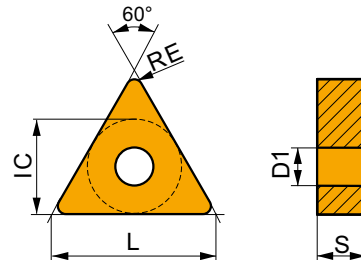
EL-geometri med venstrehendt design for middels til halv grov bearbeiding og kontinuerlige kutt.

TNMM 220412EL	T9335	1.2	190	0.35	2.1	110	0.32	2.1	—	—	—	—	—	—	40	0.25	1.7	—	—	—
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TNGA CER



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



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	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)



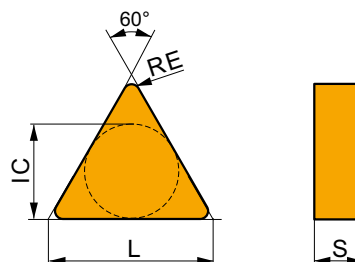
For maskinering med høye hastigheter og kontinuerlige kutt.

TNGA 160408 T01020	TC100	0.8	—	—	—	—	—	—	475	0.20	1.5	—	—	—	—	—	—	—	—	—
TNGA 160412 T01020	TC100	1.2	—	—	—	—	—	—	500	0.20	1.5	—	—	—	—	—	—	—	—	—

TNGN CER

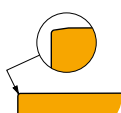


	IC	L	S
	(mm)	(mm)	(mm)
1604	9.525	16.50	4.76
1607	9.525	16.50	7.94



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere 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)



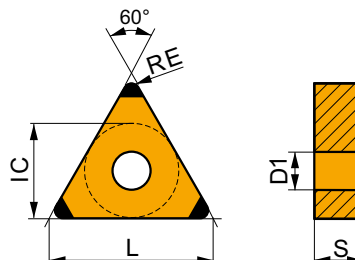
For maskinering med høye hastigheter og kontinuerlige kutt.

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

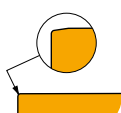


	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1604	9.525	3.81	16.50	4.76



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

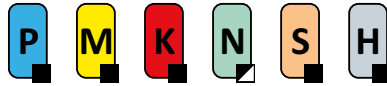
Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)



For ferdig bearbeiding og kontinuerlige kutt.

TNGA 160408S01020C	TB310	0.8	—	—	—	—	—	—	450	0.15	0.6	—	—	—	115	0.11	0.5	95	0.15	1.0
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DTFN(RL) EXT

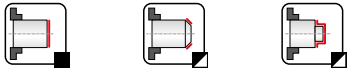
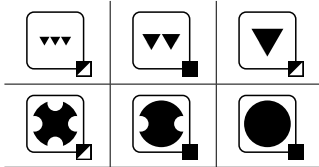
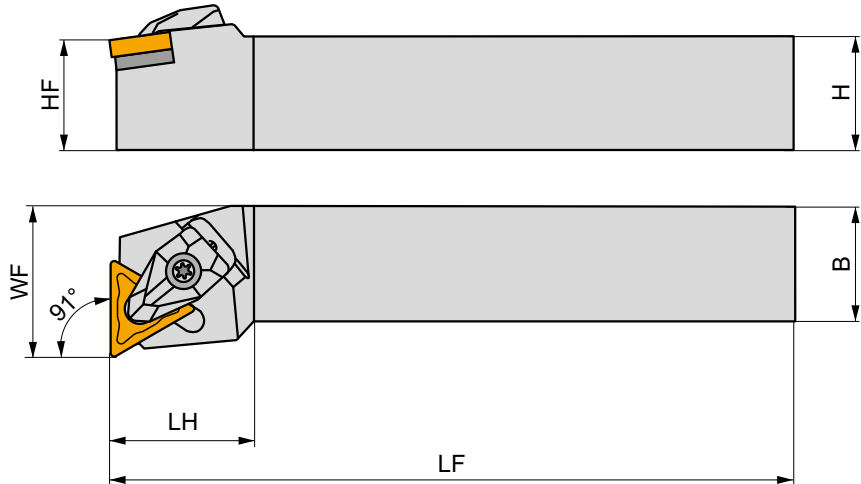
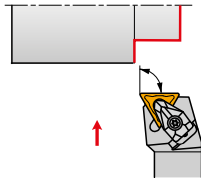


PRAMET

D

**Utvendig dreieholder med klemhode 91 ° skjærevinkel for TN .. Skjær**

Utvendig høyre / venstre dreieholder med klemhode, 91 ° skjærevinkel. Egnet for overflatedreining med skulder og fasing med negative TN .. 16 eller 22 skjærstørrelse. Tilgjengelig i 20x20 og 25x25 mm skaft. Bbehandlet for lengre levetid.



	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	DTFNR 2020 K 16	20	20	20	25	125	23.6	-6	-6	0.43	GI024	DT16
	DTFNR 2525 M 16	25	25	25	32	150	23.6	-6	-6	0.77	GI024	DT16
	DTFNR 2525 M 22	25	25	25	32	150	30.5	-6	-6	0.79	GI025	DT22
L	DTFNL 2020 K 16	20	20	20	25	125	23.6	-6	-6	0.43	GI024	DT16
	DTFNL 2525 M 16	25	25	25	32	150	23.6	-6	-6	0.76	GI024	DT16
	DTFNL 2525 M 22	25	25	25	32	150	30.5	-6	-6	0.79	GI025	DT22



GI024

TN.. 1604..

GI025

TN.. 2204..



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



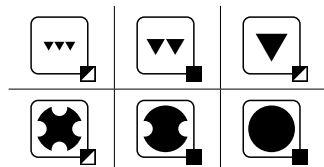
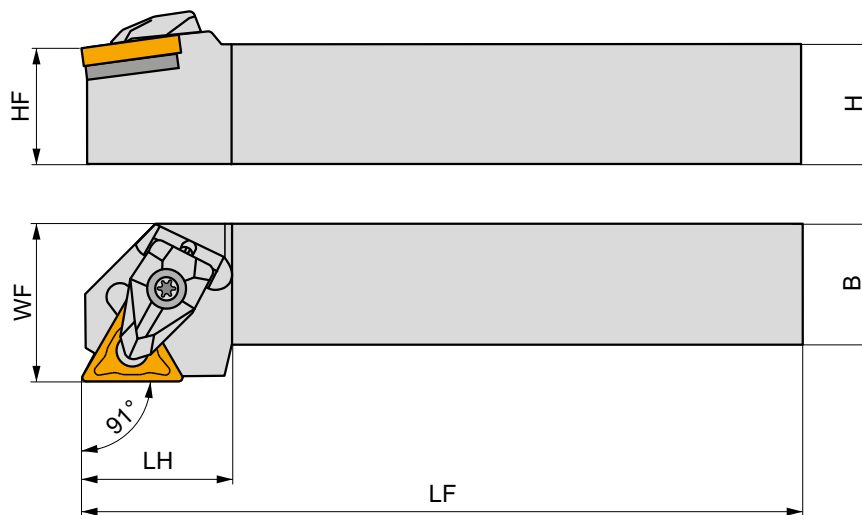
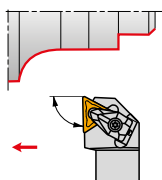
PRAMET

D



Utvendig dreieholder med klemhode 91° skjærevinkel for TN .. Skjær

Utvendig høyre / venstre dreieholder med klemhod, 91° skjærevinkel. Passer for langsgående dreining med skulder, konisk dreining og fasing med negative TN .. 16 eller 22 skjærstørrelse. Tilgjengelig i 20x20 opp til 32x32 mm skaft. Behandlet for lengre levetid.



Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	DTGNR 2020 K 16	20	20	20	25	125	25.4	-6	-6	0.43	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..



DT16

DCS 09

1.7

DTS 315-02

US 2004-T09P

FLAG T09P

DT22

DCS 12

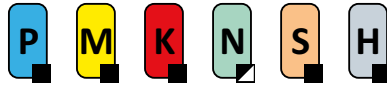
3.9

DTS 315-04

US 2002-T15P

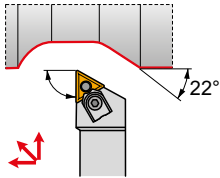
FLAG T15P/3,5

MTJN(RL) EXT



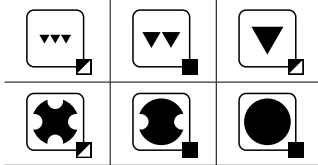
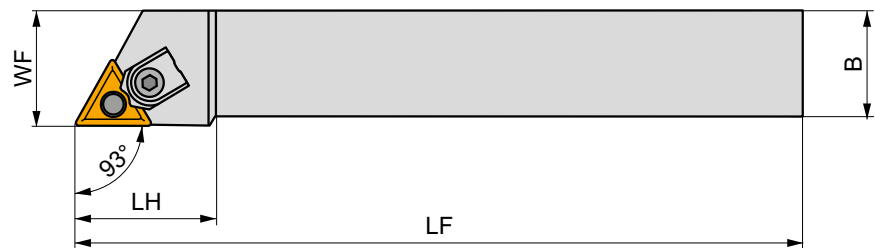
PRAMET

M



Utvendig dreieholder med klemhod, 93 ° skjærevinkel for TN .. Skjær

Utvendig høyre / venstre hånd dreieholder med klemhode, skjærevinkel på 93 °. Passer til langsgående dreiging med skulder, konisk dreiging og forming som dreier opp til 22 °, og avfasning med negative TN .. 16 eller 22 skjærestørrelse. Tilgjengelig i 20x20 opp til 32x32 mm skaft. Behandlet for lengre levetid.



	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
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..



MT16

UE 16

3.0

MTN 160312

UC 52

HS 93

HXX 5

MT22

UE 22

5.0

MTN 220612

UC 53

HS 94

HXX 5

PTFN(RL) EXT

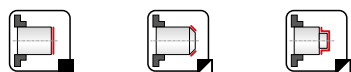
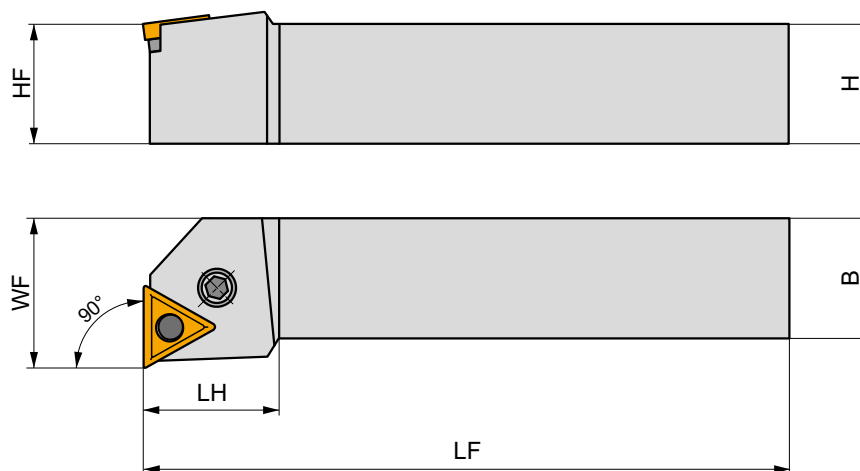
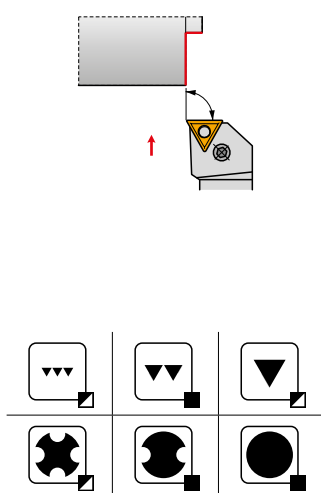


PRAMET

P

**Utvendig dreieholder med 90° (overflate) skjærevinkel for TN .. Skjær**

Utvendig høyre / venstre hånd dreieholder med 90° skjærevinkel. Egnet for overflatedreining med skulder og fasing med negative TN .. 16, 22 eller 27 skjærstørrelse. Tilgjengelig i skaft 16x16 opptil 40x40 mm. Behandlet for lengre levetid.



	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
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..



PT10

TNU 160308

PU 01

US 34

5.0

M 6x0.75

19

NT 04

MT 04

HXX 3

PT11

TNU 160308

PU 01

US 46

5.0

M 6x0.75

13.2

NT 04

MT 04

HXX 3

PT20

TNU 220312

PU 02

US 35

6.0

M 8x1

22.5

NT 05

MT 05

HXX 4

PT40

TNU 270416

PU 04

US 36

6.0

M 8x1

26

NT 07

MT 07

HXX 4

PTGN(RL) EXT



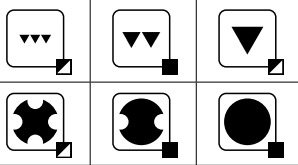
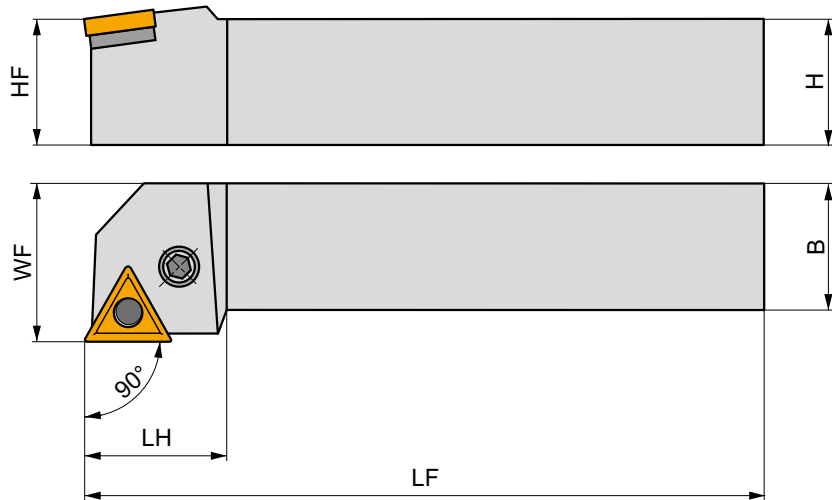
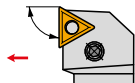
PRAMET

P



Utvendig dreieholder med 90° skjærevinkel for TN .. Skjær

Utvendig høyre / venstre hånd dreieholder med 90° skjærevinkel. Egnet for langsgående dreining med skulder, konisk dreining og fasing med negative TN .. 16, 22 eller 27 skjærstørrelse. Tilgjengelig i skaft 16x16 opptil 40x40 mm. Behandlet for lengre levetid.



Product		H	B	HF	WF	LF	LH	LAMS	GAMO	kg	GI024	GI025
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
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
L	PTGNR 4040 R 27	40	40	40	50	200	40	-6	-6	2.55	GI077	PT40
	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..



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



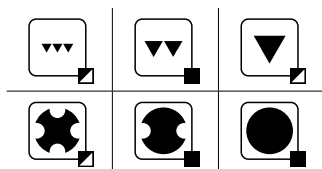
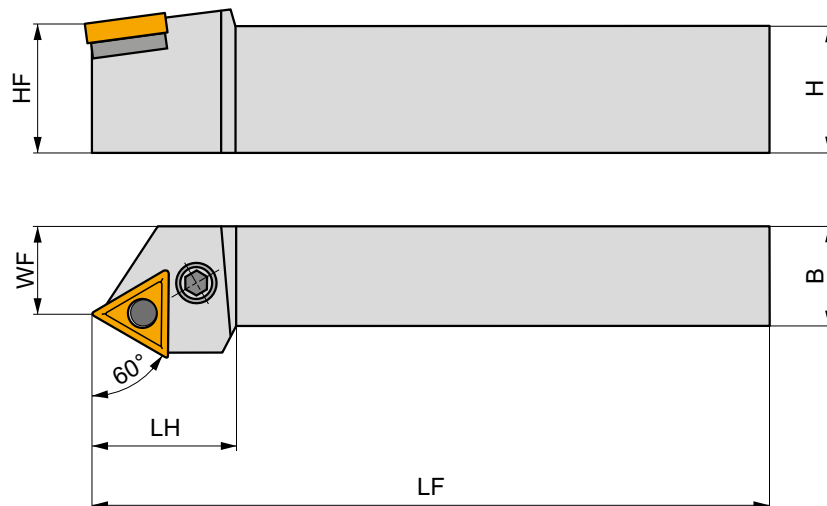
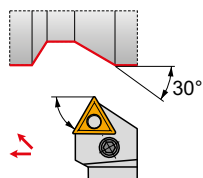
PRAMET

P



Utvendig dreieholder med 60° skjærevinkel for TN .. Skjær

Utvendig høyre / venstre hånd dreieholder med 60° skjærevinkel. Egnet for langsgående dreining med skulder, konisk og formdreining opptil 30° og avfasning med negative TN .. 16 og 22 skjærstørrelse. Tilgjengelig i 20x20 opp til 32x25 mm skaft. Behandlet for lengre levetid.



	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
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..



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

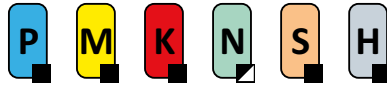
M 8x1

22.5

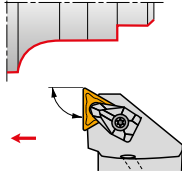
NT 05

MT 05

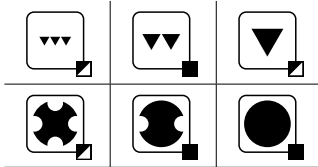
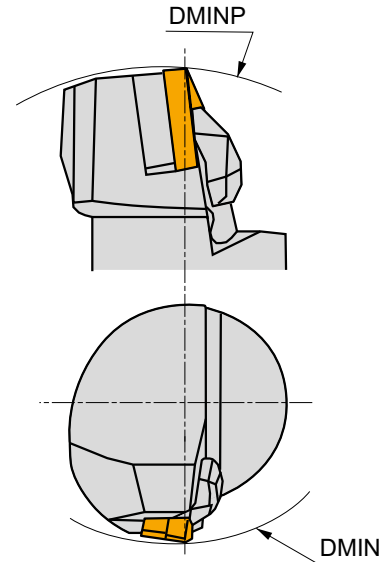
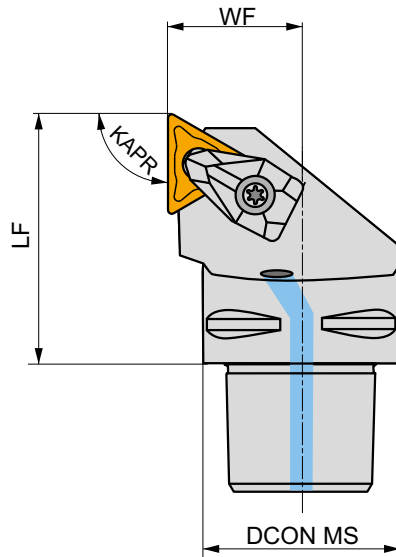
HXK 4

NEW**C.-DTJN(RL) EXT**

PRAMET

D**Utvendig PSC hurtigveksling dreieholder, klemhode, skjærvinkel på 93 °, TN .. Skjær**

Utvendig høyre / venstre hånd dreieholder med klemhode, Innvendig kjøling, med 93° skjærvinkel for langsgående dreining med skulder, form dreining og fasing med negativ TN .. 16 skjærstørrelse. Tilgjengelig med PSC (Polygon Shank Coupling) C4 og C5 skaft. Behandlet for lengre levetid.



Product		DCON MS	DMIN	DMINP	WF	LF	KAPR	LAMS	GAMO				
		(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)	(°)		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

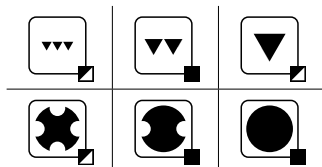
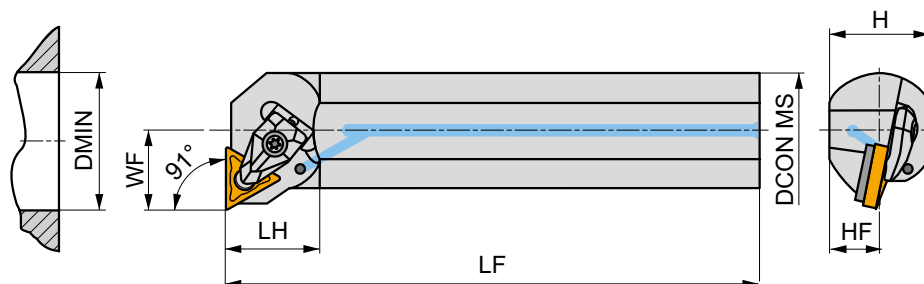
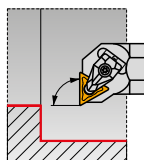


PRAMET

D

**Innvendig dreiebom med klemhode og 91° skjærevinkel for TN .. Skjær**

Innvendig høyre/venstre dreiebom med toppklemming, med innvendig kjøling, 91° skjærevinkel for TN .. 16 og 22 skjær. Minimum innvendig dreiediameter Ø32 mm. For innvendig konisk og langsgående dreining med skulder- og fasing. Finnes med skaftstørrelse Ø25 opp til Ø40 mm. Behandlet for lengre levetid.



Product	DCON MS	DMIN	WF	H	HF	LF	LH	LAMS	GAMO		kg		
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)				
R	A25T-DTFNR 16	25	32	17	23	11.5	300	32	-12	-6	✓	0.96	GI024 DT116
	A32T-DTFNR 16	32	40	22	30	15	300	33	-10	-6	✓	1.67	GI024 DT116
	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 DT116
	A32T-DTFNL 16	32	40	22	30	15	300	33	-10	-6	✓	1.67	GI024 DT116
	A40T-DTFNL 22	40	50	27	37	18.5	300	36	-13	-6	✓	2.58	GI025 DT22



GI024

TN.. 1604..

GI025

TN.. 2204..



DT22

DCS 12

3.9

DTS 315-04

US 2002-T15P

FLAGT15P/3,5

DT116

DCS 09

1.7

DTS 316-01

US 2004-T09P

FLAGT09P

PTFN(RL) INT

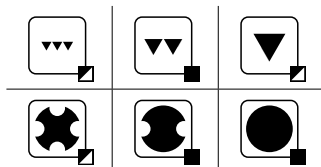
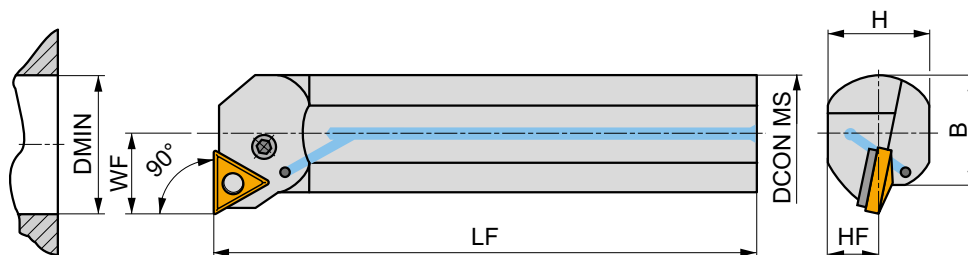
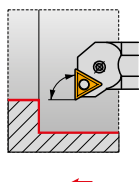


PRAMET

P

**Innvendig dreiebom med 90° skjærevinkel for TN.. Skjær**

Innvendig høyre/venstre hånd dreiebom, tilgjengelig med innvendig kjøling, 90° skjærevinkel for TN .. 16 og 22 skjær. Minimum innvendig dreiediameter Ø32 mm. For innvendig konisk og langsgående dreieing med skulder- og fasing. Ø25 opp til Ø40 mm skaft tilgjengelig. Behandlet for lengre levetid.



Product		DCON MS	DMIN	WF	H	B	LF	LAMS	GAMO		kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)				
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..



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

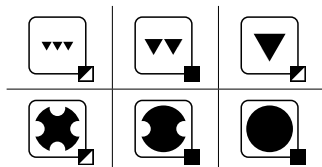
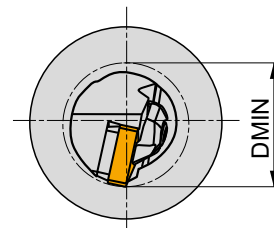
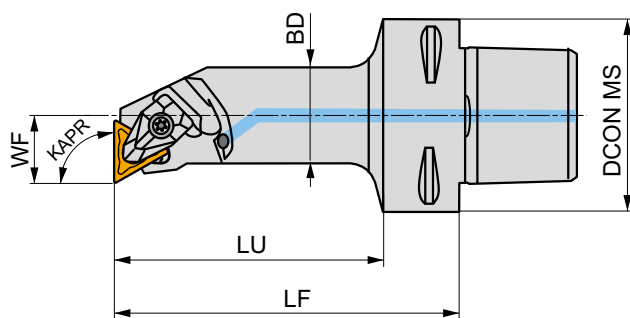
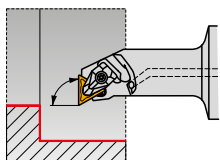
HXK 4

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

PRAMET

D**Innvendig PSC hurtig veksling dreieholder, klemhode, 91° skjærevinkel, TN.. Skjær**

Innvendig høyre/venstre dreieholder med toppklemming, med innvendig kjøling, med 91° skjærevinkel for et bredt spekter av innvendige dreieapplikasjoner med TN .. 16 skjær, minimum dreiediameter Ø32mm. PSC -skaft (Polygon Shank Coupling) størrelse C4 med dreielengde på 68 mm. Behandlet for lengre levetid.



Product	DCON MS (mm)	DMIN (mm)	WF (mm)	LF (mm)	LU (mm)	BD (mm)	KAPR (°)	LAMS (°)	GAMO (°)				
R C4-DTFNR-17090-16	40	32	17	90	68	25	91	-12	-6	✓	0.51	G1024	DT116

G1024	TN.. 1604..

DT116	DCS 09	1.7	DTS 316-01	US 2004-T09P	FLAG T09P

CARBIDE INSERTS

VNMG



356

CER AND CBN INSERTS

VNGA CER



359

VNGA CBN



359

MATCH THE RIGHT SIZE (example)

Insert

VNMG 160404E-SF

Tool Holder

DVJNL 2020 K 16

ISO DREIING – EKSTERN

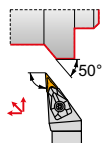
DVJN(RL) EXT

93°

VN..



16

20×20
32×25

360

356 – 359

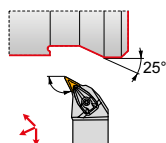
DVPN(RL) EXT

62°30'

VN..



16

20×20
32×25

361

356 – 359

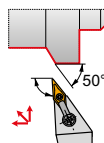
MVJN(RL) EXT

93°

VN..



16

20×20
32×25

362

356 – 359

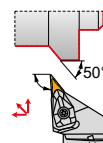
C.-DVJN(RL) EXT **NEW**

93°

VN..



16

C4
C6

363

356 – 359

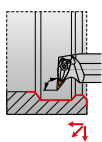
ISO DREIING – INTERN

DVUN(RL) INT

VN..



16



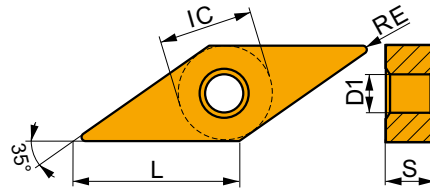
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364

356 – 359

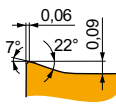
VNMG

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



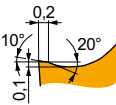
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

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)



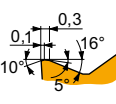
FF-geometri med meget positiv design for finbearbeiding og kontinuerlige til lett avbrutte kutt.

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 positiv design for fin til halv-grov bearbeiding og kontinuerlige til lett avbrutte kutt.

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	—	—	—



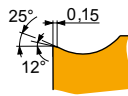
L-PR venstrehåndsgeometri, førstevalg for avstikk, og kontinuerlig til avbrutte kutt.

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	—	—	—	—	—	—	—	—

CN	DN	KN	LN	RN	SN	TN	VN	WN
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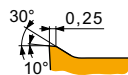
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product	RE (mm)	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)



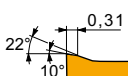
NF-geometri med meget positiv design for finbearbeiding til middels bearbeiding og kontinuerlige kutt.

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 positiv design for finbearbeiding, middels og grov bearbeiding, med kontinuerlige kutt.

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	—	—	—



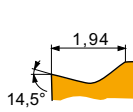
NMR-geometri med positiv design for middels til grov bearbeiding og kontinuerlige kutt.

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	—	—	—

CN	DN	KN	LN	RN	SN	TN	VN	WN
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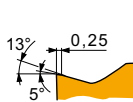
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product	RE (mm)	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 positiv design for finbearbeiding og for bearbeiding av tynne vegger, med kontinuerlige kutt.

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	■	—	—	—



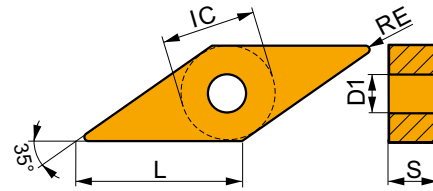
SM-geometri med positiv design for middels bearbeiding og kontinuerlige til avbrutte kutt.

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



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



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere 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)



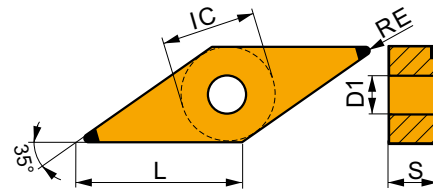
For maskinering med høye hastigheter og kontinuerlige kutt.

VNGA 160404 T01020	TC100	0.4	—	—	—	—	—	—	425	0.10	1.0	—	—	—	—	—	—	—	—
VNGA 160408 T01020	TC100	0.8	—	—	—	—	—	—	395	0.20	1.0	—	—	—	—	—	—	—	—

VNGA CBN



	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1604	9.525	3.81	16.00	4.76



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere 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)



For ferdig bearbeiding og kontinuerlige kutt.

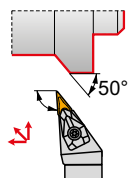
VNGA 160404S01020B	TB310	0.4	—	—	—	—	—	—	360	0.10	0.4	—	—	—	95	0.07	0.3	75	0.15	1.0
VNGA 160408S01020B	TB310	0.8	—	—	—	—	—	—	370	0.15	0.6	—	—	—	95	0.11	0.5	75	0.15	1.0

DVJN(RL) EXT

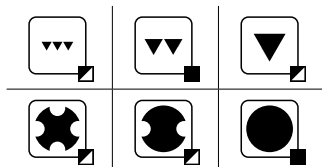
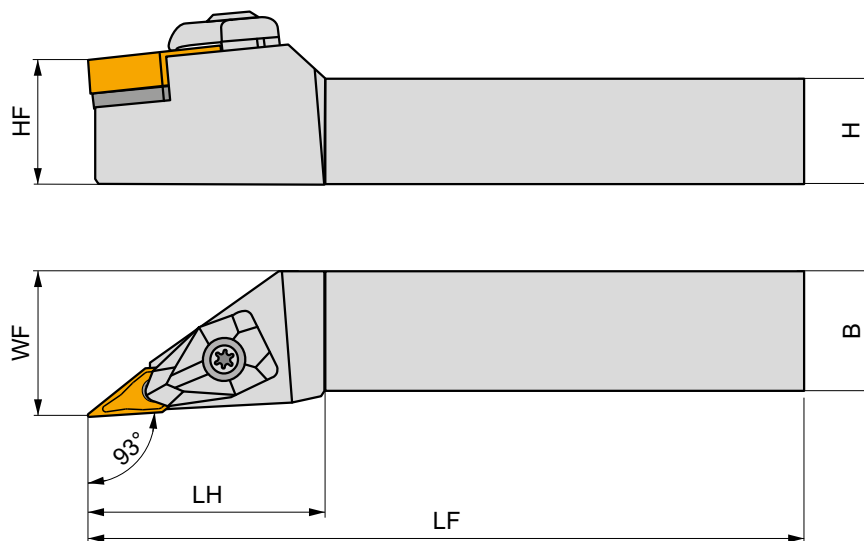


PRAMET

D

**Utvendig dreieholder med klemhode 93 ° skjæringsvinkel for VN .. Skjær**

Utvendig høyre / venstre dreieholder med klemhode, 93 ° skjærevinkel. Passer for langsgående dreining med skulder, forming og konisk dreining og fasing med negativ VN .. 16 skjærestørrelse. Tilgjengelig i 20x20 opp til 32x32 mm skaft. Behandlet for lengre levetid.



	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	DVJNR 2020 K 16	20	20	20	25	125	46.4	-13	-4	0.43	GI048	DV16
	DVJNR 2525 M 16	25	25	25	32	150	46.4	-13	-4	0.75	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



FLAGT15P/3,5

DVPN(RL) EXT

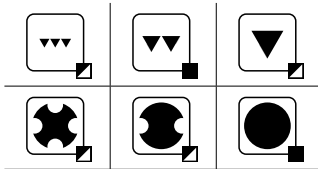
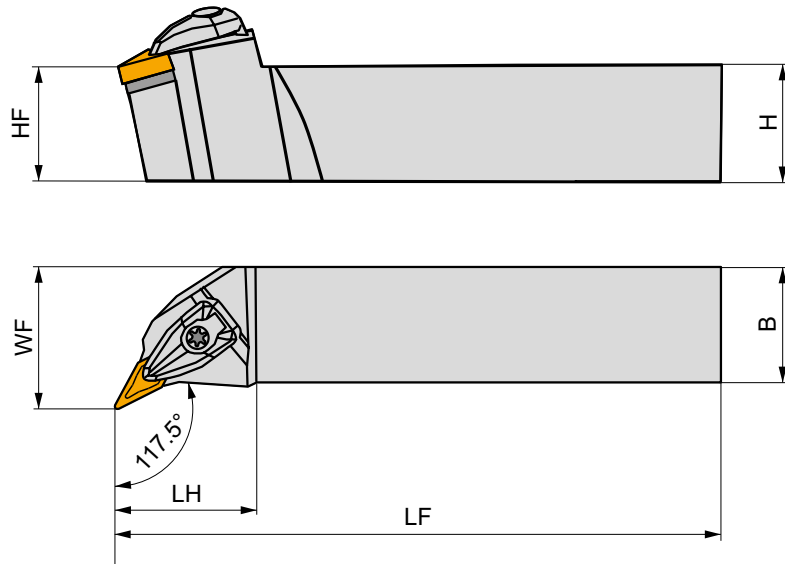
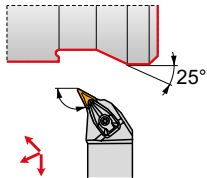


PRAMET

D

**Utvendig dreieholder med klemhode med 117,5 ° skjærevinkel for VN .. Skjær**

Utvendig høyre / venstre dreieholder med klemhode, 117,5 ° skjærevinkel. Passer for langsgående og overflatedreining med skulder, form og konisk dreining og fasing med negativ VN .. 16 skjærestørrelse. Tilgjengelig i skaft 25x25 og 32x25 mm. Behandlet for lengre levetid.



Product		H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
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	DVPLN 2525 M 16	25	25	25	32	150	39.2	-13	-4	0.74	GI048	DV16
	DVPLN 3225 P 16	32	25	32	32	170	39.2	-13	-4	1.06	GI048	DV16



GI048



VN.. 1604..



DV16



DCS 16V



Nm

3.0



DVS 269-01



US 2009-T15P



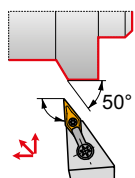
FLAG T15P/3,5

MVJN(RL) EXT

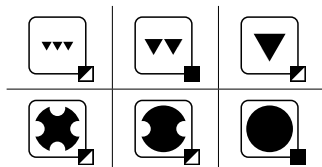
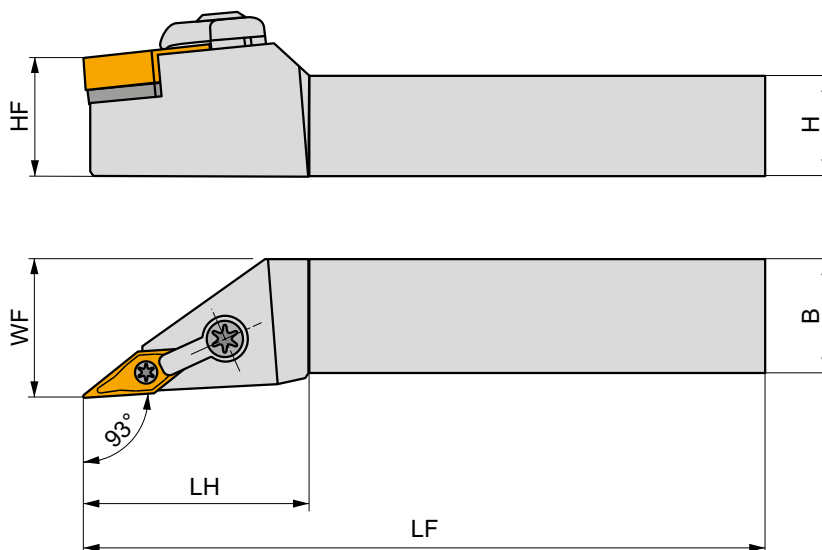


PRAMET

M

**Utvendig dreieholder med klemhode, 93 ° skjærevinkel for VN .. Skjær**

Utvendig høyre / venstre hånd dreieholder med klemhode og skjærevinkel på 93 °. Egnet for langsgående dreining med skulder, formdreining opp til 50 °, konisk og fasing med negativ VN .. 16 skjær. Tilgjengelig med skaftstørrelse 20x20 opp til 32x25 mm. Behandlet for lengre levetid.



	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
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..



MV2



UPC 22



MVN 160316



UP 0909-T09P



2.0



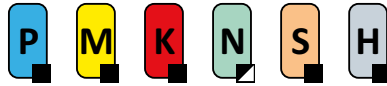
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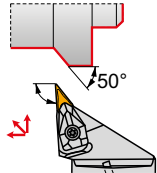
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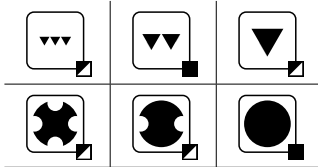
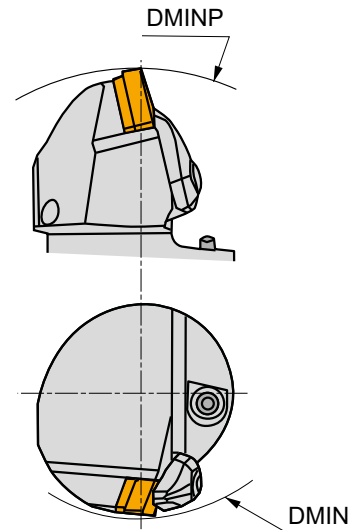
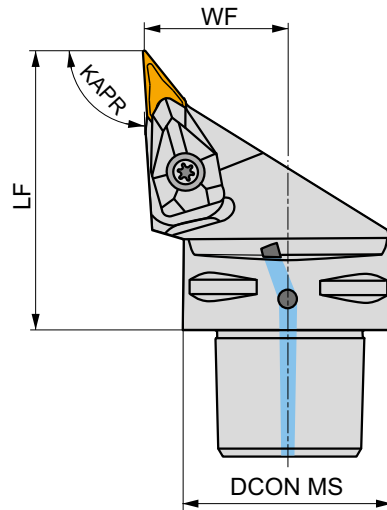
FLAG T09P

NEW**C.-DVJN(RL) EXT**

PRAMET

D**Utvendig PSC hurtigveksling dreieholder, klemhode, 93 ° skjærvinkel, VN .. Skjær**

Utvendig høyre / venstre hånd dreieholder med klemhode, innvendig kjøling, med 93° skjærvinkel for langsgående dreining med skulder, form og konisk dreining og fasing med negative VN .. 16 skjærstørrelse. Tilgjengelig med PSC (Polygon Shank Coupling) C4 opp til C6 skaft. Behandlet for lengre levetid.



Product		DCON MS	DMIN	DMINP	WF	LF	KAPR	LAMS	GAMO		kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)	(°)				
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..

C-DV16-1
C-DV16-2DCS 16V
DCS 16V3.0
3.0DVS 269-01
DVS 269-01US 2009-T15P
US 2009-T15PFLAGT15P/3,5
FLAGT15P/3,5CN 034-01
CN 034-02

DVUN(RL) INT

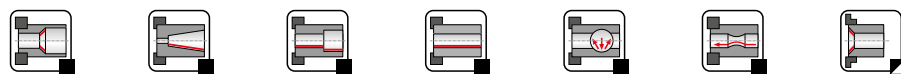
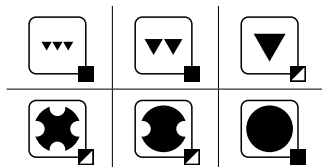
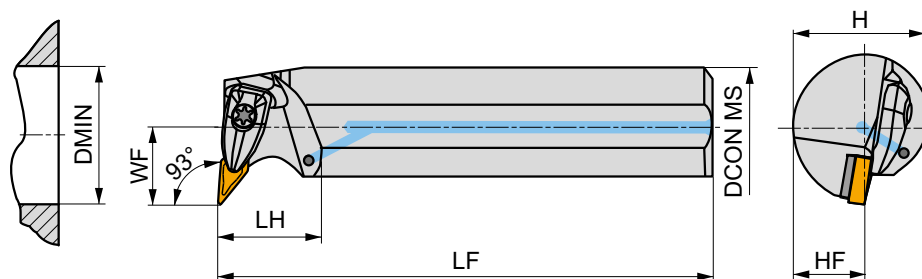
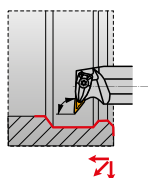


PRAMET

D

**Innvendig dreiebom med klemhode og 93° skjærevinkel for VN .. Skjær**

Innvendig høyre/venstre dreiebom med toppklemming, med innvendig kjøling, med 93° skjærevinkel for VN .. 16 skjær. Minimum innvendig dreiediameter Ø50 mm. Passer for innvendig konisk, langsgående dreining med skulder, kopiering og fasing. Finnes kun med skaftstørrelse Ø40 mm. Behandlet for lengre levetid.



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



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

WNMA 080408

Tool Holder

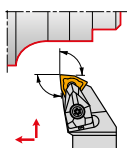
DWLNL 2020 K 08

ISO DREIING – EKSTERN

DWLN(RL) EXT

95°

WN..

06
08
10
1316×16
40×40

377

366 – 376

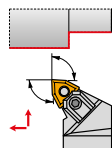
MWLN(RL) EXT

95°

WN..



08

25×25
40×40

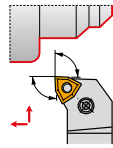
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366 – 376

PWLN(RL) EXT

95°

WN..

06
0816×16
32×25

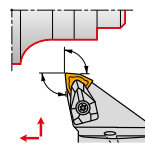
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366 – 376

C.-DWLN(RL) EXT **NEW**

95°

WN..

06
08C4
C6

381

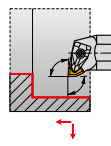
366 – 376

ISO DREIING – INTERN

DWLN(RL) INT

95°

WN..

06
0832
63

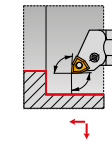
382

366 – 376

PWLN(RL) INT

95°

WN..

06
0820
80

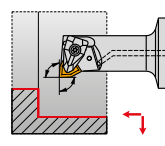
383

366 – 376

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

95°

WN..

06
0827
33

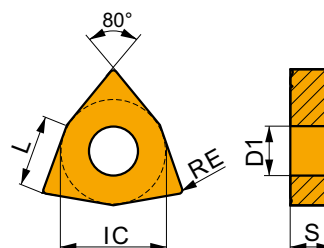
385

366 – 376

WNMA

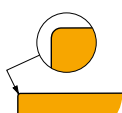


	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
0804	12.700	5.16	8.70	4.76



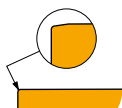
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

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)



For fin til halv-grov bearbeiding og kontinuerlige til lett avbrutte kutt.

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



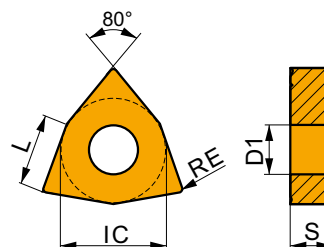
For fin til halv-grov bearbeiding og kontinuerlige til lett avbrutte kutt.

WNMA 080408S	T5305	0.8	—	—	—	—	—	—	220	0.20	4.0	—	—	—	—	—	—	45	0.15	1.0
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WNMG

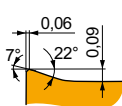


	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
0604	9.525	3.81	6.50	4.76
06T3	9.525	3.81	6.50	3.97
0804	12.700	5.16	8.70	4.76



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere 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)



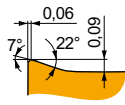
FF-geometri med meget positiv design for finbearbeiding og kontinuerlige til lett avbrutte kutt.

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	—	—	—	—	—	—	—	—

CN	DN	KN	LN	RN	SN	TN	VN	WN
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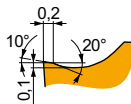
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	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 meget positiv design for finbearbeiding og kontinuerlige til lett avbrutte kutt.

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	—	—	—	—	—	—	—	—	—



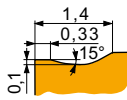
FM-geometri med positiv design for fin til halv-grov bearbeiding, og kontinuerlige til lett avbrutte kutt.

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	—	—	—
	T8330	0.8	205	0.20	1.4	120	0.18	1.4	190	0.20	1.4	—	—	—	50	0.14	1.1	—	—	—
WNMG 06T308E-FM	T8430	0.8	235	0.20	1.4	125	0.18	1.4	190	0.20	1.4	—	—	—	50	0.14	1.1	—	—	—
	T9325	0.8	285	0.20	1.4	170	0.18	1.4	270	0.20	1.4	—	—	—	60	0.16	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	—	—	—

CN	DN	KN	LN	RN	SN	TN	VN	WN
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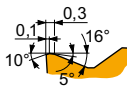
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(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)



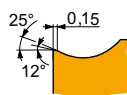
KR-geometri for middels til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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 for fin til middels bearbeiding, og kontinuerlig til avbrutt kutt.

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	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	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	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—



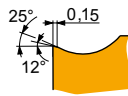
NF-geometri med meget positiv design for finbearbeiding til middels bearbeiding og kontinuerlige kutt.

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	—	—	—
	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	—	—	—
	T9325	0.8	300	0.19	1.0	180	0.17	1.0	285	0.19	1.0	—	—	—	65	0.15	0.8	—	—	—

CN	DN	KN	LN	RN	SN	TN	VN	WN
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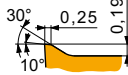
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	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 positiv design for finbearbeiding til middels bearbeiding og kontinuerlige kutt.

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	—	—	—



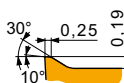
NM-geometri med meget positiv design for finbearbeiding, middels og grov bearbeiding, med kontinuerlige kutt.

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	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
WNMG 060412E-NM	T9325	0.8	265	0.25	1.8	155	0.23	1.8	—	—	—	—	—	—	55	0.20	1.4	—	—	—
	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	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
WNMG 080404E-NM	T9325	1.2	255	0.30	1.8	150	0.27	1.8	—	—	—	—	—	—	55	0.24	1.4	—	—	—
	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	—	—	—

CN	DN	KN	LN	RN	SN	TN	VN	WN
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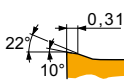
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product	RE (mm)	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)



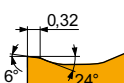
NM-geometri med meget positiv design for finbearbeiding, middels og grov bearbeiding, med kontinuerlige kutt.

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 positiv design for middels til grov bearbeiding og kontinuerlige kutt.

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	—	—	—
	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	—	—	—



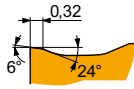
NRM-geometri med positiv design for middels til grov bearbeiding, og kontinuerlig til moderat avbrutt kutt.

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	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—

CN	DN	KN	LN	RN	SN	TN	VN	WN
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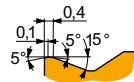
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	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)



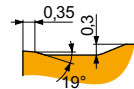
NRM-geometri med positiv design for middels til grov bearbeiding, og kontinuerlig til moderat avbrutt kutt.

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 for halv-grov til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—



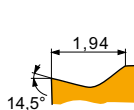
RM-geometri for halv-grov til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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	—	—	—	—	—	—	—	—	—

CN	DN	KN	LN	RN	SN	TN	VN	WN
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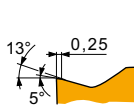
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product	RE (mm)	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(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)



SF-geometri med positiv design for finbearbeiding og for bearbeiding av tynne vegger, med kontinuerlige kutt.

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	—	—	—
	T9315	0.8	—	—	—	95	0.18	1.0	155	0.20	1.0	495	0.24	1.0	50	0.14	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
	T7325	0.8	220	0.20	1.0	170	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 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	—	—	—



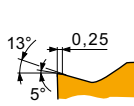
SM-geometri med positiv design for middels bearbeiding og kontinuerlige til avbrutte kutt.

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	—	—	—

CN	DN	KN	LN	RN	SN	TN	VN	WN
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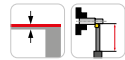
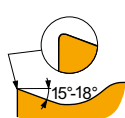
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(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)



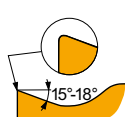
SM-geometri med positiv design for middels bearbeiding og kontinuerlige til avbrutte kutt.

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 høyrehendt geometri for fin til halv-grov bearbeiding, og kontinuerlige kutt.

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	■	–	–	–
WNMG 080408ER-SI	T9325	0.4	■	270	0.20	1.7	■	160	0.18	1.7	■	–	–	–	■	–	–	–	■	60	0.18	1.4	■	–	–	–
	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	■	–	–	–
WNMG 080412ER-SI	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	■	–	–	–
	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	■	–	–	–



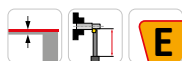
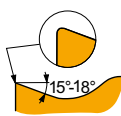
EL-SI geometri med positiv venstrehendt design for fin til halv-grov bearbeiding og kontinuerlige kutt.

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	■	–	–	–

CN	DN	KN	LN	RN	SN	TN	VN	WN
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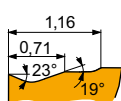
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(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)



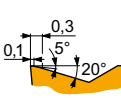
EL-SI geometri med positiv venstrehendt design for fin til halv-grov bearbeiding og kontinuerlige kutt.

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	—	—	—



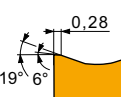
W-F Wipergeometri for finbearbeiding med økt mating og forbedret overflate.

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	—	—	—	—	—	—	—	—	—



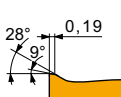
W-M wipergeometri for halv-grov til grov bearbeiding med økt mating og forbedret overflate.

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-MR wipergeometri for fin til grov bearbeiding med økt mating og forbedret overflate.

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	—	—	—	—	—	—	—	—	—



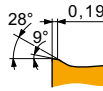
W-NM-wiperergeometri for fin til grov bearbeiding med økt mating og forbedret overflate.

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	—	—	—

CN	DN	KN	LN	RN	SN	TN	VN	WN
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Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(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)



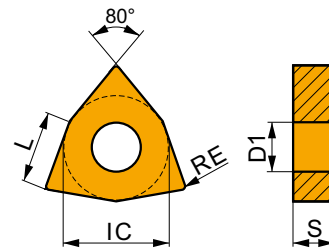
W-NM-wiperergeometri for fin til grov bearbeiding med økt mating og forbedret overflate.

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

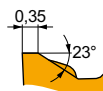


	IC (mm)	D1 (mm)	L (mm)	S (mm)
0804	12.700	5.16	8.70	4.76
1006	15.875	6.35	10.80	6.35
1306	19.050	7.94	13.00	6.35



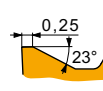
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(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)



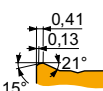
DR-geometri for middels til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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 for medium til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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	—	—	—



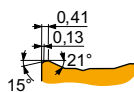
NR2 geometri for middels til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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	—	—	—

CN	DN	KN	LN	RN	SN	TN	VN	WN
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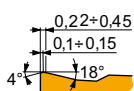
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(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)



NR2 geometri for middels til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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	—	—	—



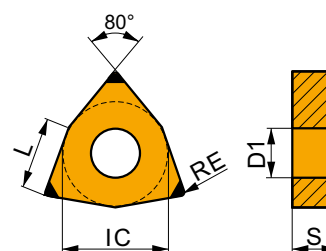
OR geometri for middels til grov bearbeiding, og kontinuerlig til avbrutt kutt.

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

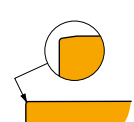
PRAMET

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



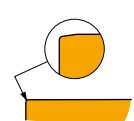
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(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)



For ferdig bearbeiding og kontinuerlige kutt.

WNGA 080408S01020C	TB310	0.8	—	—	—	—	—	—	530	0.15	0.6	—	—	—	140	0.11	0.5	110	0.15	1.0
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For ferdig bearbeiding og kontinuerlige kutt.

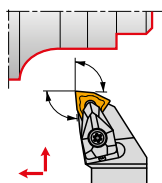
WNGA080408S01020WC	TB310	0.8	—	—	—	—	—	—	530	0.15	0.6	—	—	—	140	0.11	0.5	110	0.15	1.0
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DWLN(RL) EXT



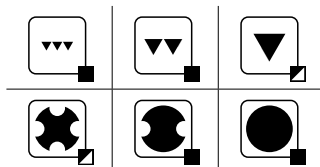
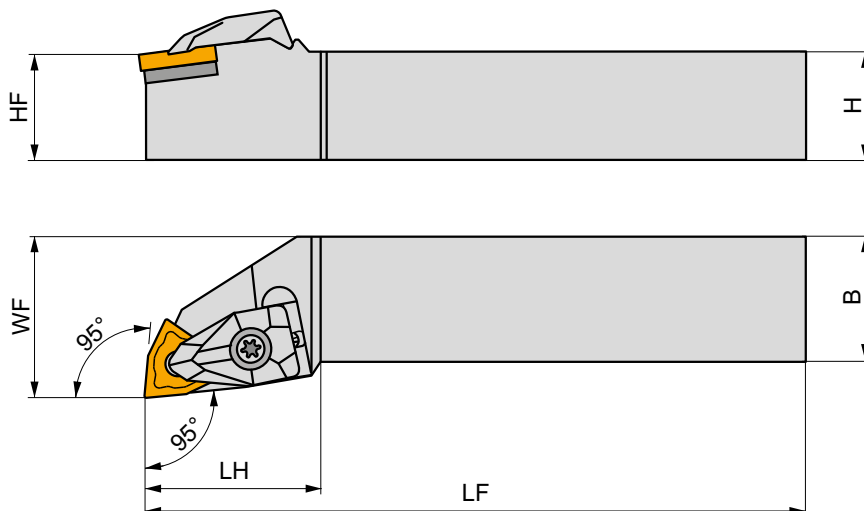
PRAMET

D



Utvendig klemhode med 95 ° skjærevinkel for WN .. Skjær

Utvendig høyre / venstre hånd dreieholder med klemhode, skjærevinkel på 95 °. Passer for langsgående dreieing med skulder, overflate, konisk og avfasing med negativ WN .. 06 til 13 skjær. Tilgjengelig med skaftstørrelse 16x16 opp til 40x40 mm. Behandlet for lengre levetid.



Product		H	B	HF	WF	LF	LH	LAMS	GAMO	kg			
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)				
R	DWLN 1616 H 06	16	16	16	20	100	26.4	-6	-6	0.22	GI028	DW06	—
	DWLN 2020 K 06	20	20	20	25	125	27.1	-6	-6	0.41	GI028	DW06	—
	DWLN 2525 M 06	25	25	25	32	150	27.1	-6	-6	0.75	GI028	DW06	—
	DWLN 2020 K 08	20	20	20	25	125	34.3	-6	-6	0.43	GI072	DW08	AT004
	DWLN 2525 M 08	25	25	25	32	150	35	-6	-6	0.75	GI072	DW08	AT004
	DWLN 3225 P 08	32	25	32	32	170	35	-6	-6	1.01	GI072	DW08	AT004
	DWLN 3225 P 10	32	25	32	32	170	38	-6	-6	1.06	GI166	DW10	—
	DWLN 3232 P 13	32	32	32	40	170	40	-6	-6	1.44	GI167	DW13	—
L	DWLN 4040 S 13	40	40	40	50	250	41	-6	-6	3.19	GI167	DW13	—
	DWLN 1616 H 06	16	16	16	20	100	26.4	-6	-6	0.22	GI028	DW06	—
	DWLN 2020 K 06	20	20	20	25	125	27.1	-6	-6	0.41	GI028	DW06	—
	DWLN 2525 M 06	25	25	25	32	150	27.1	-6	-6	0.76	GI028	DW06	—
	DWLN 2020 K 08	20	20	20	25	125	34.3	-6	-6	0.43	GI072	DW08	AT004
	DWLN 2525 M 08	25	25	25	32	150	35	-6	-6	0.75	GI072	DW08	AT004
	DWLN 3225 P 08	32	25	32	32	170	35	-6	-6	1.10	GI072	DW08	AT004
	DWLN 3225 P 10	32	25	32	32	170	38	-6	-6	1.14	GI166	DW10	—
	DWLN 3232 P 13	32	32	32	40	170	40	-6	-6	1.45	GI167	DW13	—
	DWLN 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

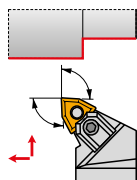
		
AT004a	CER WN.N 0804..	DCS 12C4
AT004b	CER WN.A 0804..	DCS 12C2

MWLN(RL) EXT



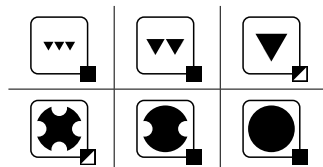
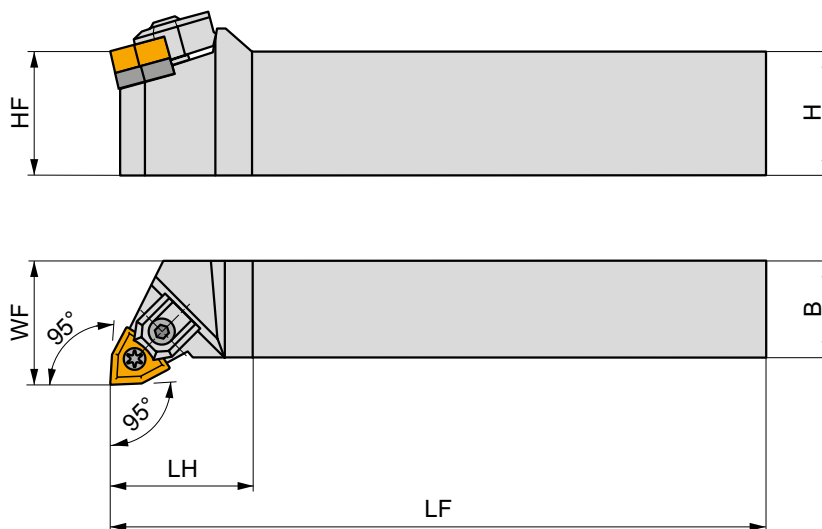
PRAMET

M



Utvendig dreieholder med klemhode, 95 ° skjærevinkel for WN .. Skjær

Utvendig høyre / venstre hånd dreieholder med klemhode og skjærevinkel på 95 °. Passer til langsgående dreining med skulder, overflate, konisk og fasing med negativ WN .. 08 skjær. Tilgjengelig med skaftstørrelse 25x25 opp til 40x40 mm. Behandlet for lengre levetid.



	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	MWLN 2525 M 08	25	25	25	32	150	32	-6	-6	0.73	GI072	MW1
	MWLN 3225 P 08	32	25	32	32	170	32	-6	-6	1.30	GI072	MW1
	MWLN 4040 R 08	40	40	40	50	200	32	-6	-6	2.50	GI072	MW1
L	MWLN 2525 M 08	25	25	25	32	150	32	-6	-6	0.70	GI072	MW1
	MWLN 3225 P 08	32	25	32	32	170	32	-6	-6	1.02	GI072	MW1
	MWLN 4040 R 08	40	40	40	50	200	32	-6	-6	2.50	GI072	MW1



GI072



WN.. 0804..



MW1



UE 05



5.0



WNW 080412



UC 51



HS 0408



HXK 3

PWLN(RL) EXT



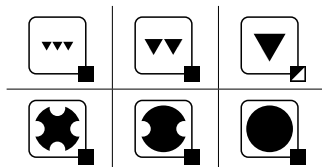
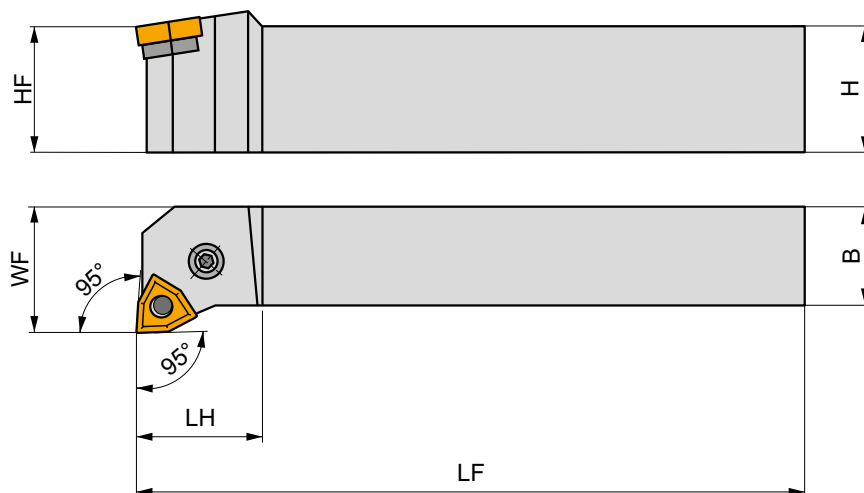
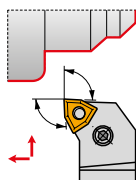
PRAMET

P



Utvendig dreieholder med 95° skjærevinkel for WN .. Skjær

Utvendig dreieholder for høyre / venstre hånd med skjærevinkel på 95°. Passer for langsgående dreining med skulder, overflate, konisk og fasing med negativ WN .. 06 og 08 skjær. Tilgjengelig med skaftstørrelse 16x16 opp til 32x25 mm. Behandlet for lengre levetid.



	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	PWLN R 1616 H 0604	16	16	16	20	100	20	-6	-6	0.23	GI028	PW11
	PWLN R 2020 K 0604	20	20	20	25	125	20	-6	-6	0.40	GI028	PW10
	PWLN R 2525 M 0604	25	25	25	32	150	20	-6	-6	0.78	GI028	PW10
	PWLN R 2020 K 08	20	20	20	25	125	22	-6	-6	0.42	GI072	PW22
	PWLN R 2525 M 08	25	25	25	32	150	22	-6	-6	0.73	GI072	PW20
	PWLN R 3225 P 08	32	25	32	32	170	22	-6	-6	1.05	GI072	PW20
L	PWLN L 1616 H 0604	16	16	16	20	100	20	-6	-6	0.21	GI028	PW11
	PWLN L 2020 K 0604	20	20	20	25	125	20	-6	-6	0.40	GI028	PW10
	PWLN L 2525 M 0604	25	25	25	32	150	20	-6	-6	0.75	GI028	PW10
	PWLN L 2020 K 08	20	20	20	25	125	22	-6	-6	0.40	GI072	PW22
	PWLN L 2525 M 08	25	25	25	32	150	22	-6	-6	0.74	GI072	PW20
	PWLN L 3225 P 08	32	25	32	32	170	22	-6	-6	1.05	GI072	PW20



GI028

WN.. 0604..

GI072

WN.. 0804..



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

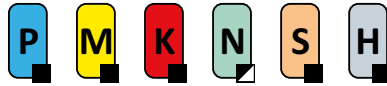
M 8x1

21

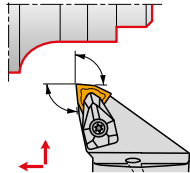
NT 05

MT 05

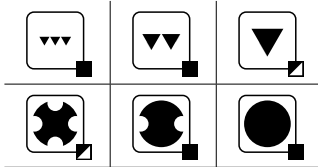
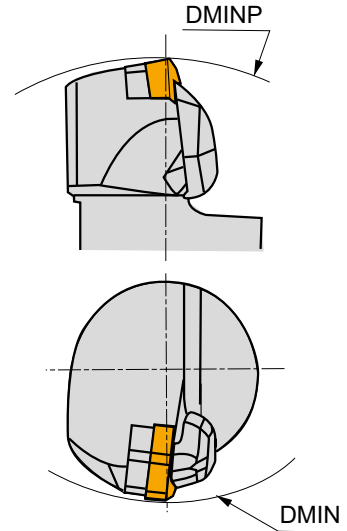
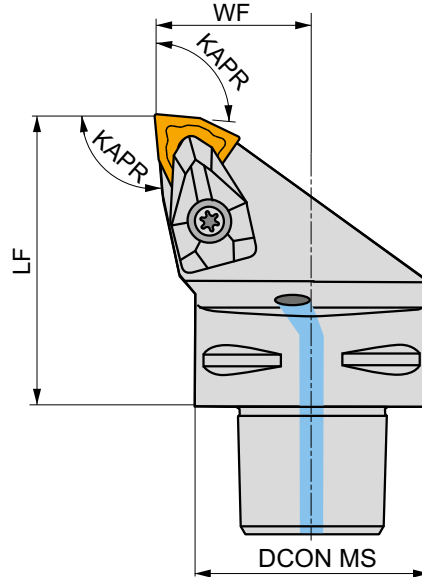
HXK 4

NEW**C-DWLN(RL) EXT**

PRAMET

D**Utvendig PSC hurtigveksling dreieholder, klemhode, 95 ° skjærevinkel, WN .. skjær**

Utvendig høyre / venstre hånd dreieholder med klemhode, innvendig kjøling, med 95 ° skjærevinkel for overflate og langsgående dreining med skulder, konisk og fasing med negativ WN .. 06 og 08 skjær. Tilgjengelig med PSC (Polygon Shank Coupling) størrelse C4 opp til C6. Behandlet for lengre levetid.



Product		DCON MS	DMIN	DMINP	WF	LF	KAPR	LAMS	GAMO		kg			
		(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)	(°)					
R	C4-DWLN-27050-06	40	60	140	27	50	95	-6	-6	✓	0.42	GI028	C-DW06	—
	C4-DWLN-27050-08	40	110	140	27	50	95	-6	-6	✓	0.42	GI072	C-DW08-1	AT004
	C5-DWLN-35060-08	50	110	165	35	60	95	-6	-6	✓	0.74	GI072	C-DW08-2	AT004
	C6-DWLN-45065-08	63	110	190	45	65	95	-6	-6	✓	1.34	GI072	C-DW08-2	AT004
L	C4-DWLN-27050-06	40	60	140	27	50	95	-6	-6	✓	0.43	GI028	C-DW06	—
	C4-DWLN-27050-08	40	110	140	27	50	95	-6	-6	✓	0.42	GI072	C-DW08-1	AT004
	C5-DWLN-35060-08	50	110	165	35	60	95	-6	-6	✓	0.76	GI072	C-DW08-2	AT004
	C6-DWLN-45065-08	63	110	190	45	65	95	-6	-6	✓	1.34	GI072	C-DW08-2	AT004

GI028
GI072WN.. 0604..
WN.. 0804..

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
AT004bCER WN.N 0804..
CER WN.A 0804..DCS 12C4
DCS 12C2

DWLN(RL) INT

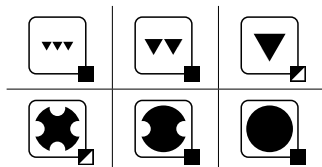
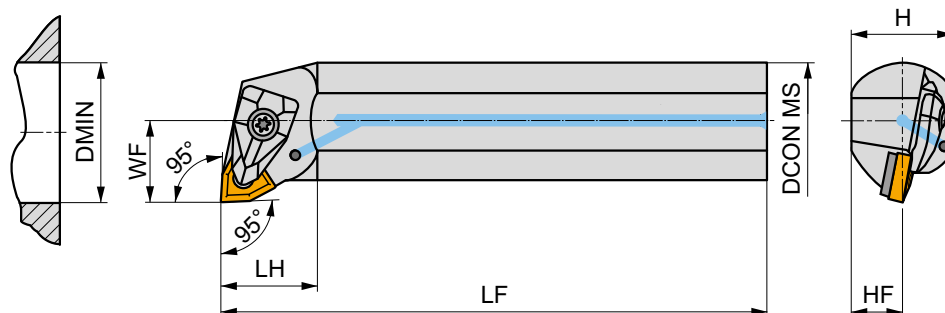
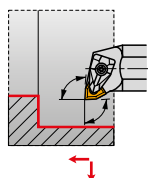


PRAMET

D

**Innvendig dreiebom med klemhode og 95° skjærevinkel for WN .. Skjær**

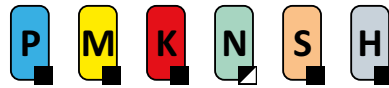
Innvendig høyre/venstre dreiebom med toppklemming, med innvendig kjøling, 95° skjærevinkel for negative WN .. 06 og 08 skjær. Minimum innvendig dreiediameter Ø32 mm. For innvendig koning, langsgående dreining med skulder- og fasing. skaftstørrelser Ø25 opp til Ø50 mm tilgjengelig. Behandlet for lengre levetid.



Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	HF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)				
R A25T-DWLN R 06	25	32	17	23	11.5	300	31	-14	-6	✓	0.97	GI028	DW06
A25T-DWLN R 08	25	33	17	23	11.5	300	31	-12	-6	✓	0.98	GI072	DWI08
A32T-DWLN R 08	32	40	22	30	15	300	33	-10	-6	✓	1.71	GI072	DWI08
A40T-DWLN R 08	40	50	27	37	18.5	300	36	-13	-6	✓	2.59	GI072	DW08
A50U-DWLN R 08	50	63	35	47	23.5	350	39	-11	-6	✓	5.24	GI072	DW08
L A25T-DWLN L 06	25	32	17	23	11.5	300	31	-14	-6	✓	0.97	GI028	DW06
A25T-DWLN L 08	25	33	17	23	11.5	300	31	-12	-6	✓	0.98	GI072	DWI08
A32T-DWLN L 08	32	40	22	30	15	300	33	-10	-6	✓	1.70	GI072	DWI08
A40T-DWLN L 08	40	50	27	37	18.5	300	36	-13	-6	✓	2.59	GI072	DW08
A50U-DWLN L 08	50	63	35	47	23.5	350	39	-11	-6	✓	5.25	GI072	DW08

GI028
GI072WN.. 0604..
WN.. 0804..DW06
DW08
DWI08DCS 09
DCS 12
DCS 121.7
3.9
3.9DWS 328-01
DWS 331-12
DWS 328-02US 2004-T09P
US 2002-T15P
US 2002-T15PFLAG T09P
FLAG T15P/3,5
FLAG T15P/3,5

PWLN(RL) INT

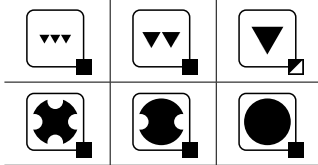
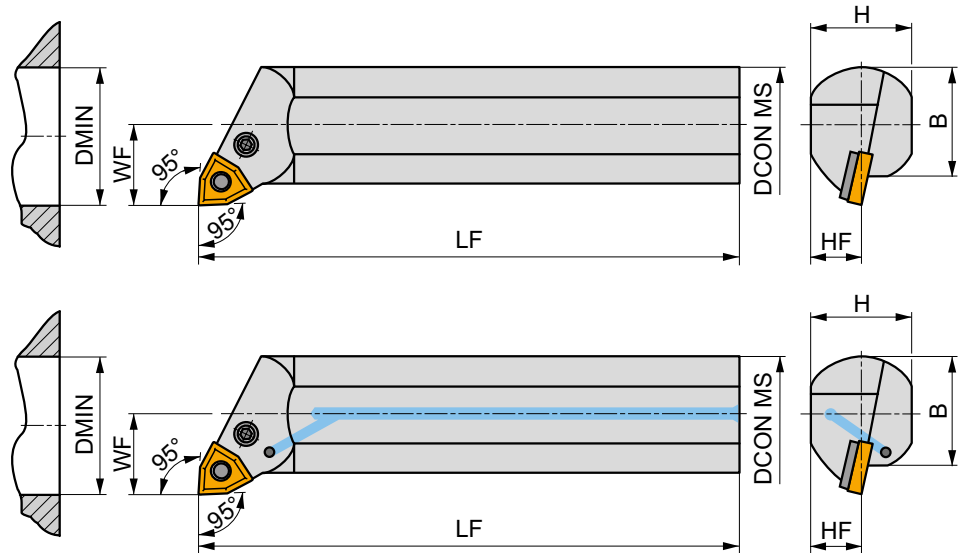
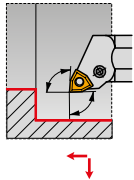


PRAMET

P

**Innvendig dreiebom med 95 ° skjærevinkel for WN .. skjær**

Innvendig høyre/venstre hånd dreiebom, tilgjengelig med innvendig kjøling, 95° skjærevinkel for WN .. 06 og 08 skjær. Minimum innvendig dreiediameter Ø20 mm. For innvendig konisk og langsgående dreieing med skulder- og fasing. Skaftstørrelser Ø16 til Ø60 mm tilgjengelig. Behandlet for lengre levetid.



	Product	DCON MS	DMIN	WF	H	B	LF	LAMS	GAMO				
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)				
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
	A16M-PWLNL 0604	16	20	11	15	15	150	-13.5	-6	✓	0.22	GI028	PW09
L	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

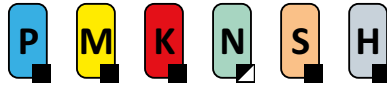
GI072



WN.. 0604..

WN.. 0804..

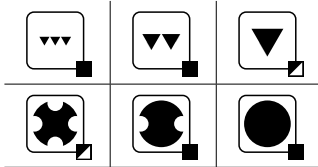
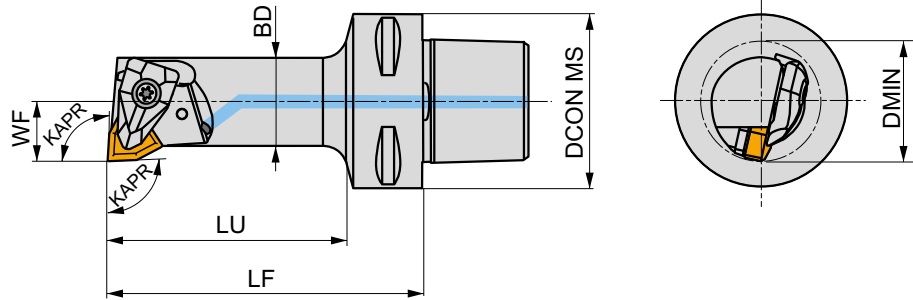
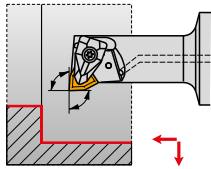
				 Nm					
PW09	—	PU 3611-A	PS 0512-A	2.0	M 5	12	—	—	HXK 2
PW11	WNU 060308	PU 01	US 46	5.0	M 6x0.75	13.2	NT 04	MT 04	HXK 3
PW20	WNU 080312	PU 02	US 35	6.0	M 8x1	22.5	NT 05	MT 05	HXK 4
PW21	WNU 080312	PU 02	US 41	6.0	M 8x1	17	NT 05	MT 05	HXK 4
PW25	—	PU 32	US 46	5.0	M 6x0.75	13.2	—	—	HXK 3

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

PRAMET

D**Innvendig PSC hurtig veksling dreieholder, klemhode, 95° skjærevinkel, WN .. Skjær**

Innvendig høyre/venstre hånd dreieholder med klemhode, med innvendig kjøling, med 95° skjærevinkel for innvendig konisk og langsgående dreining med skulder og fasing med WN .. 06 og 08 skjær, minimum innvendig diameter Ø27 mm. Tilgjengelig med PSC -skaft (Polygon Shank Coupling) størrelse C4. Behandlet for lengre levetid.



Product		DCON MS (mm)	DMIN (mm)	WF (mm)	LF (mm)	LU (mm)	BD (mm)	KAPR (°)	LAMS (°)	GAMO (°)				
R	C4-DWLN-13075-06	40	27	13	75	52	20	95	-17	-6	✓	0.42	GI028	DW06
	C4-DWLN-17090-08	40	33	17	90	68	25	95	-12	-6	✓	0.53	GI072	DWI08
L	C4-DWLN-13075-06	40	27	13	75	52	20	95	-17	-6	✓	0.42	GI028	DW06
	C4-DWLN-17090-08	40	33	17	90	68	25	95	-12	-6	✓	0.53	GI072	DWI08



GI028

GI072



WN.. 0604..

WN.. 0804..



DW06

DWI08



DCS 09

DCS 12



1.7

3.9



DWS 328-01

DWS 328-02



US 2004-T09P

US 2002-T15P



FLAG T09P

FLAG T15P/3,5

PARTING-OFF & GROOVING



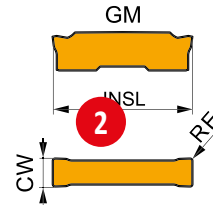
TURNING – GENERAL CONTENT

 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

1 GL. D - GM

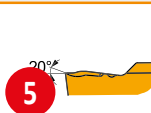
PRAMET

	CW	CWTOLL	CWTOLU	INSL
	[mm]	[mm]	[mm]	[mm]
200	2.00	3 -0.05	0.05	25.0
300	3.00	3 -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



Workpiece material suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap).

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]



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	—	—	—
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	—	—	—
GL4-D400M04-GM	G8330	0.4	150	0.25	1.2	90	0.23	1.2	140	0.25	1.2	35	0.18	1.0	—	—	—
GL4-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	—	—	—
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	—	—	—
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

PARTING – OFF & GROOVING INSERTS – PAGE OVERVIEW

Pos.	Description	Pos.	Description
1	Designation of insert	7	ISO insert code
2	Schematic drawing of insert	8	Grade
3	Table with insert sizes (mm)	9	Insert radii (mm)
4	Picture of representative insert	10	Geometry description
5	Profile of main cutting edge	11	Application area of insert
6	Icons – specific features and cutting edge type		

1 GG.(RL) INT



PRAMET

3 G

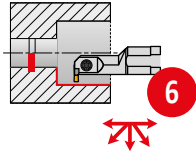


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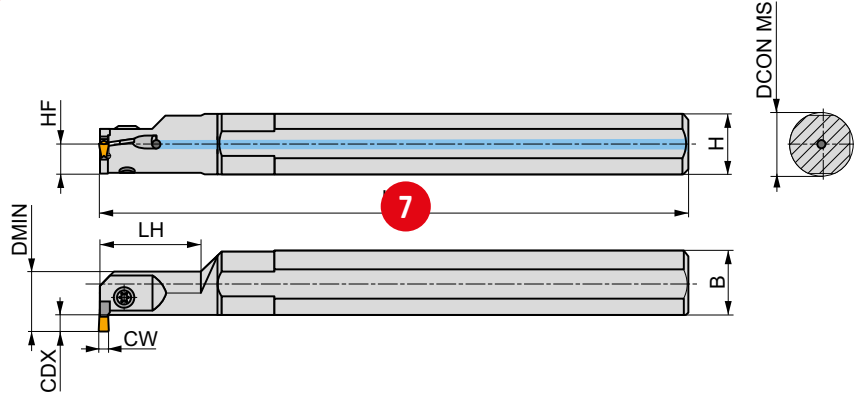
5

LCM. Uç için Delik Kanal Kateri

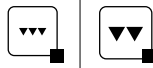
LCM. 0313 veya 0413 uçlar için Sağ/Sol delik kanal kateri. Minimum kanal açma çapı Ø16mm. Delik içi kanal açma ve çok yönlü tornalama için uygundur. Ø16-32mm shaft ölçülerinde bulunur. Gövde uzun takım ömrü için işlem görmüştür.



6



7



8



9



10

Product	DCON MS [mm]	HF [mm]	H [mm]	B [mm]	LH [mm]	LH [mm]	CW [mm]	CDX [mm]	DMIN [mm]		kg		
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-GGHR 0413	25	11.5	23	24	250	40	4.00	6.5	25	✓	0.81	GI143	GL06
A32T-GGHL 0413	32	15	30	31	300	50	4.00	9.5	32	✓	1.59	GI170	GL06
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



18



GI143

LCM. 0313..

GI170

LCM. 0413..

GI190

LCM. 0313.....04



GL06



SR 85011-T15P



5.0



M 5



9



FLAG T15P

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⁾ Dreieholder vises primært i sin høyre-design (R)

²⁾ GAMO = ortogonal rakevinkel (se teknisk del)
LAMS = hellingsvinkel til hovedkuttegg (se teknisk del)

³⁾ Kode til gruppe med compatible skjær, reservedeler og spesialutstyr brukes kun i forbindelse med denne katalogen. Den kan ikke brukes for ordrer.

⁴⁾ Ikoner for reservedeler og spesialutstyr utformes skjematisk for forståelighet. De er ikke inkludert i listen over ikoner. Skruer blir, i noen tilfeller, fullført med info om tiltrekkingsmoment i Nm, lengde til skruer og størrelse til gjenger.

PARTING – OFF & GROOVING – ICONS OVERVIEW

GENERAL ICONS

	Primary use		Finishing – very good surface quality		Suitable for stable working conditions
	Possible use		Medium machining – good surface quality		Suitable for unstable working conditions
			Roughing – unlimited surface roughness		Suitable for very unstable working conditions

TURNING OPERATIONS

	Copy turning (multi directional machining)		Internal grooving		Shallow radial groove
	Deep and wide axial groove (with following expansion)		Internal grooving (with following expansion)		Tube parting off
	Deep axial groove		Parting off		Wide radial groove (with following expansion)
	Deep radial groove		Shallow and wide axial groove (with following expansion)		
	Face copy turning		Shallow axial groove		

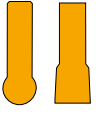
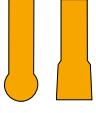
FEATURES

	First choice		Universal wide range option		Rounded edge
	Large overhang		Heavy working conditions		Rounded edge with facet

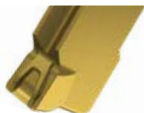
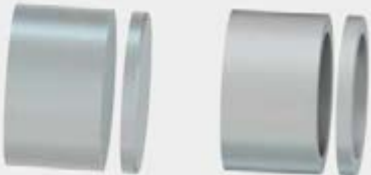
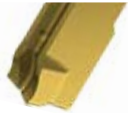
OTHER

	Clamping torque of screw (Nm)		Internal supply of coolant
--	-------------------------------	---	----------------------------

INSERTS FOR PARTING – OFF & GROOVING – NAVIGATOR

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	

PARTING – OFF & GROOVING GEOMETRIES – NAVIGATOR

		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

PARTING – OFF & GROOVING GRADES – NAVIGATOR

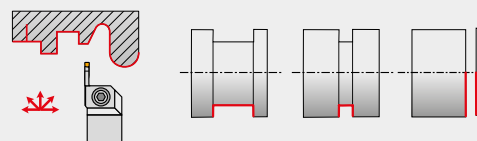
Grade Identification	Area of Application	Application	Feed	Cutting speed	Resistance to adverse Working Conditions	Coating	Colour	Substrate	Coolant benefit	Grade description
T9325	P15 - P35	■				MT-CVD		FGM	++	From a technological perspective this is an extremely versatile grade with high resistance to mechanical damage in adverse cutting conditions and retains excellent wear resistance. The correct application of this material requires high cutting speeds.
	M10 - M30	■								
	K15 - K35	■								
	S10 - S20	■								
T7325	P15 - P35	■				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.
	M10 - M25	■								
	S10 - S25	■								
6640	P20 - P40	■				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.
	M20 - M35	■								
	K25 - K40	■								
T8330	P25 - P40	■				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.
	M20 - M35	■								
	K20 - K40	■								
	N15 - N30	■								
	S15 - S25	■								
G8330	P25 - P40	■				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.
	M20 - M35	■								
	K20 - K40	■								
	S15 - S25	■								

Substrat	
H	WC-Co basert substrat
submicron H	WC-Co-basert substrat, finkornet (< 1 µm)
FGM	Funksjonelt gradert substrat

Belegg	
MT-CVD	Medium-temperatur kjemisk metode for belegging
PVD	Lav-temperatur fysisk metode for belegging

Benefits of cutting fluid	
+++	Use of coolant is essential
++	Highly recommended

AVSTIKKING OG SPORDREIING – EKSTERN



GLSF(RL) EXT NEW	
	GL.D
	GL2 GL3 GL4 GL5 GL6
	20×20 25×25
	410
	406 – 408

GLSF(RL) EXT-G NEW	
	GL.D
	GL2 GL3 GL4 GL5 GL6
	20×20 25×25
	412
	406 – 408

GLSF(RL) EXT-S NEW	
	GL.D
	GL2 GL3 GL4
	12×12 16×16
	413
	406 – 408

GFK(RL) EXT	
	LCMF
	0220
	16×16 25×25
	455
	418 – 454

GFI(RL) EXT	
	LCMF, LCMR
	0316 0416 0516 0616 0830
	16×16 32×25
	437
	418 – 454

GFM(RL) EXT	
	LCMF, LCMR
	0316 0416 0516 0616 0830
	20×20 32×25
	439
	418 – 454

P61 (RL) EXT NEW	
	X61
	16×16 25×25
	470
	468 – 469

XLCHF(RL)	
	LFUX
	03 04 05 06
	16×12 32×25
	465
	464

XLCCN 25 BS + MS-EN	
	LCMF, LCMR
	0316 0416 0516 0616
	25×25 32×25
	442, 443
	418 – 454

XLCHF(NRL) BS + MS-EN	
	LFMX
	1.50 1.60 2.00 2.20 3.10 4.10 5.10 6.35
	12×12 32×25
	461, 463
	456 – 458

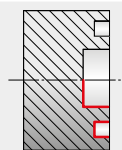
GLS B + DU, D NEW	
	GL.D
	GL2 GL3 GL4 GL5 GL6
	20×20 32×29
	414, 415
	406 – 409

XLCCN B + DU, D	
	LCMF, LCMR
	0316 0416 0516 0616
	20×20 32×29
	440, 441
	418 – 454

XLCFN B + DU, D	
	LFMX
	1.50 1.60 2.00 2.20 3.10 4.10 5.10 6.35
	20×20 40×36
	459, 460
	456 – 458

XLCFN B LFUX + DU, D	
	LFUX
	03 04 05 06
	20×20 40×40
	466, 467
	464

SPORSTIKKING AXIELT



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

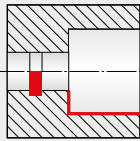
GFMR-L AXIAL	
LCMF, LCMR	
 0413 0416	
 17-30 140-230	
 428, 450	 418 – 454

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

SPORSTIKKING AXIELT



GG.(RL) INT	
	LCMF, LCMR
	0313 0413
	421
	418 – 454

P61 (RL) INT NEW	
	X61
	471
	468

P61S(RL)-1 INT NEW	
	X61-1
	474
	472

PARTING-OFF & GROOVING INSERTS – GL – CODE DESIGNATION

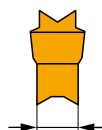
1	2	3	4	5	6	7	8
GL	3	–	D	300	G	02	L06 – PM



1	2	3	4
Tool group	Pocket size	Number of edges	Cutting width – CW

1, 2, 3, 4, 5, 6

GL



S

One edge

D

Two edges



	CW
200	2.00
250	2.50
300	3.00
400	4.00
500	5.00
600	6.00

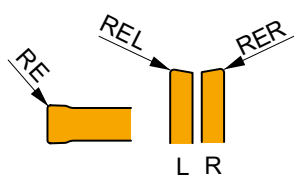
5	6	7	8
Edge design	Nose radius	Primary cutting edge angle	Chipbreaker designation

G

Ground

M

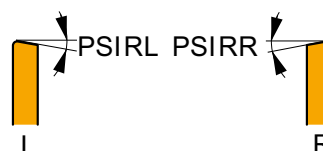
Direct pressed



ROUND GEOMETRY

RE (mm)
RE = CW/2

MO

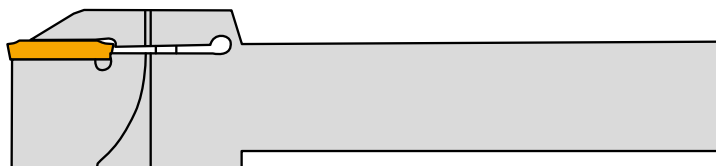


	(°)
06	6
12	12

PM
PR
GM
MM

PARTING – OFF & GROOVING HOLDERS (EXTERNAL TURNING) – GL – CODE DESIGNATION

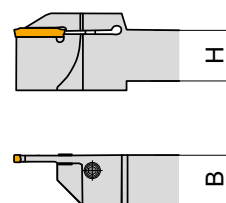
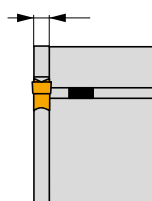
1	2		3	4	5	6	7		8		9	10	11
GL	3	–	S	2525	M	F	L	–	20	–	R	120	090



1	2	3	4

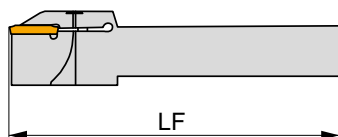
1, 2, 3, 4, 5, 6

GL

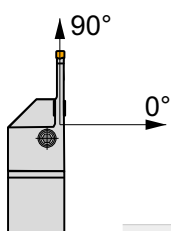


	H/B (mm)/(mm)
1212	– 12/12
1616	– 16/16
2020	– 20/20
2525	– 25/25

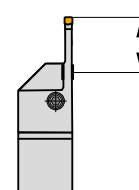
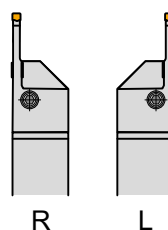
5	6	7	8



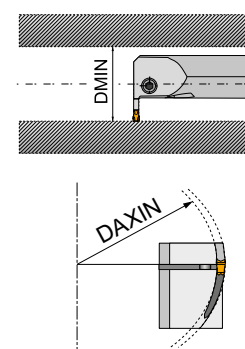
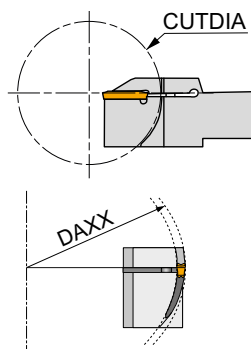
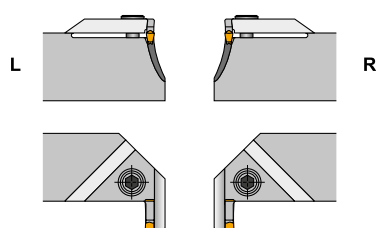
	LF (mm)
H	100
K	125
M	150
P	170



	(°)
G	0
F	90



9	10	11



PARTING – OFF & GROOVING BLADES (EXTERNAL TURNING) – GL – CODE DESIGNATION

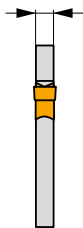
1	2		3	4	5	6
GL	3	–	S	32	M	B



1	2	3

1, 2, 3, 4, 5, 6

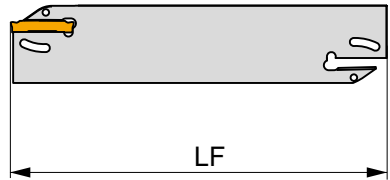
GL



4	5	6

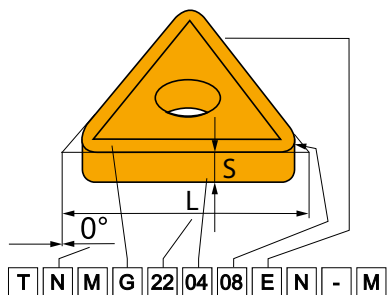


	H (mm)
26	26
32	32



	LF (mm)	LF (")
K	125	5.000"
M	150	6.000"

VENDESKJÆR – ISO KODEBETEGNELSE



ISO

ANSI

1

T

T

1

T

T

2

N

N

2

N

N

3

U

M

3

U

M

4

N

G

4

G

G

1

1

Skjærform

H



O



P



R



S



T



C



D



E



M



V



W



L



A



B



K



2

2

Frivinkel for skjør

A



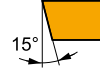
B



C



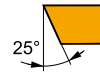
D



E



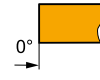
F



G



N



P



O

Spesial

4

4

Skjærtype

N



R



F



A



M



G



W



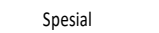
T



Q



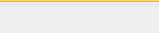
U



B



H



C



J



X

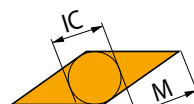
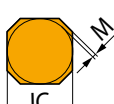
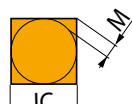
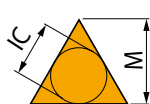
Spesial

3

3

Toleranser

	(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"



VENDESKJÆR – ISO KODEBETEGNELSE

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

5

Skjærlengde (skjærstørrelse)

d = I.C.		H	O	P	S	T	C	D	E	M	V	W	R	K
(mm)	(in)													
3.97	5/32"				03	06		04			06	02		
4.76	3/16"				04	08	04	05	04	04	08	L3		
5.56	7/32"				05	09	05	06	05	05	09	03		
6.35	1/4"	03	02	04	08	11	06	07	08	08	11	04	06	
7.94	5/16"	04	03	05	07	13	08	09	06	07	13	05	07	
9.525	3/8"	05	04	07	09	16	09	11	09	09	16	06	09	16
12.7	1/2"	07	05	09	12	22	12	15	13	12	22	08	12	
15.875	5/8"	09	06	11	15	27	16	19	16	15	27	10	15	
19.05	3/4"	11	07	13	19	33	19	23	19	19	33	13	19	
25.40	1"	14	10	18	25	44	25	31	26	25	44	17	25	
31.75	1 1/4"	18	13	23	31	54	32	38	32	31	54	21	31	

6

Skjærtykkelse

	
	
	S
	(mm)
	(")
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"

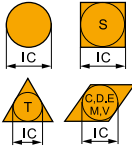
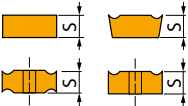
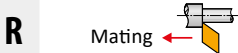
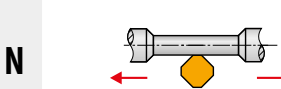
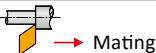
7

Skjær nesoradius

	RE	
	(mm)	(")
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 skjær		
d = I.C.		
(")		00
(mm)		M0





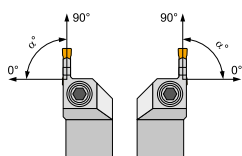
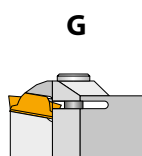
ANSI			8			8		
5			6			7		
Innskrevet sirkel			Skjærtykkelse			Innsats neseradius		
								
Symbol	d = I.C.		Symbol	S		Symbol	RE	
	(mm)	(")		(mm)	(")		(mm)	(")
1	3.175	1/8"	1	1.588	1/16"	0	0	0"
1.2	3.969	5/32"	1.2	1.984	5/64"	0.2	0.099	1/256"
1.5	4.763	3/16"	1.5	2.381	3/32"	0.5	0.198	1/128"
1.8	5.556	7/32"	2	3.175	1/8"	1	0.397	1/64"
2	6.350	1/4"	2.5	3.969	5/32"	2	0.794	1/32"
2.5	7.938	5/16"	3	4.763	3/16"	3	1.191	3/64"
3	9.525	3/8"	3.5	5.556	7/32"	4	1.588	1/16"
4	12.700	1/2"	4	6.350	1/4"	5	1.984	5/64"
5	15.875	5/8"	5	7.938	5/16"	6	2.381	3/32"
6	19.050	3/4"	6	9.525	3/8"	7	2.778	7/64"
7	22.225	7/8"	7	11.113	7/16"	8	3.175	1/8"
8	25.400	1"	8	12.700	1/2"	10	3.969	5/32"
10	31.750	5/4"	9	14.288	9/16"	12	4.763	3/16"
12	38.100	6/4"	10	15.875	5/8"	14	5.556	7/32"
						16	6.350	1/4"
						8		
						Skjæreggdesign		
								
								
								
						9		
						Materetning		
								
								
						10		
						Sponbryter betegnelse		

PARTING – OFF & GROOVING TOOLS – EXTERNAL TURNING – ISO CODE DESIGNATION

ISO	1	2	3	4	5	6	7	8	9	10	11
	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	



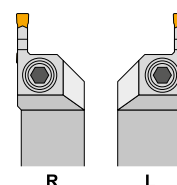
1	1	2	2	3	3	4	4
Infestningsmetode		Holderstil – skjærvinkel		Cutting depth maximum – CDX		Versjon (høyre/venstre) R/L	



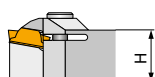
α°	
G = 0°	K = 75°
R = 15°	F = 90°
T = 30°	B = 105°
S = 45°	E = 120°
W = 60°	D = 135°



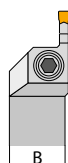
G = 2.0 × CW	N = 5.5 × CW
H = 2.5 × CW	O = 6.0 × CW
I = 3.0 × CW	P = 6.5 × CW
J = 3.5 × CW	Q = 7.0 × CW
K = 4.0 × CW	R = 7.5 × CW
L = 4.5 × CW	S = 8.0 × CW
M = 5.0 × CW	T = 8.5 × CW



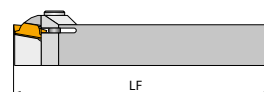
5	5	6	6	7	7	8	8
Skaft høyde (mm)		Skaft bredde (mm)		Holder total lengde		Skjærbredde	



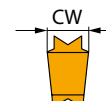
12 = 12 mm
16 = 16 mm
20 = 20 mm
etc.



12 = 12 mm
16 = 16 mm
20 = 20 mm
etc.



	LF (mm)		LF (")
H	100	A	4.000"
J	110	B	4.500"
K	125	C	5.000"
L	140	D	6.000"
M	150	E	7.000"
N	160	F	8.000"
P	170		
Q	180		
R	200		

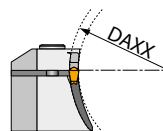


	CW (mm)	CW (")
02	2.0	.079"
03, 0313, 0316	3.0	.118"
04, 0413, 0416	4.0	.157"
05, 0516	5.0	.197"
06, 0616	6.0	.236"
08, 0830	8.0	.315"

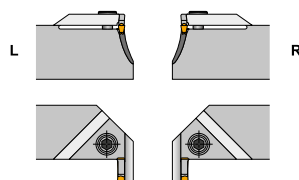
5 & 6		
	B (")	H (")
05	5/16"	5/16"
06	3/8"	3/8"
08	1/2"	1/2"
10	5/8"	5/8"
12	3/4"	3/4"
16	1"	1"
85	1"	1 1/4"
86	1"	1 1/2"
20	1 1/4"	1 1/4"
24	1 1/2"	1 1/2"
32	2"	2"

For kvadratiske skaft, er dette antall 16-deler av en tomme i bredde og høyde. For rektangulære skaft, er det første sifferet antall 8-deler av en tomme i bredde, og det andre sifferet er antallet 4-deler av en tomme i høyde.

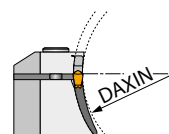
10	10
Maksimumsdiameter - aksial spor	
Tilleggsinformasjon for aksial dreining.	



9	9
Bladkurvaturretning	
Tilleggsinformasjon for aksial dreining.	

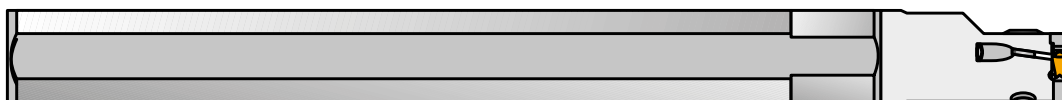


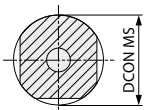
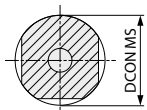
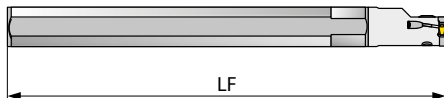
11	11
Minimumsdiameter - aksial spor	
Tilleggsinformasjon for aksial dreining.	

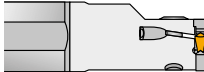
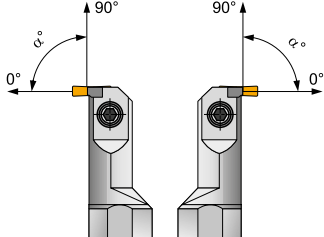


PARTING – OFF & GROOVING TOOLS – INTERNAL TURNING – ISO CODE DESIGNATION

ISO	1 A	2 25	3 S	—	4 G	5 G	6 H	7 L	8 0313
ANSI	1 A	2 16	3 S	—	4 G	5 G	6 H	7 L	8 0313



1		1		2		2		3		3	
Skaft				Diameter til skaft		Diameter til skaft		Holder total lengde			
S	Stålskaft										
			DCON MS (mm)		DCON MS (")		LF (mm)		LF (")		LF (mm)
A	Stålskaft med kjølekanal	12	12	08	.500"	M	150	6.000"	S	250	10.000"
		16	16	10	.625"	P	170	6.250"	T	300	12.000"
		20	20	12	.750"	Q	180	7.250"	U	350	14.000"
		25	25	16	1.000"	R	200	8.000"	V	400	15.750"
		32	32	20	1.250"						
		40	40	24	1.500"						

4	4	5	5	6	6																								
Infestningsmetode		Verktøystil – skjæregg		Cutting depth maximum – CDX																									
G 		 <table> <tr> <th colspan="2">α°</th></tr> <tr> <td>$G = 0^\circ$</td><td>$K = 75^\circ$</td></tr> <tr> <td>$R = 15^\circ$</td><td>$F = 90^\circ$</td></tr> <tr> <td>$T = 30^\circ$</td><td>$B = 105^\circ$</td></tr> <tr> <td>$S = 45^\circ$</td><td>$E = 120^\circ$</td></tr> <tr> <td>$W = 60^\circ$</td><td>$D = 135^\circ$</td></tr> </table>		α°		$G = 0^\circ$	$K = 75^\circ$	$R = 15^\circ$	$F = 90^\circ$	$T = 30^\circ$	$B = 105^\circ$	$S = 45^\circ$	$E = 120^\circ$	$W = 60^\circ$	$D = 135^\circ$	 <table> <tr> <td>$E = 1.0 \times CW$</td><td>$J = 3.5 \times CW$</td></tr> <tr> <td>$F = 1.5 \times CW$</td><td>$K = 4.0 \times CW$</td></tr> <tr> <td>$G = 2.0 \times CW$</td><td>$L = 4.5 \times CW$</td></tr> <tr> <td>$H = 2.5 \times CW$</td><td>$M = 5.0 \times CW$</td></tr> <tr> <td>$I = 3.0 \times CW$</td><td>$N = 5.5 \times CW$</td></tr> <tr> <td colspan="2">X = Speciaal</td></tr> </table>		$E = 1.0 \times CW$	$J = 3.5 \times CW$	$F = 1.5 \times CW$	$K = 4.0 \times CW$	$G = 2.0 \times CW$	$L = 4.5 \times CW$	$H = 2.5 \times CW$	$M = 5.0 \times CW$	$I = 3.0 \times CW$	$N = 5.5 \times CW$	X = Speciaal	
α°																													
$G = 0^\circ$	$K = 75^\circ$																												
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$S = 45^\circ$	$E = 120^\circ$																												
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$H = 2.5 \times CW$	$M = 5.0 \times CW$																												
$I = 3.0 \times CW$	$N = 5.5 \times CW$																												
X = Speciaal																													

7

7

Versjon (høyre/venstre) R/L

R

L

8

8

Skjærbredde

CW (mm)

0313

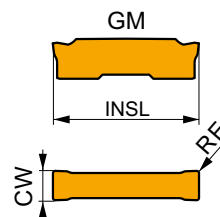
3.0

0413

4.0

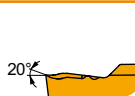
NEW**GL. D - GM****PRAMET**

	CW	CWTOLL	CWTOLU	INSL
(mm)	(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



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	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)

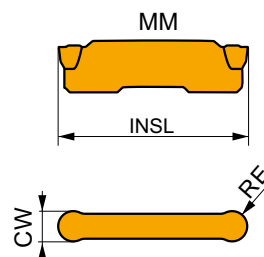


GM-geometri for sporing og langsgående dreining, og kontinuerlige til avbrutte kutt.

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)	(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



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	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)

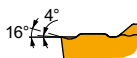


MM-geometri, med full radiusform for kopiprofilering og langsgående dreining, og kontinuerlige til avbrutte kutt.

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	—	—	—

Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	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-geometri, med full radiusform for kopiprofilering og langsgående dreining, og kontinuerlige til avbrutte kutt.

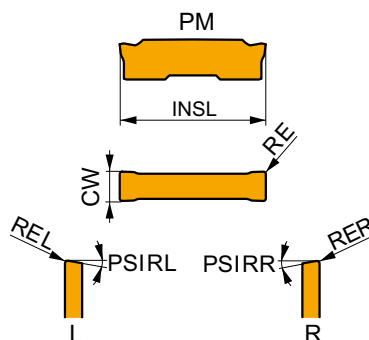
GL3-D300MM0-MM	G8330	1.5	210	0.20	1.2	125	0.18	1.2	195	0.20	1.2	—	—	—	50	0.14	1.0	—	—	—
	T7325	1.5	240	0.20	1.2	185	0.18	1.2	—	—	—	—	—	—	75	0.14	1.0	—	—	—
GL4-D400MM0-MM	G8330	2.0	220	0.20	1.2	130	0.18	1.2	205	0.20	1.2	—	—	—	55	0.14	1.0	—	—	—
	T7325	2.0	250	0.20	1.2	195	0.18	1.2	—	—	—	—	—	—	80	0.14	1.0	—	—	—
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

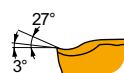
PRAMET

	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



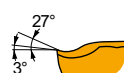
Egnethet og startverdier for skjærehastighet (vc) og mating (f). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	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)		



PM-geometri, førstevalg for avstikking og sporing, og kontinuerlige til lett avbrutte kutt.

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	—	—	—	—
	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	—	—	—	—

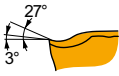


R-PM høyrehendt geometri, førstevalg for avstikk, og kontinuerlige til lett avbrutte kutt.

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	—
	T7325	0.2	150	0.10	115	0.09	—	—	—	—	45	0.07	—	—	6	—
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	—
	T7325	0.2	150	0.12	115	0.11	—	—	—	—	45	0.10	—	—	6	—
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	—

Egnethet og startverdier for skjærehastighet (vc) og mating (f). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	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-PM venstrehåndsgometri, førstevalg for avstikk og kontinuerlige til lett avbrutte kutt.

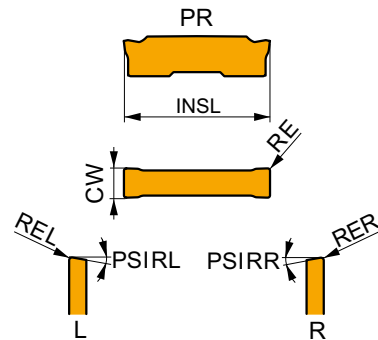
GL2-D200G02L06-PM	G8330	0.2	130	0.08	75	0.07	120	0.08	—	—	30	0.06	—	—	—	6
	T7325	0.2	150	0.08	115	0.07	—	—	—	—	45	0.06	—	—	—	6
GL2-D200G02L12-PM	G8330	0.2	130	0.08	75	0.07	120	0.08	—	—	30	0.06	—	—	—	12
GL3-D300G02L06-PM	G8330	0.2	130	0.10	75	0.09	120	0.10	—	—	30	0.07	—	—	—	6
	T7325	0.2	150	0.10	115	0.09	—	—	—	—	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

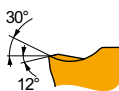
PRAMET

	CW (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



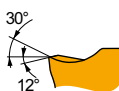
Egnethet og startverdier for skjærehastighet (vc) og mating (f). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	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)		



PR-geometri, førstevalg for avstikking og sporing, og kontinuerlige til avbrutte kutt.

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	—	—	—	—	—	—	—	—

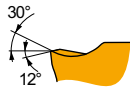


R-PR høyrehendt geometri, førstevalg for avstikk og kontinuerlige til avbrutte kutt.

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	—

Egnethet og startverdier for skjærehastighet (vc) og mating (f). Se vår Machining Calculator-app for ytterligere 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)	(m/min) (mm/rev)	(m/min) (mm/rev)	(m/min) (mm/rev)	(m/min) (mm/rev)	(m/min) (mm/rev)		



L-PR venstrehåndsgeometri, førstevalg for avstikk, og kontinuerlige til avbrutte kutt.

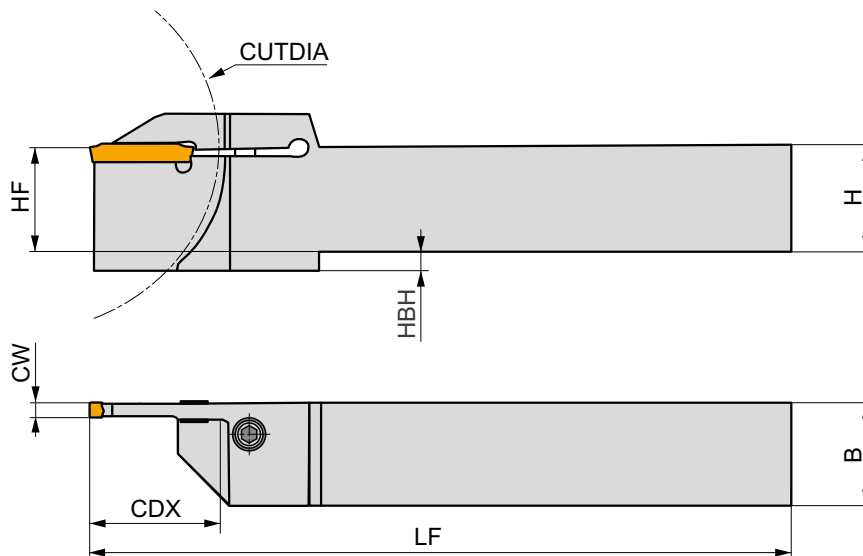
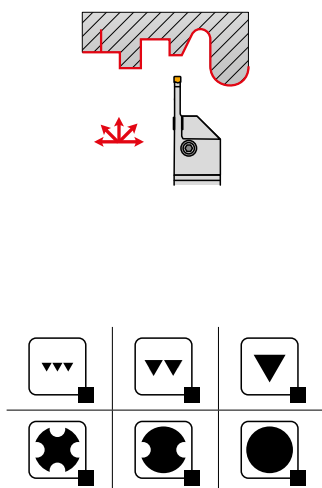
GL2-D200G02L06-PR	G8330	0.2	■	130	0.10	▣	75	0.09	■	120	0.10	—	—	—	—	6
GL2-D200G02L12-PR	G8330	0.2	■	130	0.10	▣	75	0.09	■	120	0.10	—	—	—	—	12
GL3-D300G02L06-PR	G8330	0.2	■	130	0.12	▣	75	0.11	■	120	0.12	—	—	—	—	6
GL3-D300G02L12-PR	G8330	0.2	■	130	0.12	▣	75	0.11	■	120	0.12	—	—	—	—	12
GL4-D400G02L06-PR	G8330	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

PRAMET
G

Utvendig V-Spor dreieholder for sporing og avstikking, tilpasset GL-skjær

Utvendig høyre / venstre hånd radial dreieholder for sporing med dobbeltsidig GL 2, 3, 4, 5 eller 6 skjærtyper. Egnet for radial spor og avstikking, opptil 32 mm maksimal skjæredybde. Fås med skaftstørrelse 20x20 eller 25x25 mm. Forsterket kroppsdesign for lengre levetid og lave vibrasjoner.



	Product	HF	HBH	H	B	LF	CW	CDX	CUTDIA	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)			
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
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	HBH	H	B	LF	CW	CDX	CUTDIA			
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)			
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..

					
GL11	US 5018-T20P	5.0	M 5	18.2	LK T20P

Skjæredybder på maskinert diameter på side xxx.

NEW

GLSF(RL) EXT-G



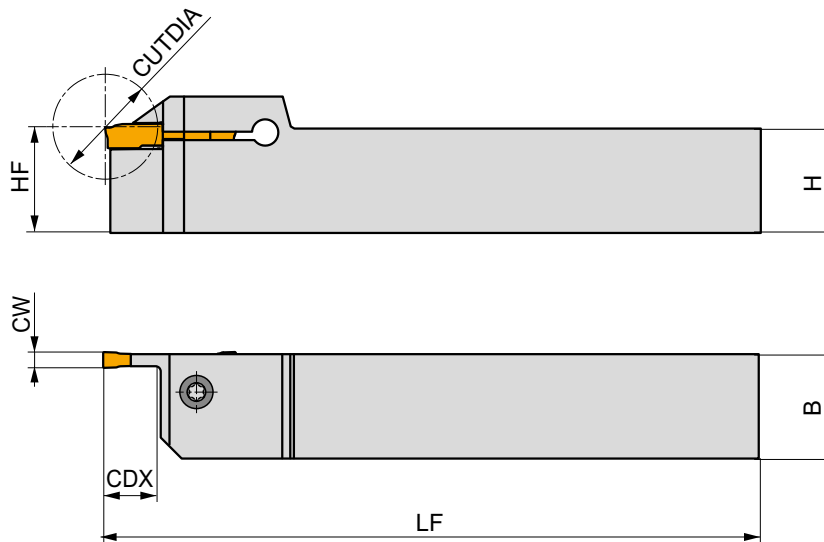
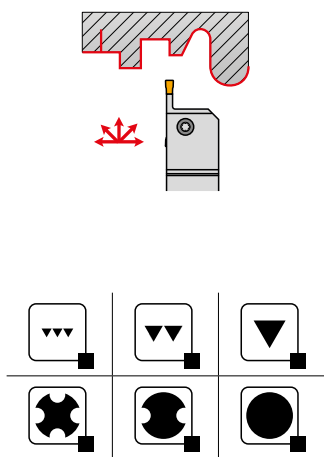
PRAMET

G



Utvendig V-Spor dreieholder for sporing og dreining, tilpasset for GL-skjær

Utvendig høyre / venstre hånd radial dreieholder for sporing med dobbeltsidig GL 2, 3, 4, 5 eller 6 skjærtyper. Egnert for radial sporing, langsgående dreining og profilering, opptil 12 mm maksimal skjæredybde. Fås med skaftstørrelse 20x20 eller 25x25 mm. Behandlet for lengre levetid.



	Product	⌀	H	B	L	CW	CDX	CUTDIA	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)			
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
L	GL6-S2525MFR-12	25	25	25	150	6.00	12	24	0.68	GI338	GL11
	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..

GL11	US 5018-T20P	5.0	M 5	18.2	LKT20P

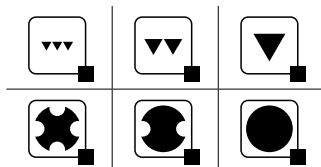
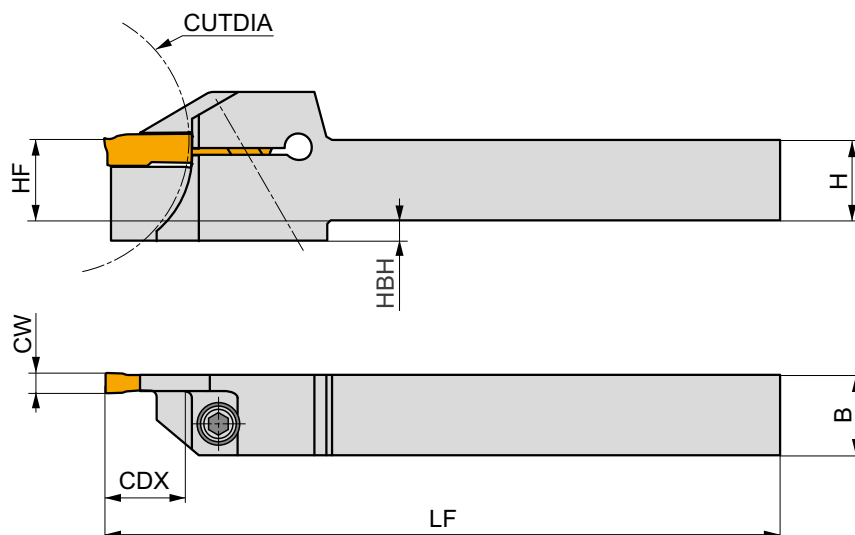
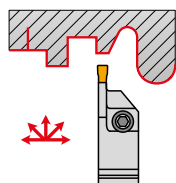
NEW

GLSF(RL) EXT-S


PRAMET
G


Utvendig spor- og avsktickingholder, GL-skjær

Utvendig høyre / venstre hånd radial dreieholder for automatbenker GL 2, 3, 4 sporbredde. For radial spor, profilering og avstikking opptil 16 mm maksimal skjæredybde. Fås med skaftstørrelse 12x12 eller 16x16 mm. Forsterket kroppsdesign for lengre levetid for verktøyet og lave vibrasjoner, lett å klemme.



	Product	HF	HBH	H	B	LF	CW	CDX	CUTDIA	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)			
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..										

GL12	HS 0516	5.0	M 5	16	HXK 4							
GL13	HS 0412	5.0	M 4	12	HXK 3							

Skjæredybder på maskinert diameter på side xxx.

NEW

GLS B



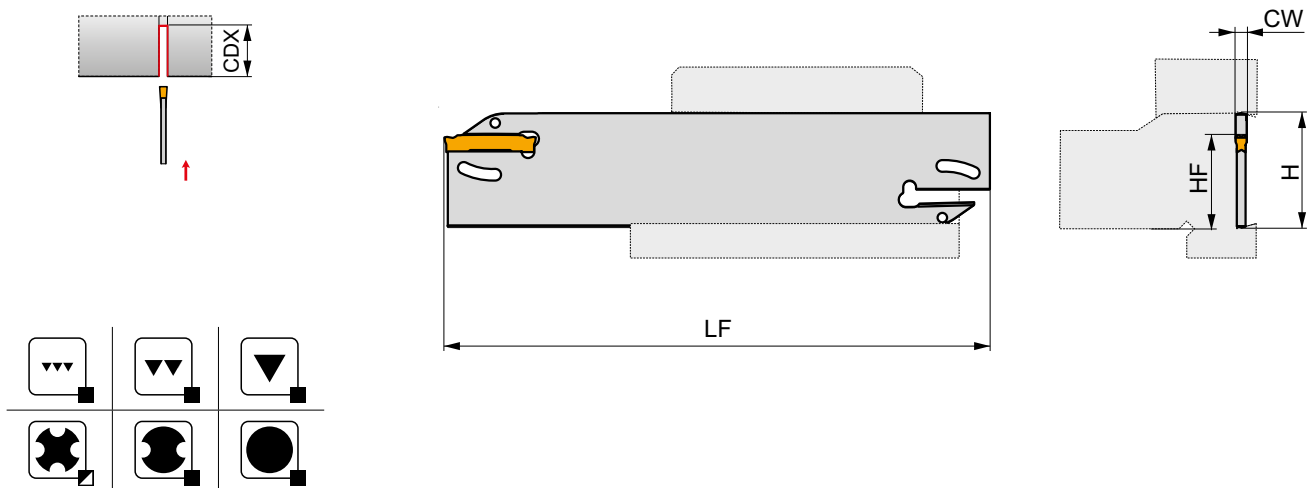
PRAMET

X



Dobbel-endet avstikkblad for GL-skjær

Blad for avstikking applikasjoner opp til 60 mm maksimal dybde eller Ø120 mm stangmateriale. Passer for GL-familien sine dobbeltsidige skjær. Tilgjengelig i høyden 26 og 32 mm. Kan monteres i DU Pramet basisholdere. Blad behandlet for lengre levetid.



Product	≡ (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

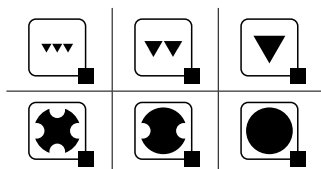
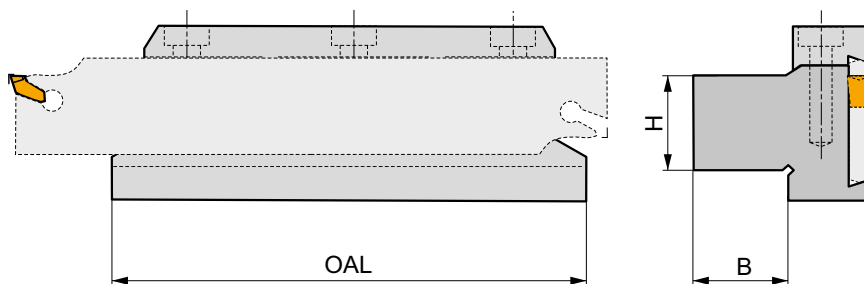
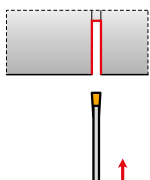
DU, D

PRAMET



Grunnholder for avstikkingsblad

Verktøyholder for GL eller XLC. blad for avstikking. Tilgjengelig med skaftstørrelse 20x20 opp til 40x40 mm. Behandlet for lengre levetid.



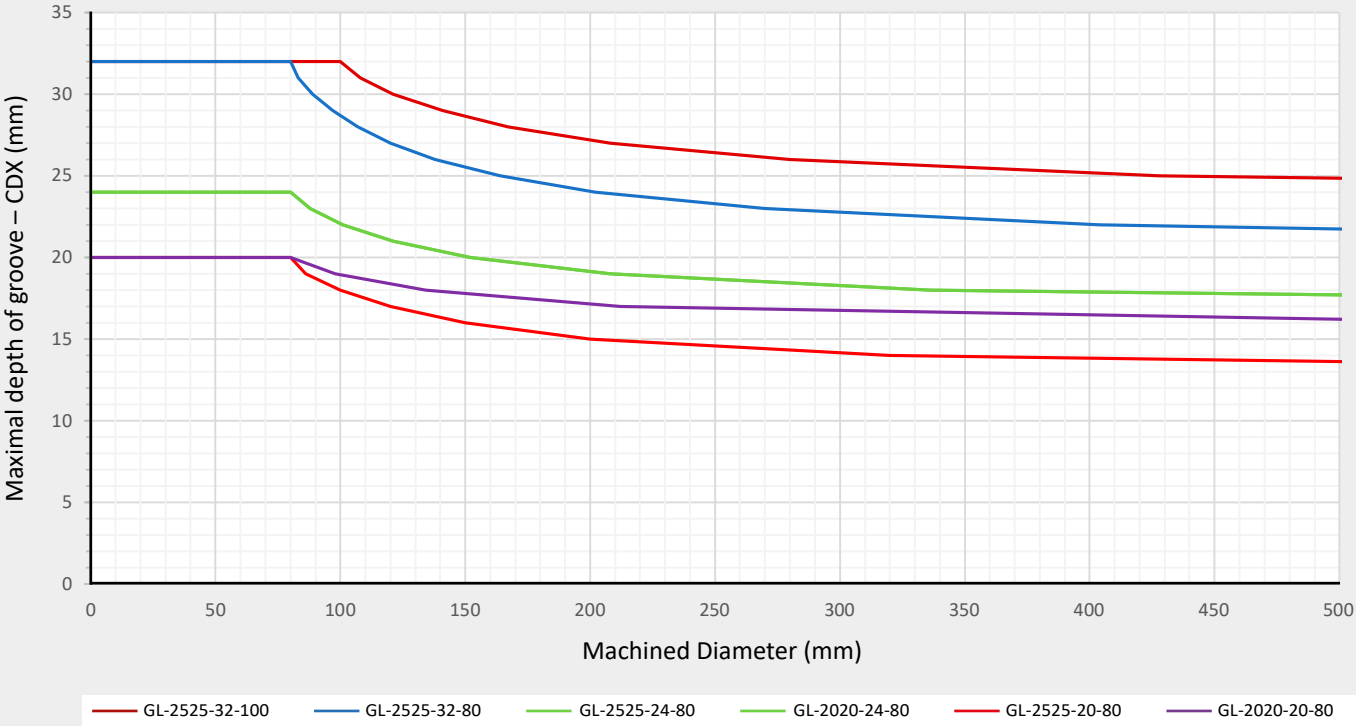
Product	H (mm)	B (mm)	OAL (mm)	kg		
26-DU 2020	20	20	90	0.70	GI007	ND2
26-D 2020	20	20	100	0.82	GI007	ND2
32-DU 2523	25	23	110	1.02	GI008	ND2
32-DU 2532	25	32	110	1.10	GI008	ND2
32-DU 3229	32	29	110	1.25	GI008	ND2
32-D 2530	25	30	115	1.30	GI008	ND2
45-DU 3229	32	29	110	1.50	GI009	ND7
45-DU 4036	40	36	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..	-

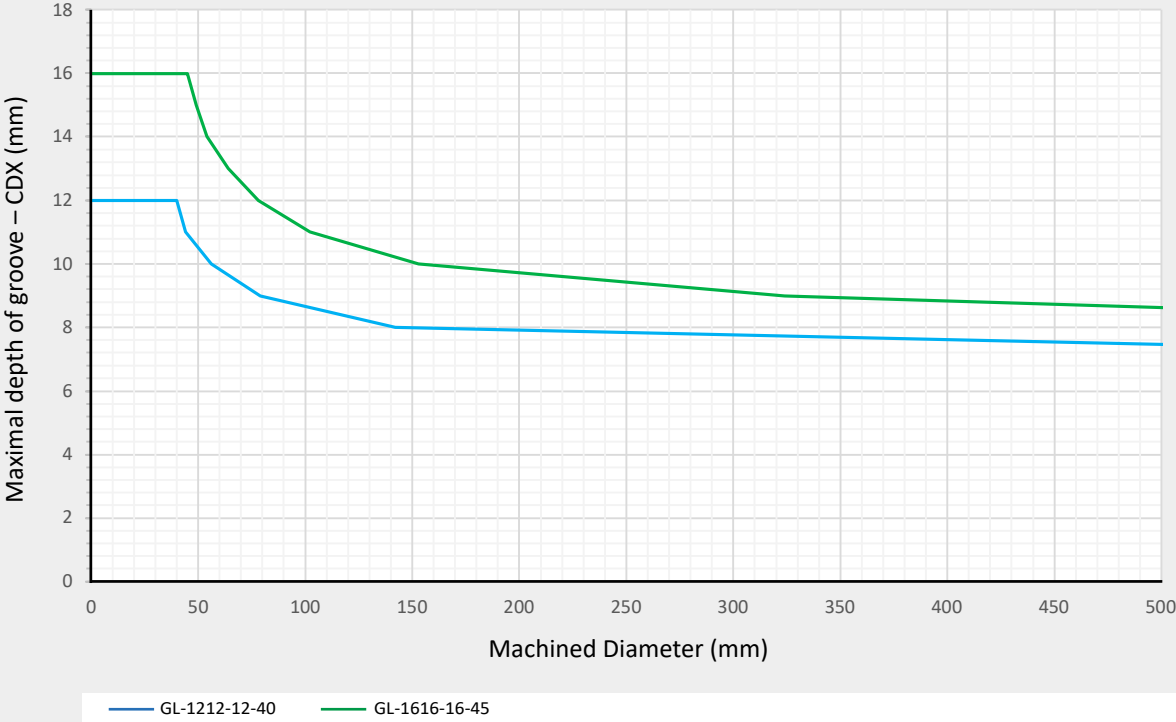
ND2	HS 0625	6.0	M 6	25	HXK 5
ND3	HS 1030	8.0	M 10	30	HXK 8
ND7	HS 0630	6.0	M 6	30	HXK 5

CUTTING DEPTHS DEPENDING ON MACHINED DIAMETER

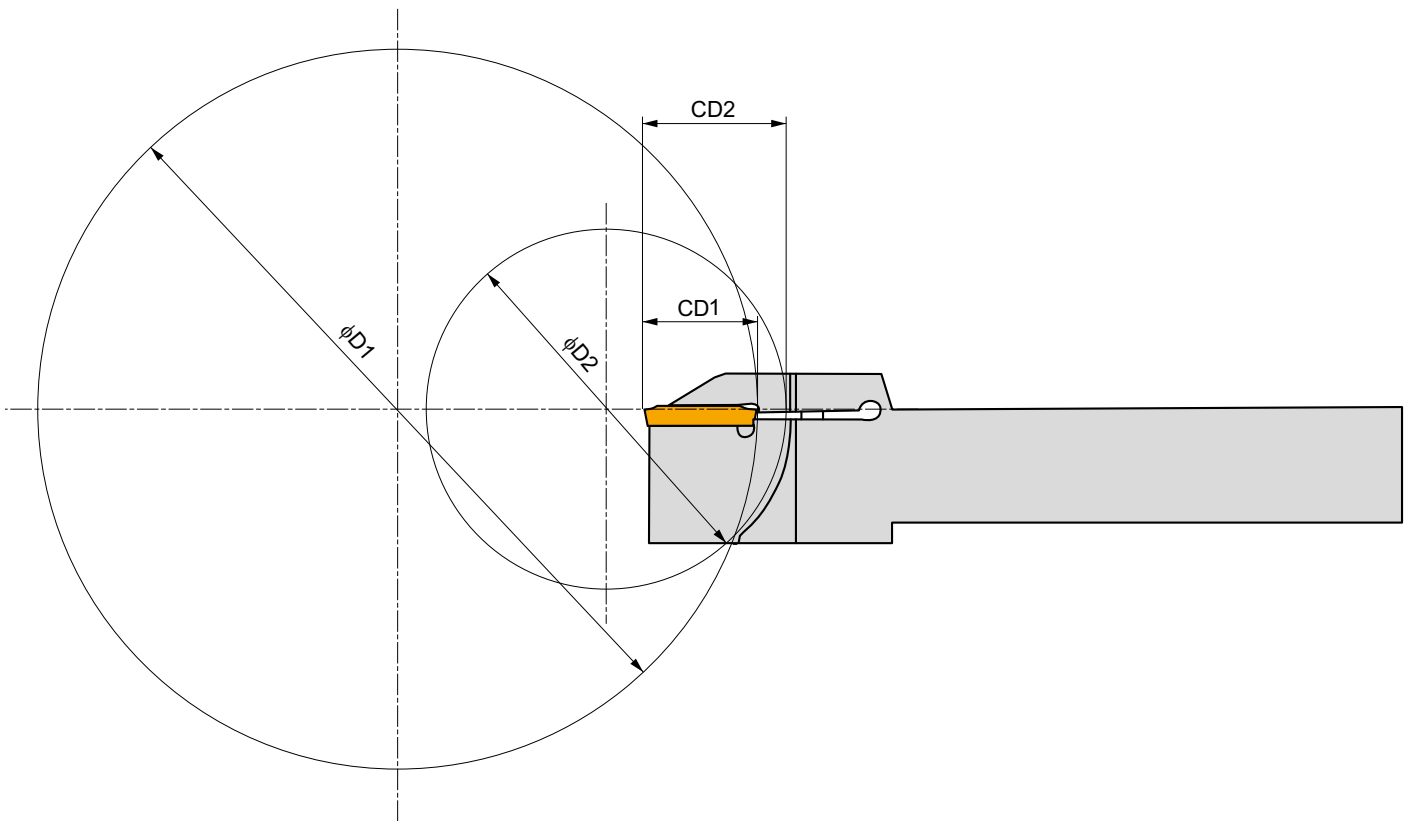
GLSF (RL) EXT



GLSF (RL) EXT-S



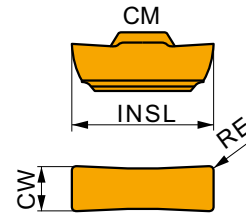
CUTTING DEPTHS DEPENDING ON MACHINED DIAMETER



LCMF 13 - CM

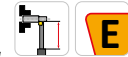
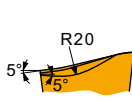


	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
0313	3.00	-0.05	0.05	12.6
0413	4.00	-0.05	0.05	12.6



Egnethet og startverdier for skjærehastighet (vc) og mating (f). Se vår Machining Calculator-app for ytterligere 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 og førstevalg for sporing.

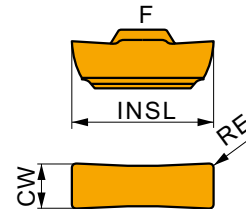
LCMF 031304-CM	T8330	0.4	130	0.11	75	0.10	120	0.11	—	—	—	—	—	—	—
LCMF 031304-CM-04	T8330 ¹⁾	0.4	130	0.11	75	0.10	120	0.11	—	—	—	—	—	—	—
LCMF 041304-CM	T8330	0.4	130	0.11	75	0.10	120	0.11	—	—	—	—	—	—	—

¹⁾ Insert for internal holder A16Q-GGERIL0313-04, A20R-GGFRIL0313-04.

LCMF 13 - F

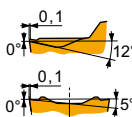


	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
0313	3.00	-0.05	0.05	12.6
0413	4.00	-0.05	0.05	12.6



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere 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 og førstevalg for dreining.

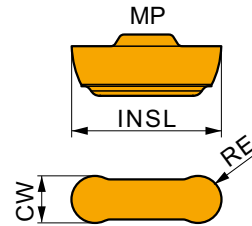
LCMF 031302-F	T8330	0.2	195	0.10	0.3	115	0.09	0.3	185	0.10	0.3	—	—	—	—	—	—	—	—
LCMF 031302-F-04	T8330 ¹⁾	0.2	195	0.10	0.3	115	0.09	0.3	185	0.10	0.3	—	—	—	—	—	—	—	—
LCMF 031304-F	T8330	0.4	185	0.13	0.5	110	0.12	0.5	175	0.13	0.5	—	—	—	—	—	—	—	—
LCMF 031304-F-04	T8330 ¹⁾	0.4	185	0.13	0.5	110	0.12	0.5	175	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

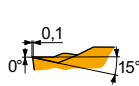


	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
0313	3.00	-0.05	0.05	12.6
0413	4.00	-0.05	0.05	12.6



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere 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 for langsgående dreining, kopiprofilering, finbearbeiding, ferdig bearbeiding og kontinuerlig til avbrutt kutt.

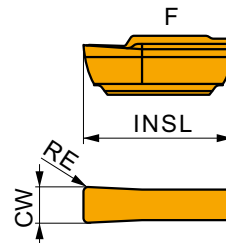
LCMF 0313MO-MP	T8330	1.5	■	190	0.30	0.8	■	110	0.27	0.8	■	180	0.30	0.8	—	—	—	—	—	—
LCMF 0313MO-MP-04	T8330 ¹⁾	1.5	■	190	0.30	0.8	■	110	0.27	0.8	■	180	0.30	0.8	—	—	—	—	—	—
LCMF 0413MO-MP	T8330	2.0	■	175	0.40	1.0	■	105	0.36	1.0	■	165	0.40	1.0	—	—	—	—	—	—

¹⁾ Insert for internal holder A16Q-GGERIL0313-04, A20R-GGFRIL0313-04.

LCMR 13 - F

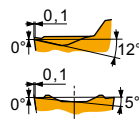


	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
0313	3.00	-0.05	0.05	12.6
0413	4.00	-0.05	0.05	12.6



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere 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)



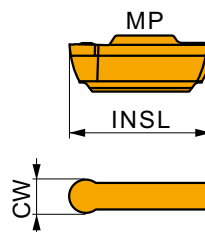
F geometri for sponing og dreining, finbearbeiding, og kontinuerlige til lett avbrutte kutt.

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	—	—	—	—	—	—

LCMR 13 - MP

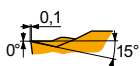


	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
0313	3.00	-0.05	0.05	12.6
0413	4.00	-0.05	0.05	12.6



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere 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 for langsgående dreining og kopiprofilering, og kontinuerlig til avbrutt kutt.

LCMR 0313MO-MP	T8330	1.5	190	0.30	0.8	110	0.27	0.8	180	0.30	0.8	—	—	—	—	—	—	—	—
LCMR 0413MO-MP	T8330	2.0	175	0.40	1.0	105	0.36	1.0	165	0.40	1.0	—	—	—	—	—	—	—	—

GG.(RL) INT



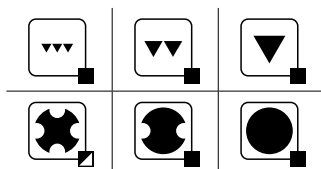
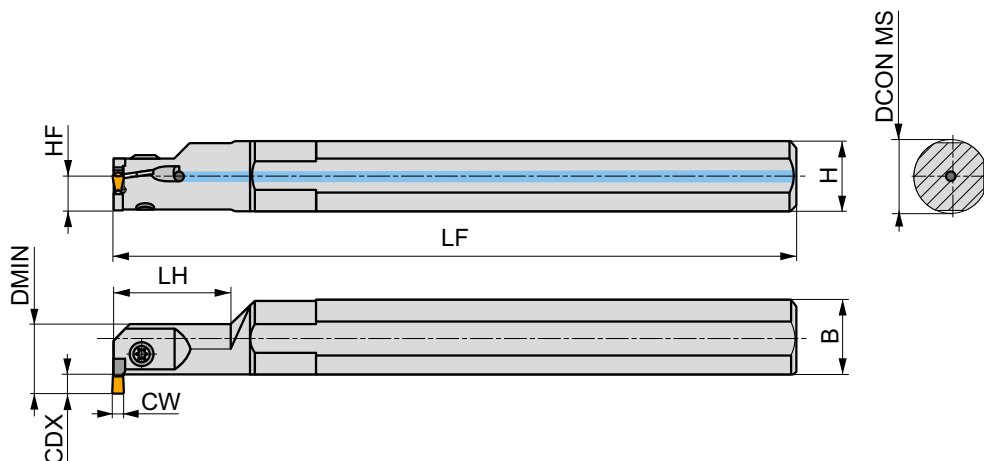
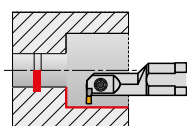
PRAMET

G



Innvendig spor dreiebom for LCM. Skjær

Innvendig høyre/venstre hånd dreiebom for spordreie med LCM. 0313 og 0413 skjær. Minimum innvendig spordiameter Ø16 mm. Passer for innvendig spor og multi-dreiretninger. Finnes med skaftstørrelse Ø16 opp til Ø32 mm. Behandlet for lengre levetid.



	Product	DCON MS	HF	H	B	LF	LH	CW	CDX	DMIN		kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)				
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
L	A32T-GGHR 0413	32	15	30	31	300	50	4.00	9.5	32	✓	1.59	GI170	GL06
	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



GL06

SR 85011-T15P

5.0

M 5

9

FLAG T15P

GFIL-L AXIAL



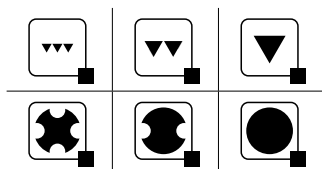
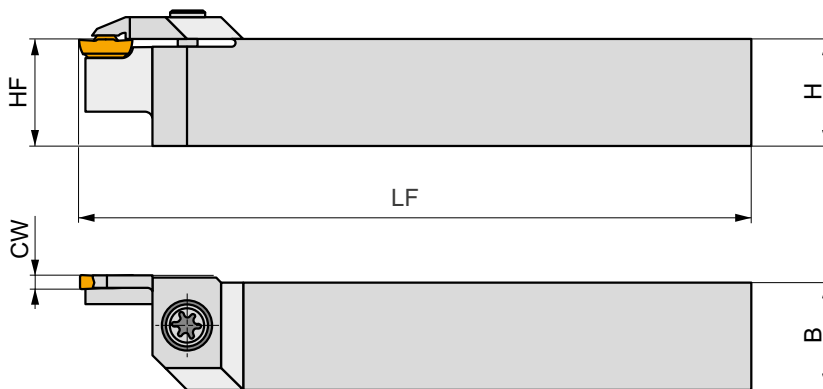
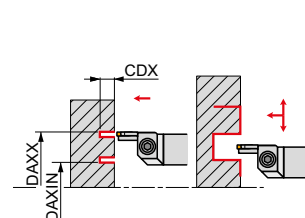
PRAMET

G



Utvendig aksialt V-spor topp klemming sporingsverktøy holder for LCM. 03 skjær

Utvendig venstre aksial verktøyholder for sporing med enkel eller dobbeltsidig LCM. 0313 eller 0316 skjær. Egnet for aksial sporing, aksial profilering eller sporutvidelse Ø17 opp til Ø170 mm applikasjoner med maksimal skjæredybde 9 mm. Fås med skaftstørrelse 25x25 mm. Behandlet for lengre levetid.



Product	HF	H	B	LF	CW	CDX	DAXIN	DAXX				
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)				
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..

GL02	US 5015-T20P	5.0	M 5	15	FLAGT20P
GL07	US 5018-T20P	5.0	M 5	18.2	FLAGT20P

GFIL-R AXIAL



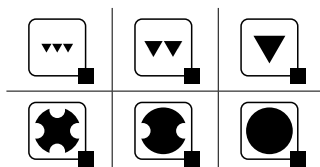
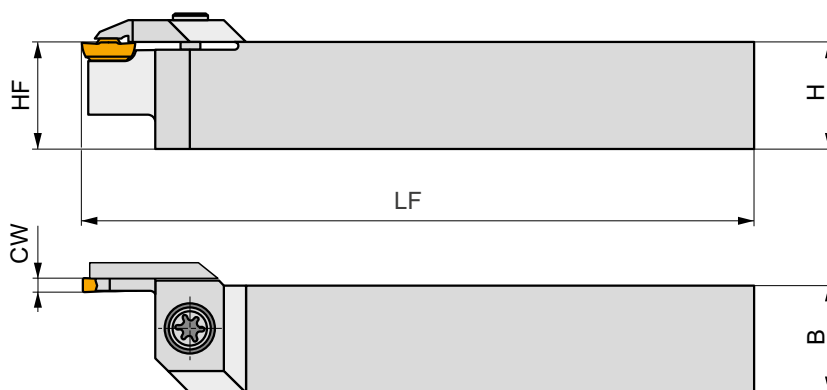
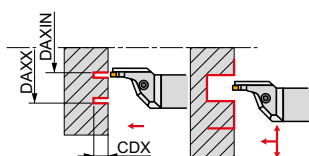
PRAMET

G



Utvendig aksialt V-spor Topp klemming sporingsverktøy holder for LCM. 03 eller 04 skjær

Utvendig venstre aksial verktøyholder for sporing med enkel eller dobbeltsidig LCM. 0313, 0316, 0413 eller 0416 skjær. Egnet for aksial sporing, aksial profilering eller sporutvidelse Ø17 opp til Ø230 mm applikasjoner, med maksimal skjæredybde 12 mm. Tilgjengelig med skaftstørrelse 25x25. Behandlet for lengre levetid.



Product	HF	H	B	LF	CW	CDX	DAXIN	DAXX	kg			
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)				
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..



GL07

US 5018-T20P

5.0

M 5

18.2

FLAG T20P

—

GL08

US 6020-T25P

6.0

M 6

20.2

—

SDRT25P

GFIR-L AXIAL

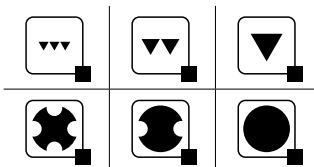
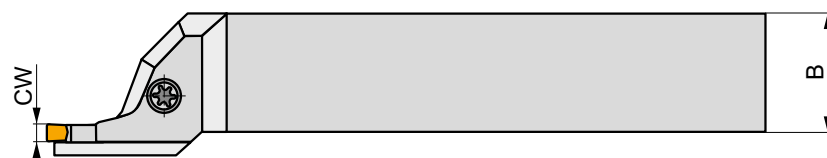
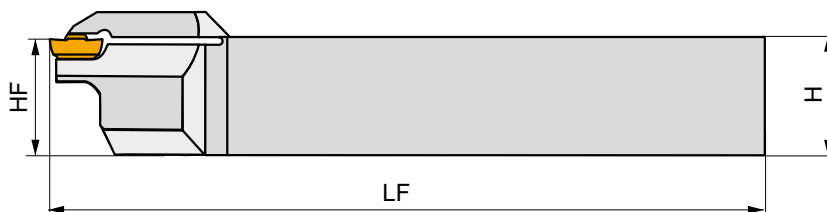
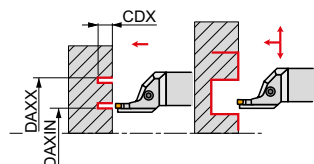


PRAMET

G

Utvendig aksial V-Spor toppklemme dreieholder for LCM. 03 eller 04 skjær

Utvendig høyre aksial dreieholder for spor med enkel eller dobbeltsidig LCM. 0313, 0316, 0413 eller 0416 skjær. Passer for aksial sporing, aksial profilering eller sporvidde Ø17 opp til Ø230 mm applikasjoner, med maksimal kuttebde 12 mm. Tilgjengelig med skaftstørrelse 25x25 mm. Behandlet for lengre levetid.



Product	HF	H	B	LF	CW	CDX	DAXIN	DAXX	kg		
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)			
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..

GL07	US 5018-T20P	5.0	M 5	18.2	FLAG T20P	—
GL08	US 6020-T25P	6.0	M 6	20.2	—	SDRT25P

GFIR-R AXIAL



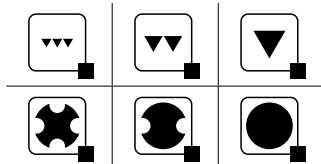
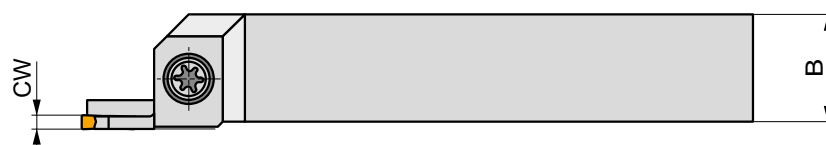
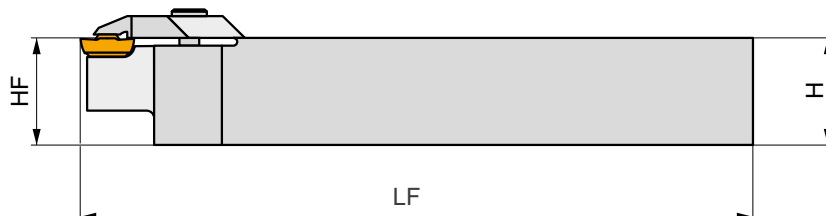
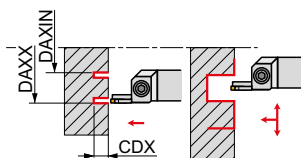
PRAMET

G



Utvendig aksialt V-Spor toppklemme dreieholder for LCM. 03 skjær

Utvendig høyre aksial dreieholder for spor med enkel eller dobbeltsidig LCM. 0313 eller 0316 skjær. Passer for aksial sporing, aksial profilering eller sporvidde Ø17 opp til Ø170 mm applikasjoner, med maksimal dybde 9 mm. Tilgjengelig med skaftstørrelse 25x25 mm. Behandlet for lengre levetid.



Product	HF	H	B	LF	CW	CDX	DAXIN	DAXX	kg		
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)			
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..



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



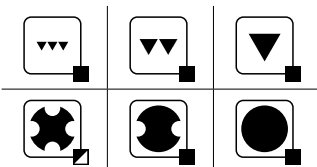
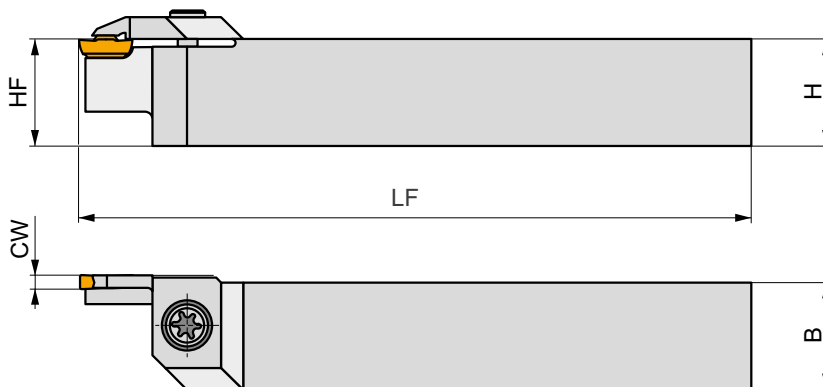
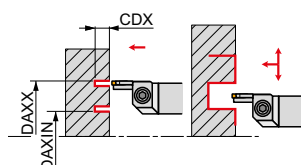
PRAMET

G



Utvedig aksialt V-spor topp klemming sporingsverktøy holder for LCM. 04 skjær

Utvendig venstre aksial verktøyholder for sporing med enkel eller dobbeltsidig LCM. 0413 eller 0416 skjær. Egnet for dyp aksial sporing, aksial profilering eller sporutvidelse Ø17 opp til Ø230 mm applikasjoner, med maksimal skjæredybde 20 mm. Fås med skaftstørrelse 25x25 mm. Behandlet for lengre levetid.



Product	HF	H	B	LF	CW	CDX	DAXIN	DAXX	kg			
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)				
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											
GI170											

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



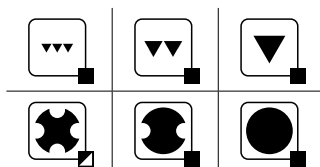
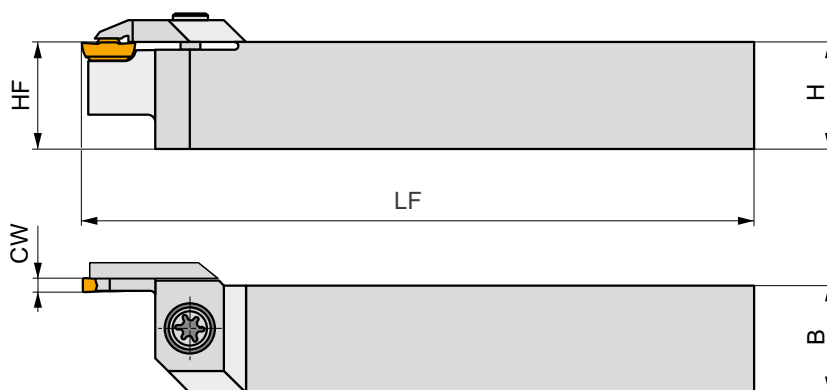
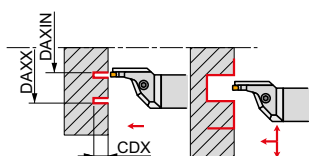
PRAMET

G



Utvendig aksialt V-spor topp klemming sporingsverktøy holder for LCM. 04 skjær.

Utvendig venstre aksial verktøyholder for sporing med enkel eller dobbeltsidig LCM. 0413 eller 0416 skjær. Egnet for dyp aksial sporing, aksial profilering eller sporutvidelse Ø17 opp til Ø230 mm applikasjoner, med maksimal skjæredybde 20 mm. Fås med skaftstørrelse 25x25 mm. Behandlet for lengre levetid.



Product	HF	H	B	LF	CW	CDX	DAXIN	DAXX	kg		
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)			
L	GFML 2525 M 0413R 030017	25	25	25	150	4.00	20	17	0.68	GI170	GL07
	GFML 2525 M 0413R 034021	25	25	25	150	4.00	20	21	0.69	GI170	GL07
	GFML 2525 M 0413R 040026	25	25	25	150	4.00	20	26	0.69	GI170	GL07
	GFML 2525 M 0413R 050032	25	25	25	150	4.00	20	32	0.68	GI170	GL07
	GFML 2525 M 0413R 060042	25	25	25	150	4.00	20	42	0.69	GI170	GL07
	GFML 2525 M 0413R 075052	25	25	25	150	4.00	20	52	0.69	GI170	GL07
	GFML 2525 M 0416R 100070	25	25	25	150	4.00	20	70	0.80	GI137	GL08
	GFML 2525 M 0416R 130090	25	25	25	150	4.00	20	90	0.78	GI137	GL08
	GFML 2525 M 0416R 170110	25	25	25	150	4.00	20	110	0.78	GI137	GL08
	GFML 2525 M 0416R 230140	25	25	25	150	4.00	20	140	0.78	GI137	GL08

GI137		LCM. 0416..
GI170		LCM. 0413..

GL07	US 5018-T20P	5.0	M 5	18.2	FLAGT20P	—
GL08	US 6020-T25P	6.0	M 6	20.2	—	SDRT25P

GFMR-L AXIAL



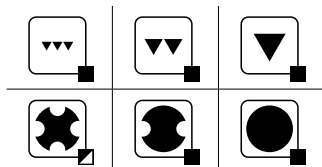
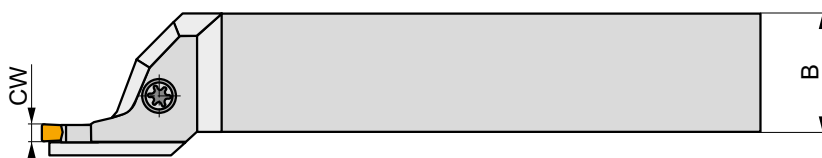
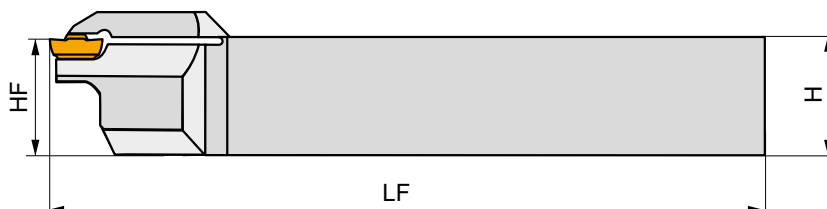
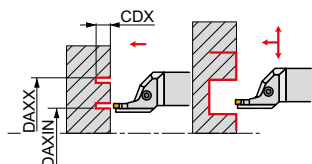
PRAMET

G



Utvendig aksial V-Spor toppklemme dreieholder for LCM. 04 skjær

Utvendig høyre aksial dreieholder for spor med enkel eller dobbeltsidig LCM. 0413 eller 0416 skjær. Passer for dyp aksial sporing, aksial profilering eller sporvidde Ø17 opp til Ø230 mm applikasjoner, med maksimal kuttedybde 20 mm. Tilgjengelig med skaftstørrelse 25x25 mm. Behandlet for lengre levetid.



Product	HF	H	B	LF	CW	CDX	DAXIN	DAXX				
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)				
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											
GI170											

GL07	US 5018-T20P	5.0	M 5	18.2	FLAG T20P	—					
GL08	US 6020-T25P	6.0	M 6	20.2	—	SDRT25P					

GFMR-R AXIAL



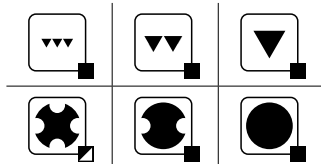
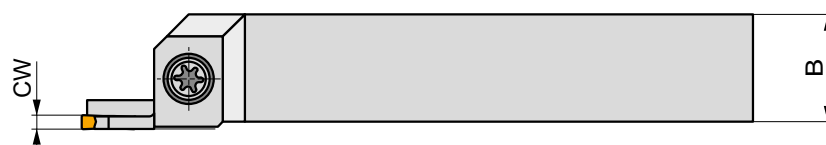
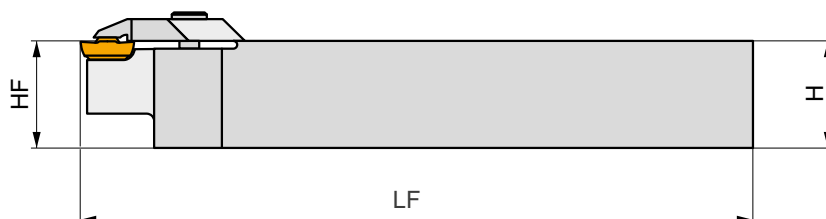
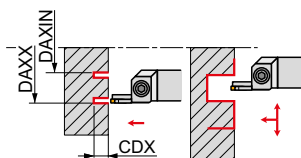
PRAMET

G



Utvendig aksialt V-Spor toppklemme dreieholder for LCM. 04 skjær

Utvendig høyre aksial dreieholder for spor med enkel eller dobbeltsidig LCM. 0413 eller 0416 skjær. Passer for dyp aksial sporing, aksial profilering eller sporvidde Ø17 opp til Ø230 mm applikasjoner, med maksimal kuttedybde 20 mm. Tilgjengelig med skaftstørrelse 25x25 mm. Behandlet for lengre levetid.



Product		HF	H	B	LF	CW	CDX	DAXIN	DAXX			
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)			
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
GI170

LCM. 0416..
LCM. 0413..



GL02
GL07

US 5015-T20P
US 5018-T20P

5.0
5.0

M 5
M 5

15
18.2

FLAG T20P
FLAG T20P

GGI(RL)-90 AXIAL



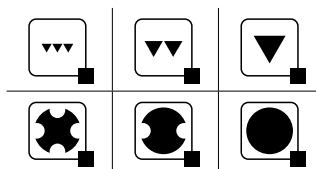
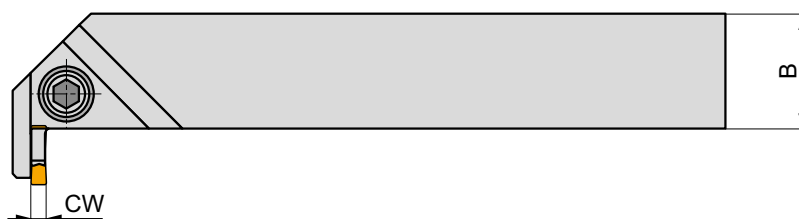
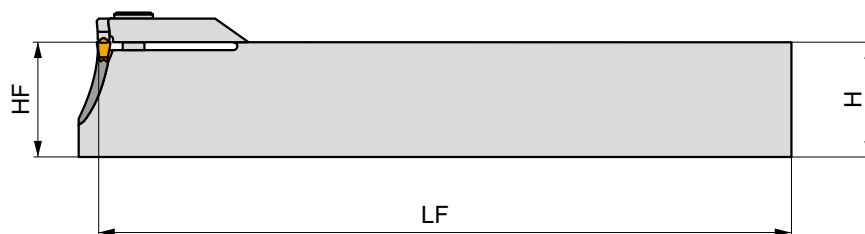
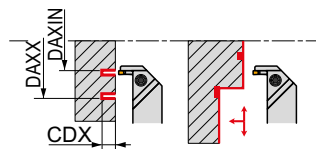
PRAMET

G



Utvendig aksialt 90° V-spore holder for LCM. 03 Skjær

Utvendig høyre / venstre aksial 90° dreieholder for sporing med enkel eller dobbeltsidig LCM. 0313 eller 0316 skjær. Egnet for aksial sporing, aksial profilering eller sporutvidelse Ø17 opp til Ø170 mm applikasjoner, med maksimal skjæredybde 11 mm. Fås med skafstørrelse 25x25 mm. Behandlet for lengre levetid.



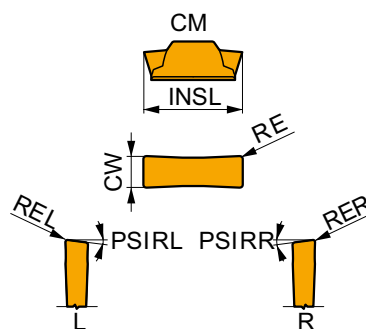
Product		HF	H	B	LF	CW	CDX	DAXIN	DAXX			
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)			
R	GGIR 2525 M 03R 030017	25	25	25	150	3.00	9.5	17	30	0.75	GI143	GL01
	GGIR 2525 M 03R 039024	25	25	25	150	3.00	9.5	24	39	0.78	GI143	GL01
	GGIR 2525 M 03R 050033	25	25	25	150	3.00	11	33	50	0.75	GI143	GL01
	GGIR 2525 M 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											
GI143											

GL01		HS 0520C		5.0		M 5		20		HXK 4	
GL04		HS 0620C		6.0		M 6		20		HXK 5	

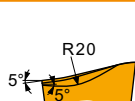
LCMF 16 - CM

	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
0316	3.00	-0.05	0.05	16.4
0416	4.00	-0.05	0.05	16.4
0516	5.00	-0.05	0.05	16.4
0616	6.00	-0.05	0.05	16.4



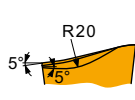
Egnethet og startverdier for skjærehastighet (vc) og mating (f). Se vår Machining Calculator-app for ytterligere beregninger.

Product	RE (mm)	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)		



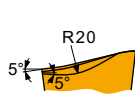
CM-geometri, førstevalg for avstikking og sporing, og kontinuerlige til lett avbrutte kutt.

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, høyrehendt design, førstevalg for avstikk og kontinuerlige til lett avbrutte kutt.

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	—



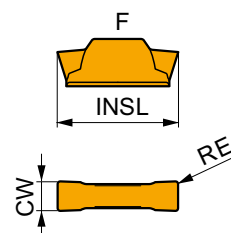
L-CM geometri, venstrehendt design, førstevalg for avstikking og kontinuerlige til lett avbrutte kutt.

LCMF 031602L15-CM	T8330 ¹⁾	0.2	130	0.11	75	0.10	120	0.11	—	—	—	—	—	—	15
LCMF 031602L6-CM	T8330	0.2	130	0.11	75	0.10	120	0.11	—	—	—	—	—	—	6
LCMF 041602L15-CM	T8330 ¹⁾	0.2	130	0.11	75	0.10	120	0.11	—	—	—	—	—	—	15
LCMF 041602L6-CM	T8330	0.2	130	0.11	75	0.10	120	0.11	—	—	—	—	—	—	6

¹⁾ Toolholders have to be modified.

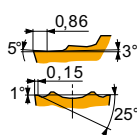
LCMF 16, LCMF 30 - F

	CW	CWTOLL	CWTOLU	INSL
(mm)	(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



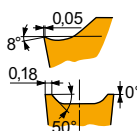
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

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 for avstikking, sporing og aksial dreining, fin- og ferdig bearbeiding, og kontinuerlige til lett avbrutte kutt.

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	—	—	—	—	—	—	—	—	—

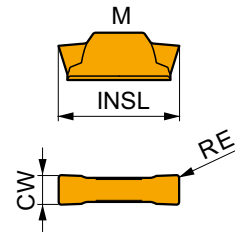


F-geometri for avstikking, sporing og aksial dreining, fin- og ferdig bearbeiding, og kontinuerlige til lett avbrutte kutt.

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	—	—	—	—	—	—	—	—	—

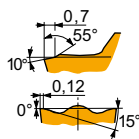
LCMF 16 - M

	CW	CWTOLL	CWTOLU	INSL
(mm)	(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



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere 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)

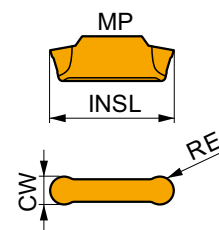


M geometri for sponing og langsgående dreining, og kontinuerlig til avbrutt kutt.

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	—	—	—	—	—	—	—	—

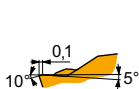
LCMF 16, LCMF 30 - MP

	CW	CWTOLL	CWTOLU	INSL
(mm)	(mm)	(mm)	(mm)	(mm)
0316	3.00	-0.05	0.05	17.5
0416	4.00	-0.05	0.05	17.6
0516	5.00	-0.05	0.05	18.3
0616	6.00	-0.05	0.05	18.5
0830	8.00	-0.05	0.05	30.9



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere 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)

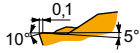


MP-geometri for langsgående dreining og kopiprofilering, og kontinuerlig til avbrutt kutt.

LCMF 0316M0-MP	T8330	1.5	190	0.30	0.8	110	0.27	0.8	180	0.30	0.8	—	—	—	—	—	—	—	—
LCMF 0416M0-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 0516M0-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	—	—	—	—	—	—	—	—

Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(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)



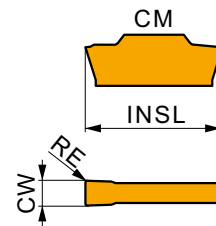
MP-geometri for langsgående dreining og kopiprofilering, og kontinuerlig til avbrutt kutt.

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

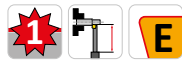
PRAMET

	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



Egnethet og startverdier for skjærehastighet (vc) og mating (f). Se vår Machining Calculator-app for ytterligere beregninger.

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



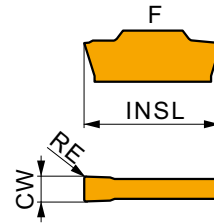
CM-geometri, førstevalg for avstikking og sporing, og kontinuerlige til lett avbrutte kutt.

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

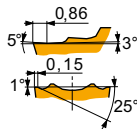
PRAMET

	CW	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



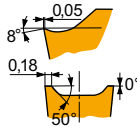
Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

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 for avstikking, sporing og langsgående dreining, fin- og ferdig bearbeiding og kontinuerlige til lett avbrutte kutt.

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	—	—	—	—	—	—	—	—



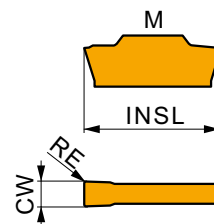
F-geometri for avstikking, sporing og langsgående dreining, fin- og ferdig bearbeiding og kontinuerlige til lett avbrutte kutt.

LCMR 083008-F	T8330	0.8	175	0.25	1.0	105	0.23	1.0	165	0.25	1.0	—	—	—	—	—	—	—	—
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LCMR 16 - M

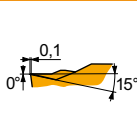
PRAMET

	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
0316	3.00	-0.05	0.05	16.4
0416	4.00	-0.05	0.05	16.4
0516	5.00	-0.05	0.05	16.4
0616	6.00	-0.05	0.05	16.4



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere 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)

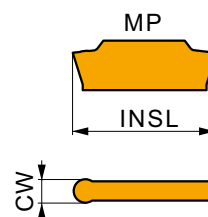


M geometri for sporing og langsgående dreining, og kontinuerlig til avbrutt kutt.

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

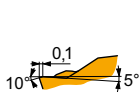
LCMR 16 - MP

	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



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product	RE (mm)	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)



MP-geometri for langsgående dreining og kopiprofilering, og kontinuerlig til avbrutt kutt.

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

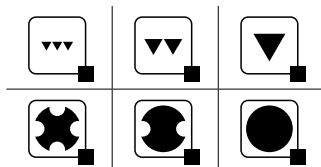
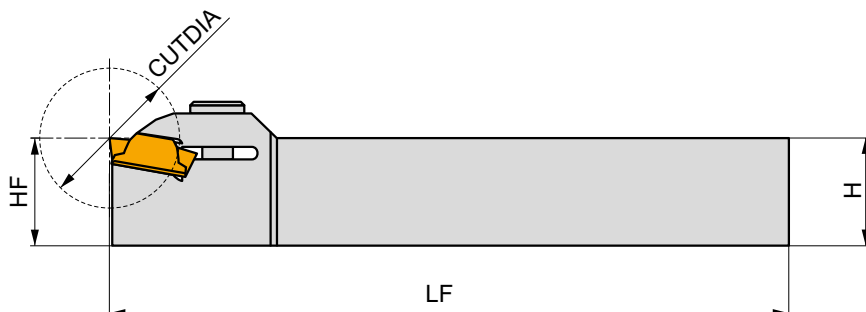
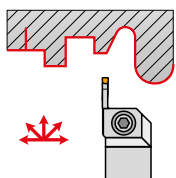


PRAMET

G

Utvendig V-spor dreieholderfor sporing og dreieing, tilpasset for LCM. skjær

Utvendig høyre / venstre hånd dreieholder for sporing med LCM. 0316, 0416, 0516, 0616 og 0830 skjær. Eget for avstikking opp til maksimalt Ø48 mm materiale i spor, profilering og langsgående dreieing. Tilgjengelig med skaftstørrelse 16x16 opp til 32x25 mm. Behandlet for lengre levetid for verktøyet.



	Product	≡	H	B	LF	CW	CUTDIA	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)			
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..

		 Nm			
GL03	HS 0616C	6.0	M 6	16	HXX 5
GL04	HS 0620C	6.0	M 6	20	HXX 5
GL05	HS 0625C	6.0	M 6	25	HXX 5
GL09	HSI 1020	8.0	M 10	20	HXX 8

GFM(RL) EXT



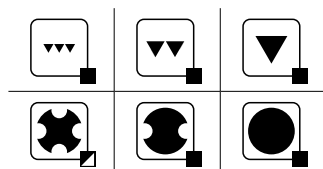
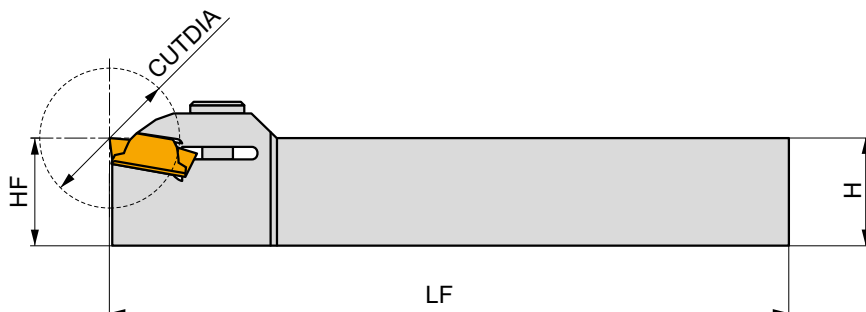
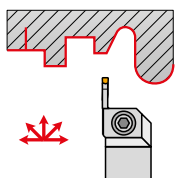
PRAMET

G



Utvendig V-spor dreieholder for sporing og dreining, tilpasset for LCM. Skjær.

Utvendig høyre / venstre hånd dreieholder for sporing med LCM. 0316, 0416, 0516, 0616 og 0830 skjær. Egnet for avstikking opp til maksimalt Ø30 til Ø80 mm materiale i spor, profilering og langsgående dreining. Tilgjengelig med skaftstørrelse 20x20 opp til 32x25 mm. Behandlet for lengre levetid for verktøyet.



	Product	HF	H	B	LF	CW	CUTDIA	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)			
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
L	GFMR 3225 P 0830	32	32	25	170	8.00	80	0.97	GI193	GL10
	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..



GL04	HS 0620C	6.0	M 6	20	HXK 5
GL10	HSI 1020	8.0	M 10	20	HXK 8

XLCCN B

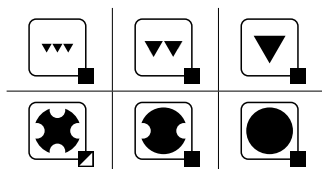
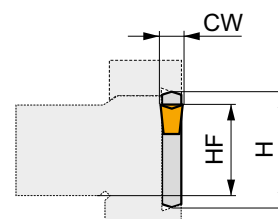
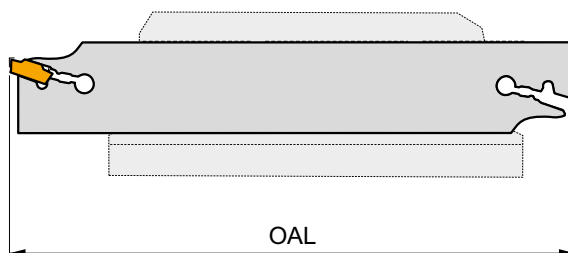
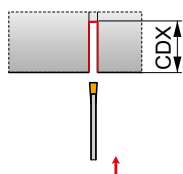


PRAMET

X

Dobbel-endet avstikkblad for LCM..skjær

Blad for avstikking applikasjoner opp til 60 mm maksimal dybde eller Ø120 mm stangmateriale. Egnet for enkeltsidig eller dobbeltsidig LCM. skjær. Tilgjengelig i høyden 26 eller 32 mm. Kan monteres i DU Pramet basisholdere. Blad behandlet for lengre levetid.



Product	≡ (mm)	H (mm)	≡ (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								
GI137								
GI138								
GI139								

KV1								

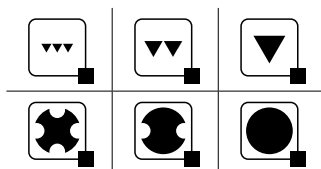
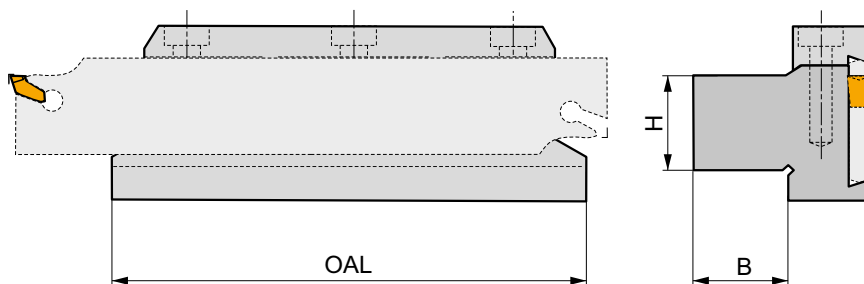
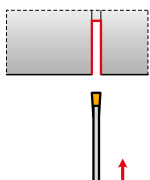
DU, D

PRAMET



Grunnholder for avstikkingsblad

Verktøyholder for GL eller XLC. blad for avstikking. Tilgjengelig med skaftstørrelse 20x20 opp til 40x40 mm. Behandlet for lengre levetid.



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..	-

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



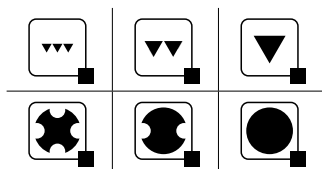
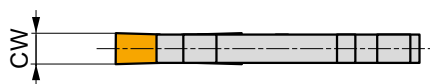
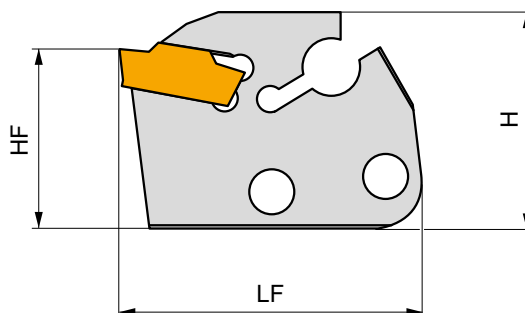
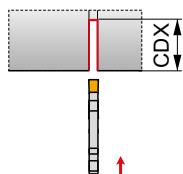
PRAMET

G



Radial Sporblad for modulær MS-EN verktøyholder tilpasset LCM. Skjær

Radial spordreingsblad for modulær MS-EN dreieholder tilpasset LCM. Skjær



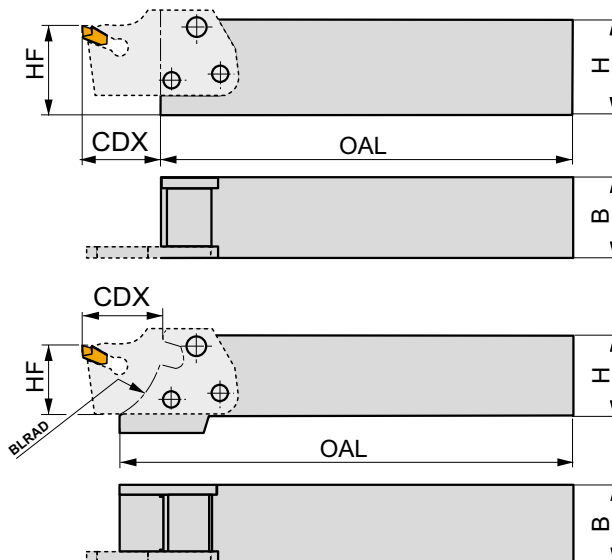
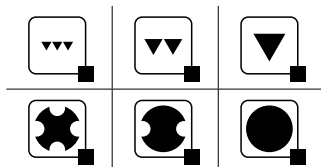
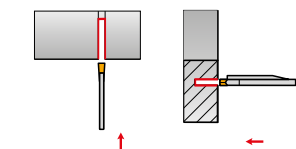
Product	⌀	H	LF	CW	CDX	kg		
	(mm)	(mm)	(mm)	(mm)	(mm)			
N XLCCN 250215-0316	24	29	40	3.00	15	0.01	GI136	—
XLCCN 250225-0316	24	29	50	3.00	25	0.02	GI136	—
XLCCN 250315-0416	24	29	40	4.00	15	0.04	GI137	—
XLCCN 250325-0416	24	29	50	4.00	25	0.04	GI137	—
XLCCN 250425-0516	24	29	50	5.00	25	0.03	GI138	—
XLCCN 250525-0616	24	29	50	6.00	25	0.04	GI139	—

GI136	LCM. 0316..
GI137	LCM. 0416..
GI138	LCM. 0516..
GI139	LCM. 0616..



Modulær verktøyholder for XLCCN, XLCF (NRL) eller XLXFL sporblad

Verktøyholder for montering av modulære sporblad fra XLC 25 BS, XLCF (NRL) BS, XLXFL BS aksialt sporblad. Tilgjengelig med skaftstørrelse 12x12 opp til 32x25 mm. Bbehandlet for lengre levetid.



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



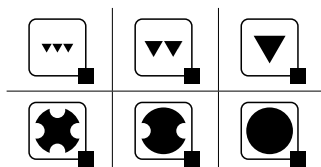
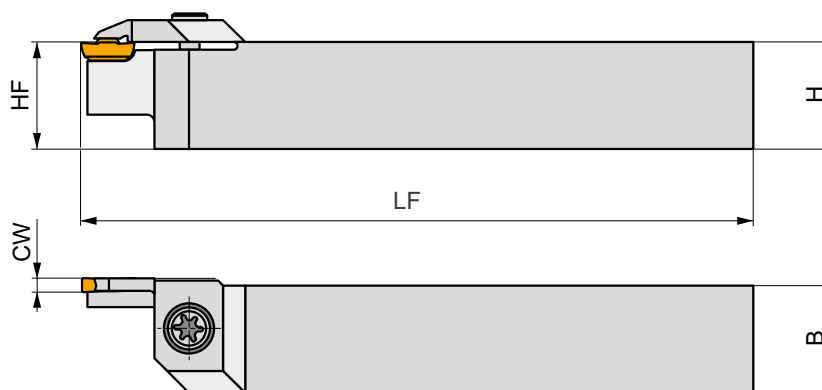
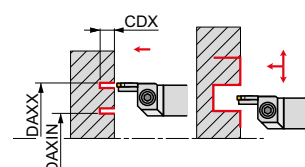
PRAMET

G



Utvendig aksialt V-spor topp klemming sporingsverktøy holder for LCM. 03 skjær

Utvendig venstre aksial verktøyholder for sporing med enkel eller dobbeltsidig LCM. 0313 eller 0316 skjær. Egnet for aksial sporing, aksial profilering eller sporutvidelse Ø17 opp til Ø170 mm applikasjoner med maksimal skjæredybde 9 mm. Fås med skaftstørrelse 25x25 mm. Behandlet for lengre levetid.



Product	HF	H	B	LF	CW	CDX	DAXIN	DAXX				
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)		(mm)				
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..

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



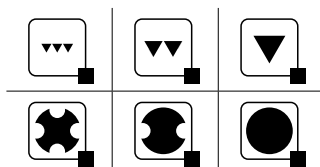
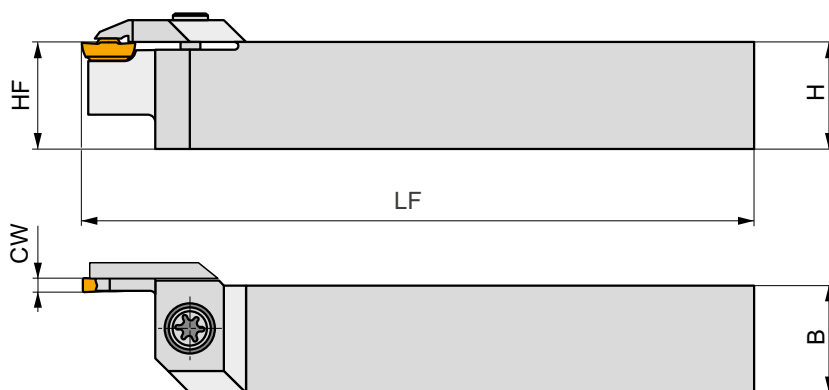
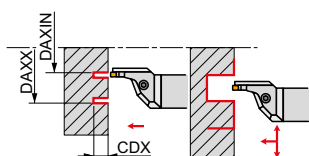
PRAMET

G



Utvendig aksialt V-spor Topp klemming springsverktøy holder for LCM. 03 eller 04 skjær

Utvendig venstre aksial verktøyholder for sporing med enkel eller dobbeltsidig LCM. 0313, 0316, 0413 eller 0416 skjær. Egnet for aksial sporing, aksial profilering eller sporutvidelse Ø17 opp til Ø230 mm applikasjoner, med maksimal skjæredybde 12 mm. Tilgjengelig med skaftstørrelse 25x25. Behandlet for lengre levetid.



Product	HF	H	B	LF	CW	CDX	DAXIN	DAXX				
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)		(mm)				
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
GI137
GI143
GI170

LCM. 0316..
LCM. 0416..
LCM. 0313..
LCM. 0413..



GL07
GL08

US 5018-T20P
US 6020-T25P

5.0
6.0

M 5
M 6

18.2
20.2

FLAG T20P
-

-
SDRT25P

GFIR-L AXIAL

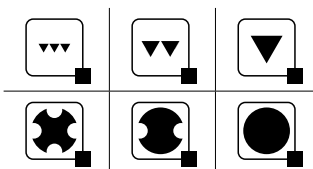
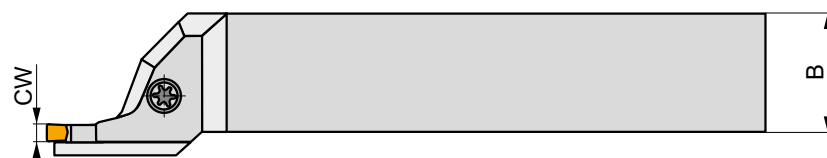
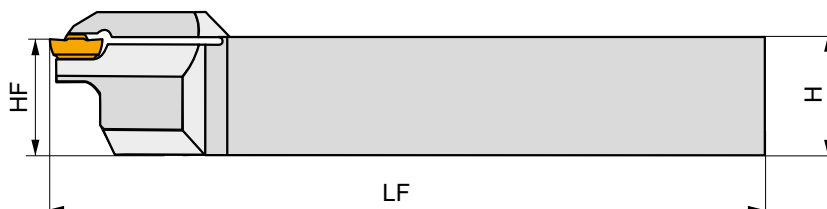
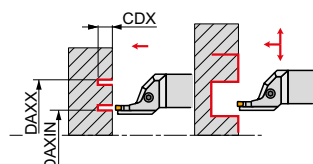


PRAMET

G

Utvendig aksialt V-Spor toppklemme dreieholder for LCM. 03 eller 04 skjær

Utvendig høyre aksial dreieholder for spor med enkel eller dobbeltsidig LCM. 0313, 0316, 0413 eller 0416 skjær. Passer for aksial sporing, aksial profilering eller sporvidde Ø17 opp til Ø230 mm applikasjoner, med maksimal kuttebybde 12 mm. Tilgjengelig med skafstørrelse 25x25 mm. Behandlet for lengre levetid.



Product	HF	H	B	LF	CW	CDX	DAXIN	DAXX	kg			
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)				
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..	

GL07	US 5018-T20P	5.0	M 5	18.2	FLAG T20P	—
GL08	US 6020-T25P	6.0	M 6	20.2	—	SDRT25P

GFIR-R AXIAL



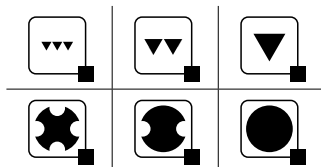
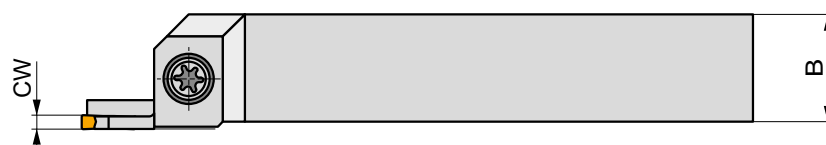
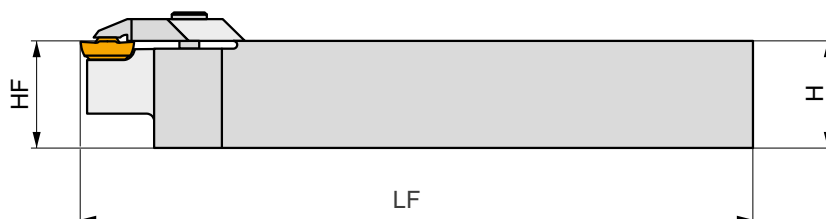
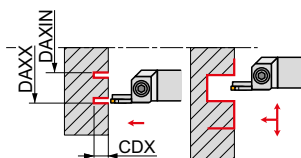
PRAMET

G



Utvendig aksialt V-Spor toppklemme dreieholder for LCM. 03 skjær

Utvendig høyre aksial dreieholder for spor med enkel eller dobbeltsidig LCM. 0313 eller 0316 skjær. Passer for aksial sporing, aksial profilering eller sporvidde Ø17 opp til Ø170 mm applikasjoner, med maksimal dybde 9 mm. Tilgjengelig med skafstørrelse 25x25 mm. Behandlet for lengre levetid.



Product		HF	H	B	LF	CW	CDX	DAXIN	DAXX			
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)			
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
GI143

LCM. 0316..
LCM. 0313..



GL02
GL07

US 5015-T20P
US 5018-T20P

5.0
5.0

M 5
M 5

15
18.2

FLAG T20P
FLAG T20P

GFML-L AXIAL



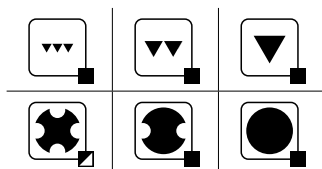
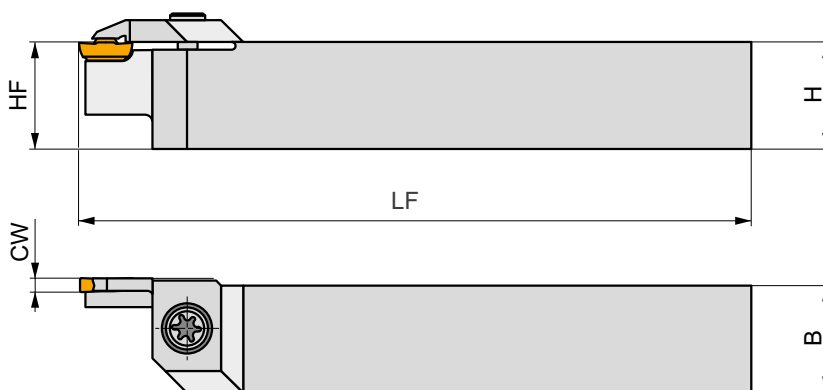
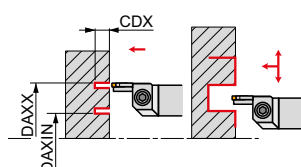
PRAMET

G



Utvedig aksialt V-spor topp klemming springsverktøy holder for LCM. 04 skjær

Utvendig venstre aksial verktøyholder for sporing med enkel eller dobbeltsidig LCM. 0413 eller 0416 skjær. Egnet for dyp aksial sporing, aksial profilering eller sporutvidelse Ø17 opp til Ø230 mm applikasjoner, med maksimal skjæredybde 20 mm. Fås med skaftstørrelse 25x25 mm. Behandlet for lengre levetid.



Product	HF	H	B	LF	CW	CDX	DAXIN	DAXX				
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)				
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											
GI170											

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



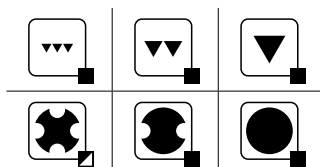
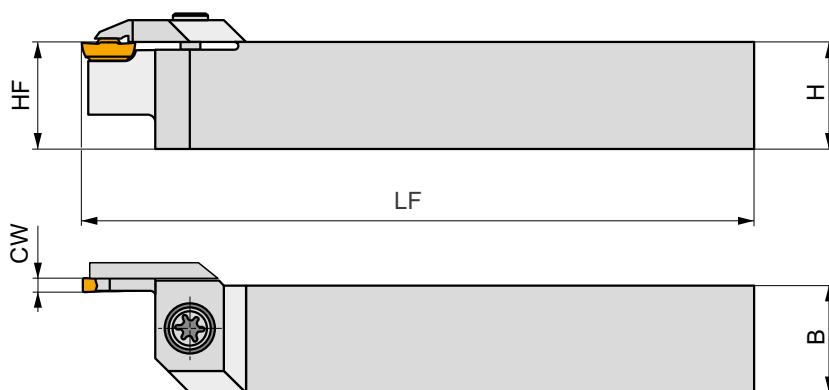
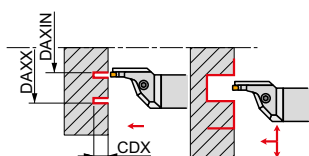
PRAMET

G



Utvendig aksialt V-spor topp klemming sporingsverktøy holder for LCM. 04 skjær.

Utvendig venstre aksial verktøyholder for sporing med enkel eller dobbeltsidig LCM. 0413 eller 0416 skjær. Egnet for dyp aksial sporing, aksial profilering eller sporutvidelse Ø17 opp til Ø230 mm applikasjoner, med maksimal skjæredybde 20 mm. Fås med skaftstørrelse 25x25 mm. Behandlet for lengre levetid.



Product	HF	H	B	LF	CW	CDX	DAXIN	DAXX				
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)				
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
GI170

LCM. 0416..
LCM. 0413..



GL07
GL08

US 5018-T20P
US 6020-T25P

5.0
6.0

M 5
M 6

18.2
20.2

FLAG T20P
-

-
SDRT25P

GFMR-L AXIAL



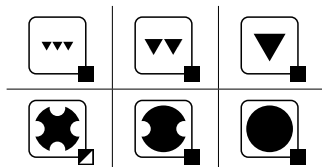
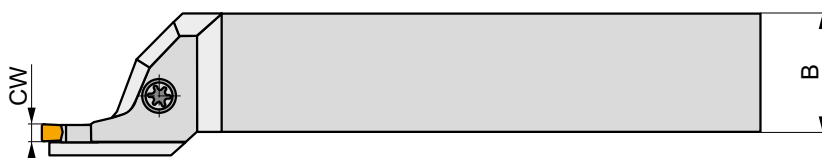
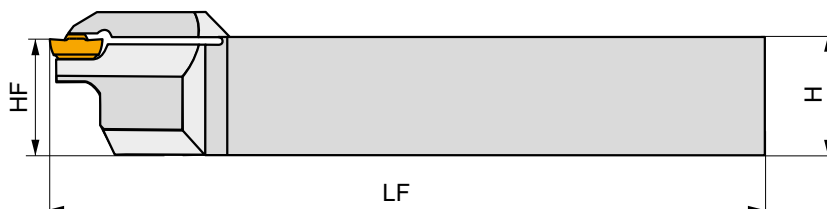
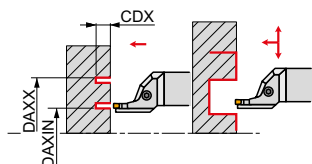
PRAMET

G



Utvendig aksialt V-Spor toppklemme dreieholder for LCM. 04 skjær

Utvendig høyre aksial dreieholder for spor med enkel eller dobbeltsidig LCM. 0413 eller 0416 skjær. Passer for dyp aksial sporing, aksial profilering eller sporvidde Ø17 opp til Ø230 mm applikasjoner, med maksimal kuttedybde 20 mm. Tilgjengelig med skaftstørrelse 25x25 mm. Behandlet for lengre levetid.



Product	HF	H	B	LF	CW	CDX	DAXIN	DAXX				
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)				
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											
GI170											

GL07		US 5018-T20P		5.0		M 5		18.2		FLAG T20P	
GL08		US 6020-T25P		6.0		M 6		20.2		—	

GFMR-R AXIAL



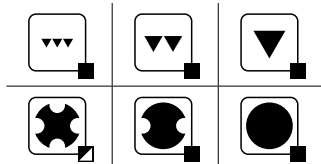
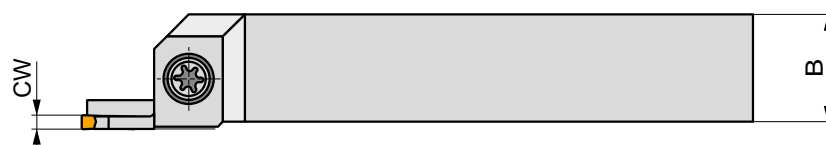
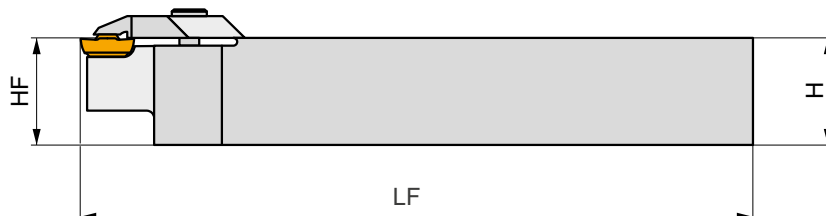
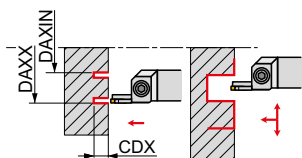
PRAMET

G



Utvendig aksial V-Spor toppklemme dreieholder for LCM. 04 skjær

Utvendig høyre aksial dreieholder for spor med enkel eller dobbeltsidig LCM. 0413 eller 0416 skjær. Passer for dyp aksial sporing, aksial profilering eller sporvidde Ø17 opp til Ø230 mm applikasjoner, med maksimal kuttedybde 20 mm. Tilgjengelig med skaftstørrelse 25x25 mm. Behandlet for lengre levetid.



Product	HF	H	B	LF	CW	CDX	DAXIN	DAXX				
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)				
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
GI170

LCM. 0416..
LCM. 0413..



GL02
GL07

US 5015-T20P
US 5018-T20P

5.0
5.0

M 5
M 5

15
18.2

FLAG T20P
FLAG T20P

GGI(RL)-90 AXIAL



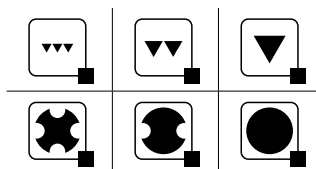
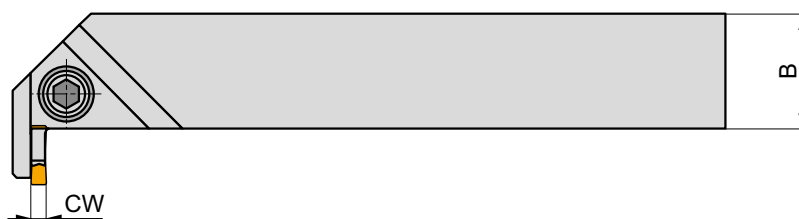
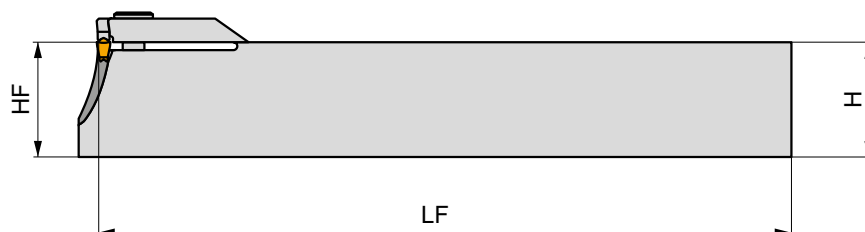
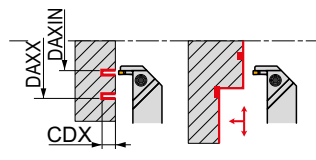
PRAMET

G



Utvendig aksialt 90° V-spore holder for LCM. 03 Skjær

Utvendig høyre / venstre aksial 90° dreieholder for sporing med enkel eller dobbeltsidig LCM. 0313 eller 0316 skjær. Egnet for aksial sporing, aksial profilering eller sporutvidelse Ø17 opp til Ø170 mm applikasjoner, med maksimal skjæredybde 11 mm. Fås med skafstørrelse 25x25 mm. Behandlet for lengre levetid.



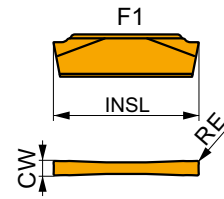
Product		HF	H	B	LF	CW	CDX	DAXIN	DAXX			
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)			
R	GGIR 2525 M 03R 030017	25	25	25	150	3.00	9.5	17	30	0.75	GI143	GL01
	GGIR 2525 M 03R 039024	25	25	25	150	3.00	9.5	24	39	0.78	GI143	GL01
	GGIR 2525 M 03R 050033	25	25	25	150	3.00	11	33	50	0.75	GI143	GL01
	GGIR 2525 M 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											
GI143											

GL01		HS 0520C		5.0		M 5		20		HXK 4	
GL04		HS 0620C		6.0		M 6		20		HXK 5	

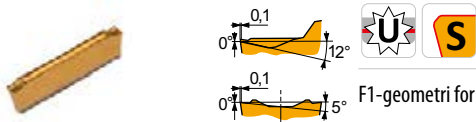
LCMF 20 - F1

	CW	CWTOLL	CWTOLU	INSL
(mm)	(mm)	(mm)	(mm)	(mm)
0220	2.00	-0.03	0.03	19.5



Egnethet og startverdier for skjærehastighet (vc) og mating (f). Se vår Machining Calculator-app for ytterligere 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)	(°)	(°)

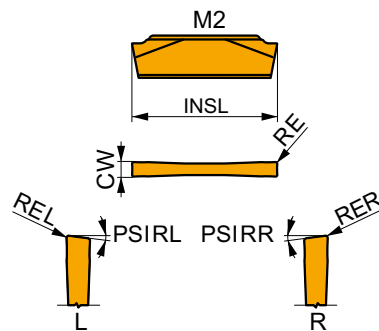


F1-geometri for avstikking og sporing, fin- og ferdig bearbeiding og kontinuerlige til lett avbrutte kutt.

LCMF 022002-F1	T8330	0.2	205	0.09	120	0.08	190	0.09	—	—	—	—	—	—	—
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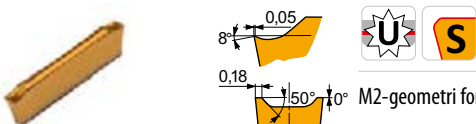
LCMF 20 - M2

	CW	CWTOLL	CWTOLU	INSL
(mm)	(mm)	(mm)	(mm)	(mm)
0220	2.00	-0.03	0.03	19.5



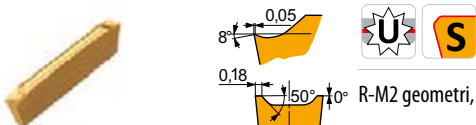
Egnethet og startverdier for skjærehastighet (vc) og mating (f). Se vår Machining Calculator-app for ytterligere beregninger.

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)	(°)	(°)



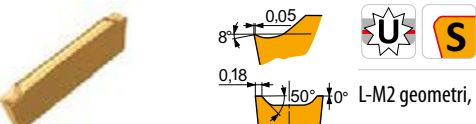
M2-geometri for avstikking og sporing, fin- og ferdig bearbeiding og kontinuerlige til lett avbrutte kutt.

LCMF 022002-M2	T8330	0.2	180	0.12	105	0.11	170	0.12	—	—	—	—	—	—	—
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R-M2 geometri, med høyrehendt design, for avstikk og kontinuerlige til lett avbrutte kutt.

LCMF 022002R6-M2	T8330	0.2	130	0.12	75	0.11	120	0.12	—	—	—	—	—	6	—
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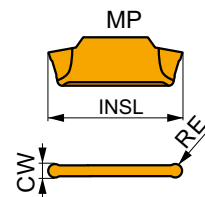
L-M2 geometri, med venstrehendt design, for avstikk og kontinuerlige til lett avbrutte kutt.

LCMF 022002L6-M2	T8330	0.2	130	0.12	75	0.11	120	0.12	—	—	—	—	—	—	6
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LCMF 20 - MP

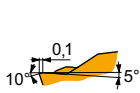


	CW	CWTOLL	CWTOLU	INSL
(mm)	(mm)	(mm)	(mm)	(mm)
0220	2.00	-0.03	0.03	19.5



Egnethet og startverdier for skjærehastighet (vc), mating (f) og skjæredybde (ap). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(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 for langsgående dreining, kopiprofilering, finbearbeiding, ferdig bearbeiding og kontinuerlig til avbrutt kutt.

LCMF 0220MO-MP	T8330	1.0	200	0.30	0.5	120	0.27	0.5	190	0.30	0.5	—	—	—	—	—	—	—	—	—
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GFK(RL) EXT



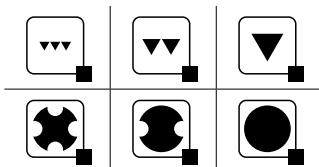
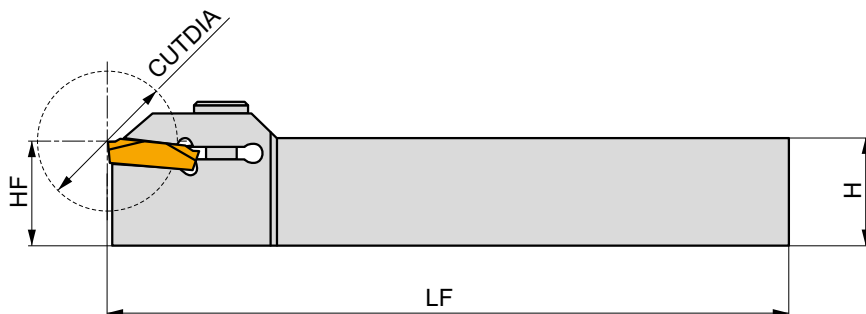
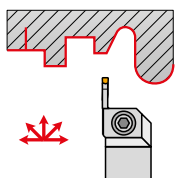
PRAMET

G



Utvendig V-Spor dreieholder for sporing og avstikking, LCMF 0220 skjær

Utvendig høyre / venstre hånd dreieholder for sporing med LCMF 0220 skjær. Egnet for avstikking, sporing og profilering på opptil 16 mm maksimal skjæredybde. Tilgjengelig med skaftstørrelse 16x16 opp til 25x25 mm. Behandlet for lengre levetid for verktøyet.



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



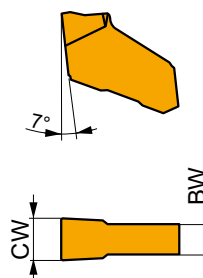
LCMF 0220..

		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

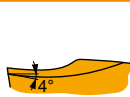


	CW	CWTOLL	CWTOLU	BW
(mm)	(mm)	(mm)	(mm)	(mm)
1.5	1.50	-0.03	0.03	1.30
1.6	1.60	-0.03	0.03	1.30
2.0	2.00	-0.03	0.03	1.60
3.1	3.10	-0.04	0.04	2.60
4.1	4.10	-0.04	0.04	3.60



Egnethet og startverdier for skjærehastighet (vc) og mating (f). Se vår Machining Calculator-app for ytterligere beregninger.

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



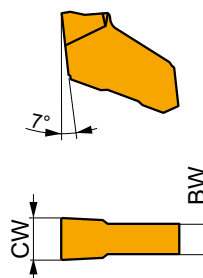
EN-F1 geometri for avstikking og sporing, og kontinuerlige kutt.

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

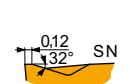


	CW	CWTOLL	CWTOLU	BW
(mm)	(mm)	(mm)	(mm)	(mm)
1.6	1.60	-0.03	0.03	1.30
2.0	2.00	-0.03	0.03	1.60
3.1	3.10	-0.04	0.04	2.60
4.1	4.10	-0.04	0.04	3.60
5.1	5.10	-0.04	0.04	4.60
6.35	6.35	-0.04	0.04	5.80



Egnethet og startverdier for skjærehastighet (vc) og mating (f). Se vår Machining Calculator-app for ytterligere beregninger.

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

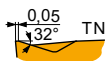


SN-F2 geometri for avstikking og sporing, og kontinuerlige kutt.

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	—	—	—	—

Egnethet og startverdier for skjærehastighet (vc) og mating (f). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	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)		



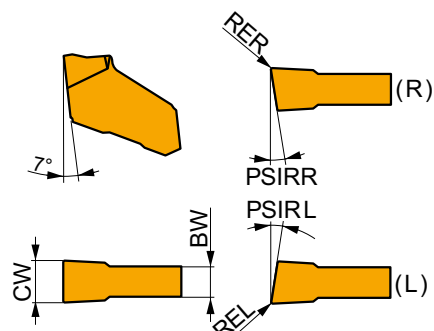
TN-F2 geometri for avstikking og spor, og kontinuerlige kutt.

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

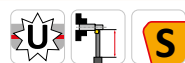
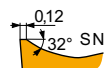
PRAMET

	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



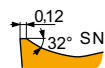
Egnethet og startverdier for skjærehastighet (vc) og mating (f). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	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 for avstikking og sporing, og kontinuerlige til lett avbrutte kutt.

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 høyrehendt design, for avstikk og kontinuerlige til lett avbrutte kutt.

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	—

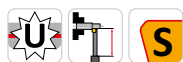
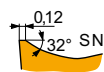
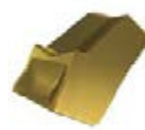


SL-M2 geometri, med venstrehendt design, for avstikk og kontinuerlige til lett avbrutte kutt.

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

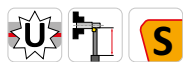
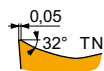
Egnethet og startverdier for skjærehastighet (vc) og mating (f). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE	P		M		K		N		S		H		PSIRR	PSIRL
			vc	f	vc	f	vc	f	vc	f	vc	f	vc	f		
			(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)												(°)	(°)	



SL-M2 geometri, med venstreendt design, for avstikk og kontinuerlige til lett avbrutte kutt.

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 for avstikking og sporing, og kontinuerlige til lett avbrutte kutt.

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

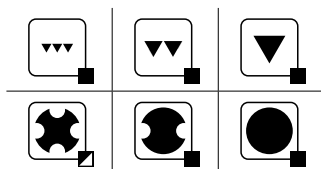
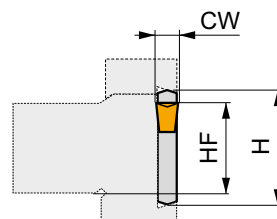
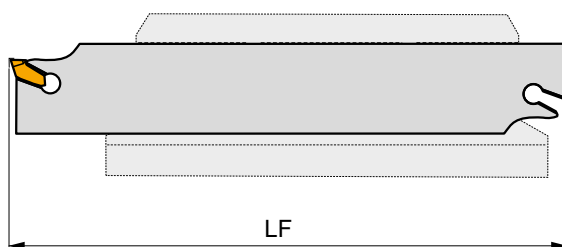
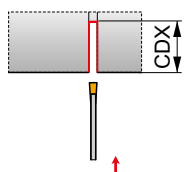


PRAMET



Dobbel-endet avstikkleblad for LFMX-skjær

Blad for avstikking applikasjoner opp til 80 mm maksimal dybde eller Ø160 mm stangmateriale. Passer til ensidige LFMX-skjær. Fås i høyder på 26, 32 eller 45 mm. Kan monteres i DU Pramet basisholdere. Blad behandlet for lengre levetid.



Product		HF	H	LF	CW	CDX			
		(mm)	(mm)	(mm)	(mm)	(mm)			
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

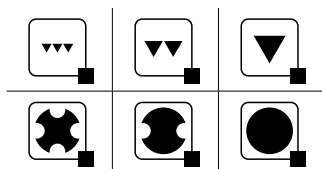
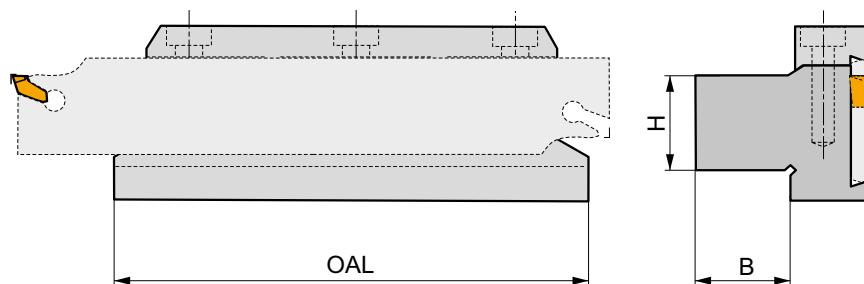
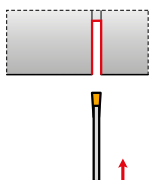
DU, D

PRAMET



Grunnholder for avstikkingsblad

Verktøyholder for GL eller XLC. blad for avstikking. Tilgjengelig med skaftstørrelse 20x20 opp til 40x40 mm. Behandlet for lengre levetid.



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..	-

ND2	HS 0625	6.0	M 6	25	HXX 5
ND3	HS 1030	8.0	M 10	30	HXX 8
ND7	HS 0630	6.0	M 6	30	HXX 5

XLCF(NRL) BS

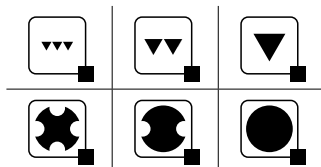
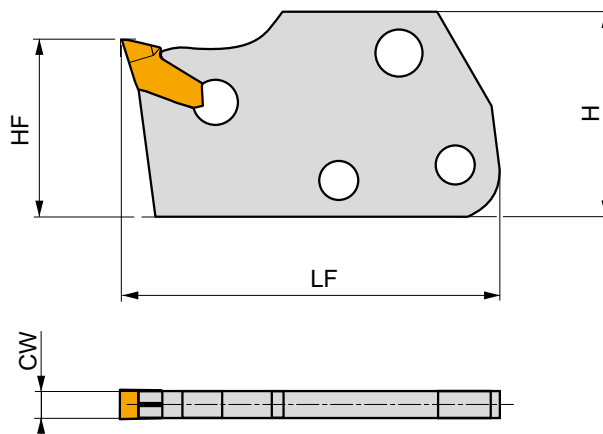
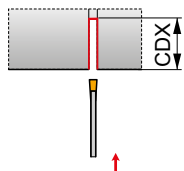


PRAMET



Radial sporblad for modulær MS-EN verktøyholder tilpasset LFMX skjær

Modulært sporblad for spordreining med ensidige LFMX-skjær. Passer for sporeller avstikking (maks. 25 mm skjæredybde). Blad behandlet for lengre levetid.



Product		⌀	H	L	CW	CDX	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)			
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



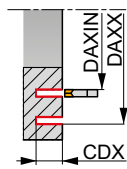
KV 5x70

XLXFL BS AXIAL



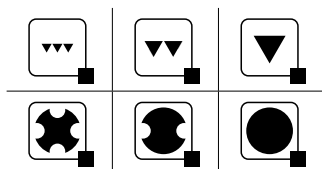
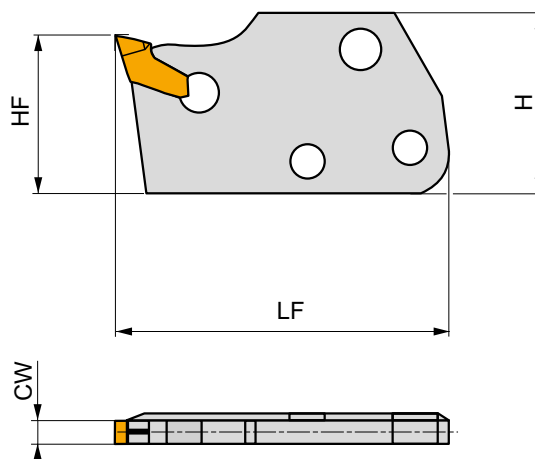
PRAMET

X



Aksialt sporblad for modulær MS-EN verktøyholder tilpasset LFMX-skjær

Modulært spordreingsblad tiplasset ensidige LFMX 3.1-skjær. Passer for applikasjoner med aksial spor (maks. 20 mm skjæredybde). Kan monteres på MS-EN dreieholder. Blad behandlet for lengre levetid.



Product	H	HF	LF	CW	CDX	DAXIN	DAXX	kg		
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)			
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

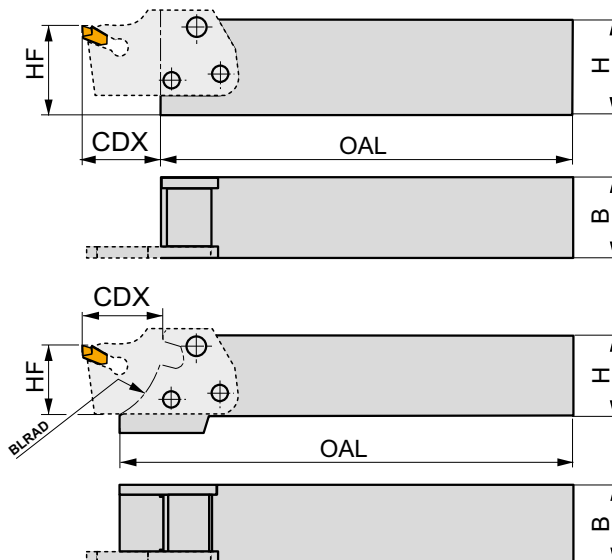
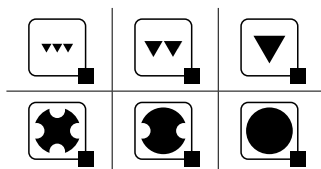
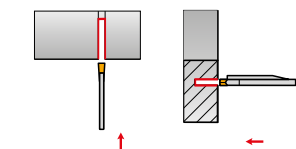


KV 5x70



Modulær verktøyholder for XLCCN, XLCF (NRL) eller XLXFL sporblad

Verktøyholder for montering av modulære sporblad fra XLC 25 BS, XLCF (NRL) BS, XLXFL BS aksialt sporblad. Tilgjengelig med skaftstørrelse 12x12 opp til 32x25 mm. Bbehandlet for lengre levetid.



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

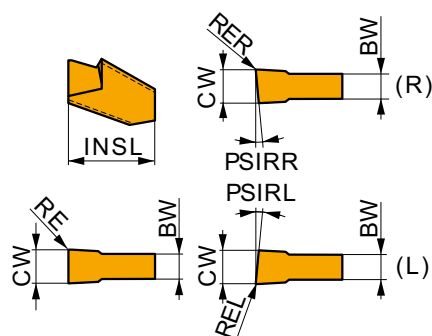
GI003	XLCC.. 25..15...	XLXFL 25...	XLCC.. 25..25...
GI006	XLCF. 16..15...	XLCF. 16..20...	—
GI060	XLCC.. 25..15...	XLCC.. 25..25...	—

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

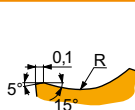
LFUX

	CW	BW	INSL
	(mm)	(mm)	(mm)
0308	3.00	2.51	11.5
0408	4.00	3.44	11.5
0508	5.00	4.30	11.5
0608	6.00	5.30	11.5



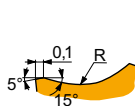
Egnethet og startverdier for skjærehastighet (vc) og mating (f). Se vår Machining Calculator-app for ytterligere beregninger.

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)	(°)	(°)



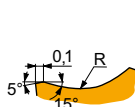
TN-geometri for avstikk og sporing, og kontinuerlige til lett avbrutte kutt.

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, høyrehendt, for avstikk og kontinuerlige til lett avbrutte kutt.

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	—



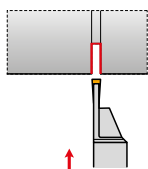
TL-geometri, venstrehendt, for avstikk og kontinuerlige til lett avbrutte kutt.

LFUX 030800TL	6640	0.2	150	0.10	—	—	140	0.10	—	—	—	—	—	5
	T8330	0.2	130	0.10	—	—	120	0.10	—	—	—	—	—	5

XLCF(RL)

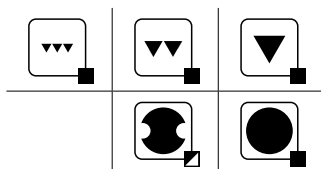
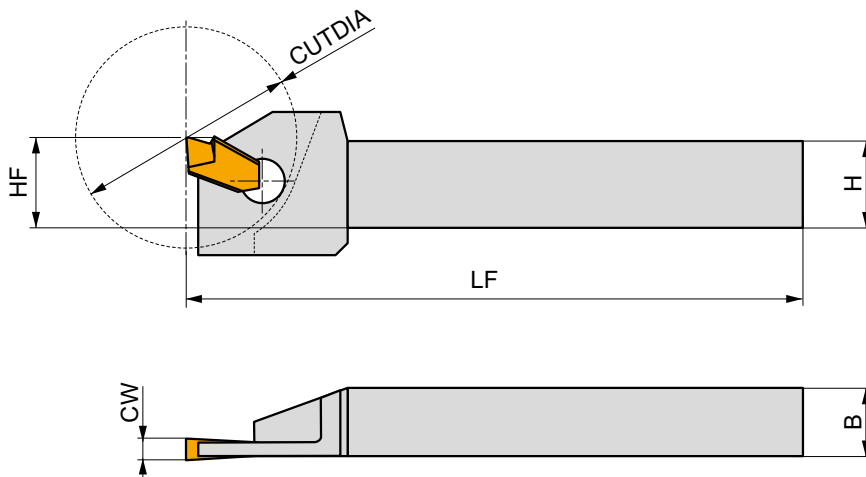


PRAMET



Utvendig spor- og avstikkingsblad for LFUX-skjær

Udtvendig høyre / venstre hånd radial dreieholder for sporing med ensidige LFUX 0308, 0408, 0508 eller 0608 skjær. Egnet for avstikking opp til maksimalt Ø65 mm. Tilgjengelig med skaftstørrelse 16x12 opp til 32x25 mm. Behandlet for lengre levetid.



Product		HF	H	B	LF	CW	CUTDIA	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)			
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
GI019
GI020
GI021

LFUX 0308..
LFUX 0408..
LFUX 0508..
LFUX 0608..



KV

KV 5x70

XLCFN B LFUX

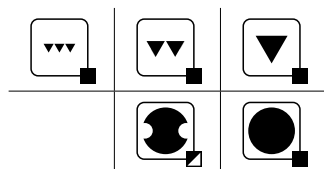
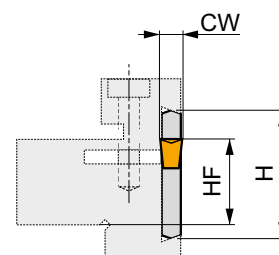
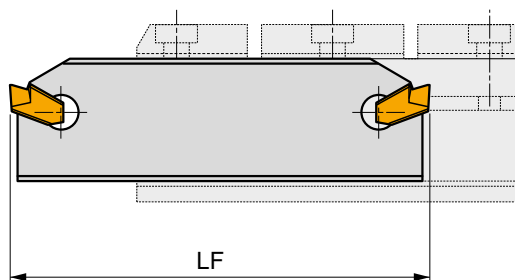
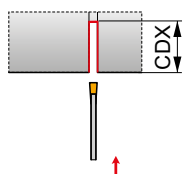


PRAMET

X

Dobbel-endet avstikkblad for LFUX-skjær

Blad for avstikking applikasjoner opp til 100 mm maksimal dybde eller Ø200 mm stangmateriale. Passer til ensidige LFUX-skjær. Fås i høyder på 26, 32 eller 47 mm. Kan monteres i DU, D Pramet basisholdere. Blad behandlet for lengre levetid.



Product	HF	H	LF	CW	CDX	kg		
	(mm)	(mm)	(mm)	(mm)	(mm)			
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

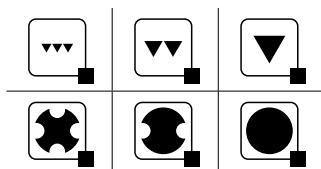
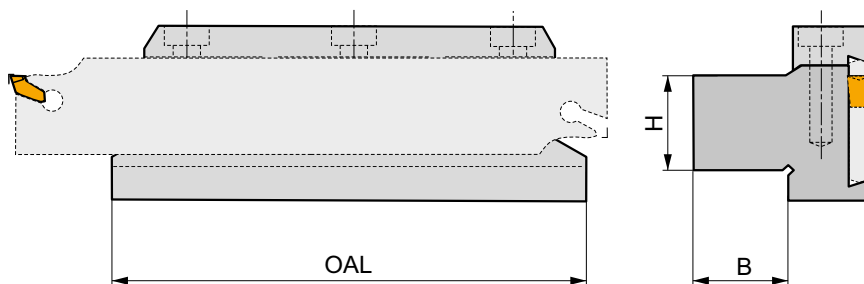
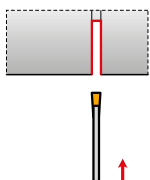
DU, D

PRAMET



Grunnholder for avstikkingsblad

Verktøyholder for GL eller XLC. blad for avstikking. Tilgjengelig med skaftstørrelse 20x20 opp til 40x40 mm. Behandlet for lengre levetid.



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..	-

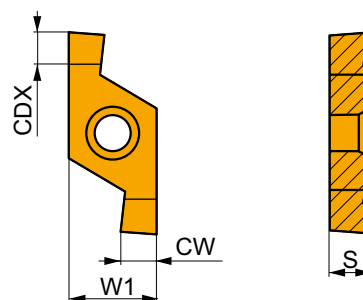
ND2	HS 0625	6.0	M 6	25	HXX 5
ND3	HS 1030	8.0	M 10	30	HXX 8
ND7	HS 0630	6.0	M 6	30	HXX 5

NEW

X 61

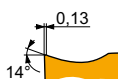
PRAMET

	W1	CWTOLL	CWTOLU	S
	(mm)	(mm)	(mm)	(mm)
0602	6.350	-0.03	0.03	2.33



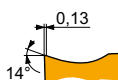
Egnethet og startverdier for skjærehastighet (vc) og mating (f). Se vår Machining Calculator-app for ytterligere beregninger.

Product	RE (mm)	P		M		K		N		S		H		CW (mm)	CDX (mm)
		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)		



X 61-R utvendig og innvendig, høyrehendt geometri, for bearbeiding av o-ring og låsespor, med kontinuerlige kutt.

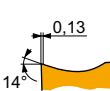
X61 0602-080 R	6640	—	■	195	0.06	■	115	0.05	■	185	0.06	—	—	0.85	0.8
	G8330	—	■	145	0.06	■	85	0.05	■	135	0.06	—	—	0.85	0.8
X61 0602-090 R	6640	—	■	195	0.06	■	115	0.05	■	185	0.06	—	—	0.95	0.8
	G8330	—	■	145	0.06	■	85	0.05	■	135	0.06	—	—	0.95	0.8
X61 0602-100 R	6640	—	■	195	0.06	■	115	0.05	■	185	0.06	—	—	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 utvendig og innvendig, venstrehendt geometri, for bearbeiding av o-ring og låsespor, med kontinuerlige kutt.

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

Egnethet og startverdier for skjærehastighet (vc) og mating (f). Se vår Machining Calculator-app for ytterligere beregninger.

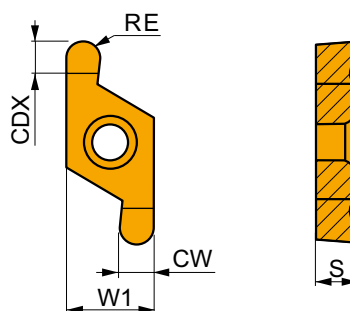
Product		RE (mm)	P		M		K		N		S		H		CW (mm)	CDX (mm)
			vc	f	vc	f	vc	f	vc	f	vc	f	vc	f		
			(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)		
		14°	X 61-L utvendig og innvendig, venstrehendt geometri, for bearbeiding av o-ring og låsespor, med kontinuerlige kutt.													
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

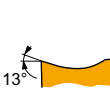
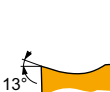
X 61 R

PRAMET

	W1 (mm)	CWTOLL (mm)	CWTOLU (mm)	S (mm)
0602	6.350	-0.03	0.03	2.33

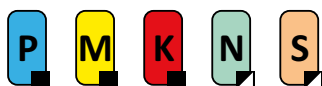


Egnethet og startverdier for skjærehastighet (vc) og mating (f). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	P		M		K		N		S		H		CW (mm)	CDX (mm)
			vc	f	vc	f	vc	f	vc	f	vc	f	vc	f		
			(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)		
		13°	X 61 R-R utvendig og innvendig, høyrehendt geometri, for bearbeiding av o-ring og låsespor, med kontinuerlige kutt.													
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
		13°	X 61 R-L utvendig og innvendig, venstrehendt geometri, for bearbeiding av o-ring og låsespor, med kontinuerlige kutt.													
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



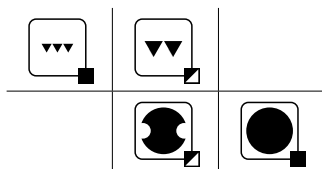
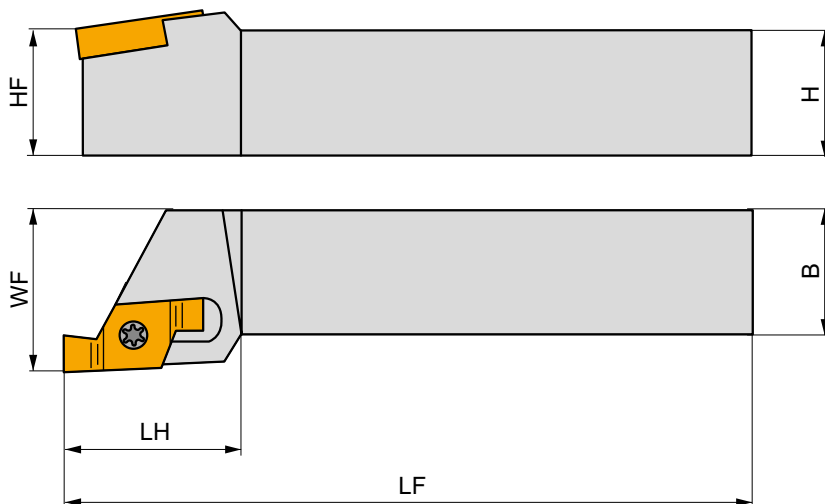
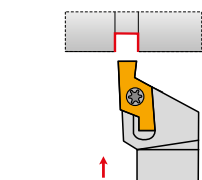
PRAMET

S



Utvendig dreieholder for sporing tilpasset X61 låseringer og O-ring skjær

Utvendig høyre / venstre hånd radial dreieholder for sporing med X61 dobbeltsidig låsering eller O-ringskjær. Gir jevn skjærehåndtering for høyt dimensjonerte tolanser. Tilgjengelig med skaftstørrelse 16x16 opp til 25x25 mm. Behandlet for lengre levetid for verktøyet.



	Product	HF	H	B	WF	LF	H	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)			
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..



SV11

US 2003-T07P

0.8

M 2.5

6.5

FLAGT07P

NEW

P61(RL) INT



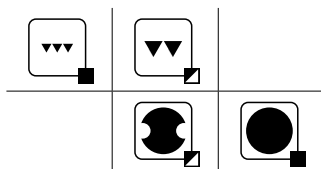
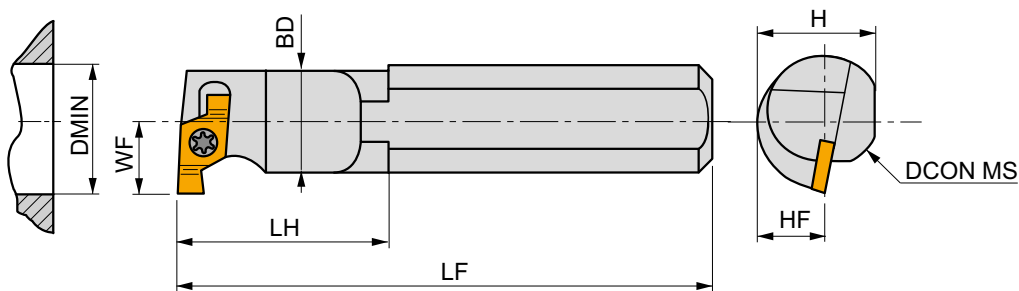
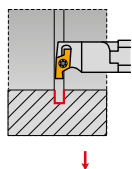
PRAMET

S



Innvendig segeringspor dreiebom for X61 skjær

Innvendig høyre/venstre hånd dreiebom for spordreining med X61 dobbeltsidige skjær. Minimum innvendig spordiameter Ø16 mm. Passer for innvendig dreining av segerring eller O-ringspor. Finnes med skaftstørrelse Ø12 opp til Ø32 mm. Behandlet for lengre levetid.



	Product	DCON MS	DMIN	BD	WF	H	LF	LH	KAPR		kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)				
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..



SV11



US 2003-T07P



0.8



M 2.5



6.5

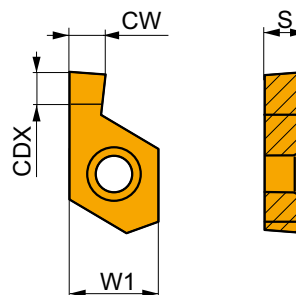


FLAG T07P

Venstre innsatsfeste til borestang til høyre.

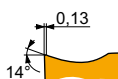
NEW**X 61-1****PRAMET**

	W1	CWTOLL	CWTOLU	S
(mm)	(mm)	(mm)	(mm)	(mm)
0602	6.350	-0.03	0.03	2.33



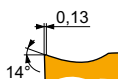
Egnethet og startverdier for skjærehastighet (vc) og mating (f). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	P		M		K		N		S		H		CW (mm)	CDX (mm)
			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)		



X 61-1-R innvendig, høyrehendt design, med en skjæregg for bearbeiding av o-ring og låsespor, med kontinuerlige kutt.

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

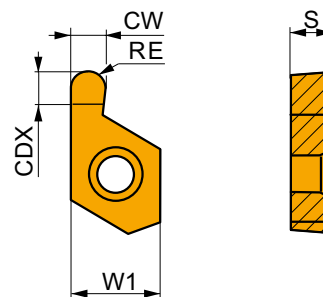


X 61-1-L innvendig, venstrehendt design, med en skjæregg for bearbeiding av o-ring og låsespor, med kontinuerlige kutt.

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

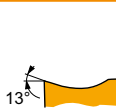
NEW**X 61 R-1****PRAMET**

	W1	CWTOLL	CWTOLU	S
(mm)	(mm)	(mm)	(mm)	(mm)
0602	6.350	-0.03	0.03	2.33



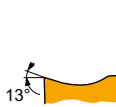
Egnethet og startverdier for skjærehastighet (vc) og mating (f). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE (mm)	P		M		K		N		S		H		CW (mm)	CDX (mm)
			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)		



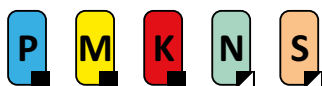
X 61 R-1-R innvendig, høyrehendt design, med en skjæregg for bearbeiding av o-ring og låsespor med kontinuerlige kutt.

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



X 61 R-1-L innvendig, venstrehendt design, med en skjæregg for bearbeiding av O-ring og låsespor, med kontinuerlige kutt.

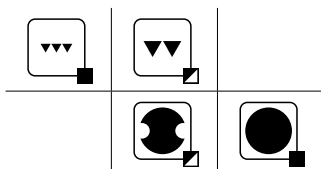
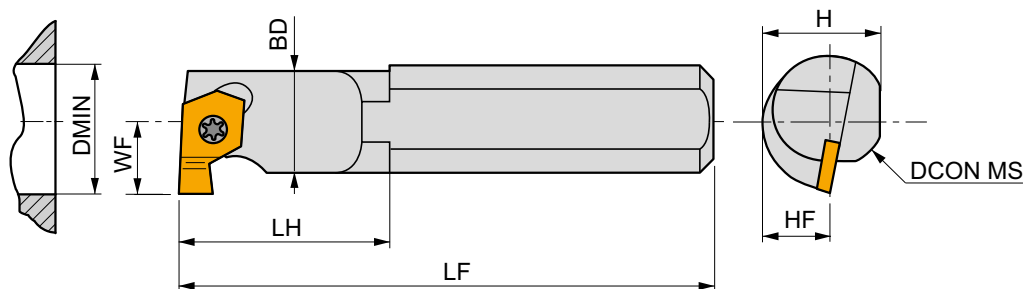
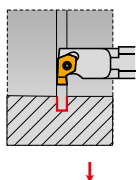
X61 0602-R050 L1	6640	0.5	■ 185	0.06	■ 110	0.05	■ 175	0.06	—	—	—	—	—	—	1.09	1.3
X61 0602-R100 L1	6640	1.0	■ 170	0.06	■ 100	0.05	■ 160	0.06	—	—	—	—	—	—	2.09	2.8

NEW**P61S(RL)-1 INT**

PRAMET

S**Innvendig segerringspor dreiebom for X61-1 skjær**

Innvendig høyre/venstre hånd dreiebom for spordreining med ensidige X61-1-skjær Minimum innvendig spordiameter Ø12,5 mm. Passer for innvendig dreining av segerring eller O-ringspor. Finnes med skaftstørrelse Ø10 og Ø12 mm. Behandlet for lengre levetid.



Product		D CON MS	D MIN	B D	W F	H	L F	L H	K A P R			
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)			
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



SV11

US 2003-T07P

0.8

M 2.5

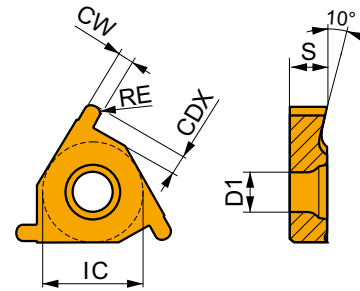
6.5

FLAG T07P

Venstre innsatsfeste til boretang til høyre.

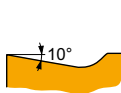
TN R EXT

	IC	D1	S	CWTOLL	CWTOLU
	(mm)	(mm)	(mm)	(mm)	(mm)
16	9.525	3.90	3.58	0.00	0.05
22	12.700	4.90	4.70	0.00	0.05



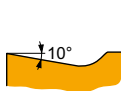
Egnethet og startverdier for skjærehastighet (vc) og mating (f). Se vår Machining Calculator-app for ytterligere beregninger.

Product	RE (mm)	P		M		K		N		S		H		CW (mm)	CDX (mm)
		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 ER-R utvendig, høyrehendt geometri, for bearbeiding av o-ring og låsespor, med kontinuerlige kutt.

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

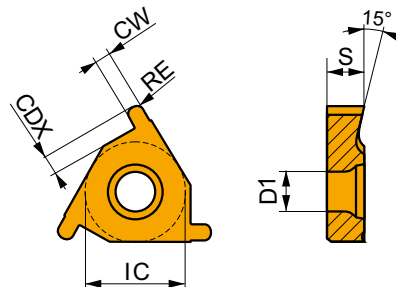


TN EL-R utvendig, venstrehendt geometri, for bearbeiding av o-ring og låsespor, med kontinuerlige kutt.

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

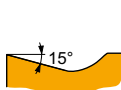
TN R INT

	IC	D1	S	CWTOLL	CWTOLU
	(mm)	(mm)	(mm)	(mm)	(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



Egnethet og startverdier for skjærehastighet (vc) og mating (f). Se vår Machining Calculator-app for ytterligere beregninger.

Product	RE (mm)	P		M		K		N		S		H		CW (mm)	CDX (mm)
		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)		

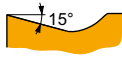


TN NR-R innvendig, høyrehendt geometri, for bearbeiding av o-ring og låsespor, med kontinuerlige kutt.

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

Egnethet og startverdier for skjærehastighet (vc) og mating (f). Se vår Machining Calculator-app for ytterligere beregninger.

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



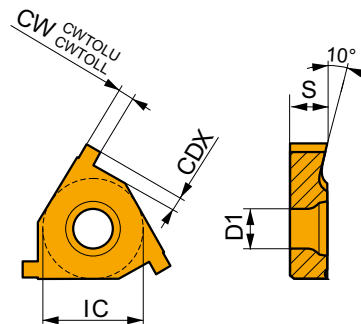
TN NL-R innvendig, venstrehendt sgeometri, for o-ring- og låsespor maskinering, med kontinuerlige kutt.

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

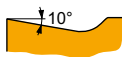
PRAMET

	IC (mm)	D1 (mm)	S (mm)
16	9.525	3.90	3.40
22	12.700	4.90	4.70



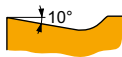
Egnethet og startverdier for skjærehastighet (vc) og mating (f). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE	P		M		K		N		S		H		CW	CWTOLL	CWTOLU	CDX
			vc	f	vc	f	vc	f	vc	f	vc	f	vc	f				
			(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)				



TN ER-ZZ utvendig, høyrehendt geometri, for bearbeiding av o-ring og låsespor, med kontinuerlige kutt.

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

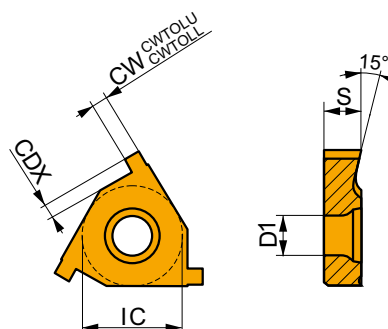


TN EL-ZZ utvendig, venstrehendt geometri, for o-ring og låsespor, med kontinuerlige kutt.

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

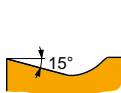
TN ZZ INT

	IC	D1	S
	(mm)	(mm)	(mm)
11	6.350	2.80	3.00
16	9.525	3.90	3.40
22	12.700	4.90	4.70



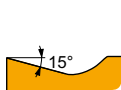
Egnethet og startverdier for skjærehastighet (vc) og mating (f). Se vår Machining Calculator-app for ytterligere beregninger.

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 NR-ZZ innvendig, høyrehendt geometri, for bearbeiding av o-ring og låsespor, med kontinuerlige kutt.

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 innvendig, venstrehendt geometri, for o-ring og låsespor bearbeiding, med kontinuerlige kutt.

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)

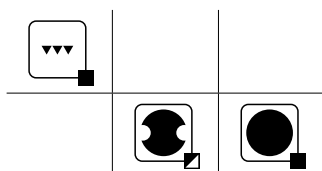
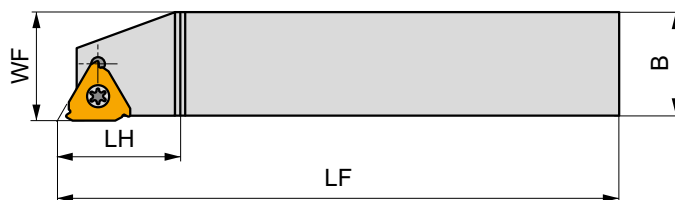
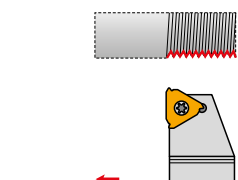


PRAMET

S

**Utvendig dreieholder for gjengeskjær tilpasset TN 16 eller 22 skjær**

Høyre/venstre hånd dreieholder for utvendig gjenging med TN16 eller 22 ER/EL skjær. Passer for gjenging i metrisk eller tommerprofil. Passer også til enkel sporing. Behandlet for lengre levetid.



Product	H	HF	B	WF	LF	H	LAMS		
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)		
R	SER 2020 K 16	20	20	20	125	22.5	—	GI068	Z12
	SER 2525 M 16	25	25	25	150	24	—	GI068	Z12
	SER 3225 P 16	32	32	25	170	24.5	—	GI068	Z12
	SER 2525 M 22-A	25	25	25	150	25.5	—	GI071	Z13
	SER 3225 P 22-A	32	32	25	170	25.5	—	GI071	Z13
L	SEL 2020 K 16	20	20	20	125	22.5	—	GI068	Z12
	SEL 2525 M 16	25	25	25	150	24	—	GI068	Z12
	SEL 3225 P 16	32	32	25	170	24.5	—	GI068	Z12
	SEL 2525 M 22-A	25	25	25	150	25.5	—	GI071	Z13
	SEL 3225 P 22-A	32	32	25	170	25.5	—	GI071	Z13

GI068									
GI071									

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)

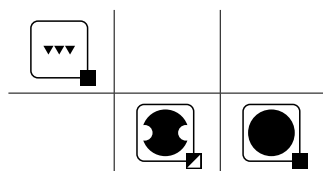
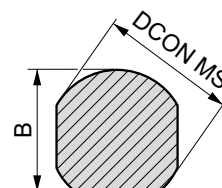
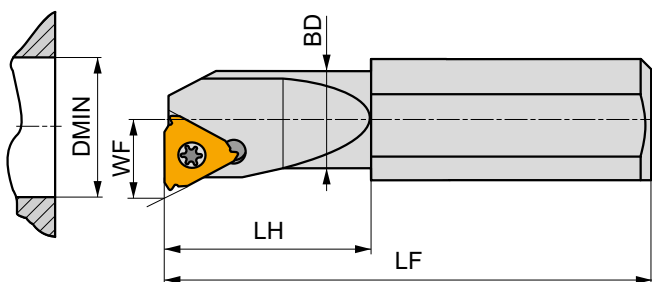
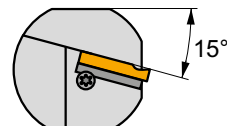
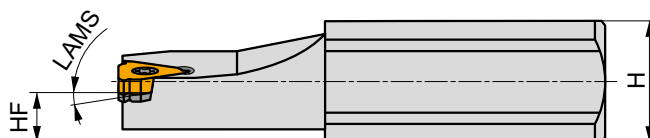
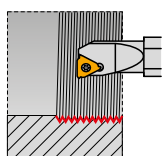


PRAMET

S

Innendig dreiebom for gjengeskjærtilpasset TN 11, 16 eller 22 skjær

Høyre/venstre hånd dreiebom for innendig gjenging med TN11, 16 eller 22 ER/EL skjær. Passer for gjenging i metrisk eller tommerprofil. Minimum innvendig diameter Ø13 mm. Passer også til enkel sporing. Finnes med skaftstørrelse Ø16 opp til Ø40 mm. Behandlet for lengre levetid.



	Product	B	DCON MS	DMIN	BD	WF	H	HF	LF	LH	LAMS			
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)			
R	SIR 0010 K 11-0	14.5	16	13	10	7.45	14	7	125	25	0	–	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
L	SIR 3240 T 22-A	38	40	48	40	25.85	32	16	300	–	–	–	GI076	Z13
	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..

		 Nm							
Z10	US 3510A-T15P	3.0	M 3.5	10.6	—	—	FLAG T15P	—	—
Z11	US 2506-T07P	0.9	M 2.5	6.3	—	—	FLAG T07P	—	—
Z12	US 3512A-T15P	3.0	M 3.5	12.7	—	HS 0304	FLAG T15P	HXK 2.5	 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							
SER16; SIL16	PE16+4.5	PE16+3.5	PE16+2.5	PE16+1.5	PE16+0.5	PE16-0.5	PE16-1.5	PE16ZZ
SEL16; SIR16	PI16+4.5	PI16+3.5	PI16+2.5	PI16+1.5	PI16+0.5	PI16-0.5	PI16-1.5	PI16ZZ
SER22; SIL22	PE22+4.5	PE22+3.5	PE22+2.5	PE22+1.5	PE22+0.5	PE22-0.5	PE22-1.5	PE22ZZ
SEL22; SIR22	PI22+4.5	PI22+3.5	PI22+2.5	PI22+1.5	PI22+0.5	PI22-0.5	PI22-1.5	PI22ZZ
SER-S22; SIL-S22	PE22S+4.5	PE22S+3.5	PE22S+2.5	PE22S+1.5	PE22S+0.5	PE22S-0.5	PE22S-1.5	-
SEL-S22; SIR-S22	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 $\lambda = 1.5^\circ$. A different helix angle can be selected by changing the anvil.
Shims for holders SER-S, SIR-S are marked with „S“

THREAD TURNING



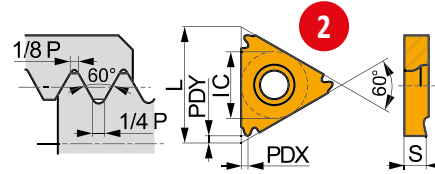
TURNING – GENERAL CONTENT

 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

1 TN M INT

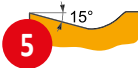
PRAMET

	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



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]
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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	—	40	—	0.50	—	0.8	0.8
TN 16NR075M	T8010	—	175	105	165	480	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

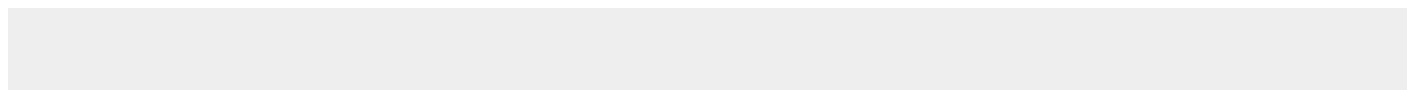
TN 16NR075M:T8010

Use full insert specification code when ordering!

Grade

Include colon

ISO insert code



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)

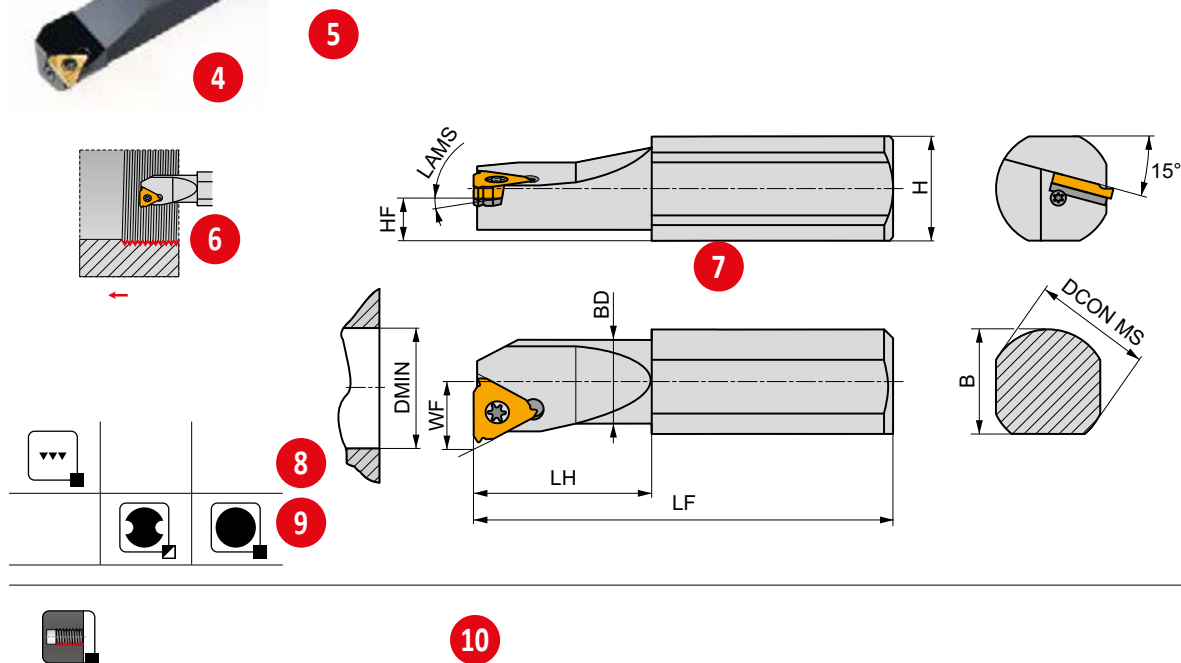
P M K N S H 2

PRAMET 3 S



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.



Product	B	DCON MS	DMIN	BD	WF	H	HF	LF	LH	LAMS			
	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[°]			
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
11 SIR 0013 12	14.5	16	16	13	9	14	7	150	32	1	14	15	16
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
R 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	HXX 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

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⁾ Dreieholder vises primært i sin høyre-design (R)

²⁾ GAMO = ortogonal rakevinkel (se teknisk del)

LAMS = hellingsvinkel til hovedkuttegg (se teknisk del)

³⁾ Kode til gruppe med kompatible skjær, reservedeler og spesialutstyr brukes kun i forbindelse med denne katalogen. Den kan ikke brukes for ordrer.

⁴⁾ Ikoner for reservedeler og spesialutstyr utformes skjematisk for forståelighet. De er ikke inkludert i listen over ikoner. Skruer blir, i noen tilfeller, fullført med info om tiltrekkingsmoment i Nm, lengde til skrue og størrelse til gjenger.

THREAD TURNING – ICONS OVERVIEW

GENERAL ICONS

	Primary use		Finishing – very good surface quality		Suitable for stable working conditions
	Possible use		Medium machining – good surface quality		Suitable for unstable working conditions
			Roughing – unlimited surface roughness		Suitable for very unstable working conditions

FEATURES

	Thread turning – external		Thread turning – internal
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COATING

	First choice		Universal wide range option		Sharp edge
	For tough materials (long chipping)		Rounded edge		

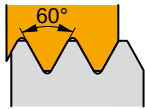
OTHER

	Clamping torque of screw (Nm)		Internal supply of coolant
--	-------------------------------	---	----------------------------

M

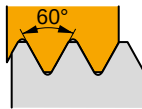
Full profile

TN M EXT **NEW**



495

TN M INT **NEW**

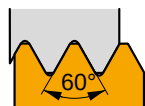


497

M

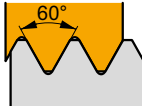
Partiell profil

TN 60° PP EXT



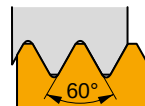
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TN 60° PP INT



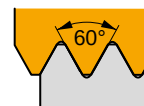
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TN 60°-S PP EXT



501

TN 60°-S PP INT

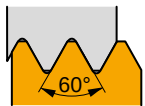


501

MJ

Full profile

TN MJ EXT **NEW**

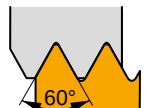


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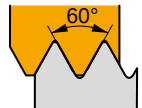
Full profile

TN UN EXT



502

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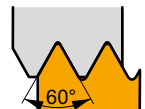


503

UNJ

Full profile

TN UNJ EXT **NEW**



504

W

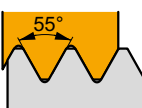
Full profile

TN W EXT



505

TN W INT

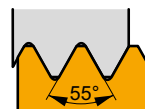


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W

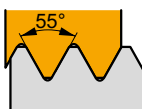
Partiell profil

TN 55° PP EXT



508

TN 55° PP INT

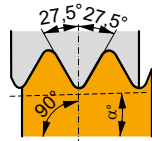


509

BSPT

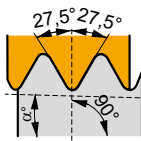
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TN BSPT EXT



510

TN BSPT INT

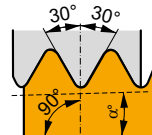


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NPT

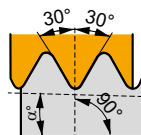
Full profile

TN NPT EXT



511

TN NPT INT

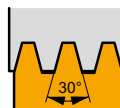


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TR

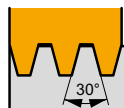
Full profile

TN TR EXT



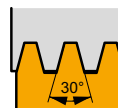
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TN TR INT



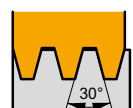
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TN TR-S EXT



514

TN TR-S INT



514

ACME

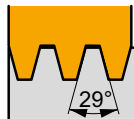
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TN ACME EXT



515

TN ACME INT

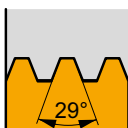


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STACME

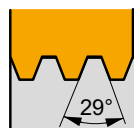
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TN STACME EXT **NEW**



517

TN STACME INT **NEW**

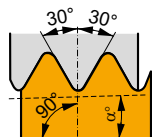


518

API RD

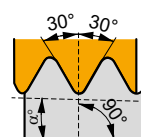
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TN API RD EXT



519

TN API RD INT

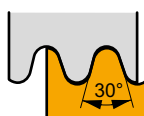


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RD

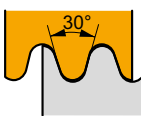
Full profile

TN RD EXT



520

TN RD INT



520

THREADING GRADES – NAVIGATOR

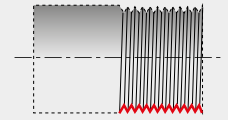
Grade Identification	Area of Application	Application	Feed	Cutting speed	Resistance to adverse Working Conditions	Coating	Colour	Substrate	Coolant benefit	Grade description
T8010	P05 - P15	■				PVD		submicron H	+ + +	This grade is suitable for continuous high precision thread turning of steels, stainless steel, cast iron and super alloys. Offering excellent wear resistance while ensuring operational reliability
	M05 - M15	■								
	K10 - K20	■								
	S10 - S15	■								
T8030	P25 - P40	■				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.
	M20 - M35	■								
	K20 - K40	■								
	N15 - N30	■								
	S15 - S25	■								
	H15 - H25	■								
HF7	M10 - M20	■				X		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.
	K10 - K25	■								
	N10 - N25	■								

Substrat

submicron H	WC-Co based substrate fine grained (< 1 µm)
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Coating

PVD	Low-temperature physical method of coating
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**SE(RL)-S**

		TN..
		22
	25x25 32x25	459 – 521

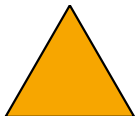
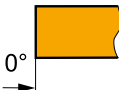
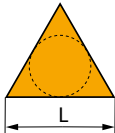
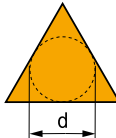
A schematic diagram of a bolted joint. A bolt is shown passing through a plate. A horizontal dashed line represents the shear plane, which is located at the bottom of the bolt's threaded section. The area below the shear plane is shaded with red diagonal lines, indicating the shear zone.

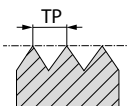
SI(RL)-S

	TN..  22
	 526

INDEXABLE CUTTING INSERTS FOR THREADING ISO – CODE DESIGNATION

ISO	1	2	3	4	5	6	7	8
	T	N	16	E	R	175	M	– P1
ANSI	1	2	3	4	5	6	7	8
	T	N	16	E	R	120	W	– P1

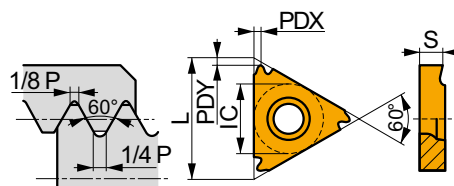
1		1		2		2		3		3		4		4	
Skjærform				Frivinkel for skjær				Skjærnatlengde (skjærstørrelse)				Ekstern - Intern			
T				N											
								L				d = IC			
								(mm)		(")		(mm)		(")	
								11		.433"		6,350		1/4"	
								16		.650"		9,525		3/8"	
22		.866"		12,7		1/2"									
												N			
												Intern			

5		5		6		7		7							
Retning til kutt				Gjengestigning		Gjengeprofil									
R	Høyre		s × 100	Gjengestigning mm × 100		M	Metrisk 60°	TR	TR 30° ISO 2901/3–1977						
L	Venstre										MJ	SEA MA1370	UN	Amerikansk UN 60° ISO 5864–1978	
N	Nøytral											W	Whitworth 55° ISO 228–1982	UNJ	SEA AS8879
									6						
									Ant. gjenger						
									No. gjenger per tomme × 10						

8	8
Sponbryter	
P1	Presset
AL	For nonferous

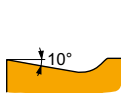
NEW**TN M EXT****PRAMET**

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47
22	12.700	22.00	4.71



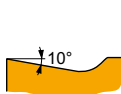
Egnethet og startverdier for skjærehastighet (vc). Se vår Machining Calculator-app for ytterligere beregninger.

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)
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TN M ER utvendig, høyrehendt design for bearbeiding av ISO-metriske gjenger og kontinuerlige kutt.

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

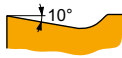


TN M EL utvendig, venstrehendt design, for bearbeiding av ISO-metriske gjenger og kontinuerlige kutt.

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

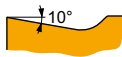
Egnethet og startverdier for skjærehastighet (vc). Se vår Machining Calculator-app for ytterligere beregninger.

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)
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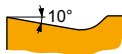
TN M EL utvendig, venstrehendt design, for bearbeiding av ISO-metriske gjenger og kontinuerlige kutt.

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 utvendig, høyrehendt design for bearbeiding av ISO-metriske gjenger og kontinuerlige kutt.

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 utvendig, høyrehendt design, for bearbeiding av ISO-metriske gjenger og kontinuerlige kutt.

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

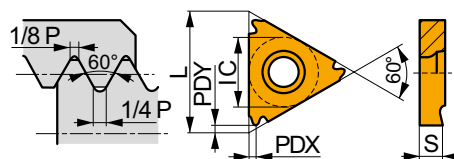
¹⁾ Toolholders have to be modified.

NEW

TN M INT

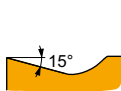
PRAMET

	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



Egnethet og startverdier for skjærehastighet (vc). Se vår Machining Calculator-app for ytterligere 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)
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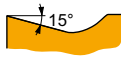


TN M NR innvendig, høyrehendt design, for bearbeiding av ISO-metriske gjenger og kontinuerlige kutt.

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

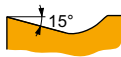
Egnethet og startverdier for skjærehastighet (vc). Se vår Machining Calculator-app for ytterligere beregninger.

Product	RE	P	M	K	N	S	H	TP	TPI	PDX	PDY
		VC (m/min)	VC (m/min)	VC (m/min)	VC (m/min)	VC (m/min)	VC (m/min)	(mm)		(mm)	(mm)



TN M NL innvendig, venstrehendt design, for bearbeiding av ISO-metriske gjenger og kontinuerlige kutt.

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 presset innvendig, høyrehendt design for bearbeiding av ISO-metriske gjenger og kontinuerlige kutt.

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



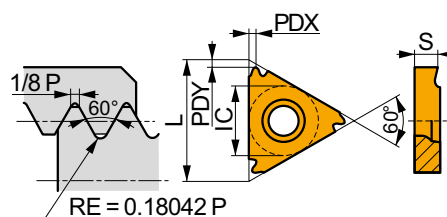
TN M-AL NR innvendig, høyrehendt design, for bearbeiding av ISO-metriske gjenger og kontinuerlige kutt.

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.

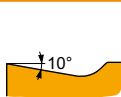
NEW**TN MJ EXT****PRAMET**

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47



Egnethet og startverdier for skjærehastighet (vc). Se vår Machining Calculator-app for ytterligere 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)
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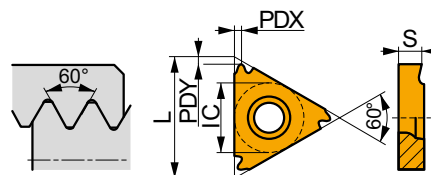


TN MJ ER utvendig, høyrehendt design for bearbeiding av metriske "J-form"-gjenger og kontinuerlige kutt.

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

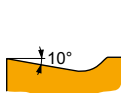
TN 60° PP EXT**PRAMET**

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47
22	12.700	22.00	4.71



Egnethet og startverdier for skjærehastighet (vc). Se vår Machining Calculator-app for ytterligere 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)
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TN M60 PP ER utvendig, høyrehendt design, for bearbeiding av metriske og UN gjenger og kontinuerlige kutt.

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

Egnethet og startverdier for skjærehastighet (vc). Se vår Machining Calculator-app for ytterligere beregninger.

Product	RE	P	M	K	N	S	H	TPN	TPX	TPIN	TPIX	PDX	PDY
	(mm)	VC (m/min)	VC (m/min)	VC (m/min)	VC (m/min)	VC (m/min)	VC (m/min)	(mm)	(mm)			(mm)	(mm)



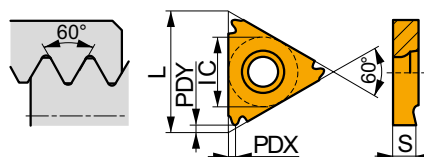
TN M60 PP EL utvendig, venstrehendt design, for bearbeiding av metriske og UN gjenger, og kontinuerlige kutt.

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 60° PP INT

PRAMET

	IC	L	S
	(mm)	(mm)	(mm)
11	6.350	11.00	3.00
16	9.525	16.50	3.47
22	12.700	22.00	4.71



Egnethet og startverdier for skjærehastighet (vc). Se vår Machining Calculator-app for ytterligere beregninger.

Product	RE	P	M	K	N	S	H	TPN	TPX	TPIN	TPIX	PDX	PDY
	(mm)	VC (m/min)	VC (m/min)	VC (m/min)	VC (m/min)	VC (m/min)	VC (m/min)	(mm)	(mm)			(mm)	(mm)



TN M60 PP NR innvendig, høyrehendt design, for bearbeiding av metriske og UN gjenger, og kontinuerlige kutt.

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



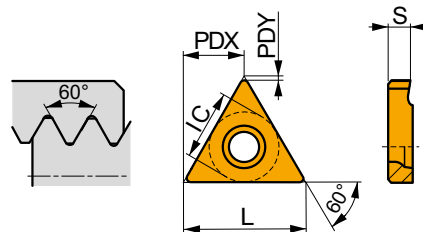
TN M60 PP NL innvendig, venstrehendt design, for bearbeiding av metriske og UN, og kontinuerlige kutt.

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 60°-S PP EXT

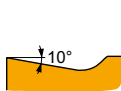
PRAMET

	IC (mm)	L (mm)	S (mm)
22	12.700	22.00	4.60



Egnethet og startverdier for skjærehastighet (vc). Se vår Machining Calculator-app for ytterligere 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 (mm)	TPIX (mm)	PDX (mm)	PDY (mm)
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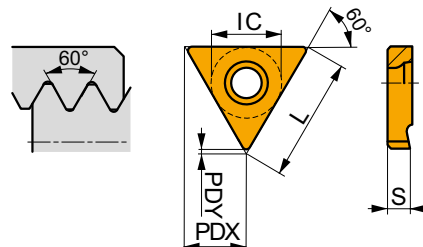
TN M60-S PP EN utvendig, venstre og høyrehendt design for bearbeiding av metriske og UN gjenger og kontinuerlige kutt.

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

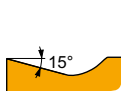
PRAMET

	IC (mm)	L (mm)	S (mm)
22	12.700	22.00	4.60



Egnethet og startverdier for skjærehastighet (vc). Se vår Machining Calculator-app for ytterligere 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 (mm)	TPIX (mm)	PDX (mm)	PDY (mm)
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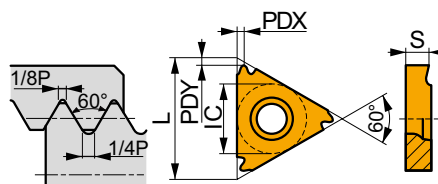
TN M60-S PP NN innvendig, venstre og høyrehendt design for bearbeiding av metriske og UN gjenger og kontinuerlige kutt.

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

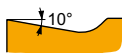
PRAMET

	IC	L	S
	(mm)	(mm)	(mm)
16	9.525	16.50	3.47
22	12.700	22.00	4.71



Egnethet og startverdier for skjærehastighet (vc). Se vår Machining Calculator-app for ytterligere beregninger.

Product	RE	P	M	K	N	S	H	TP	TPI	PDX	PDY
	(mm)	vc (m/min)	vc (m/min)	vc (m/min)	vc (m/min)	vc (m/min)	vc (m/min)	(mm)		(mm)	(mm)



TN UN ER utvendig, høyrehendt design, for bearbeiding av UN gjenger og kontinuerlige kutt.

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

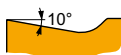


TN UN EL utvendig, venstrehendt design, for bearbeiding av UN gjenger og kontinuerlige kutt.

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

Egnethet og startverdier for skjærehastighet (vc). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE	P	M	K	N	S	H	TP	TPI	PDX	PDY
		(mm)	vc (m/min)	vc (m/min)	vc (m/min)	vc (m/min)	vc (m/min)	vc (m/min)	(mm)		(mm)	(mm)



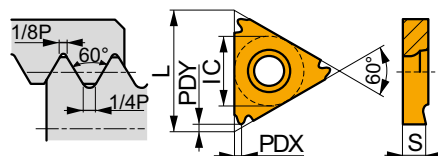
TN UN-P1 ER presset utvendig, høyrehendt design for bearbeiding av UN gjenger og kontinuerlige kutt.

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	L	S
	(mm)	(mm)	(mm)
16	9.525	16.50	3.47
22	12.700	22.00	4.71



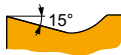
Egnethet og startverdier for skjærehastighet (vc). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE	P	M	K	N	S	H	TP	TPI	PDX	PDY
		(mm)	vc (m/min)	vc (m/min)	vc (m/min)	vc (m/min)	vc (m/min)	vc (m/min)	(mm)		(mm)	(mm)



TN UN NR innvendig, høyrehendt design, for bearbeiding av UN gjenger og kontinuerlige kutt.

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 innvendig, venstrehendt design, for bearbeiding av UN gjenger og kontinuerlige kutt.

TN 16NL320UN	T8030	—	■	160	■	95	■	150	■	480	■	40	—	—	32.0	0.8	0.8
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Egnethet og startverdier for skjærehastighet (vc). Se vår Machining Calculator-app for ytterligere 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)
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TN UN NL innvendig, venstrehendt design, for bearbeiding av UN gjenger og kontinuerlige kutt.

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 presset innvendig, høyrehendt design for bearbeiding av UN gjenger og kontinuerlige kutt.

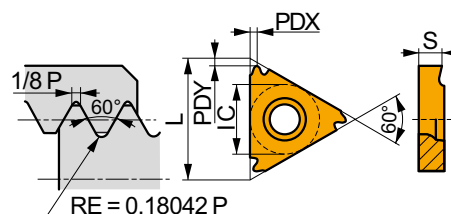
TN 16NR200UN-P1	T8030	—	■	160	■	95	■	150	■	480	■	40	—	—	20.0	0.8	0.8
TN 16NR180UN-P1	T8030	—	■	160	■	95	■	150	■	480	■	40	—	—	18.0	0.8	0.8
TN 16NR160UN-P1	T8030	—	■	160	■	95	■	150	■	480	■	40	—	—	16.0	0.8	0.8
TN 16NR140UN-P1	T8030	—	■	160	■	95	■	150	■	480	■	40	—	—	14.0	1.5	1.2
TN 16NR120UN-P1	T8030	—	■	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

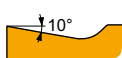
PRAMET

	IC	L	S
	(mm)	(mm)	(mm)
16	9 525	16 50	3 47



Egnethet og startverdier for skjærehastighet (vc). Se vår Machining Calculator-app for ytterligere 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)
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TN UNJ ER utvendig, høyrehendt design, for bearbeiding av UN "J-form" -gjenger og kontinuerlige kutt.

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

Egnethet og startverdier for skjærehastighet (vc). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE	P	M	K	N	S	H	TP	TPI	PDX	PDY
		(mm)	vc (m/min)	vc (m/min)	vc (m/min)	vc (m/min)	vc (m/min)	vc (m/min)	(mm)		(mm)	(mm)



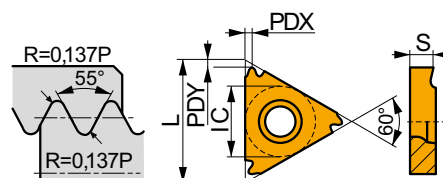
TN UNJ EL utvendig, venstrehendt design, for bearbeiding av UN "J-form" -gjenger og kontinuerlige kutt.

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

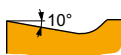
PRAMET

	IC	L	S
	(mm)	(mm)	(mm)
16	9.525	16.50	3.47
22	12.700	22.00	4.71



Egnethet og startverdier for skjærehastighet (vc). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE	P	M	K	N	S	H	TP	TPI	PDX	PDY
		(mm)	vc (m/min)	vc (m/min)	vc (m/min)	vc (m/min)	vc (m/min)	vc (m/min)	(mm)		(mm)	(mm)

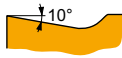


TN W ER utvendig, høyrehendt design for bearbeiding av Whitworth-gjenger og kontinuerlige kutt.

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

Egnethet og startverdier for skjærehastighet (vc). Se vår Machining Calculator-app for ytterligere 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)
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TN W EL utvendig, venstrehendt design, for bearbeiding av Whitworth-gjenger og kontinuerlige kutt.

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



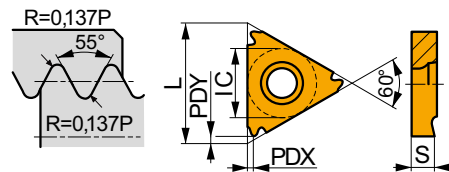
TN W-P1 ER presset utvendig, høyrehendt design for bearbeiding av Whitworth-gjenger og kontinuerlige kutt.

TN 16ER190W-P1	T8030	—	■	160	■	95	■	150	■	480	■	40	—	—	19.0	0.8	0.8
TN 16ER140W-P1	T8030	—	■	160	■	95	■	150	■	480	■	40	—	—	14.0	1.5	1.2
TN 16ER110W-P1	T8030	—	■	160	■	95	■	150	■	480	■	40	—	—	11.0	1.5	1.2

TN W INT

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



Egnethet og startverdier for skjærehastighet (vc). Se vår Machining Calculator-app for ytterligere 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)
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TN W NR innvendig, høyrehendt design, for bearbeiding av Whitworth-gjenger og kontinuerlige kutt.

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

Egnethet og startverdier for skjærehastighet (vc). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE	P		M		K		N		S		H		TP	TPI	PDX	PDY
			VC	VC	VC	VC	VC	VC	VC									
			(mm)	(m/min)	(m/min)	(m/min)	(m/min)	(m/min)	(m/min)	(m/min)								



TN W NR innvendig, høyrehendt design, for bearbeiding av Whitworth-gjenger og kontinuerlige kutt.

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 innvendig, venstrehendt design, for bearbeiding av Whitworth-gjenger og kontinuerlige kutt.

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



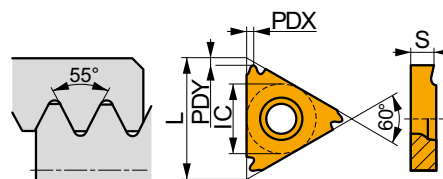
TN W-P1 NR presset innvendig, høyrehendt design for bearbeiding av Whitworth-gjenger og kontinuerlige kutt.

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

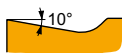


	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47
22	12.700	22.00	4.71



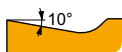
Egnethet og startverdier for skjærehastighet (vc). Se vår Machining Calculator-app for ytterligere beregninger.

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)
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TN W55 PP ER utvendig, høyrehendt design, for bearbeiding av Whitworth-gjenger og kontinuerlige kutt.

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

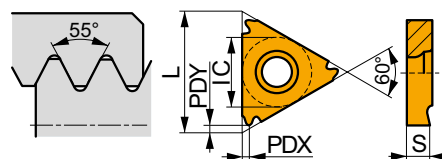


TN W55 PP EL utvendig, venstrehendt design, for bearbeiding av Whitworth-gjenger og kontinuerlige kutt.

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

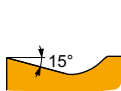
TN 55° PP INT

	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



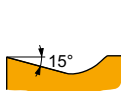
Egnethet og startverdier for skjærehastighet (vc). Se vår Machining Calculator-app for ytterligere beregninger.

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 (mm)	TPIX (mm)	PDX (mm)	PDY (mm)
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TN W55 PP NR innvendig, høyrehendt design, for bearbeiding av Whitworth-gjenger og kontinuerlige kutt.

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



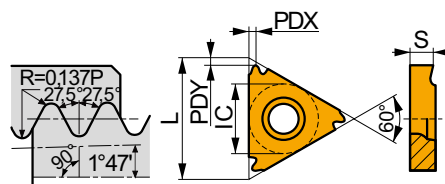
TN W55 PP NL innvendig, venstrehendt design, for bearbeiding av Whitworth-gjenger og kontinuerlige kutt.

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

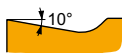


	IC	L	S
	(mm)	(mm)	(mm)
16	9.525	16.50	3.47



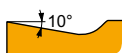
Egnethet og startverdier for skjærehastighet (vc). Se vår Machining Calculator-app for ytterligere beregninger.

Product	RE	P	M	K	N	S	H	TP	TPI	PDX	PDY
	(mm)	VC (m/min)	VC (m/min)	VC (m/min)	VC (m/min)	VC (m/min)	VC (m/min)	(mm)		(mm)	(mm)



TN BSPT ER utvendig, høyrehendt design, for bearbeiding av BSPT-gjenger og kontinuerlige kutt.

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



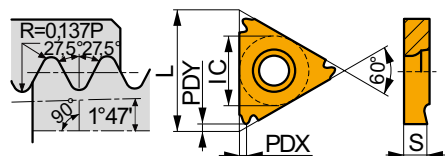
TN BSPT EL utvendig, venstrehendt design, for bearbeiding av BSPT-gjenger og kontinuerlige kutt.

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



	IC	L	S
	(mm)	(mm)	(mm)
16	9.525	16.50	3.47



Egnethet og startverdier for skjærehastighet (vc). Se vår Machining Calculator-app for ytterligere beregninger.

Product	RE	P	M	K	N	S	H	TP	TPI	PDX	PDY
	(mm)	VC (m/min)	VC (m/min)	VC (m/min)	VC (m/min)	VC (m/min)	VC (m/min)	(mm)		(mm)	(mm)



TN BSPT NR innvendig, høyrehendt design, for bearbeiding av BSPT-gjenger og kontinuerlige kutt.

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

Egnethet og startverdier for skjærehastighet (vc). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE	P	M	K	N	S	H	TP	TPI	PDX	PDY
		(mm)	vc (m/min)	vc (m/min)	vc (m/min)	vc (m/min)	vc (m/min)	vc (m/min)	(mm)		(mm)	(mm)



TN BSPT NR innvendig, høyrehendt design, for bearbeiding av BSPT-gjenger og kontinuerlige kutt.

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



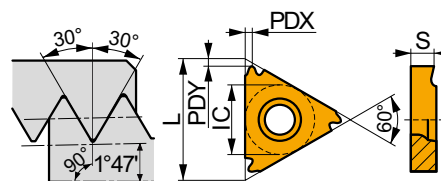
TN BSPT NL innvendig, venstrehandt design, for bearbeiding av BSPT-gjenger og kontinuerlige kutt.

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



	IC	L	S
	(mm)	(mm)	(mm)
16	9.525	16.50	3.47



Egnethet og startverdier for skjærehastighet (vc). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE	P	M	K	N	S	H	TP	TPI	PDX	PDY
		(mm)	vc (m/min)	vc (m/min)	vc (m/min)	vc (m/min)	vc (m/min)	vc (m/min)	(mm)		(mm)	(mm)



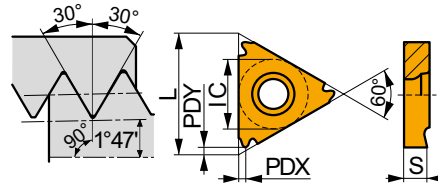
TN NPT ER utvendig, høyrehendt design, for maskinering av NPT-gjenger og kontinuerlige kutt.

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



Egnethet og startverdier for skjærehastighet (vc). Se vår Machining Calculator-app for ytterligere 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)
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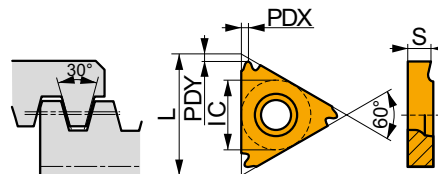
TN NPT NR innvendig, høyrehendt design, for bearbeiding av NPT-gjenger og kontinuerlige kutt.

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



Egnethet og startverdier for skjærehastighet (vc). Se vår Machining Calculator-app for ytterligere 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)
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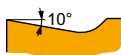


TN TR ER utvendig, høyrehendt design, for bearbeiding av trapesformede gjenger og kontinuerlige kutt.

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

Egnethet og startverdier for skjærehastighet (vc). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE	P	M	K	N	S	H	TP	TPI	PDX	PDY
		(mm)	vc (m/min)	vc (m/min)	vc (m/min)	vc (m/min)	vc (m/min)	vc (m/min)	(mm)		(mm)	(mm)



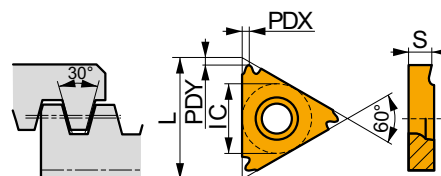
TN TR EL utvendig, venstrehendt design, for bearbeiding av trapesformede gjenger og kontinuerlige kutt.

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 INT

PRAMET

	IC	L	S
	(mm)	(mm)	(mm)
16	9.525	16.50	3.47
22	12.700	22.00	4.71



Egnethet og startverdier for skjærehastighet (vc). Se vår Machining Calculator-app for ytterligere beregninger.

Product		RE	P	M	K	N	S	H	TP	TPI	PDX	PDY
		(mm)	vc (m/min)	vc (m/min)	vc (m/min)	vc (m/min)	vc (m/min)	vc (m/min)	(mm)		(mm)	(mm)



TN TR NR innvendig, høyrehendt design, for bearbeiding av trapesformede gjenger og kontinuerlige kutt.

TN 16NR150TR	T8030	—	■	160	■	95	■	150	■	480	■	40	—	1.50	—	0.8	0.9
TN 16NR200TR	T8030	—	■	160	■	95	■	150	■	480	■	40	—	2.00	—	1.5	1.3
TN 16NR300TR	T8030	—	■	160	■	95	■	150	■	480	■	40	—	3.00	—	1.6	1.3
TN 22NR400TR	T8030	—	■	160	■	95	■	150	■	480	■	40	—	4.00	—	2.2	1.8
TN 22NR500TR	T8030	—	■	160	■	95	■	150	■	480	■	40	—	5.00	—	2.2	1.8



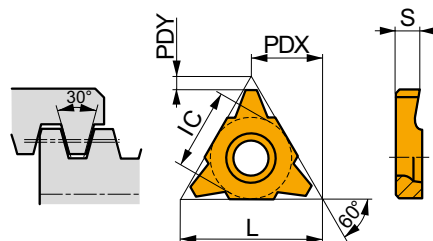
TN TR NL innvendig, venstrehendt design, for bearbeiding av trapesformede gjenger og kontinuerlige kutt.

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-S EXT

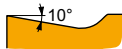
PRAMET

	IC (mm)	L (mm)	S (mm)
22	12.700	22.00	4.60



Egnethet og startverdier for skjærehastighet (vc). Se vår Machining Calculator-app for ytterligere beregninger.

Product	RE	P	M	K	N	S	H	TP	TPI	PDX	PDY
		vc (m/min)	vc (m/min)	vc (m/min)	vc (m/min)	vc (m/min)	vc (m/min)	(mm)		(mm)	(mm)



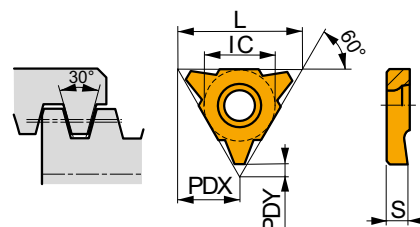
TN TR-S PP EN utvendig, venstre og høyrehendt design for bearbeiding av trapesformede gjenger og kontinuerlige kutt.

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



Egnethet og startverdier for skjærehastighet (vc). Se vår Machining Calculator-app for ytterligere beregninger.

Product	RE	P	M	K	N	S	H	TP	TPI	PDX	PDY
		vc (m/min)	vc (m/min)	vc (m/min)	vc (m/min)	vc (m/min)	vc (m/min)	(mm)		(mm)	(mm)

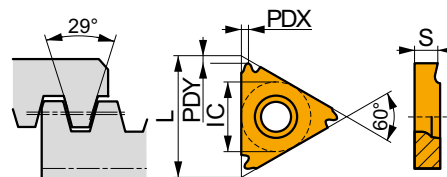


TN M60-S PP NN innvendig, venstre og høyrehendt design for bearbeiding av metriske og UN gjenger og kontinuerlige kutt.

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

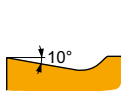
TN ACME EXT

	IC	L	S
	(mm)	(mm)	(mm)
16	9.525	16.50	3.47
22	12.700	22.00	4.71



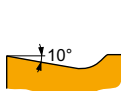
Egnethet og startverdier for skjærehastighet (vc). Se vår Machining Calculator-app for ytterligere beregninger.

Product	RE	P	M	K	N	S	H	TP	TPI	PDX	PDY
	(mm)	vc (m/min)	vc (m/min)	vc (m/min)	vc (m/min)	vc (m/min)	vc (m/min)	(mm)		(mm)	(mm)



TN ACME ER utvendig, høyrehendt design, for bearbeiding av ACME-gjenger og kontinuerlige kutt.

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



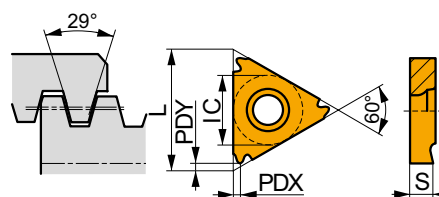
TN ACME EL utvendig, venstrehendt design, for bearbeiding av ACME-gjenger og kontinuerlige kutt.

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



Egnethet og startverdier for skjærehastighet (vc). Se vår Machining Calculator-app for ytterligere 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)
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TN ACME NR innvendig, høyrehendt design, for bearbeiding av ACME-gjenger og kontinuerlige kutt.

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



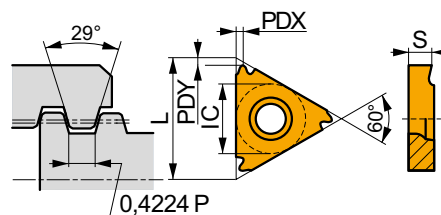
TN ACME NL innvendig, venstrehendt design, for bearbeiding av ACME-gjenger og kontinuerlige kutt.

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



Egnethet og startverdier for skjærehastighet (vc). Se vår Machining Calculator-app for ytterligere 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)
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TN STACME ER utvendig, høyrehendt design, for bearbeiding av ACME-gjenger og kontinuerlige kutt.

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

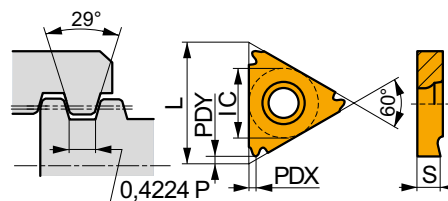


TN STACME EL innvendig, venstrehendt design, for bearbeiding av ACME-gjenger og kontinuerlige kutt.

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



Egnethet og startverdier for skjærehastighet (vc). Se vår Machining Calculator-app for ytterligere 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)
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TN STACME NR innvendig, høyrehendt, design for bearbeiding av Stub ACME-gjenger og kontinuerlige kutt.

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



TN STACME NL innvendig, venstrehendt design, for bearbeiding av ACME-gjenger og kontinuerlige kutt.

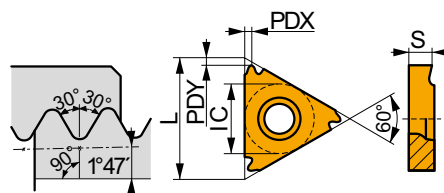
TN 16NL160STACME	T8030	—	160	95	150	480	40	—	—	16.0	0.8	0.8
TN 16NL120STACME	T8030	—	160	95	150	480	40	—	—	12.0	0.8	0.8
TN 16NL100STACME	T8030	—	160	95	150	480	40	—	—	10.0	1.5	1.3
TN 16NL080STACME	T8030	—	160	95	150	480	40	—	—	8.0	1.5	1.3
TN 16NL060STACME	T8030 ¹⁾	—	160	95	150	480	40	—	—	6.0	1.3	1.3

¹⁾ Toolholders have to be modified.

TN API RD EXT

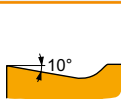


	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47



Egnethet og startverdier for skjærehastighet (vc). Se vår Machining Calculator-app for ytterligere 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)
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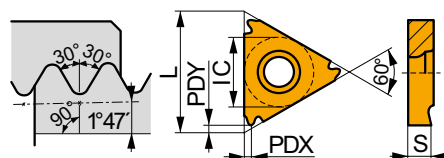
TN API ER utvendig, høyrehendt design, for bearbeiding av API-gjenger og kontinuerlige kutt.

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

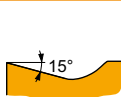


	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47



Egnethet og startverdier for skjærehastighet (vc). Se vår Machining Calculator-app for ytterligere 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)
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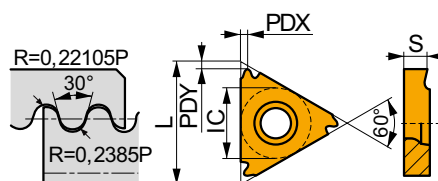
TN API NR innvendig, høyrehendt design, for bearbeiding av API-gjenger og kontinuerlige kutt.

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

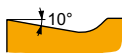


	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47
22	12.700	22.00	4.71



Egnethet og startverdier for skjærehastighet (vc). Se vår Machining Calculator-app for ytterligere 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)
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TN RD ER utvendig, høyrehendt design, for bearbeiding av metriske runde gjenger og kontinuerlige kutt.

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



TN RD EL utvendig, venstrehendt design, for bearbeiding av metriske runde gjenger og kontinuerlige kutt.

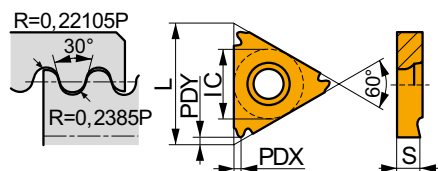
TN 16EL100RD	T8030	—	160	95	150	480	40	—	—	10.0	1.5	1.2
TN 16EL080RD	T8030	—	160	95	150	480	40	—	—	8.0	1.5	1.2
TN 16EL060RD	T8030 ¹⁾	—	160	95	150	480	40	—	—	6.0	1.5	1.2
TN 22EL060RD	T8030	—	160	95	150	480	40	—	—	6.0	2.5	1.8

¹⁾ Toolholders have to be modified.

TN RD INT



	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47
22	12.700	22.00	4.71



Egnethet og startverdier for skjærehastighet (vc). Se vår Machining Calculator-app for ytterligere 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)
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TN RD NR innvendig, høyrehendt design, for bearbeiding av metriske gjenger og kontinuerlige kutt.

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

Egnethet og startverdier for skjærehastighet (vc). Se vår Machining Calculator-app for ytterligere 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)
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TN RD NR innvendig, høyrehendt design, for bearbeiding av metriske gjenger og kontinuerlige kutt.

TN 16NR060RD	T8030¹⁾	–	■	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 innvendig, venstrehendt design, for bearbeiding av metriske gjenger og kontinuerlige kutt.

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	T8030¹⁾	–	■	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)

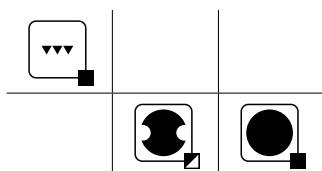
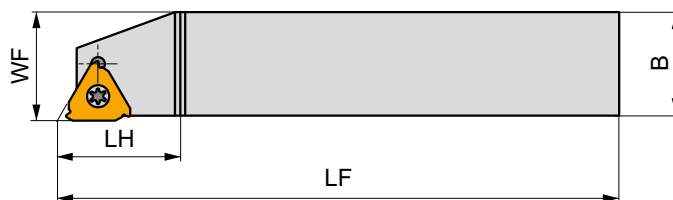
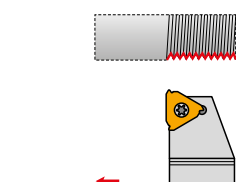


PRAMET

S

**Utvendig dreieholder for gjengeskjær tilpasset TN 16 eller 22 skjær**

Høyre/venstre hånd dreieholder for utvendig gjenging med TN16 eller 22 ER/EL skjær. Passer for gjenging i metrisk eller tommerprofil. Passer også til enkel sporing. Behandlet for lengre levetid.



	Product	H	HF	B	WF	LF	H	LAMS		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)		
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..

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



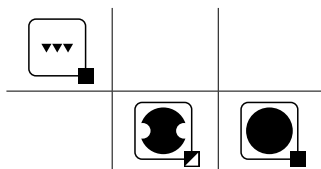
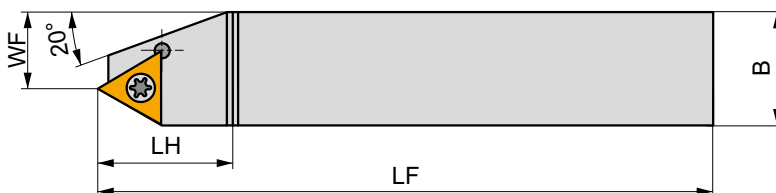
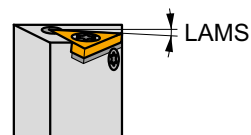
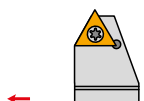
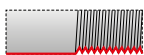
PRAMET

S



Utvendig dreieholder for gjengeskjær tilpasset TN 22 nøytral skjær

Høyre/venstre hånd dreieholder for større utvendig gjenger med TN22 EN skjær. Passer for gjenging i metrisk eller tommerprofil. Behandlet for lengre levetid.



Product		H	HF	B	WF	LF	LH	LAMS		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)		
R	SER-S 2525 M 22-A	25	25	25	14	150	30	—	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



M 4.5



14



SP 0405



FLAG T20



604

SI(RL)

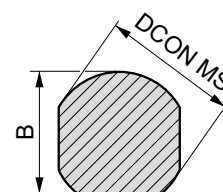
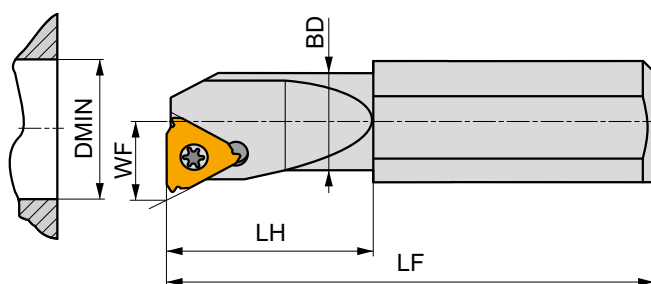
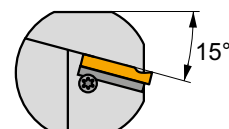
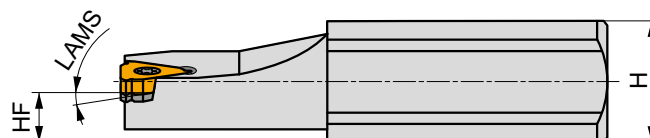
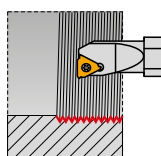


PRAMET

S

Innvendig dreiebom for gjengeskjærtilpasset TN 11, 16 eller 22 skjær

Høyre/venstre hånd dreiebom for innvendig gjenging med TN11, 16 eller 22 ER/EL skjær. Passer for gjenging i metrisk eller tommerprofil. Minimum innvendig diameter Ø13 mm. Passer også til enkel sporing. Finnes med skaftstørrelse Ø16 opp til Ø40 mm. Behandlet for lengre levetid.



Product	B	DCON MS	DMIN	BD	WF	H	HF	LF	LH	LAMS			
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)			
R	SIR 0010 K 11-0	14.5	16	13	10	7.45	14	7	125	25	0	–	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..

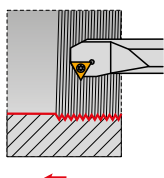
									
Z10	US 3510A-T15P	3.0	M 3.5	10.6	—	—	FLAG T15P	—	—
Z11	US 2506-T07P	0.9	M 2.5	6.3	—	—	FLAG T07P	—	—
Z12	US 3512A-T15P	3.0	M 3.5	12.7	—	HS 0304	FLAG T15P	HXX 2.5	 604
Z13	US 4514A-T20	5.0	M 4.5	14	SP 0405	—	FLAG T20	—	 604
Z14	US 4514A-T20	5.0	M 4.5	14	—	—	FLAG T20	—	—
Z9	US 3510A-T15P	3.0	M 3.5	10.6	—	—	FLAG T15P	—	P-16

SI(RL)-S



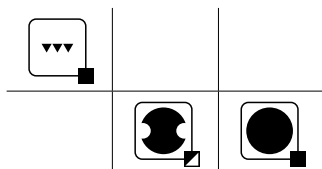
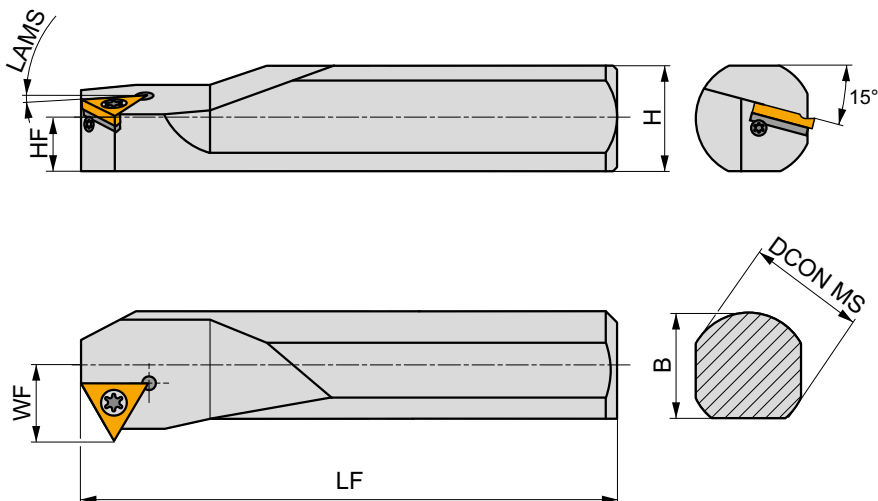
PRAMET

S



Innvendig dreiebom for gjengeskjær tilpasset TN 22 nøytral skjær

Høyre/venstre hånd dreiebom for større innvendig gjenger med TN22 EN skjær. Passer for gjenging i metrisk eller tommerprofil. Minimum innvendig Ø39 mm. Finnes med skaftstørrelse Ø32 opp til Ø40 mm. Behandlet for lengre levetid.



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	M 4.5	14	SP 0405	FLAG T20	604



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.
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BROACHING



TURNING – GENERAL CONTENT

 6		WMG & ISO 13399
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BROACHING – ICONS OVERVIEW

GENERAL ICONS

	Primary use		Finishing – very good surface quality		Suitable for stable working conditions
	Possible use		Medium machining – good surface quality		Suitable for unstable working conditions
			Roughing – unlimited surface roughness		Suitable for very unstable working conditions

FEATURES

	Internal shaping		Universal wide range option		Sharp edge
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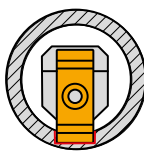
OTHER

	Clamping torque of screw (Nm)		Internal supply of coolant
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BROACHING INSERTS – NAVIGATOR

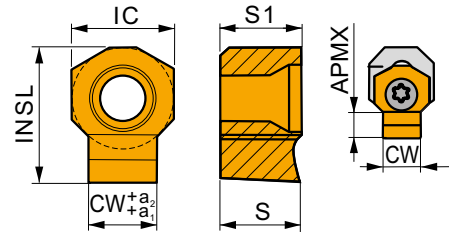
HZ	HZ-2
	
 531	 532

BROACHING HOLDERS – NAVIGATOR

PHZ	PHZ-2
	
 Ø 9,5 Ø 24,7  533	 Ø 44 Ø 58  534
HZ  03 04 05 06 08 10 12  531	HZ/2..  14 16 18 20  532

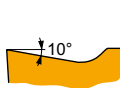
HZ

	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



Egnethet og startverdier for skjærehastighet (vc) og mating (fz). Se vår Machining Calculator-app for ytterligere 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)

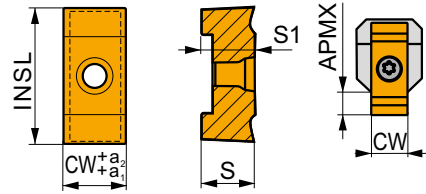


Positiv geometri for sporverkerktøy (en skjæregg).

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

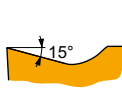
HZ-2

	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



Egnethet og startverdier for skjærehastighet (vc) og mating (fz). Se vår Machining Calculator-app for ytterligere beregninger.

Product	RE (mm)	P		M		K		N		S		H		CW (mm)	CWTOLL (mm)	CWTOLU (mm)
		vc (m/min)	fz (mm/tooth)	vc (m/min)	fz (mm/tooth)	vc (m/min)	fz (mm/tooth)	vc (m/min)	fz (mm/tooth)	vc (m/min)	fz (mm/tooth)	vc (m/min)	fz (mm/tooth)			



Positiv geometri for sporverktøy (to skjæregger).

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



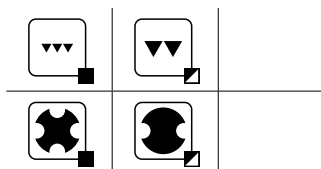
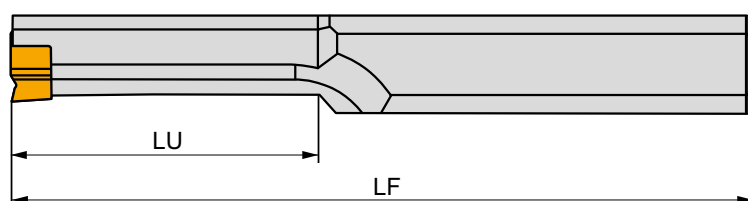
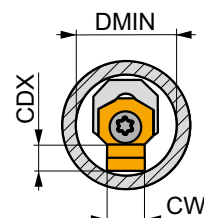
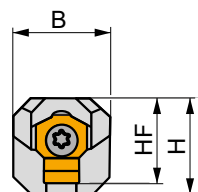
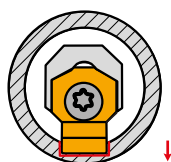
PRAMET

S



Innv. Kilespordrager holder for små diametre med ensidige HZ-skjær

Innvendig kilespordrager holder for kilespor opp til 12 mm bredde. Minimum innvendig diameter Ø9,5 mm. Behandlet for lengre levetid.



Product	H	HF	B	OAL	LU	CW	DMIN	CDX	kg		
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)			
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	

		Nm			
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



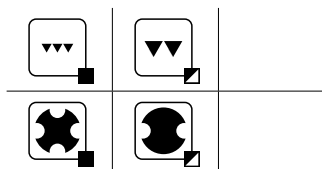
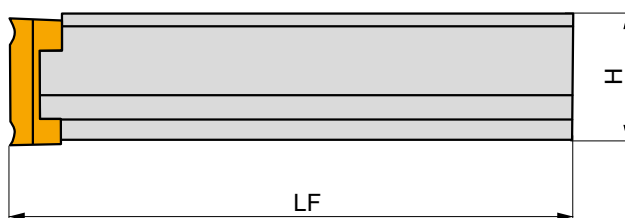
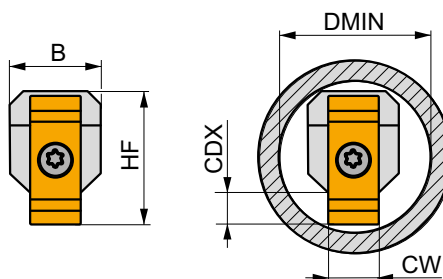
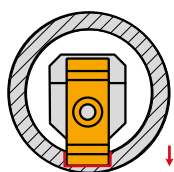
PRAMET

S



Innv. Kilespordrager holder for større diametre med dobbeltsidige HZ-skjær

Innvendig kilespordrager holder for kilespor opp til 20 mm bredde. Minimum innvendig diameter Ø44 mm. Behandlet for lengre levetid.



Product	H	HF	B	OAL	CW	DMIN	CDX	kg		
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)			
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										
GI241										

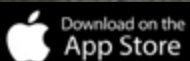
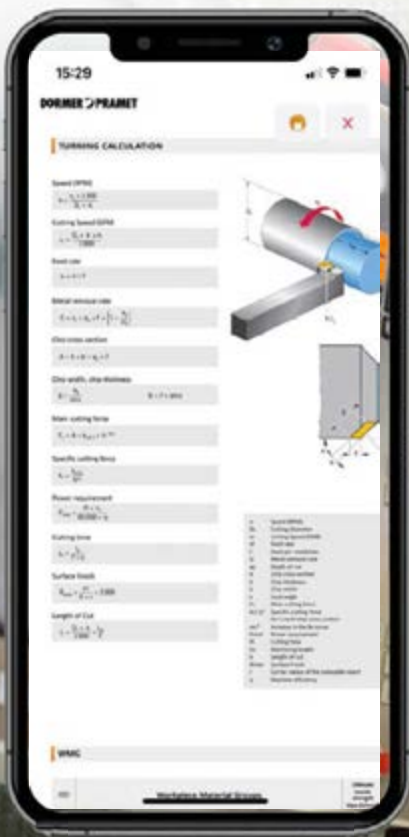
					
SH23	5513 020-14	8.5	M 6	18	TX225PLUS
SH24	5513 021-03	13.0	M 8	22	DMN 3124

DORMER PRAMET



HELP IS AT HAND

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Simply Reliable.



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GENERAL TECHNICAL INFORMATION

ISO TURNING

WORKPIECE MATERIAL GROUP (WMG)

ISO

To select a cutting grade and geometry for a broad range of workpiece materials

General definition

i.e. Steel, Stainless Steel...

P M K N S H

Subgroup

To navigate and select a tool by suitability for a more specific range of workpiece materials

Definition

by structure/composition

i.e. Plain Carbon Steel, Alloy Steel...

P M K N S H

P1

P2

P3

P4

WMG

To select and provide cutting conditions within a bandwidth of $\pm 10\%$

Definition

by hardness/ultimate tensile strength

i.e. $160 < 220 \text{ HB}$, $620 < 900 \text{ N/mm}^2$...

P

P1

P1.1

P1.2

P1.3

P2

P2.1

P2.2

P2.3

P3

P3.1

P3.2

P3.3

P4

P4.1

P4.2

P4.3

ABOUT DORMER PRAMET'S WORKPIECE MATERIAL CLASSIFICATION

Workpiece Material Groups (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.

WORKPIECE MATERIAL GROUP (WMG)

ISO group	Subgroup	WMG (Work Material Group)	k_{wg}	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 < 45HRC)	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 15522, 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 115Mn30, DIN 1.0715, SS 1912, ČSN 11109, BS 230M7, UNE F.2111, GB Y15, AFNOR S250, GOST A40G, UNI CF95Mn28
		P1.3 Free machining sulfurized/phosphorized and leaded carbon steel with a hardness of < 180 HB	1.53	AISI 12L13, EN 115MnPb30, DIN 1.0718, SS 1914, ČSN 12110, BS 210M16, UNE F.2114, GB Y15Pb, AFNOR S250Pb, GOST A35G2, 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 S22ps, 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 F.513, 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

WORKPIECE MATERIAL GROUP (WMG)

ISO group	Subgroup	WMG (Work Material Group)	k _{vc}	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 5429, EN X7Cr14, DIN 1.4001, SS 2326, BS 434517, 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 430517, UNE F.3154, GB 10Cr17, AFNOR Z10CA524, GOST 12Ch17, UNI X16Cr26
		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 410521, UNE F.3117, AFNOR Z10CF17, UNI X10CrS17
	M2 Martensitic stainless steel (straight chromium hardenable alloys)	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 6X6CrNi 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
		M3.1 Stainless steel, austenitic with a hardness of < 200 HB	1.00	AISI 304, EN X5CrNi18-12, DIN 1.4303, SS 2352, ČSN 17249, BS 305517, UNE F.3513, GB 10Cr18Ni12, AFNOR Z8CN18.12, UNI X7CrNi18 10
	M3 Austenitic stainless steel (chromium-nickel and chromium-nickel- manganese alloys)	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 1G23Ni13, 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 331540, 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 318513, UNE F.3552, GB 022Cr25NiMo2N, AFNOR Z1NCUDU25.20
		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 301513, UNE F.3217, GB 07Cr17Ni7Al, AFNOR Z9CNA17-07, GOST 09Ch17N7Jut, UNI X53CrMnNiN21 9

ISO group	Subgroup	WMG (Work Material Group)	k_{wg}	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 Fc10D, 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 Fc20D, GOST Ч420, 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 Fc35D, 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 K435-10
		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 K445-7, UNI GMN 45
	K3 Ductile iron (GGG) (iron-carbon castings with a nodular graphite microstructure)	K3.1 Ductile (nodular/spheroidal) 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 B440
		K3.2 Ductile (nodular/spheroidal) 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 B450
		K3.3 Ductile (nodular/spheroidal) 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 B460
	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,

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ISO group	Subgroup	WMG (Work Material Group)	k _{vc}	Examples of material (AISI, EN, DIN, ČSN, GB, SS, STN, BS, UNE, AFNOR, ASTM, GOST, 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 ADC, 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 AMu, 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 AlCu45, BS LM11, STN 424331, UNE AlSi1Cu, GOST AMg5K, 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 AK7, 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 C91540, EN CuNi25Cr, 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 M1f, 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, ME, MPF, PA, PAL, 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, Mehtacrylate, 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-01R0, 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, R8650,

ISO group	Subgroup	WMG (Work Material Group)	k_{wg}	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 strength 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 TiAl6VELL, 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, Inconel 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 36HXT10, AISI A-286, Discaloy, Haynes 556, Inconel 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 Waspalloy, AFNOR NCKD 20ATV, GOST XH80T5K0, 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 ЛK52, 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 ЛK52, AISI Haynes 25, Stellite 21, 31

WORKPIECE MATERIAL GROUP (WMG)

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 AC38XTM, 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 AC38XTM, 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 B01, UNE F.5220, GB 9CrWMn, AFNOR 90MnWCrV5, GOST 9XBТ, 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 B01, UNE F.5220, GB 9CrWMn, AFNOR 90MnWCrV5, GOST 9XBТ, UNI 95MnWCr5KU

CORRECTION FACTORS

Correction factors for specific type of operation C_{VcO}

 	FF			F			M			R			HR		
	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
	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}

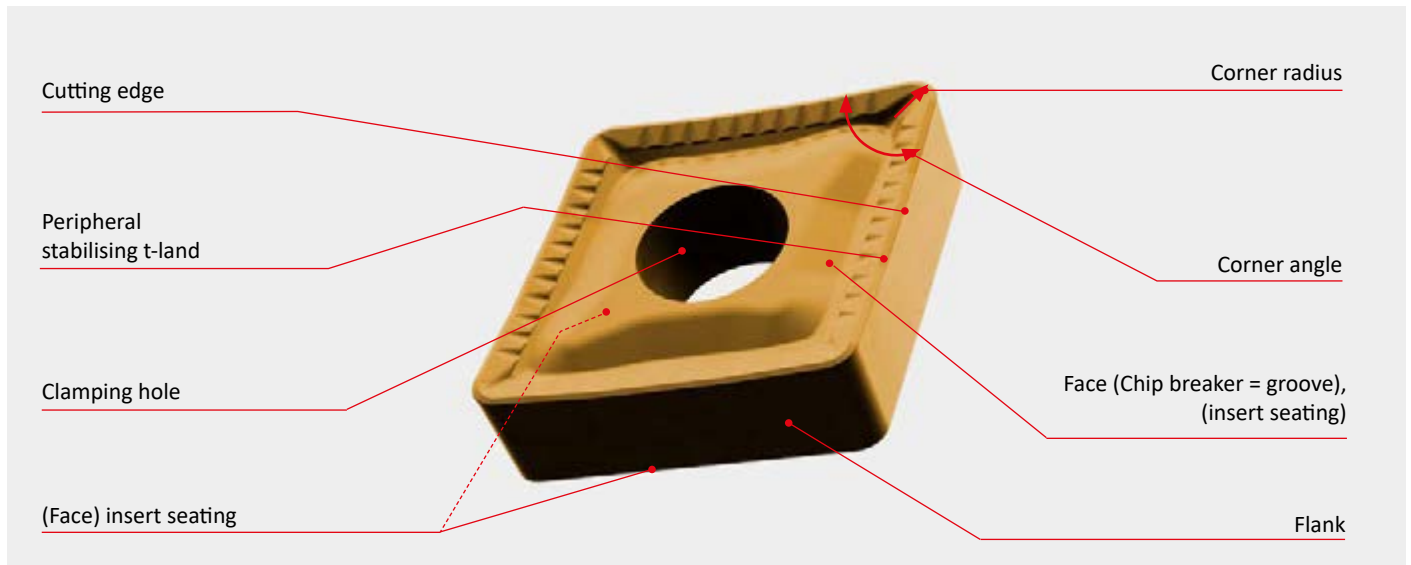
Machining environment	C_{VcA}
Condition of the work-material (hard skin due to forging or casting)	0.70
Internal turning	0.75
Parting and grooving (radial)	0.88
Face grooving	0.80
Interrupted cut	0.80
Unstable machining conditions	0.85
Common machining conditions	1.00
Stable machining conditions	1.20

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)

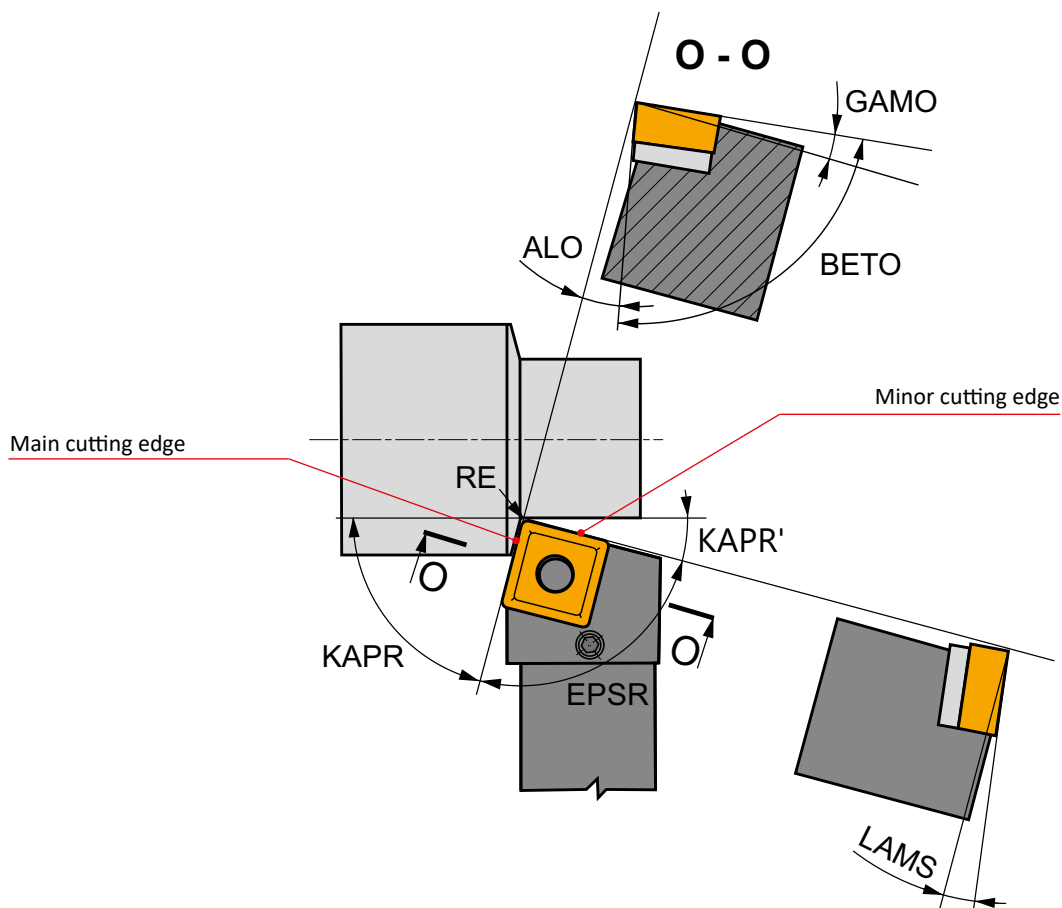
Working and construction angles of turning tools

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 $AN = 0^\circ$ and a rake angle $GAMP = 0^\circ$, however the insert is clamped in the tool holder to give a working clearance angle $ALO = 6^\circ$ and a working rake angle $GAMO = -6^\circ$. 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 $GAMO = +25^\circ$ 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.

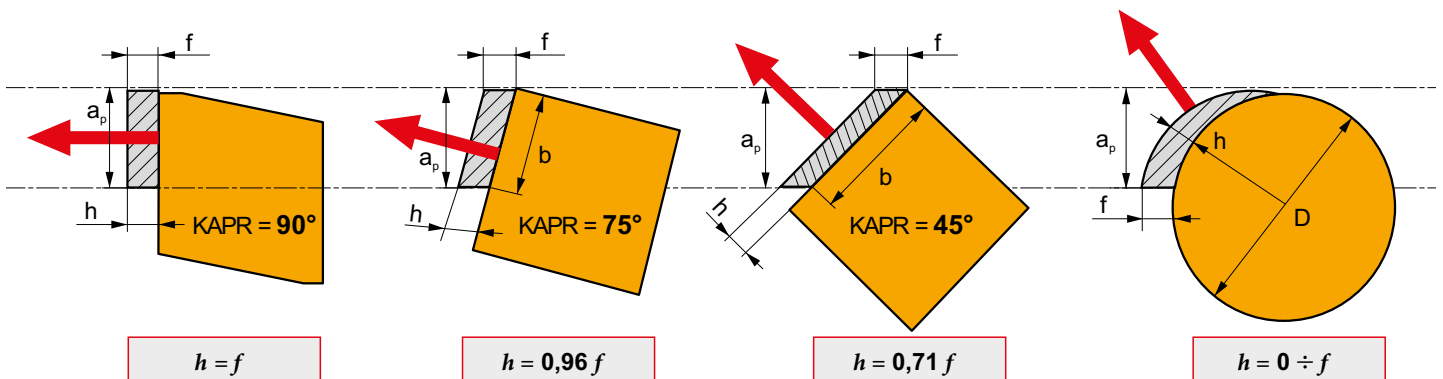
Clearance angle ALO affects the value of friction between the flank and the machined surface. Increasing the clearance angle ALO reduces this friction and thereby flank wear as well.

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 $KAPR = 90^\circ$ 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.



DEFINITION OF BASIC TERMS

Effect of working tool geometry

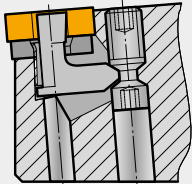
Parameter	Change	Abrasion of the flank	Crater wear formation	Tendency for plastic deformation	Resistance to adverse working conditions	Surface	Cutting forces	Tendency to vibrate	Medium cutting temperature	Chip formation
Main cutting edge angle	Less than or greater than 90°	Slightly reduced	Slightly reduced	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 $f = 0.2 \text{ mm/rev}$ $a_p = 2 \text{ mm}$ $\text{KAPR } 90^\circ$ $\text{RE } 0.4$	Cutting speed: V_c (m/min)	Cutting speed: V_c (m/min)	Cutting speed: V_c (m/min)
Depth of cut and cutting force $V_c = 100 \text{ m/min}$ $a_p = 0.2 \text{ mm/rev}$ $\text{KAPR } 90^\circ$ $\text{RE } 0.4$	Depth of cut: a_p (mm)	Depth of cut: a_p (mm)	Depth of cut: a_p (mm)
Cutting feed and cutting force $V_c = 100 \text{ m/min}$ $a_p = 2 \text{ mm}$ $\text{KAPR } 90^\circ$ $\text{RE } 0.4$	Feed: F (mm/rev)	Feed: F (mm/rev)	Feed: F (mm/rev)
Corner radius and cutting force $V_c = 100 \text{ m/min}$ $f = 0.2 \text{ mm/rev}$ $a_p = 1.2 \text{ mm}$ $\text{KAPR } 90^\circ$	Corner radius: RE (mm)	Corner radius: RE (mm)	Corner radius: RE (mm)
Main cutting edge angle $V_c = 100 \text{ m/min}$ $f = 0.2 \text{ mm/rev}$ $a_p = 2 \text{ mm}$ $\text{KAPR } 45^\circ, 60^\circ, 75^\circ, 90^\circ$ (values on the x axis) $\text{RE } 0.4$	KAPR	KAPR	KAPR
Rake angle and cutting force $V_c = 100 \text{ m/min}$ $f = 0.2 \text{ mm/rev}$ $a_p = 2 \text{ mm}$ $\text{KAPR } 90^\circ$ $\text{RE } 0.4$	GAMO	GAMO	GAMO

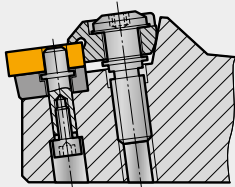
Tool holder choice with regard to the clamping technique

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.



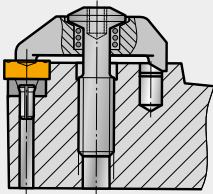
ISO P

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.



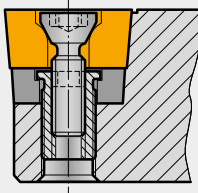
ISO M

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.



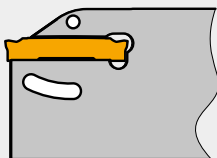
ISO C

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.



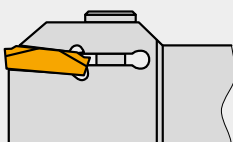
ISO S

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.



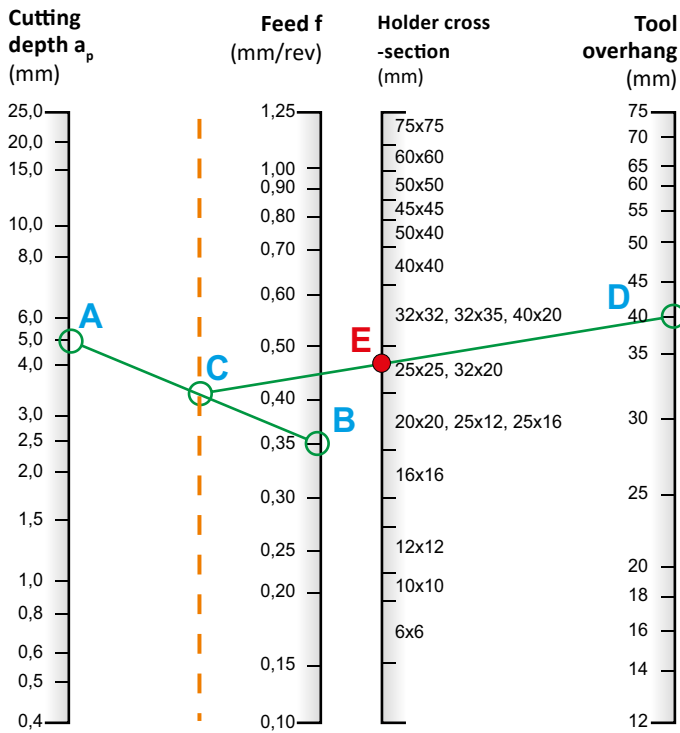
ISO G

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.

CHOICE OF CUTTING TOOL

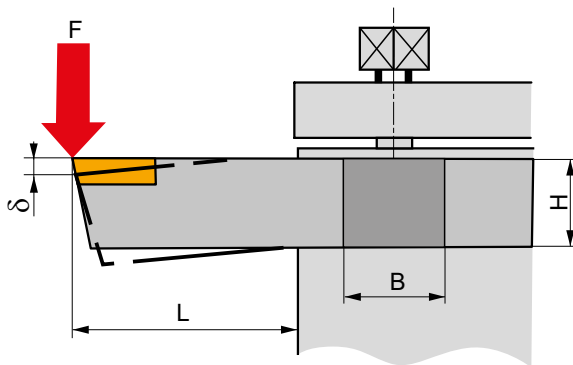
With reference to square cutting tool

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.

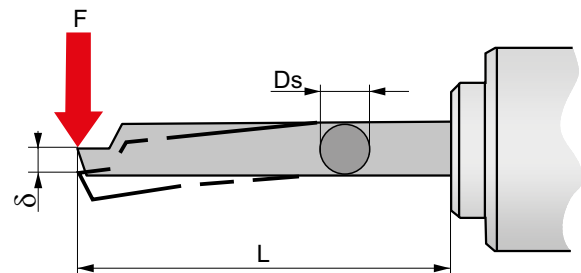


Bending stress

$$\sigma = \frac{6 \cdot F \cdot L}{B \cdot H^2} \text{ (MPa)}$$

Tool holder deflection

$$\delta = \frac{4 \cdot F \cdot L^3}{E \cdot B \cdot H^3} \text{ (mm)}$$



Bending stress

$$\sigma = \frac{32 \cdot F \cdot L}{\pi \cdot D_s^3} \text{ (MPa)}$$

Tool holder deflection

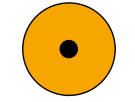
$$\delta = \frac{64 \cdot F \cdot L^3}{3 \cdot \pi \cdot E \cdot D_s^3} \text{ (mm)}$$

σ	Bending stress in the body (MPa)
F	Cutting force (N)
L	Tool overhang (mm)
B	Body width (mm)
H	Body height (mm)
D_s	Body diameter (mm)
E	Body material elastic modulus (MPa)

Material	MPa (N/mm ²)	(kgf/mm ²)
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%.**

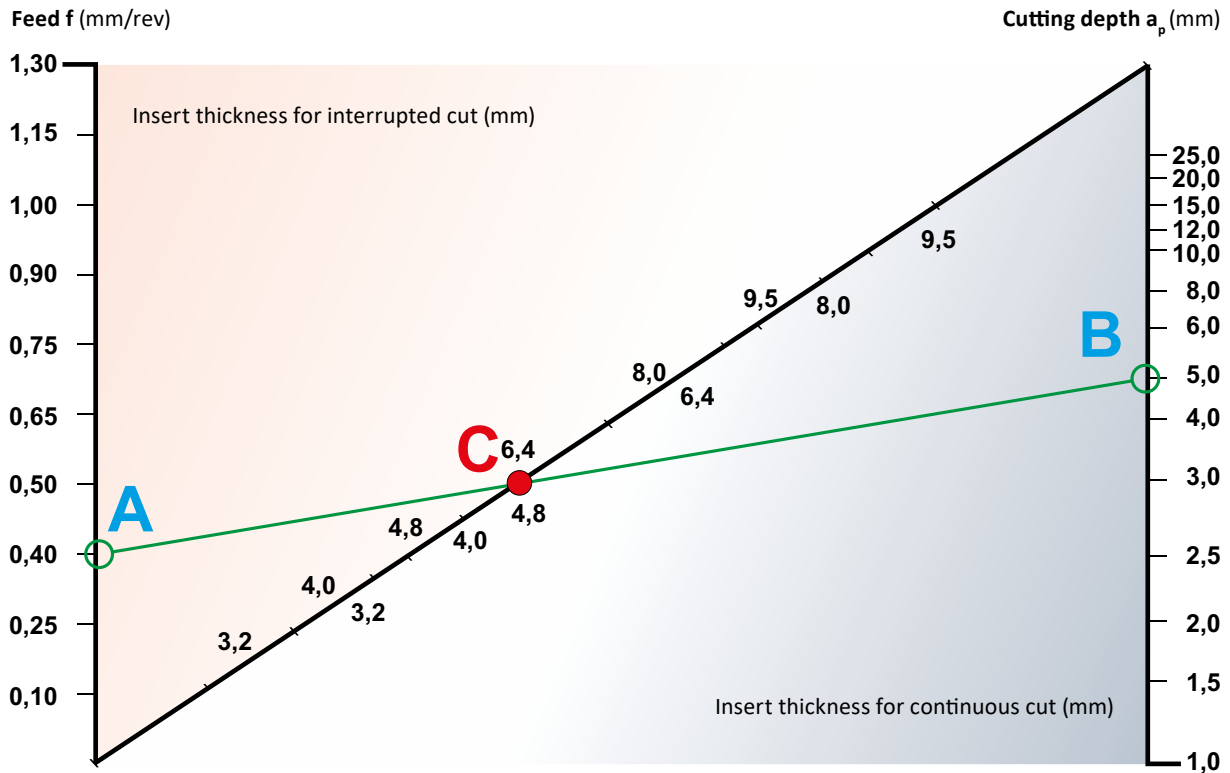
Choosing the shape and size of the insert

Priority of choice	Insert shape	Nose angle	Insert size		Maximum length of cutting edge L _{max}		Roughing	Light roughing	Finishing	Profile turning	Face turning	Versatile applications	Tendency to vibrate	Hard material	Interrupted cut
			ISO	ANSI		(mm) (")									
Increasing the accessibility of the cutting edge for profiling and fewer vibrations. + I P_c [kW] 1 2 P_c [kW] Increasing the strength of the cutting edge and suitability for interrupted cut. F_t		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"							
		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"							

CHOICE OF INSERT

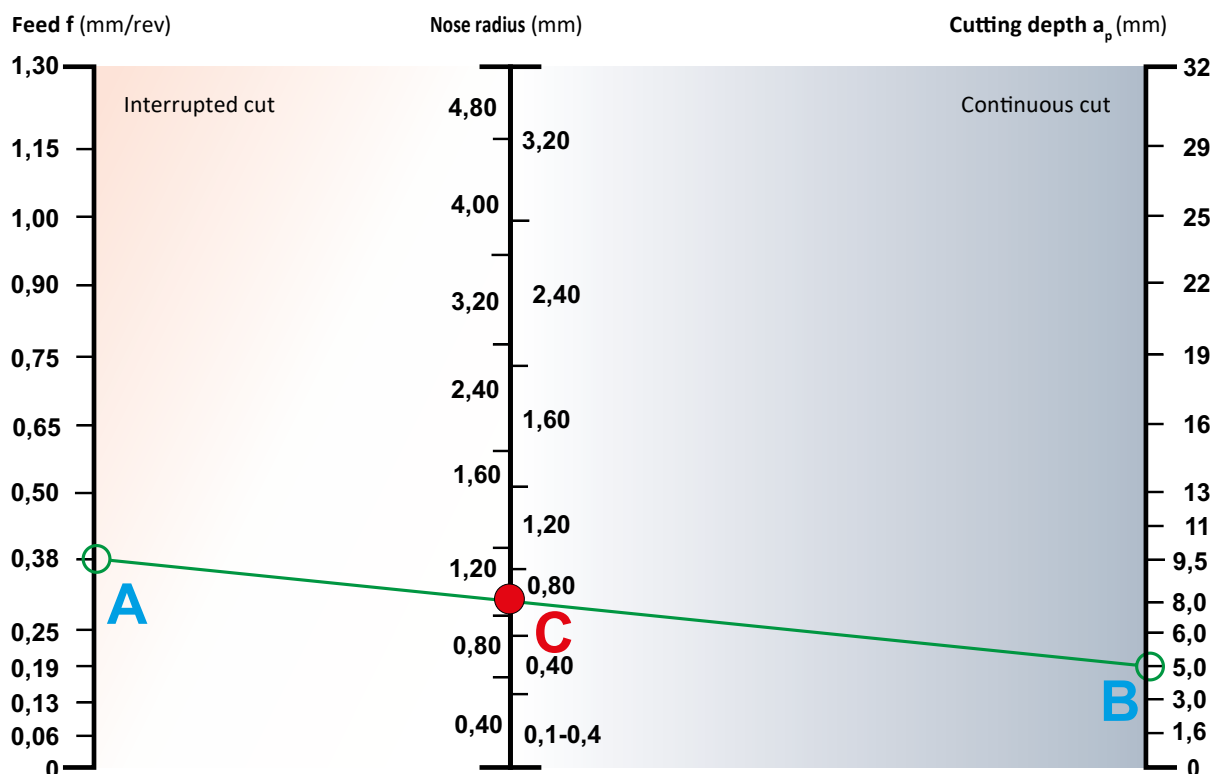
Choosing the optimum thickness of the insert

Based on practice, we recommend performing this only for interrupted cut and at a maximum load of inserts.



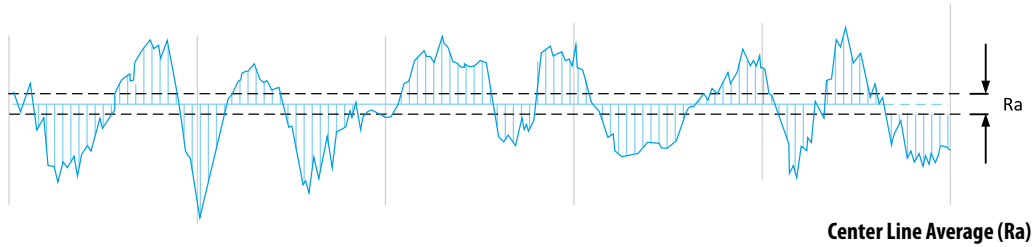
Choosing the nose radius of the insert

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.

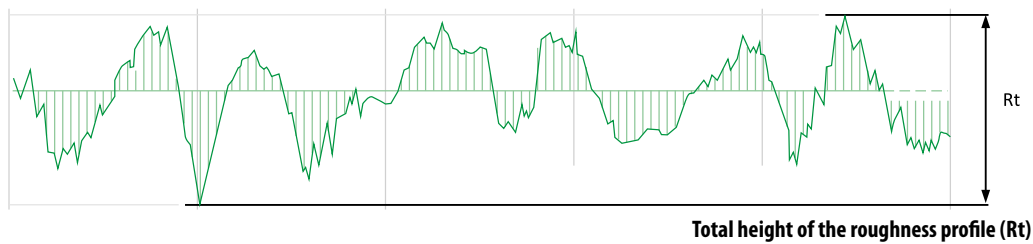
At the beginning of this section, we indicate the main roughness parameters most often specified in engineering practice.



Ra – Average roughness

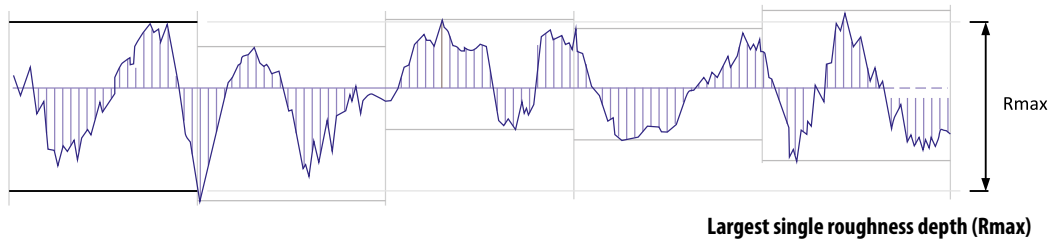
Ra is also known as Arithmetic Average (AA) or Center Line Average (CLA). It is the average roughness in the area between the roughness profile and its mean line. Graphically, Ra is the area between the roughness profile and its center-line divided by the evaluation length. The evaluation length is normally 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:



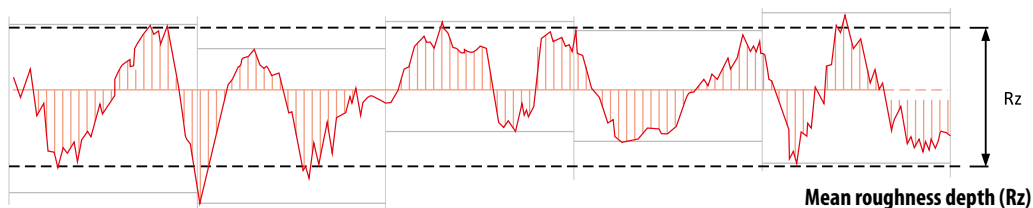
Rt – Total height of roughness profile

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.



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.



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 Points Mean Roughness RzJIS (μm)	Roughness Grade	Note: (Relationship with Triangle)
0.025	0.1	0.1	N1	VVV
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	VV
0.8	3.2	3.2	N6	
1.6	6.3	6.3	N7	
3.2	12.5	12.5	N8	V
6.3	25	25	N9	
12.5	50	50	N10	V
25	100	100	N11	

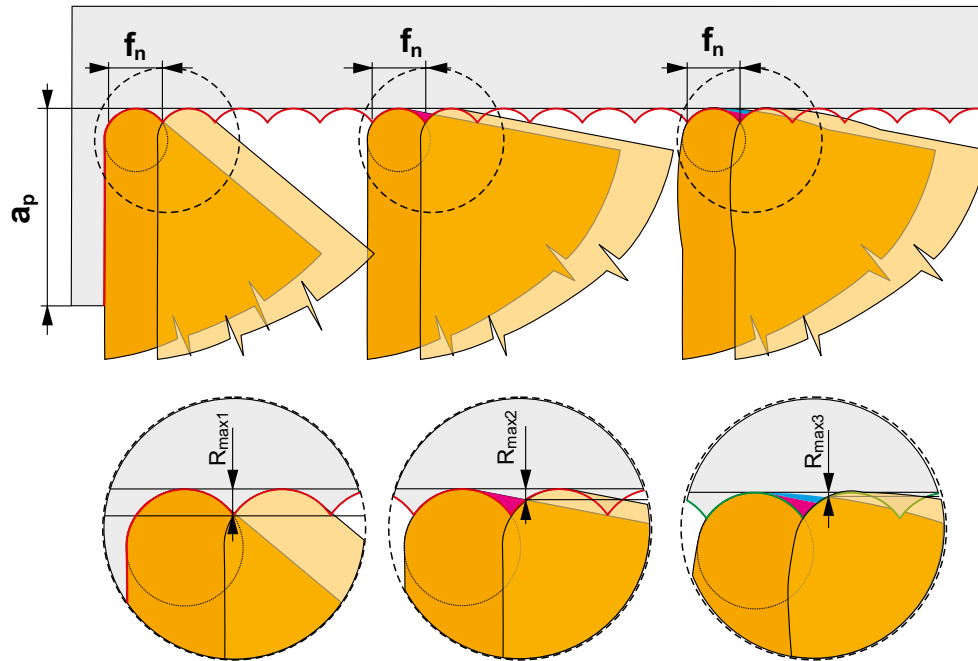
Note: Finishing symbol (Triangle and wave~) was removed from JIS standard in the 1994 Revision.

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 $KAPR = 90^\circ - 95^\circ$,

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.



Overflatekvalitet ved dreining R_{max}

$$R_{max} = \frac{f^2}{8 \cdot RE} \cdot 1000$$

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
	Overflate 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 dårlig sponbryting

Overflatekvalitet ved dreining R_a

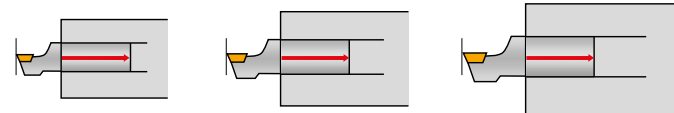
$$R_a = 43,9 \frac{f^{1,88}}{RE^{0,97}}$$

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
	Overflate 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

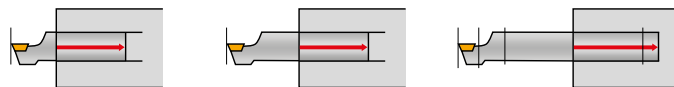
Fare for dårlig sponbryting



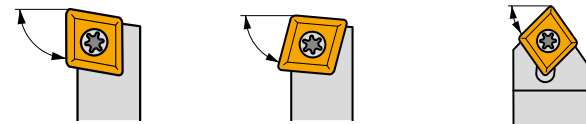
Hardness of chip formation – great attention must be paid to proper chip formation (the chip must be easily transportable from the cutting point and, at the same time, it should have the smallest possible plastic deformation, i.e. the lowest possible cutting forces).



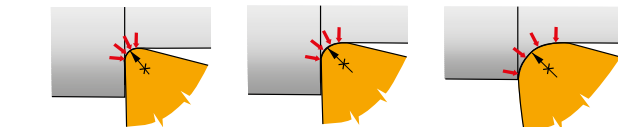
Tool body cross section (clamping rigidity) – the rigidity of the clamping itself is important. Therefore, we recommend using cutting tools with the largest possible body cross section that can be clamped. We also prefer to use monoblocks (PSC).



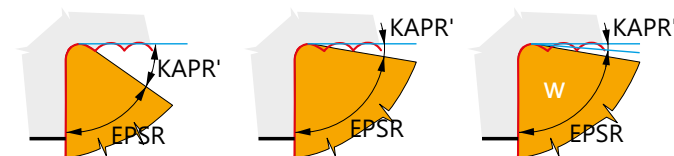
Overhang (clamping rigidity) – the tool overhang, or the rigidity of the clamping itself, is of great importance as well. Therefore, we recommend minimising the overhang.



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.



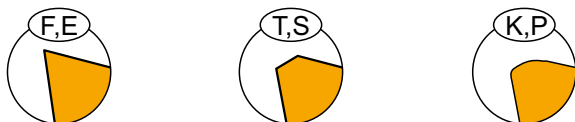
Insert radius – if there is a risk of vibration, we recommend selecting an insert with the smallest possible tip radius.



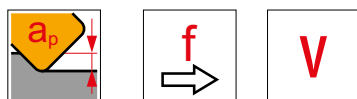
Corner angle and minor cutting edge angle – in this case it is recommended to choose an insert with the smallest possible tip angle, i.e. V (35°), D or K (55°), or T (60°). C or W shapes, or inserts with WIPER geometry, are not recommended. Please note this does not always apply (if torsional vibrations 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.

CHOICE OF CUTTING CONDITIONS

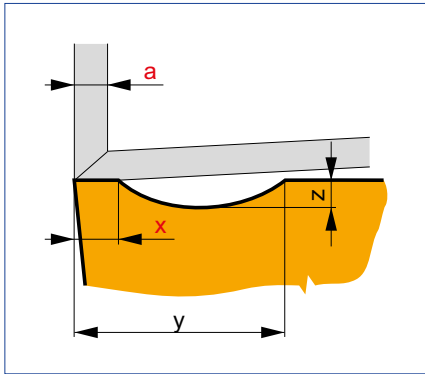
Choosing the chip breaker

The shape of the chip depends on several factors – the properties of the machined component, material strength, toughness and micro-structure, 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.

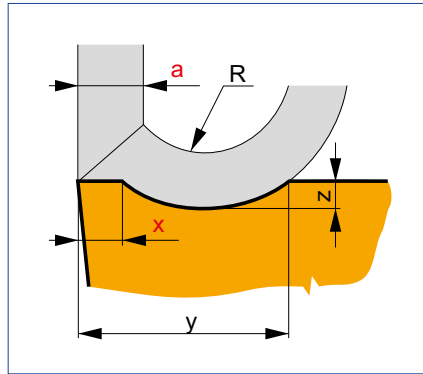
Virtually all of these factors in the cutting process work to combine

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.

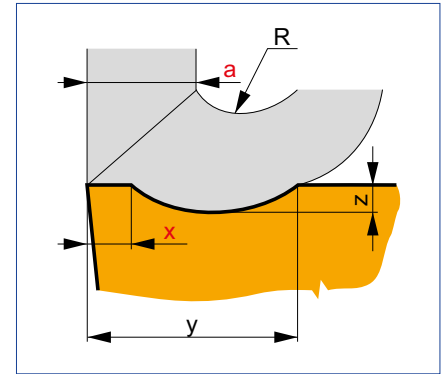
The minimum feed at which the chip breaker functions depends on the width of Top Land „ x ” and it's angle. The maximum feed depends on the distance from the cutting edge to the end of the chip breaker y and the depth of the chip breaker z .



If the thickness of layer „ a ” cut away (at setting angle $KAPR = 90^\circ$, 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).

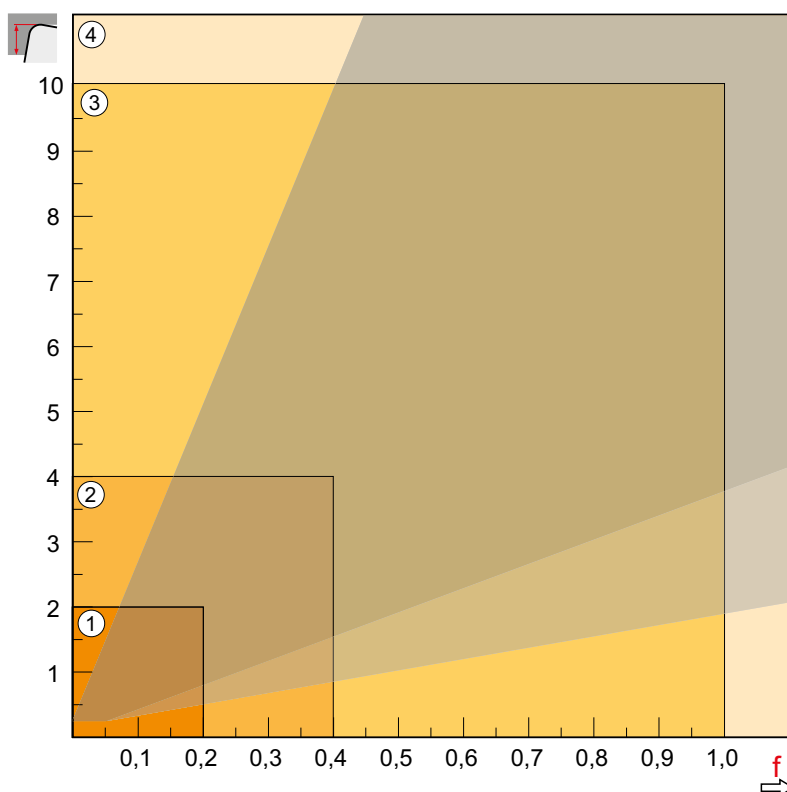


If the feed „ f ” is greater (thickness greater than the depth of „ a ” and $x < a$ (f)), the chip enters the chip breaker and is curved at specific values of radius R (see picture).



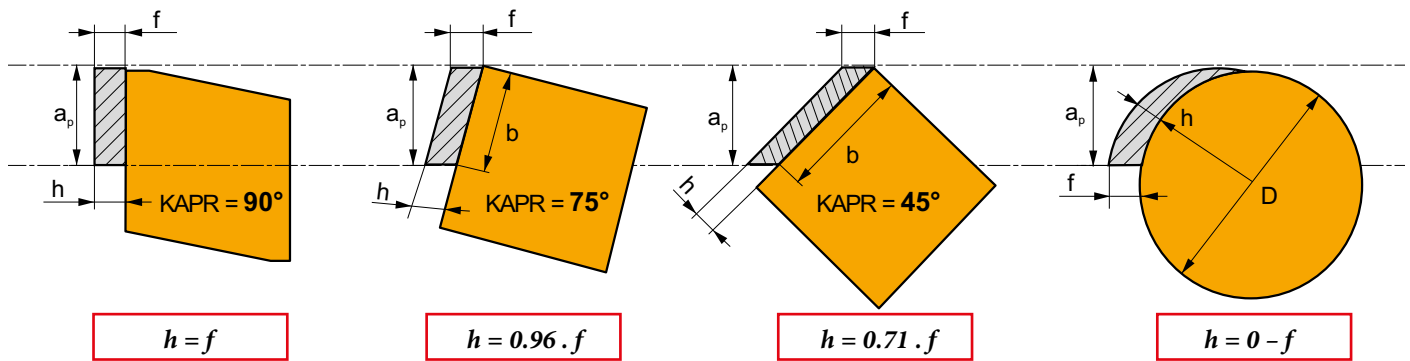
If $x \ll a$ (see picture) the chip is excessively deformed (chip is crushed). If the chip misses the chip breaker it will not be broken.

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.



1	FF F	f → 0.05 – 0.2	a_p ↓ 0.05 – 2
2	M	f → 0.2 – 0.4	a_p ↓ 2 – 4
3	R	f → 0.4 – 1.0	a_p ↓ 4 – 10
4	HR	f → > 1.0	a_p ↓ > 10

CHOICE OF CUTTING TOOL



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.

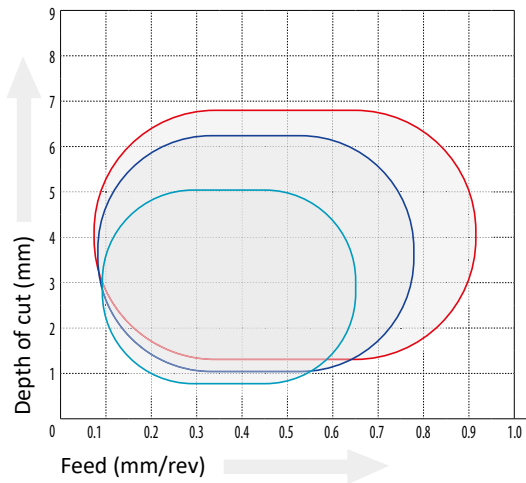
Material		min b/h	max b/h	
P		5	15	
M		8	12	
K		3	30	
N		9	11	
S		8	12	
H	Square chip $b=h$	5	20	Ribbon chip $b/h > 30$

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 re-

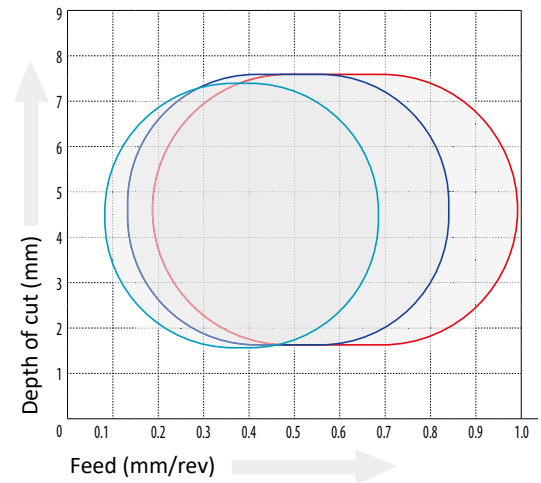
lates to non-ferrous metal alloys, in particular aluminium alloys with or without a low silicon content. This is followed by superalloys and stainless steels (especially austenitic and duplex steels). Next are steels, and the best situation is with hardened materials and cast irons.

CHOICE OF CUTTING TOOL

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)



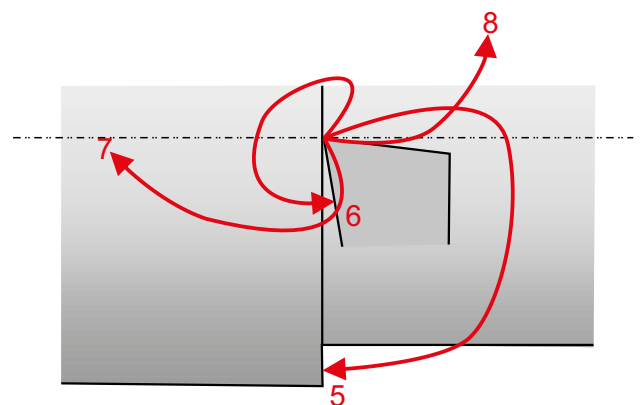
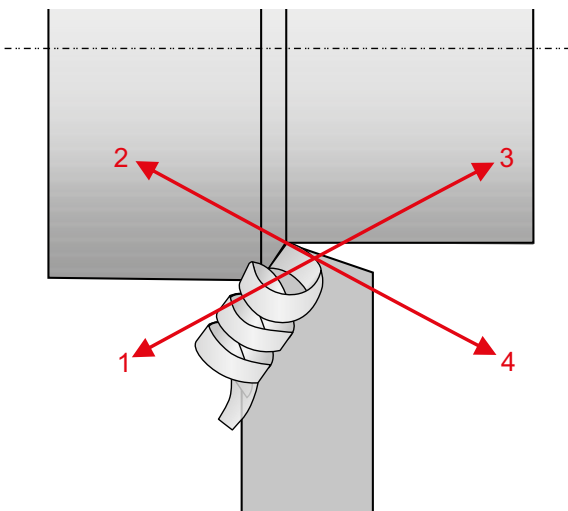
- An insert with the tip radius RE = 1.6 (mm)
- An insert with the tip radius RE = 1.2 (mm)
- An insert with the tip radius RE = 0.8 (mm)

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.



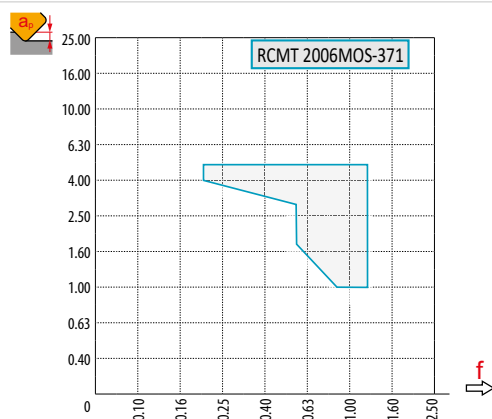
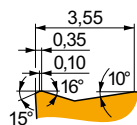
The following section clearly specifies all the geometries we offer you in structured groups. These tables should give you an optimal and more accurate choice.

OVERVIEW OF TURNING INSERT GEOMETRIES

POSITIVE INSERTS Clamping designation ISO S		NEGATIVE INSERTS Clamping designation ISO P, M, D		GEOMETRY OF CUTTING GROOVING INSERTS Clamping designation iso X and G	
					
371 (RCMT)	565	000 (LNUX)	575	GM (GL.D)	586
372 (RCMT)	565	002 (LNUX)	575	MM (GL.D)	586
...W	565	003 (LNUX)	575	PM (GL. D)	586
AL	565	08 (RNMG)	575	PR (GL. D)	586
DR4 (SCMT)	566	81 (RNMG)	576	13 CM (LCMF)	587
FF	566	432 (LNMX)	576	13 F (LCM.)	587
FF2	566	923	576	13 MP (LCM.)	587
FM	566	...A	576	16 CM (LCM.)	587
FM (RCMT)	567	DR	577	16 F (LCM.)	588
FM2	567	FF	577	16 M (LCM.)	588
NF1	567	FM	577	16 MP (LCM.)	588
NF2	567	HR	577	20 F1 (LCMF)	588
OR (SCMT)	568	HR2	578	20 M2 (LCMF)	589
RF	568	KR	578	30 F (LCM.)	589
RM	568	M	578	F1 (LFMX)	589
RM3	568	NF	578	F2 (LFMX)	589
SF2	569	NM	579	M2 (LFMX)	590
SF3	569	NMR	579	LFUX	590
SI	569	NR	579	TN. EXT	591
SR (SCMT)	569	NRM	579	TN. INT	591
UR (RCMT)	570	NR2	580	X61	591
UR	570	OR	580	X61 R	591
W-FM	570	OR1	580		
W-UR	570	R	580		
46	571	RM	581		
47	571	SF	581		
48	571	SI	581		
61	571	SM	581		
.PUN	572	SR	582		
		W-MR	582		
		W-F	582		
		W-M	582		
		W-NM	583		
POSITIVE INSERTS Clamping designation ISO P, M, D		NEGATIVE INSERTS Clamping designation ISO C			
					
31 (RCMX)	573	22	584		
321 (RCMX)	573	32	584		
331 (RCMX)	573	72	584		
361 (RCMX)	573	73	584		
RF1 (RCMX)	574	74	585		
RM1 (RCMX)	574				
RM2 (RCM.)	574				
RR2 (RCM.)	574				

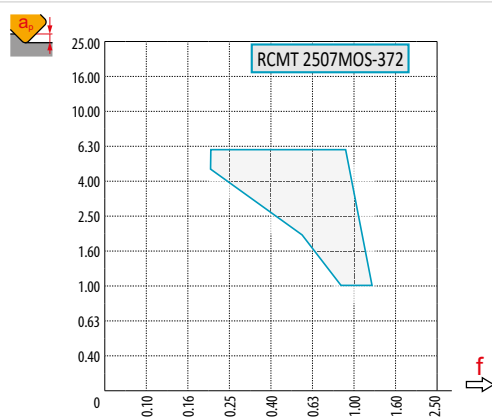
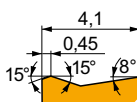
GEOMETRY OF CUTTING POSITIVE INSERTS – CLAMPING DESIGNATION ISO S

371 (RCMT)



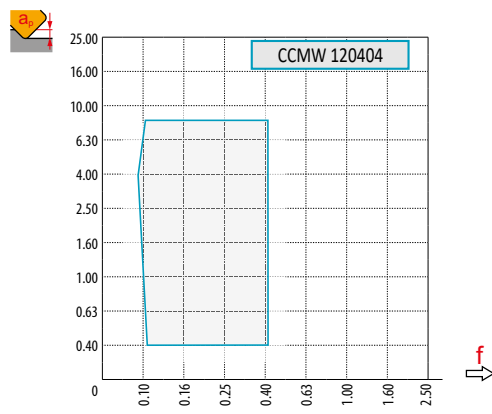
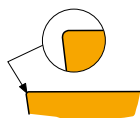
P	M	K	N	S	H
					
	0.20 – 1.20				
	1.0 – 5.0				
					
					
	RCMT				

372 (RCMT)



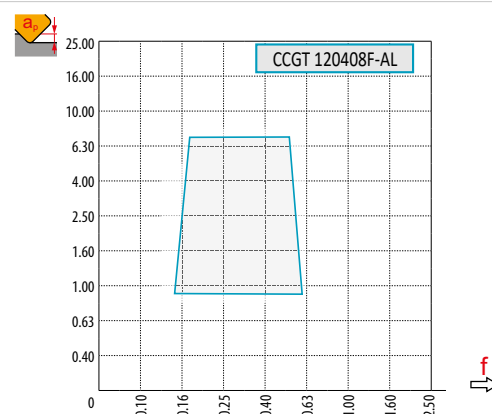
P	M	K	N	S	H
					
	0.20 – 1.20				
	1.0 – 6.0				
					
					
	RCMT				

W...



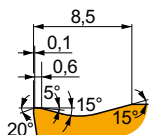
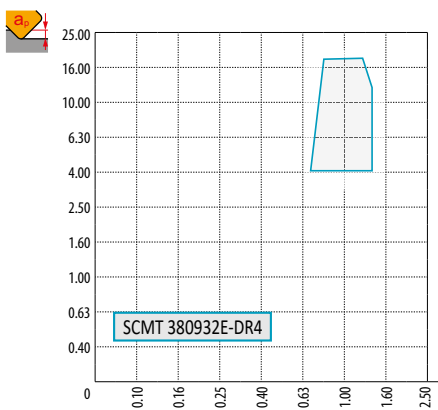
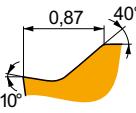
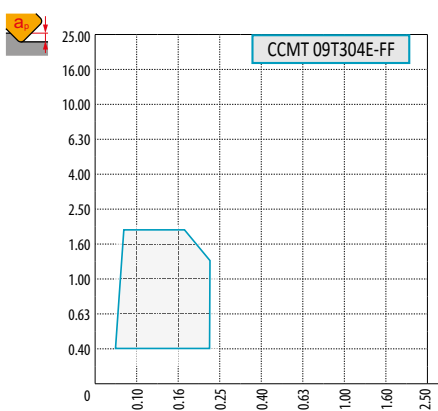
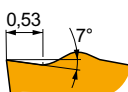
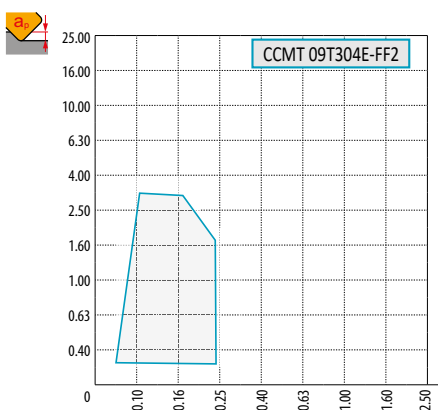
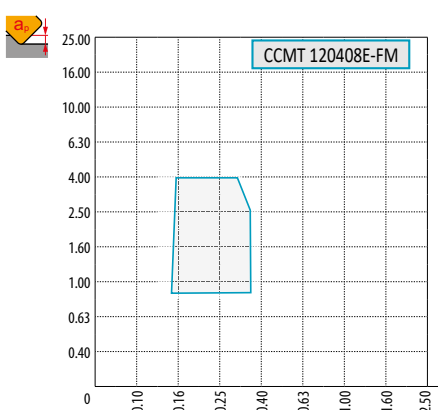
P	M	K	N	S	H
	0.05 – 0.60				
	0.4 – 8.4				
					
					
	CCMW, DCMW, SCMW, RCMW, TCMW, VCMW				

AL



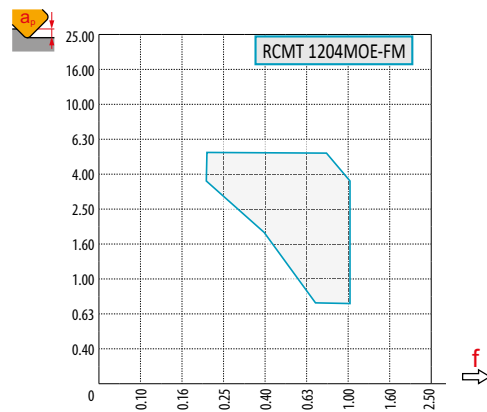
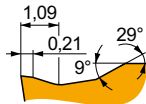
P	M	K	N	S	H
	0.05 – 0.60				
	0.2 – 7.0				
					
					
	CCGT, DCGT, SCGT, RCGT, TCGT, VCGT, WCGT				

GEOMETRY OF CUTTING POSITIVE INSERTS – CLAMPING DESIGNATION ISO S

DR4 (SCMT)			 SCMT 380932E-DR4	<table><tr><th>P</th><th>M</th><th>K</th><th>N</th><th>S</th><th>H</th></tr><tr><td>■</td><td>▣</td><td>■</td><td>■</td><td>■</td><td>■</td></tr><tr><td colspan="6">f 0.70 – 1.40</td></tr><tr><td colspan="6">a_p 4.0 – 18.0</td></tr><tr><td colspan="6"></td></tr><tr><td colspan="6"></td></tr><tr><td colspan="6"> SCMT</td></tr></table>	P	M	K	N	S	H	■	▣	■	■	■	■	f 0.70 – 1.40						a _p 4.0 – 18.0																		 SCMT					
	P	M	K	N	S	H																																								
■	▣	■	■	■	■																																									
f 0.70 – 1.40																																														
a _p 4.0 – 18.0																																														
																																														
																																														
 SCMT																																														
FF			 CCMT 09T304E-FF	<table><tr><th>P</th><th>M</th><th>K</th><th>N</th><th>S</th><th>H</th></tr><tr><td>■</td><td>▣</td><td>■</td><td>■</td><td>■</td><td>■</td></tr><tr><td colspan="6">f 0.05 – 0.23</td></tr><tr><td colspan="6">a_p 0.2 – 2.0</td></tr><tr><td colspan="6"></td></tr><tr><td colspan="6"></td></tr><tr><td colspan="6"> CCMT, DCMT</td></tr></table>	P	M	K	N	S	H	■	▣	■	■	■	■	f 0.05 – 0.23						a _p 0.2 – 2.0																		 CCMT, DCMT					
	P	M	K	N	S	H																																								
■	▣	■	■	■	■																																									
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a _p 0.2 – 2.0																																														
																																														
																																														
 CCMT, DCMT																																														
FF2			 CCMT 09T304E-FF2	<table><tr><th>P</th><th>M</th><th>K</th><th>N</th><th>S</th><th>H</th></tr><tr><td>■</td><td>▣</td><td>■</td><td>■</td><td>■</td><td>■</td></tr><tr><td colspan="6">f 0.02 – 0.28</td></tr><tr><td colspan="6">a_p 0.20 – 3.0</td></tr><tr><td colspan="6"></td></tr><tr><td colspan="6"></td></tr><tr><td colspan="6"> CCMT, CCGT, DCGT, DCMT, SCMT, TCMT, VBMT, VCGT, VCGX, WCGT</td></tr></table>	P	M	K	N	S	H	■	▣	■	■	■	■	f 0.02 – 0.28						a _p 0.20 – 3.0																		 CCMT, CCGT, DCGT, DCMT, SCMT, TCMT, VBMT, VCGT, VCGX, WCGT					
	P	M	K	N	S	H																																								
■	▣	■	■	■	■																																									
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 CCMT, CCGT, DCGT, DCMT, SCMT, TCMT, VBMT, VCGT, VCGX, WCGT																																														
FM			 CCMT 120408E-FM	<table><tr><th>P</th><th>M</th><th>K</th><th>N</th><th>S</th><th>H</th></tr><tr><td>■</td><td>■</td><td>▣</td><td>▣</td><td>■</td><td>■</td></tr><tr><td colspan="6">f 0.05 – 0.45</td></tr><tr><td colspan="6">a_p 0.2 – 4.0</td></tr><tr><td colspan="6"></td></tr><tr><td colspan="6"></td></tr><tr><td colspan="6"> CCMT, DCMT, SCMT, TCMT, VBMT, WCMT</td></tr></table>	P	M	K	N	S	H	■	■	▣	▣	■	■	f 0.05 – 0.45						a _p 0.2 – 4.0																		 CCMT, DCMT, SCMT, TCMT, VBMT, WCMT					
	P	M	K	N	S	H																																								
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 CCMT, DCMT, SCMT, TCMT, VBMT, WCMT																																														

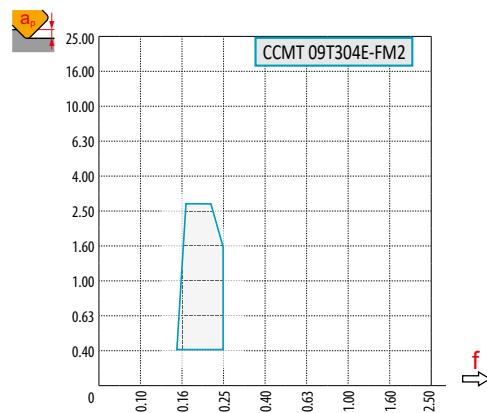
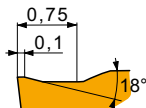
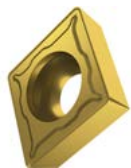
GEOMETRY OF CUTTING POSITIVE INSERTS – CLAMPING DESIGNATION ISO S

FM (RCMT)



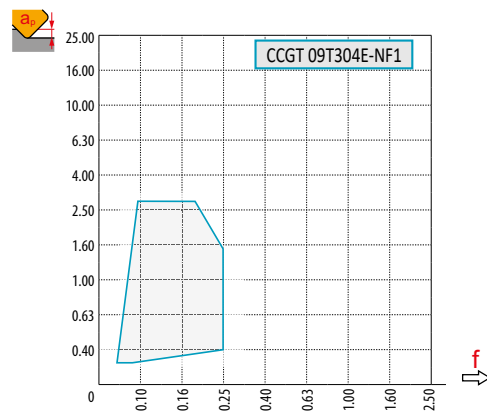
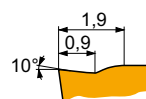
P	M	K	N	S	H
					
	0.10 – 1.0				
	0.3 – 5.0				
					
					
	RCMT				

FM2



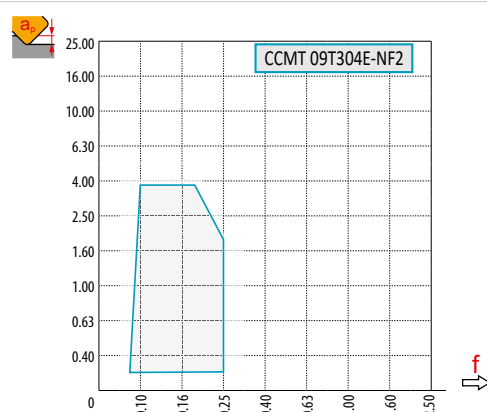
P	M	K	N	S	H
					
	0.04 – 0.4				
	0.2 – 4.0				
					
					
	CCMT, DCMT, ECMT, SCMT, TCMT, VBMT, VCGT				

NF1



P	M	K	N	S	H
					
	0.04 – 0.35				
	0.3 – 3.5				
					
					
	CCGT, DCGT, SCGT, TCGT				

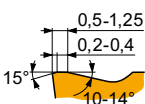
NF2



P	M	K	N	S	H
					
	0.05 – 0.45				
	0.2 – 4.0				
					
					
	CCMT, EPMT, SCMT, TCMT, VCGT				

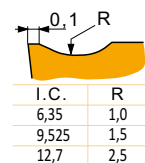
GEOMETRY OF CUTTING POSITIVE INSERTS – CLAMPING DESIGNATION ISO S

OR (SCM)



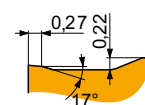
	SCMT				

RF

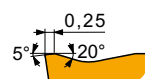


					
	CCMT, DCMT, SCMT, TCMT, WCMT				

R

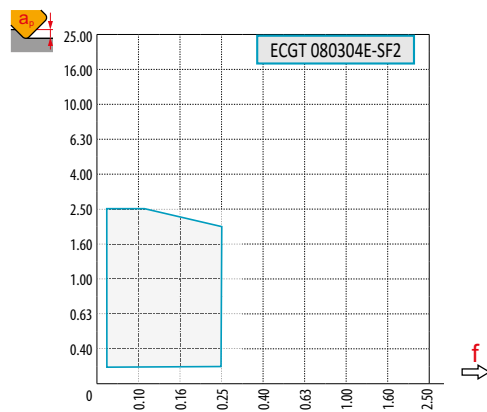
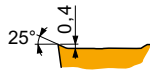


RM



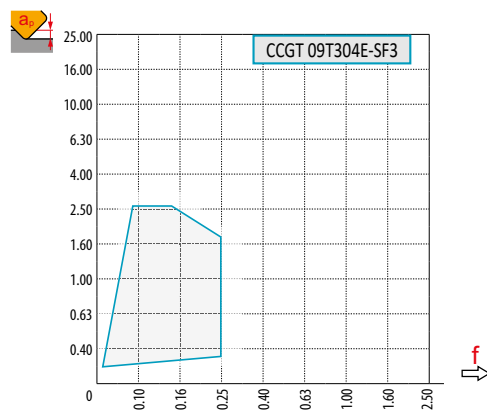
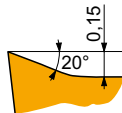
GEOMETRY OF CUTTING POSITIVE INSERTS – CLAMPING DESIGNATION ISO S

SF2



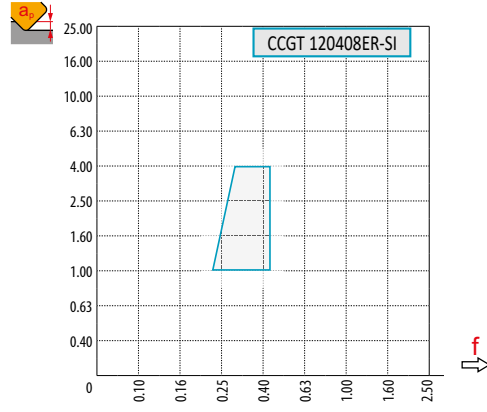
P	M	K	N	S	H
f 0.02 – 0.28					
a_p 0.1 – 2.5					
ECGT, VCGT					

SF3



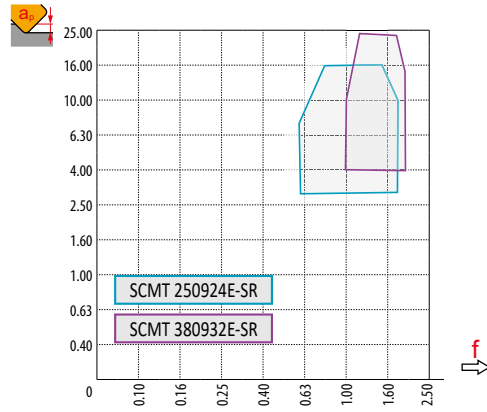
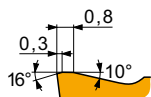
P	M	K	N	S	H
f 0.02 – 0.35					
a_p 0.2 – 4.00					
CCGT, DCGT, ECGT, SCGT, TCGT, VCGT					

SI



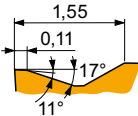
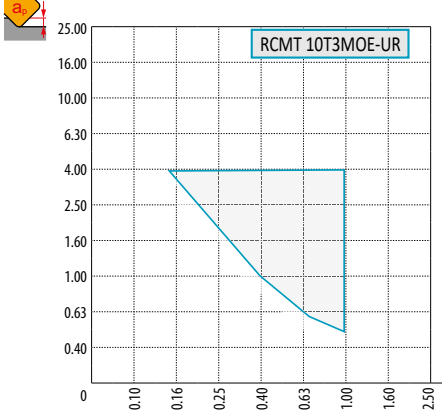
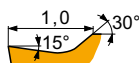
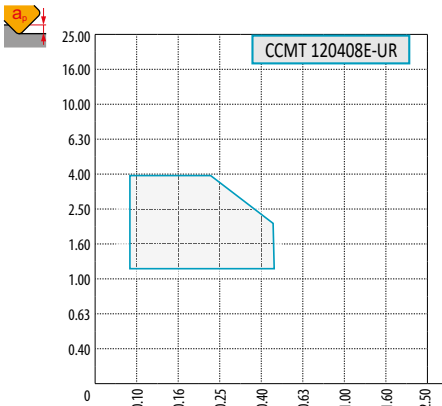
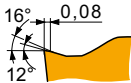
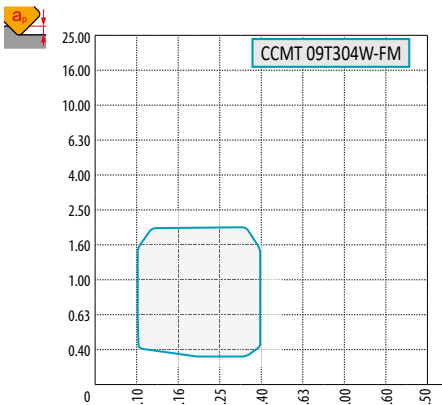
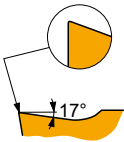
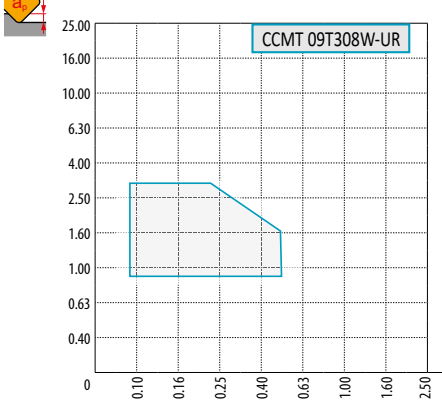
P	M	K	N	S	H
f 0.08 – 0.45					
a_p 0.4 – 4.0					
CCGT, TCGT					

SR (SCMT)



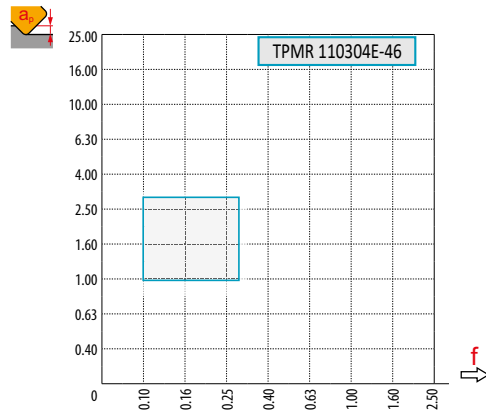
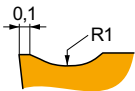
P	M	K	N	S	H
f 0.60 – 2.0					
a_p 3.0 – 24.0					
SCMT					

GEOMETRY OF CUTTING POSITIVE INSERTS – CLAMPING DESIGNATION ISO S

UR (RCMT)				<table><tr><th>P</th><th>M</th><th>K</th><th>N</th><th>S</th><th>H</th></tr><tr><td></td><td></td><td></td><td></td><td></td><td></td></tr><tr><td colspan="6">f 0.15 – 1.00</td></tr><tr><td colspan="6">a_p 0.5 – 5.0</td></tr><tr><td colspan="6"></td></tr><tr><td colspan="6"></td></tr><tr><td colspan="6"> RCMT</td></tr></table>	P	M	K	N	S	H							f 0.15 – 1.00						a_p 0.5 – 5.0																		RCMT					
	P	M	K	N	S	H																																								
f 0.15 – 1.00																																														
a_p 0.5 – 5.0																																														
RCMT																																														
UR				<table><tr><th>P</th><th>M</th><th>K</th><th>N</th><th>S</th><th>H</th></tr><tr><td></td><td></td><td></td><td></td><td></td><td></td></tr><tr><td colspan="6">f 0.10 – 0.40</td></tr><tr><td colspan="6">a_p 1.0 – 4.0</td></tr><tr><td colspan="6"></td></tr><tr><td colspan="6"></td></tr><tr><td colspan="6"> CCMT, DCMT, RCMT, SCMT, TCMT, VCMT, VBMT, WCMT</td></tr></table>	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					
	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				<table><tr><th>P</th><th>M</th><th>K</th><th>N</th><th>S</th><th>H</th></tr><tr><td></td><td></td><td></td><td></td><td></td><td></td></tr><tr><td colspan="6">f 0.1 – 0.4</td></tr><tr><td colspan="6">a_p 0.3 – 3.0</td></tr><tr><td colspan="6"></td></tr><tr><td colspan="6"></td></tr><tr><td colspan="6"> CCMT, DCMX</td></tr></table>	P	M	K	N	S	H							f 0.1 – 0.4						a_p 0.3 – 3.0																		CCMT, DCMX					
	P	M	K	N	S	H																																								
f 0.1 – 0.4																																														
a_p 0.3 – 3.0																																														
CCMT, DCMX																																														
W-UR				<table><tr><th>P</th><th>M</th><th>K</th><th>N</th><th>S</th><th>H</th></tr><tr><td></td><td></td><td></td><td></td><td></td><td></td></tr><tr><td colspan="6">f 0.08 – 0.5</td></tr><tr><td colspan="6">a_p 0.4 – 3.0</td></tr><tr><td colspan="6"></td></tr><tr><td colspan="6"></td></tr><tr><td colspan="6"> CCMT</td></tr></table>	P	M	K	N	S	H							f 0.08 – 0.5						a_p 0.4 – 3.0																		CCMT					
	P	M	K	N	S	H																																								
f 0.08 – 0.5																																														
a_p 0.4 – 3.0																																														
CCMT																																														

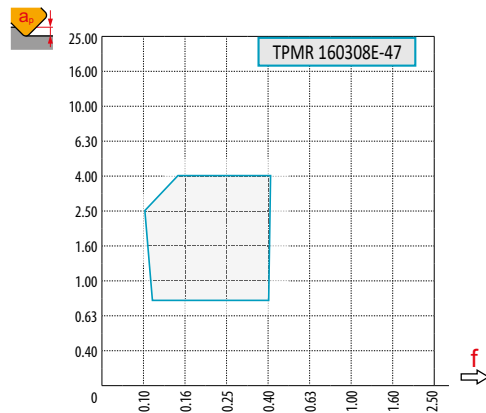
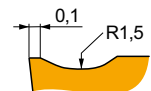
GEOMETRY OF CUTTING POSITIVE INSERTS – CLAMPING DESIGNATION ISO C

46



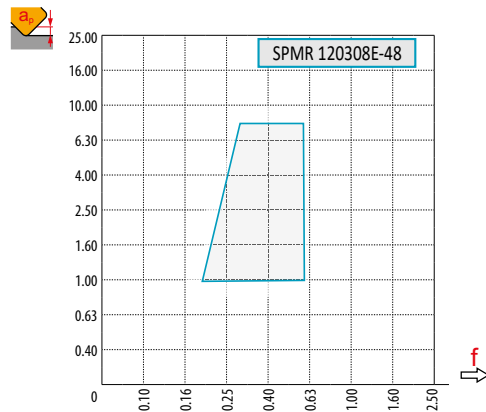
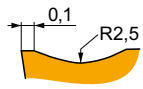
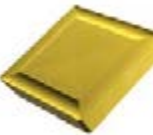
P	M	K	N	S	H
☒	☒	☒	☐	☐	☐
f 0.10 – 0.30					
a _p 1.0 – 3.0					
SPMR, TPMR					

47



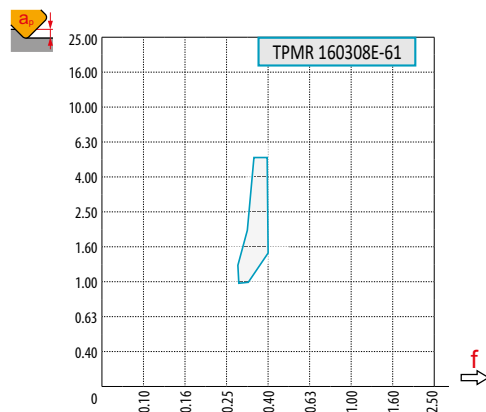
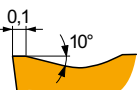
P	M	K	N	S	H
☒	☒	☒	☐	☐	☐
f 0.10 – 0.40					
a _p 0.8 – 4.0					
TPMR					

48



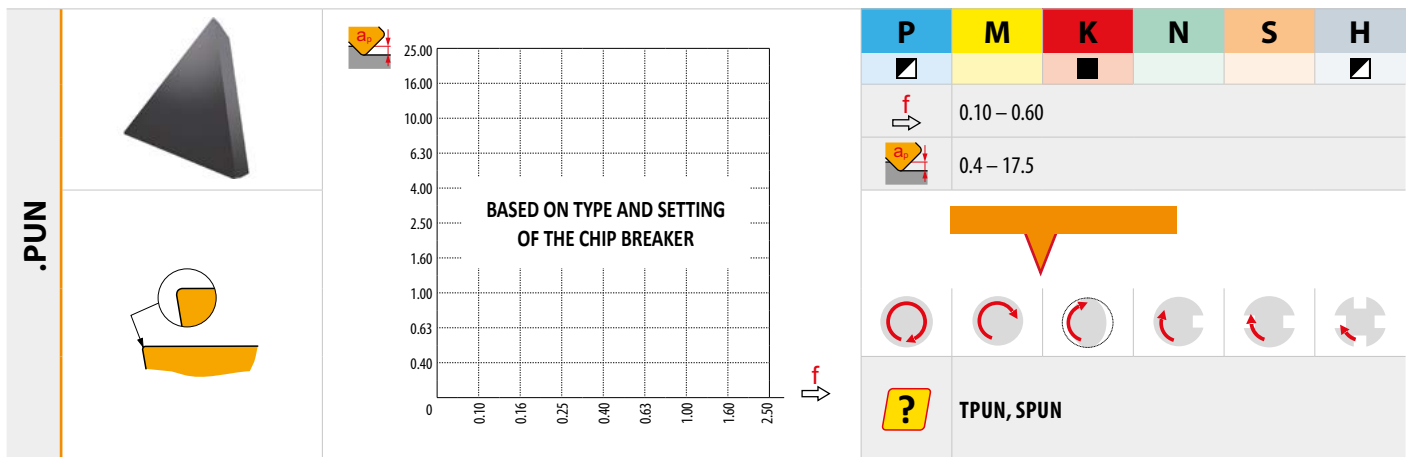
P	M	K	N	S	H
☒	☒	☒	☐	☐	☐
f 0.20 – 0.60					
a _p 1.0 – 8.0					
SPMR					

61



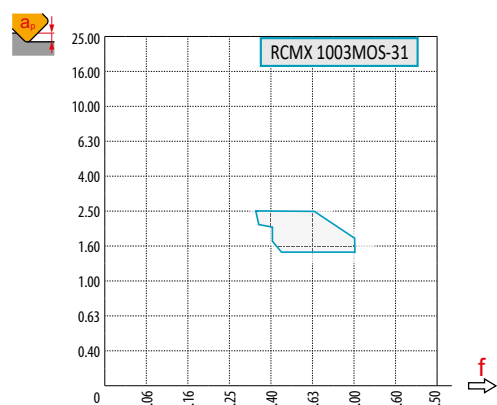
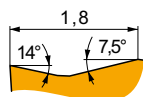
P	M	K	N	S	H
☒	☒	☒	☐	☐	☐
f 0.30 – 0.40					
a _p 1.0 – 5.3					
TPMR					

GEOMETRY OF CUTTING POSITIVE INSERTS – CLAMPING DESIGNATION ISO C



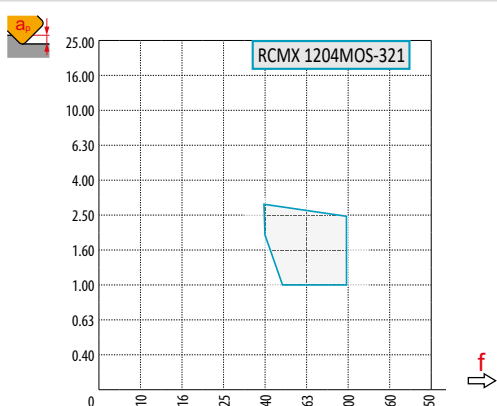
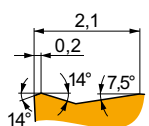
GEOMETRY OF CUTTING POSITIVE INSERTS – CLAMPING DESIGNATION ISO P, M, D

31 (RCMX)



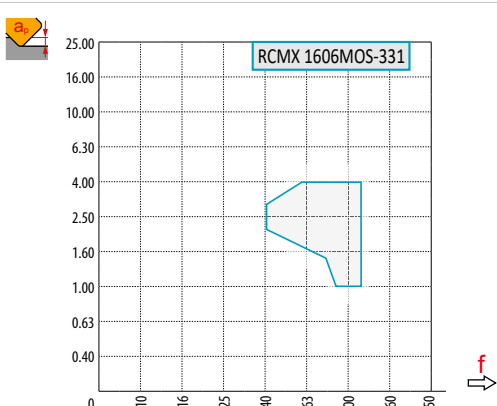
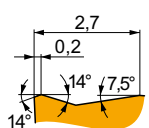
P	M	K	N	S	H
					
	0.40 – 1.00				
	1.5 – 2.5				
					
					
	RCMX				

321 (RCMX)



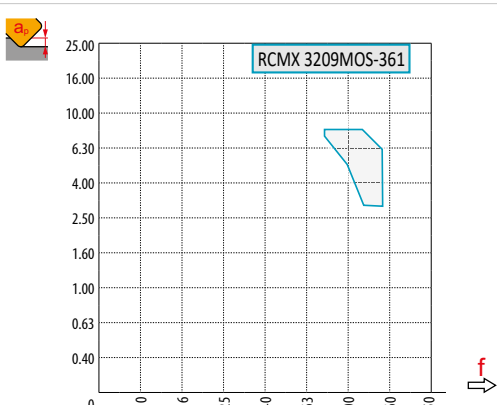
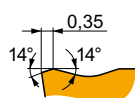
P	M	K	N	S	H
					
	0.40 – 1.00				
	1.0 – 3.0				
					
					
	RCMX				

331 (RCMX)



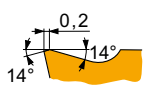
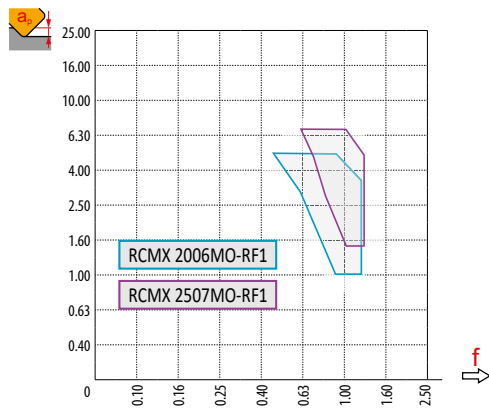
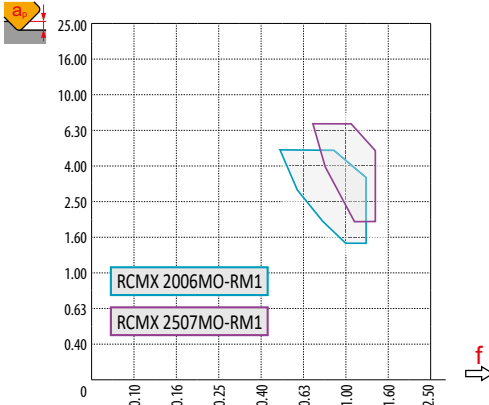
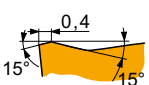
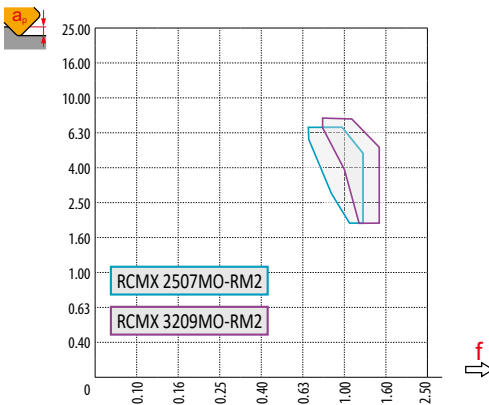
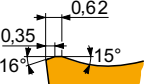
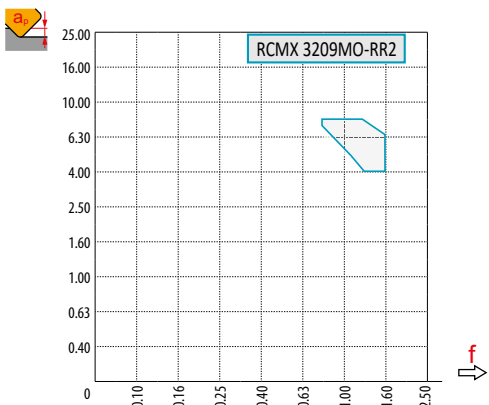
P	M	K	N	S	H
■		■			
	0.40 – 1.20				
	1.0 – 4.0				
					
					
	RCMX				

361 (RCMX)



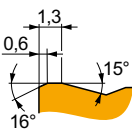
P	M	K	N	S	H
					
	0.80 – 1.50				
	3.0 – 8.0				
					
					
	RCMX				

GEOMETRY OF CUTTING POSITIVE INSERTS – CLAMPING DESIGNATION ISO P, M, D

RF1 (RCMX)	 		<table><tr><th>P</th><th>M</th><th>K</th><th>N</th><th>S</th><th>H</th></tr><tr><td>■</td><td></td><td>▣</td><td></td><td></td><td></td></tr><tr><td>f</td><td colspan="5">0.45 (0.60) – 1.20 (1.25)</td></tr><tr><td>a_p</td><td colspan="5">1.0 (1.5) – 5.0 (7.0)</td></tr><tr><td colspan="6"></td></tr><tr><td>?</td><td colspan="5">RCMX 20, RCMX 25</td></tr></table>	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				
P	M	K	N	S	H																																		
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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)	 		<table><tr><th>P</th><th>M</th><th>K</th><th>N</th><th>S</th><th>H</th></tr><tr><td>■</td><td></td><td>▣</td><td></td><td></td><td></td></tr><tr><td>f</td><td colspan="5">0.50 (0.70) – 1.30 (1.40)</td></tr><tr><td>a_p</td><td colspan="5">1.5 (2.0) – 5.0 (8.0)</td></tr><tr><td colspan="6"></td></tr><tr><td>?</td><td colspan="5">RCMX 20, RCMX 25</td></tr></table>	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				
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.)	 		<table><tr><th>P</th><th>M</th><th>K</th><th>N</th><th>S</th><th>H</th></tr><tr><td>■</td><td></td><td>▣</td><td></td><td></td><td></td></tr><tr><td>f</td><td colspan="5">0.70 (0.80) – 1.30 (1.50)</td></tr><tr><td>a_p</td><td colspan="5">2.0 – 7.0 (8.0)</td></tr><tr><td colspan="6"></td></tr><tr><td>?</td><td colspan="5">RCMX 25, RCMX 32</td></tr></table>	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				
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.)	 		<table><tr><th>P</th><th>M</th><th>K</th><th>N</th><th>S</th><th>H</th></tr><tr><td>■</td><td></td><td>■</td><td></td><td></td><td>▣</td></tr><tr><td>f</td><td colspan="5">0.80 – 1.60</td></tr><tr><td>a_p</td><td colspan="5">4.0 – 8.0</td></tr><tr><td colspan="6"></td></tr><tr><td>?</td><td colspan="5">RCMX 32</td></tr></table>	P	M	K	N	S	H	■		■			▣	f	0.80 – 1.60					a_p	4.0 – 8.0											?	RCMX 32				
P	M	K	N	S	H																																		
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f	0.80 – 1.60																																						
a_p	4.0 – 8.0																																						
																																							
?	RCMX 32																																						

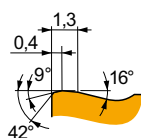
GEOMETRY OF CUTTING NEGATIVE INSERTS – CLAMPING DESIGNATION ISO P, M, D

000 (LNUX)

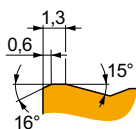


A sequence of six circular icons illustrating the progression of a clockwise rotation. The first icon shows a full circle with a red arrow indicating a 0-degree rotation. The subsequent icons show the rotation increasing in 45-degree increments: 45, 90, 135, 180, and 225 degrees. The final icon shows a 315-degree rotation, where the red arrow points towards the bottom-left. The icons are arranged horizontally and separated by vertical lines.

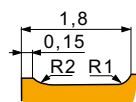
002 (LNUX)



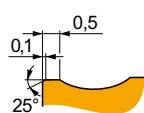
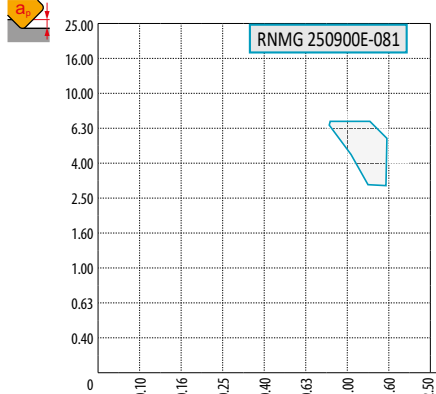
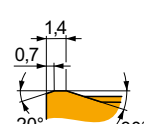
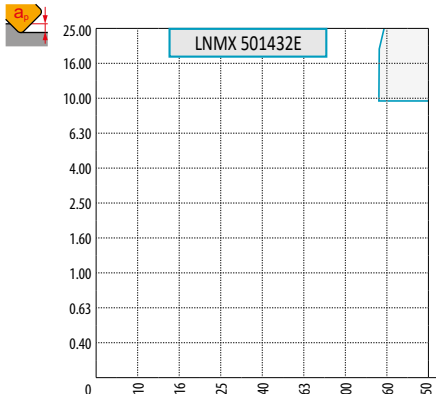
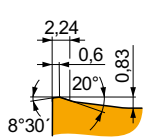
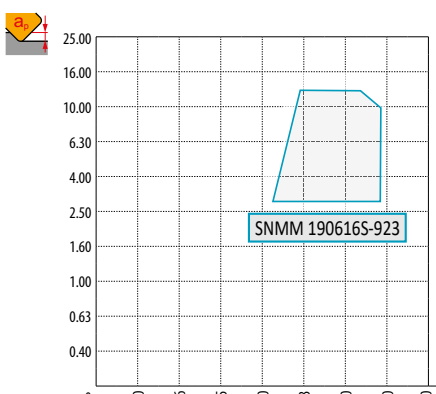
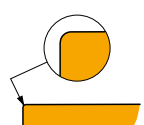
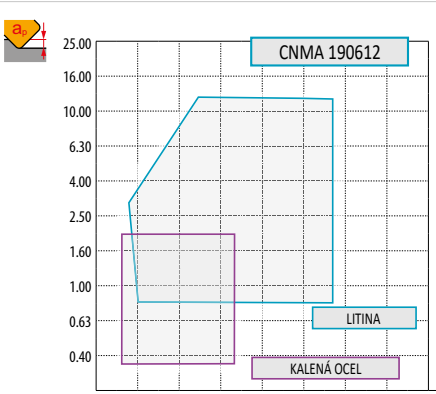
003 (LNUX)



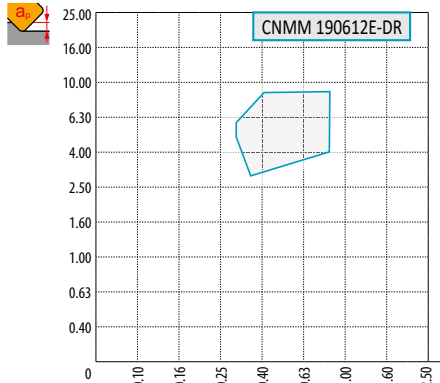
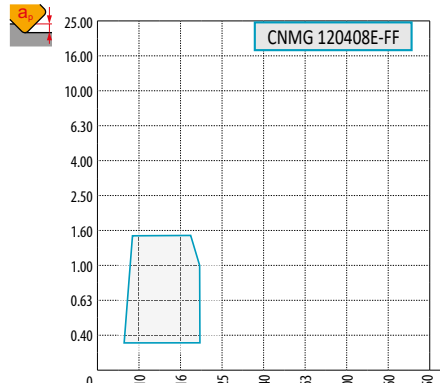
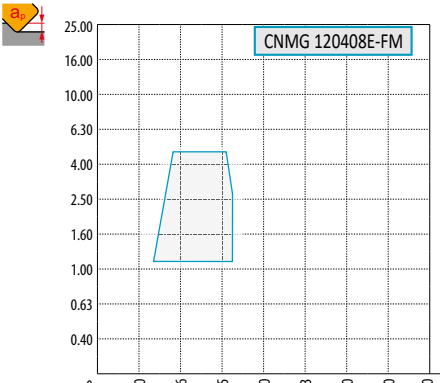
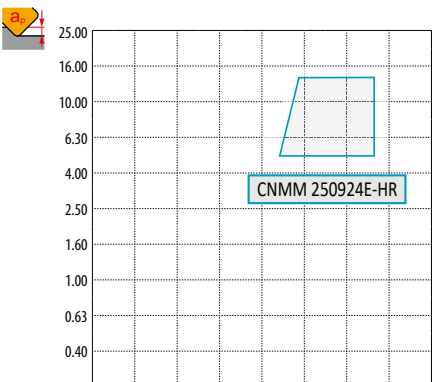
3 (RNMG)



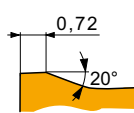
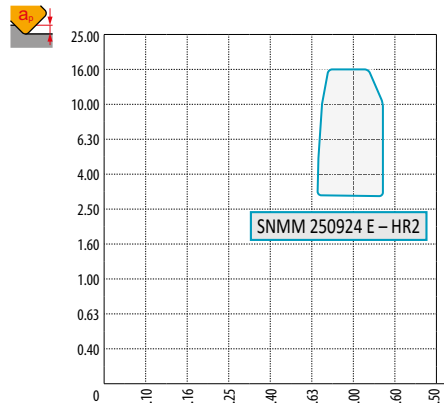
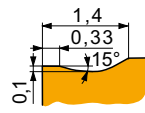
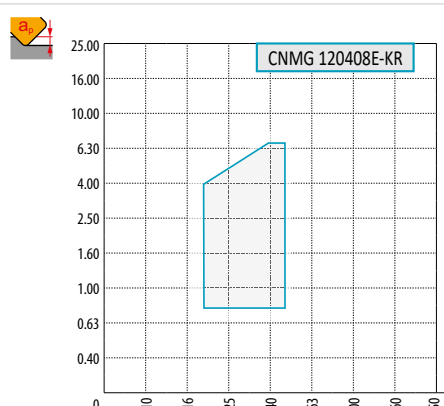
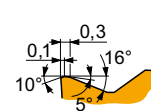
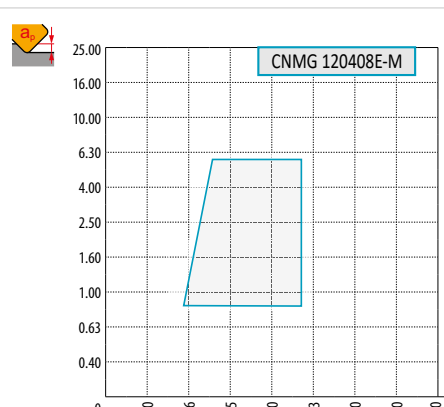
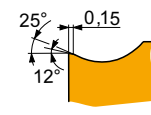
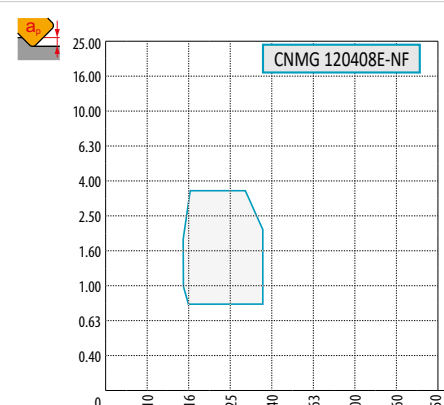
GEOMETRY OF CUTTING NEGATIVE INSERTS – CLAMPING DESIGNATION ISO P, M, D

81 (RNMG)	 	 RNMG 250900E-081	<table><tr><th>P</th><th>M</th><th>K</th><th>N</th><th>S</th><th>H</th></tr><tr><td></td><td></td><td></td><td></td><td></td><td></td></tr><tr><td></td><td colspan="5">0.80 – 1.20</td></tr><tr><td></td><td colspan="5">3.0 – 7.0</td></tr><tr><td colspan="6"></td></tr><tr><td colspan="6"> RNMG</td></tr></table>	P	M	K	N	S	H								0.80 – 1.20						3.0 – 7.0											RNMG					
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	3.0 – 7.0																																						
																																							
RNMG																																							
432 (LNMX)	 	 LNMX 501432E	<table><tr><th>P</th><th>M</th><th>K</th><th>N</th><th>S</th><th>H</th></tr><tr><td></td><td></td><td></td><td></td><td></td><td></td></tr><tr><td></td><td colspan="5">1.50 – 2.60</td></tr><tr><td></td><td colspan="5">10.0 – 35.0</td></tr><tr><td colspan="6"></td></tr><tr><td colspan="6"> LNMX 50</td></tr></table>	P	M	K	N	S	H								1.50 – 2.60						10.0 – 35.0											LNMX 50					
P	M	K	N	S	H																																		
	1.50 – 2.60																																						
	10.0 – 35.0																																						
																																							
LNMX 50																																							
923	 	 SNMM 190616S-923	<table><tr><th>P</th><th>M</th><th>K</th><th>N</th><th>S</th><th>H</th></tr><tr><td></td><td></td><td></td><td></td><td></td><td></td></tr><tr><td></td><td colspan="5">0.45 – 1.50</td></tr><tr><td></td><td colspan="5">3.0 – 16.0</td></tr><tr><td colspan="6"></td></tr><tr><td colspan="6"> CNMM, SNMM</td></tr></table>	P	M	K	N	S	H								0.45 – 1.50						3.0 – 16.0											CNMM, SNMM					
P	M	K	N	S	H																																		
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	3.0 – 16.0																																						
																																							
CNMM, SNMM																																							
...A	 	 CNMA 190612 LITINA KALENÁ OCEL	<table><tr><th>P</th><th>M</th><th>K</th><th>N</th><th>S</th><th>H</th></tr><tr><td></td><td></td><td></td><td></td><td></td><td></td></tr><tr><td></td><td colspan="5">0.10 – 1.10</td></tr><tr><td></td><td colspan="5">0.8 – 12.7</td></tr><tr><td colspan="6"></td></tr><tr><td colspan="6"> CNMA, DNMA, SNMA, TNMA, WNMA</td></tr></table>	P	M	K	N	S	H								0.10 – 1.10						0.8 – 12.7											CNMA, DNMA, SNMA, TNMA, WNMA					
P	M	K	N	S	H																																		
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CNMA, DNMA, SNMA, TNMA, WNMA																																							

GEOMETRY OF CUTTING NEGATIVE INSERTS – CLAMPING DESIGNATION ISO P, M, D

DR			<table><tr><th>P</th><th>M</th><th>K</th><th>N</th><th>S</th><th>H</th></tr><tr><td></td><td></td><td></td><td></td><td></td><td></td></tr><tr><td></td><td colspan="5">0.30 – 0.85</td></tr><tr><td></td><td colspan="5">2.5 – 9.0</td></tr><tr><td colspan="6"></td></tr><tr><td></td><td></td><td></td><td></td><td></td><td></td></tr><tr><td></td><td colspan="5">CNMM, DNMM, SNMM, TNMM, WNMM</td></tr></table>	P	M	K	N	S	H								0.30 – 0.85						2.5 – 9.0																		CNMM, DNMM, SNMM, TNMM, WNMM				
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	CNMM, DNMM, SNMM, TNMM, WNMM																																												
FF			<table><tr><th>P</th><th>M</th><th>K</th><th>N</th><th>S</th><th>H</th></tr><tr><td></td><td></td><td></td><td></td><td></td><td></td></tr><tr><td></td><td colspan="5">0.06 – 0.25</td></tr><tr><td></td><td colspan="5">0.2 – 1.6</td></tr><tr><td colspan="6"></td></tr><tr><td></td><td></td><td></td><td></td><td></td><td></td></tr><tr><td></td><td colspan="5">CNMG, DNMG, TNMG, VNMG, WNMG</td></tr></table>	P	M	K	N	S	H								0.06 – 0.25						0.2 – 1.6																		CNMG, DNMG, TNMG, VNMG, WNMG				
P	M	K	N	S	H																																								
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FM			<table><tr><th>P</th><th>M</th><th>K</th><th>N</th><th>S</th><th>H</th></tr><tr><td></td><td></td><td></td><td></td><td></td><td></td></tr><tr><td></td><td colspan="5">0.1 – 0.5</td></tr><tr><td></td><td colspan="5">0.4 – 5.0</td></tr><tr><td colspan="6"></td></tr><tr><td></td><td></td><td></td><td></td><td></td><td></td></tr><tr><td></td><td colspan="5">CNMG, DNMG, SNMG, TNMG, VNMG, WNMG</td></tr></table>	P	M	K	N	S	H								0.1 – 0.5						0.4 – 5.0																		CNMG, DNMG, SNMG, TNMG, VNMG, WNMG				
P	M	K	N	S	H																																								
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HR			<table><tr><th>P</th><th>M</th><th>K</th><th>N</th><th>S</th><th>H</th></tr><tr><td></td><td></td><td></td><td></td><td></td><td></td></tr><tr><td></td><td colspan="5">0.50 – 1.40</td></tr><tr><td></td><td colspan="5">5.0 – 14.0</td></tr><tr><td colspan="6"></td></tr><tr><td></td><td></td><td></td><td></td><td></td><td></td></tr><tr><td></td><td colspan="5">CNMM, SNMM, TNMM</td></tr></table>	P	M	K	N	S	H								0.50 – 1.40						5.0 – 14.0																		CNMM, SNMM, TNMM				
P	M	K	N	S	H																																								
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	CNMM, SNMM, TNMM																																												

GEOMETRY OF CUTTING NEGATIVE INSERTS – CLAMPING DESIGNATION ISO P, M, D

HR2			 	<table><tr><th>P</th><th>M</th><th>K</th><th>N</th><th>S</th><th>H</th></tr><tr><td></td><td></td><td></td><td></td><td></td><td></td></tr><tr><td></td><td colspan="5">0.5 – 1.4</td></tr><tr><td></td><td colspan="5">3.0 – 16.0</td></tr></table>    CNMM, SNMM	P	M	K	N	S	H								0.5 – 1.4						3.0 – 16.0				
	P	M	K	N	S	H																						
																												
	0.5 – 1.4																											
	3.0 – 16.0																											
KR			 	<table><tr><th>P</th><th>M</th><th>K</th><th>N</th><th>S</th><th>H</th></tr><tr><td></td><td></td><td></td><td></td><td></td><td></td></tr><tr><td></td><td colspan="5">0.2 – 0.7</td></tr><tr><td></td><td colspan="5">0.4 – 7</td></tr></table>    CNMG, SNMG, TNMG, WNMG	P	M	K	N	S	H								0.2 – 0.7						0.4 – 7				
	P	M	K	N	S	H																						
																												
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M			 	<table><tr><th>P</th><th>M</th><th>K</th><th>N</th><th>S</th><th>H</th></tr><tr><td></td><td></td><td></td><td></td><td></td><td></td></tr><tr><td></td><td colspan="5">0.17 – 0.80</td></tr><tr><td></td><td colspan="5">0.8 – 8.0</td></tr></table>    CNMG, DNMG, SNMG, TNMG, VNMG, WNMG	P	M	K	N	S	H								0.17 – 0.80						0.8 – 8.0				
	P	M	K	N	S	H																						
																												
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NF			 	<table><tr><th>P</th><th>M</th><th>K</th><th>N</th><th>S</th><th>H</th></tr><tr><td></td><td></td><td></td><td></td><td></td><td></td></tr><tr><td></td><td colspan="5">0.1 – 0.35</td></tr><tr><td></td><td colspan="5">0.4 – 4.0</td></tr></table>    CNMG, DNMG, SNMG, TNMG, VNMG, WNMG	P	M	K	N	S	H								0.1 – 0.35						0.4 – 4.0				
	P	M	K	N	S	H																						
																												
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GEOMETRY OF CUTTING NEGATIVE INSERTS – CLAMPING DESIGNATION ISO P, M, D

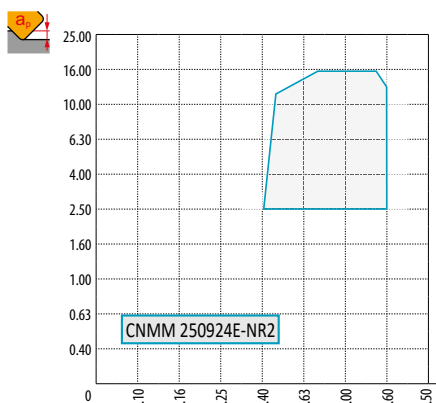
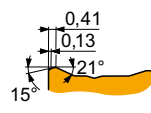
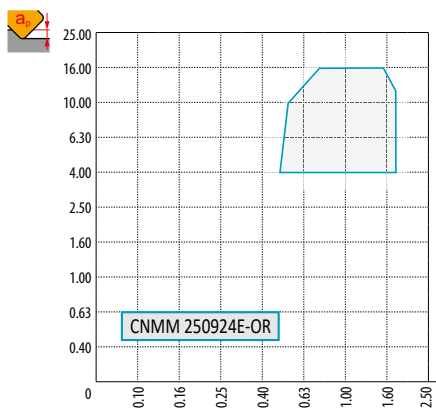
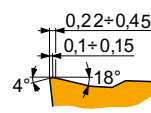
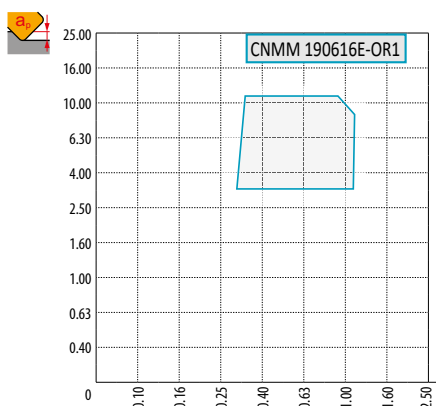
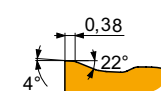
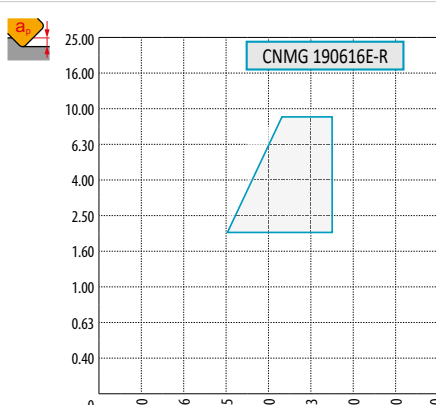
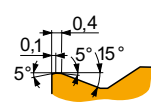
NM			<table><tr><th>P</th><th>M</th><th>K</th><th>N</th><th>S</th><th>H</th></tr><tr><td>■</td><td>■</td><td>■</td><td>■</td><td>■</td><td>■</td></tr><tr><td colspan="2">f → 0.15 – 0.55</td><td colspan="4"></td></tr><tr><td colspan="2">a_p ↓ 0.5 – 8.0</td><td colspan="4"></td></tr></table>	P	M	K	N	S	H	■	■	■	■	■	■	f → 0.15 – 0.55						a _p ↓ 0.5 – 8.0					
	P	M	K	N	S	H																					
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NMR			<table><tr><th>P</th><th>M</th><th>K</th><th>N</th><th>S</th><th>H</th></tr><tr><td>■</td><td>■</td><td>■</td><td>■</td><td>■</td><td>■</td></tr><tr><td colspan="2">f → 0.18 – 0.70</td><td colspan="4"></td></tr><tr><td colspan="2">a_p ↓ 0.4 – 8.0</td><td colspan="4"></td></tr></table>	P	M	K	N	S	H	■	■	■	■	■	■	f → 0.18 – 0.70						a _p ↓ 0.4 – 8.0					
	P	M	K	N	S	H																					
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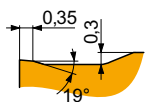
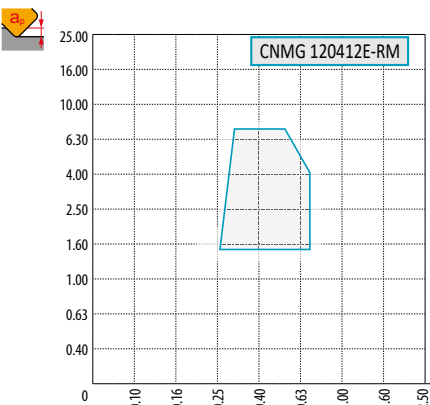
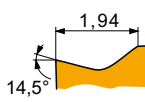
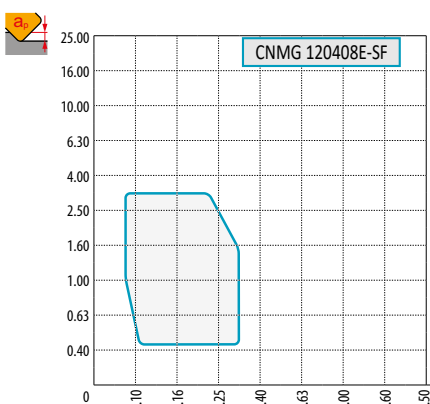
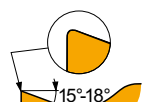
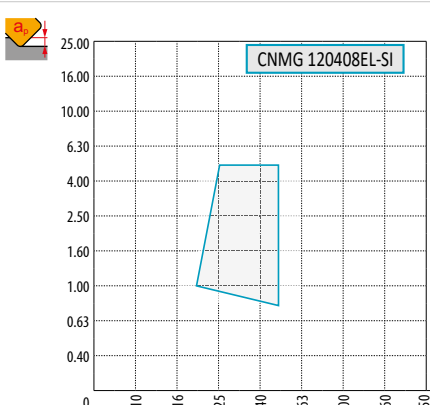
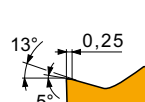
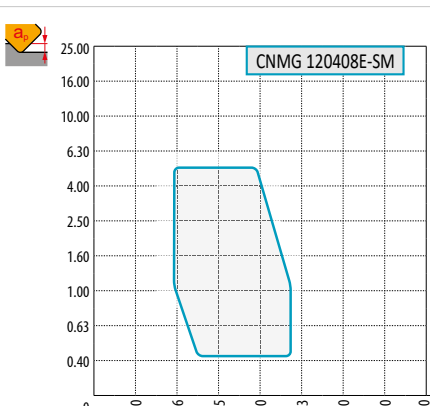
NR			<table><tr><th>P</th><th>M</th><th>K</th><th>N</th><th>S</th><th>H</th></tr><tr><td>■</td><td>■</td><td>■</td><td>■</td><td>■</td><td>■</td></tr><tr><td colspan="2">f → 0.25 – 0.80</td><td colspan="4"></td></tr><tr><td colspan="2">a_p ↓ 1.0 – 9.0</td><td colspan="4"></td></tr></table>	P	M	K	N	S	H	■	■	■	■	■	■	f → 0.25 – 0.80						a _p ↓ 1.0 – 9.0					
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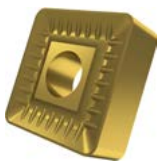
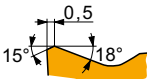
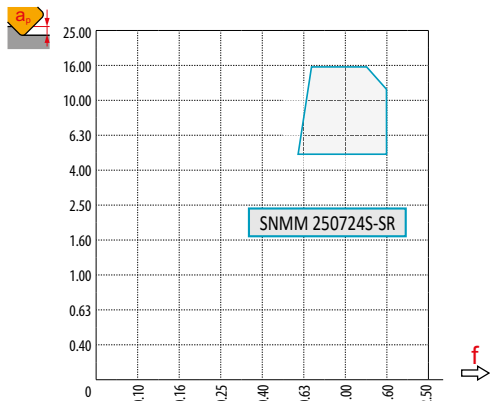
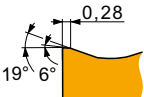
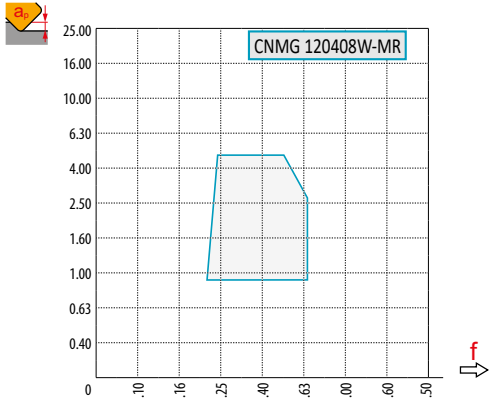
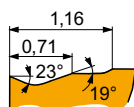
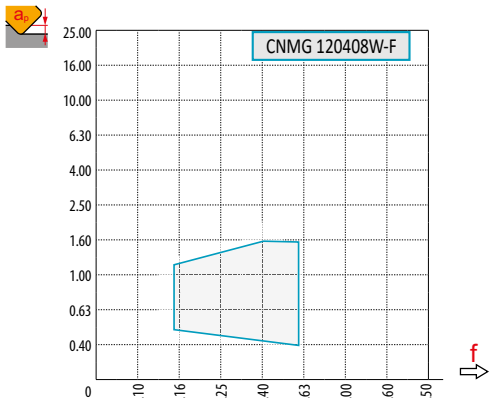
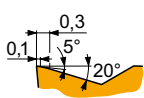
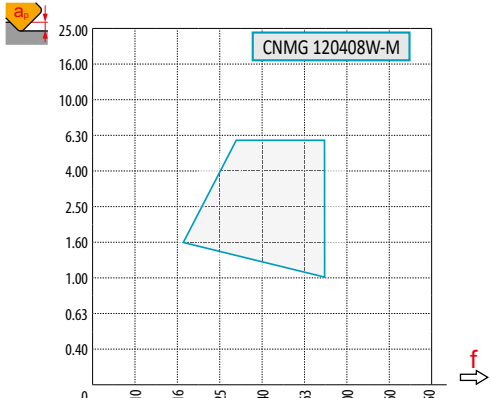
GEOMETRY OF CUTTING NEGATIVE INSERTS – CLAMPING DESIGNATION ISO P, M, D

NR2			<table><tr><th>P</th><th>M</th><th>K</th><th>N</th><th>S</th><th>H</th></tr><tr><td>■</td><td>■</td><td>▣</td><td>■</td><td>▣</td><td>■</td></tr><tr><td></td><td colspan="5">0.2 – 1.6</td></tr><tr><td></td><td colspan="5">1.0 – 16.0</td></tr><tr><td colspan="6"></td></tr><tr><td colspan="6"></td></tr><tr><td></td><td colspan="5">CNMM, DNMM, SNMM, TNMM, WNMM</td></tr></table>	P	M	K	N	S	H	■	■	▣	■	▣	■		0.2 – 1.6						1.0 – 16.0																		CNMM, DNMM, SNMM, TNMM, WNMM				
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GEOMETRY OF CUTTING NEGATIVE INSERTS – CLAMPING DESIGNATION ISO P, M, D

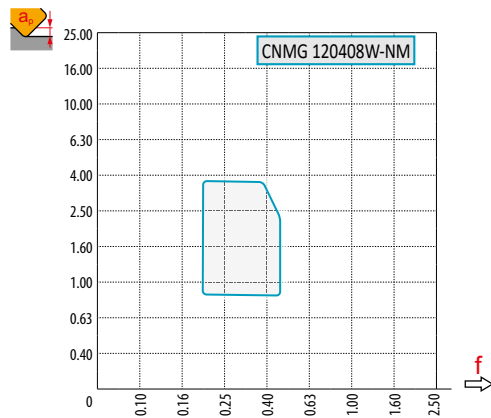
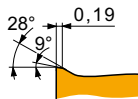
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GEOMETRY OF CUTTING NEGATIVE INSERTS – CLAMPING DESIGNATION ISO P, M, D

SR			 SNMM 250724S-SR	<table><tr><th>P</th><th>M</th><th>K</th><th>N</th><th>S</th><th>H</th></tr><tr><td>■</td><td>▣</td><td>■</td><td>■</td><td>■</td><td>■</td></tr><tr><td colspan="2">f</td><td colspan="4">0.70 – 1.60</td></tr><tr><td colspan="2">ap</td><td colspan="4">5.0 – 16.0</td></tr><tr><td colspan="6"></td></tr><tr><td colspan="6"></td></tr><tr><td colspan="2">?</td><td colspan="4">SNMM, SNMX</td></tr></table>	P	M	K	N	S	H	■	▣	■	■	■	■	f		0.70 – 1.60				ap		5.0 – 16.0																?		SNMM, SNMX			
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W-MR			 CNMG 120408W-MR	<table><tr><th>P</th><th>M</th><th>K</th><th>N</th><th>S</th><th>H</th></tr><tr><td>■</td><td>▣</td><td>▣</td><td>■</td><td>■</td><td>■</td></tr><tr><td colspan="2">f</td><td colspan="4">0.2 – 0.75</td></tr><tr><td colspan="2">ap</td><td colspan="4">0.5 – 5.0</td></tr><tr><td colspan="6"></td></tr><tr><td colspan="6"></td></tr><tr><td colspan="2">?</td><td colspan="4">CNMG, WNMG, DNMG</td></tr></table>	P	M	K	N	S	H	■	▣	▣	■	■	■	f		0.2 – 0.75				ap		0.5 – 5.0																?		CNMG, WNMG, DNMG			
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W-F			 CNMG 120408W-F	<table><tr><th>P</th><th>M</th><th>K</th><th>N</th><th>S</th><th>H</th></tr><tr><td>■</td><td>■</td><td>■</td><td>■</td><td>■</td><td>■</td></tr><tr><td colspan="2">f</td><td colspan="4">0.10 – 0.60</td></tr><tr><td colspan="2">ap</td><td colspan="4">0.4 – 1.6</td></tr><tr><td colspan="6"></td></tr><tr><td colspan="6"></td></tr><tr><td colspan="2">?</td><td colspan="4">CNMG, WNMG</td></tr></table>	P	M	K	N	S	H	■	■	■	■	■	■	f		0.10 – 0.60				ap		0.4 – 1.6																?		CNMG, WNMG			
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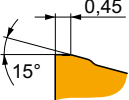
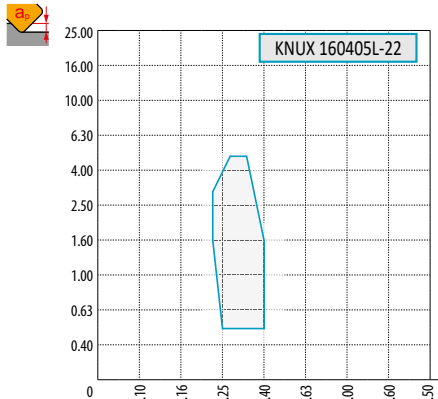
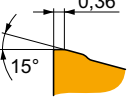
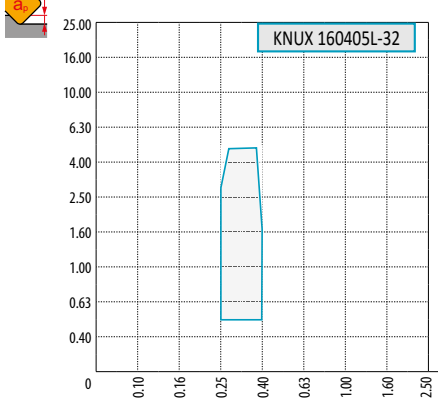
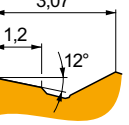
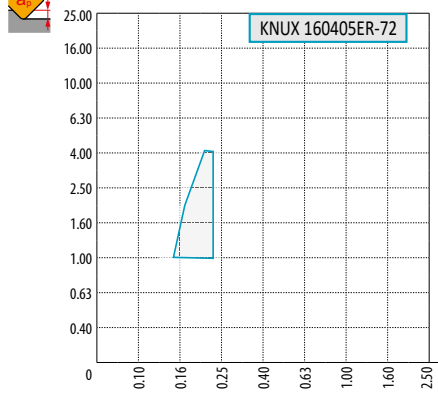
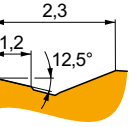
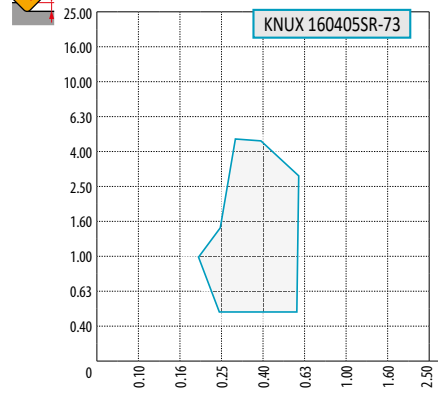
GEOMETRY OF CUTTING NEGATIVE INSERTS – CLAMPING DESIGNATION ISO P, M, D

W-NM



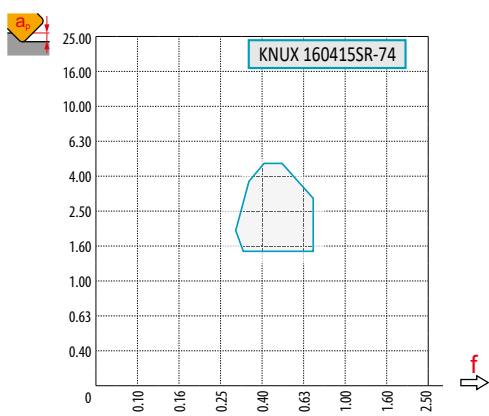
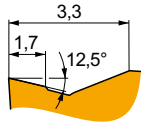
P	M	K	N	S	H
					
 	0.15 – 0.55				
	0.5 – 3.5				
					
					
	CNMG, DNMX, WNMG				

GEOMETRY OF CUTTING NEGATIVE INSERTS – CLAMPING DESIGNATION ISO C

22	 	 KNUX 160405L-22 	<table><tr><th>P</th><th>M</th><th>K</th><th>N</th><th>S</th><th>H</th></tr><tr><td></td><td></td><td></td><td></td><td></td><td></td></tr><tr><td colspan="6">f → 0.23 – 0.55</td></tr><tr><td colspan="6"> 0.50 – 4.80</td></tr><tr><td colspan="6"></td></tr><tr><td colspan="6"></td></tr><tr><td colspan="6"> KNUX</td></tr></table>	P	M	K	N	S	H							f → 0.23 – 0.55						0.50 – 4.80																		KNUX					
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32	 	 KNUX 160405L-32 	<table><tr><th>P</th><th>M</th><th>K</th><th>N</th><th>S</th><th>H</th></tr><tr><td></td><td></td><td></td><td></td><td></td><td></td></tr><tr><td colspan="6">f → 0.25 – 0.6</td></tr><tr><td colspan="6"> 0.50 – 4.80</td></tr><tr><td colspan="6"></td></tr><tr><td colspan="6"></td></tr><tr><td colspan="6"> KNUX</td></tr></table>	P	M	K	N	S	H							f → 0.25 – 0.6						0.50 – 4.80																		KNUX					
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KNUX																																													
73	 	 KNUX 160405SR-73 	<table><tr><th>P</th><th>M</th><th>K</th><th>N</th><th>S</th><th>H</th></tr><tr><td></td><td></td><td></td><td></td><td></td><td></td></tr><tr><td colspan="6">f → 0.20 – 0.60</td></tr><tr><td colspan="6"> 0.5 – 4.8</td></tr><tr><td colspan="6"></td></tr><tr><td colspan="6"></td></tr><tr><td colspan="6"> KNUX</td></tr></table>	P	M	K	N	S	H							f → 0.20 – 0.60						0.5 – 4.8																		KNUX					
P	M	K	N	S	H																																								
f → 0.20 – 0.60																																													
0.5 – 4.8																																													
KNUX																																													

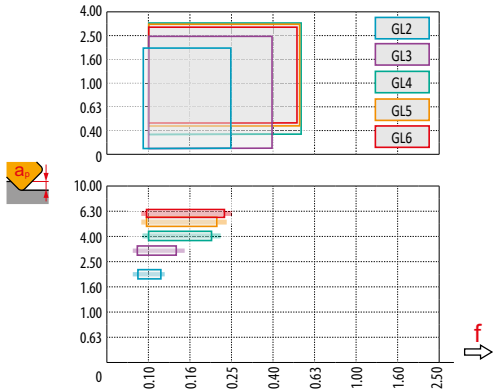
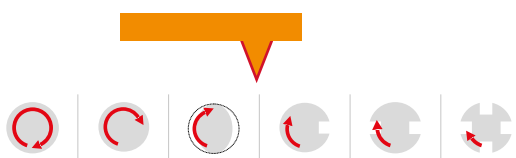
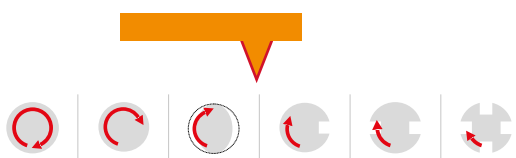
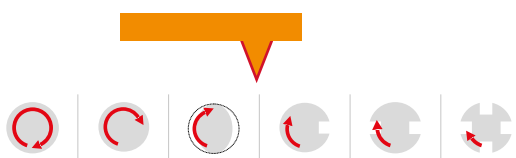
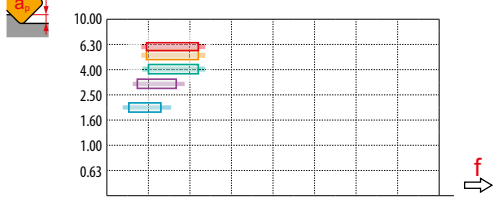
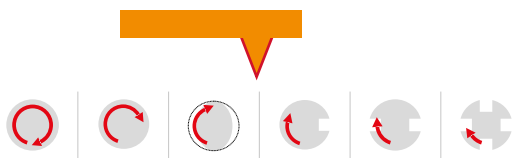
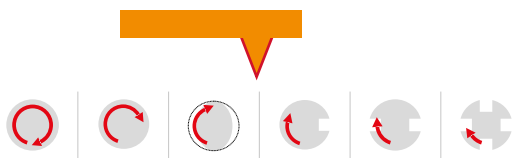
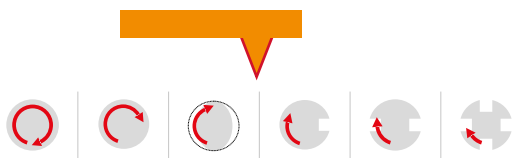
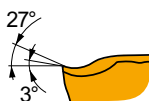
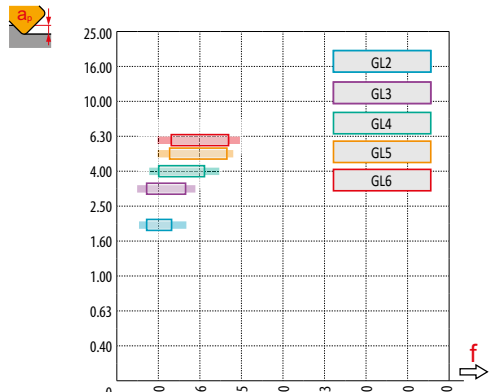
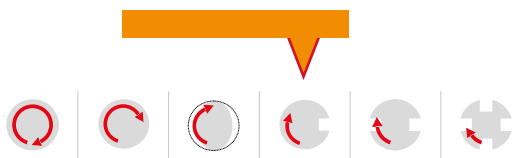
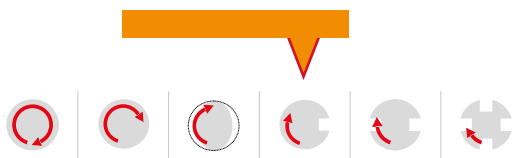
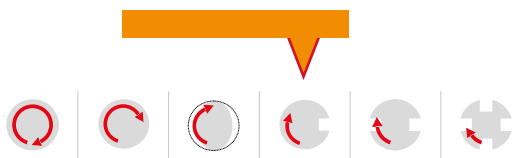
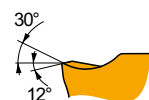
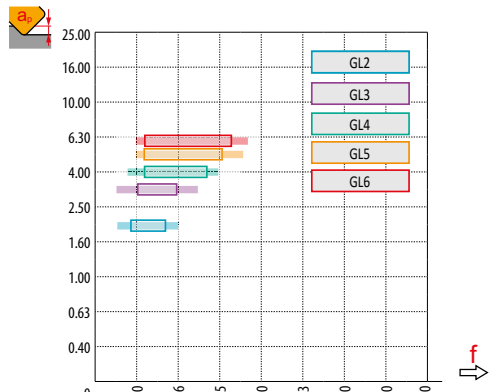
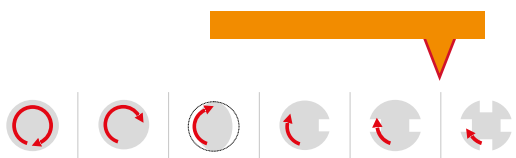
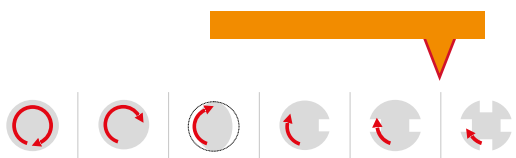
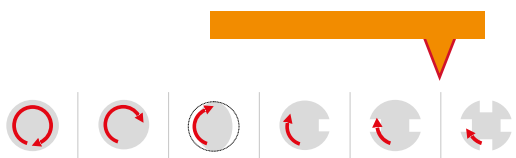
GEOMETRY OF CUTTING NEGATIVE INSERTS – CLAMPING DESIGNATION ISO C

74



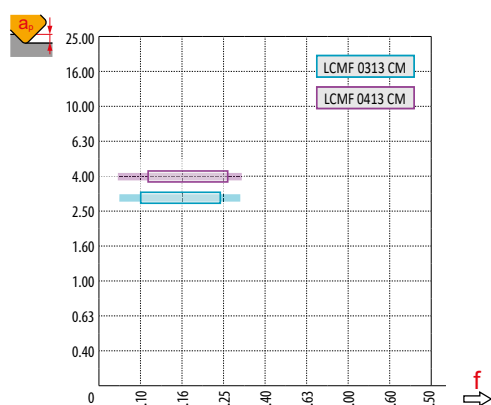
P	M	K	N	S	H
					
	0.30 – 0.7				
	1.5 – 4.8				
					
					
	KNUX				

GEOMETRY OF CUTTING GROOVING INSERTS – CLAMPING DESIGNATION ISO X AND G

GM (GL.D) NEW				<table><tr><th>P</th><th>M</th><th>K</th><th>N</th><th>S</th><th>H</th></tr><tr><td>■</td><td>■</td><td>▣</td><td>■</td><td>▣</td><td>■</td></tr><tr><td colspan="6">See diagram</td></tr><tr><td colspan="6"></td></tr><tr><td colspan="6">? GL.D</td></tr></table>	P	M	K	N	S	H	■	■	▣	■	▣	■	See diagram												? GL.D					
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See diagram																																		
																																		
? GL.D																																		
PM (GL.D) NEW				<table><tr><th>P</th><th>M</th><th>K</th><th>N</th><th>S</th><th>H</th></tr><tr><td>■</td><td>■</td><td>▣</td><td>■</td><td>▣</td><td>■</td></tr><tr><td colspan="6">See diagram</td></tr><tr><td colspan="6"></td></tr><tr><td colspan="6">? GL.D</td></tr></table>	P	M	K	N	S	H	■	■	▣	■	▣	■	See diagram												? GL.D					
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See diagram																																		
																																		
? GL.D																																		
PR (GL.D) NEW				<table><tr><th>P</th><th>M</th><th>K</th><th>N</th><th>S</th><th>H</th></tr><tr><td>■</td><td>▣</td><td>■</td><td>■</td><td>■</td><td>■</td></tr><tr><td colspan="6">See diagram</td></tr><tr><td colspan="6"></td></tr><tr><td colspan="6">? GL.D</td></tr></table>	P	M	K	N	S	H	■	▣	■	■	■	■	See diagram												? GL.D					
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See diagram																																		
																																		
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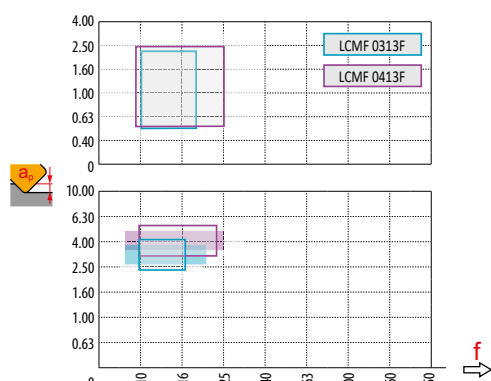
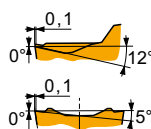
GEOMETRY OF CUTTING GROOVING INSERTS – CLAMPING DESIGNATION ISO X AND G

13 CM (LCMF)



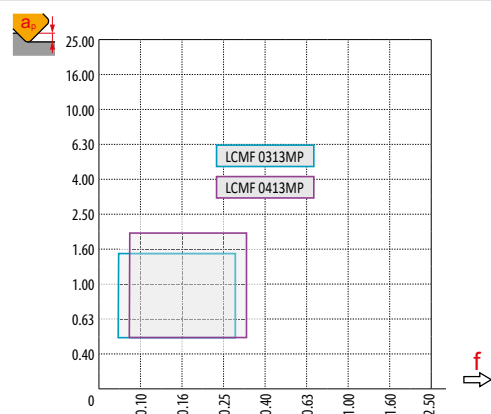
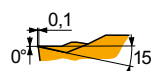
P	M	K	N	S	H
					
 	See diagram				
					
					
	LCMF 13 CM				

13 F (LCM.)



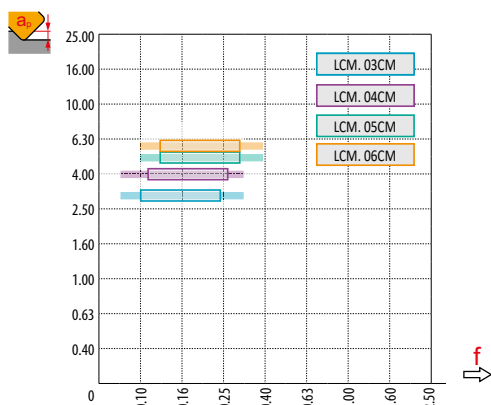
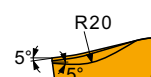
P	M	K	N	S	H
					
 	See diagram				
					
					
	LCMF 13 F, LCMR 13 F				

13 MP (LCM.)



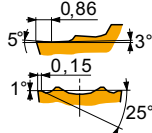
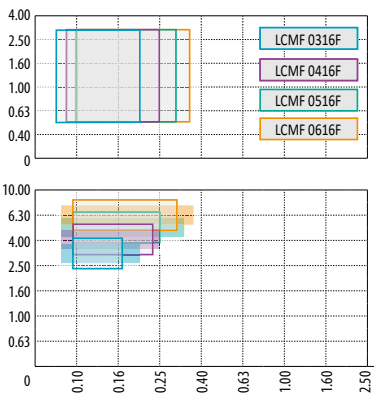
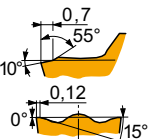
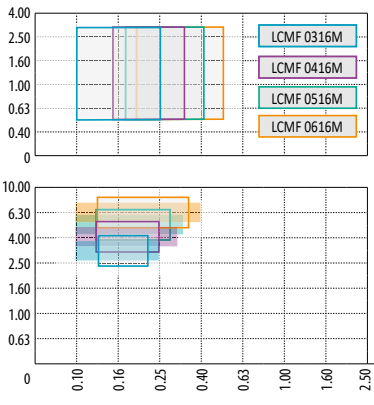
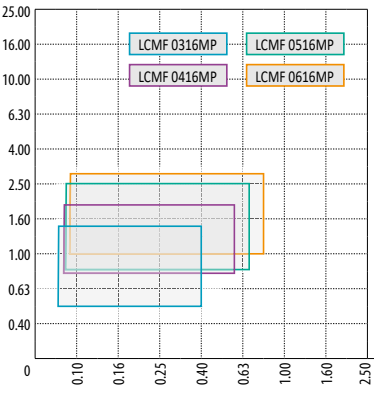
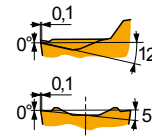
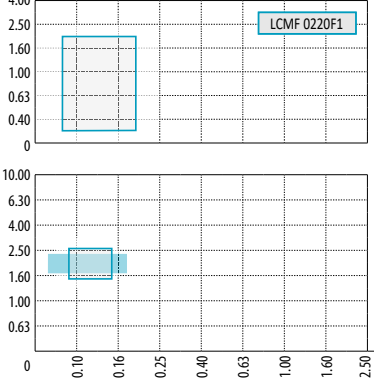
P	M	K	N	S	H
					
	See diagram				
					
					
	LCMF 13 MP, LCMR 13 MP				

16 CM (LCM.)



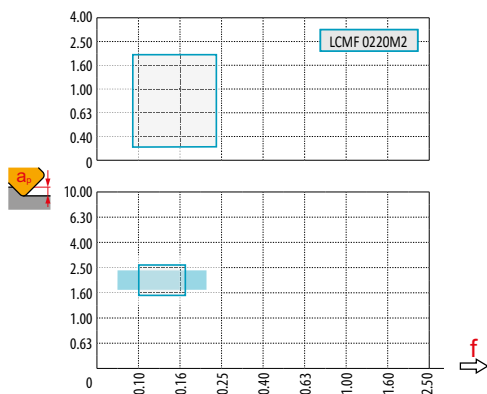
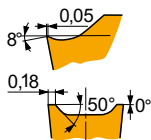
P	M	K	N	S	H
					
 	See diagram				
					
					
	LCMF 16 CM, LCMR 16 CM				

GEOMETRY OF CUTTING GROOVING INSERTS – CLAMPING DESIGNATION ISO X AND G

16 F (LCM.)			 	<table><tr><th>P</th><th>M</th><th>K</th><th>N</th><th>S</th><th>H</th></tr><tr><td>■</td><td></td><td>▣</td><td></td><td></td><td></td></tr><tr><td></td><td colspan="5">See diagram</td></tr><tr><td colspan="6"></td></tr><tr><td></td><td></td><td></td><td></td><td></td><td></td></tr><tr><td>?</td><td colspan="5">LCMF 16 F, LCMR 16 F</td></tr></table>	P	M	K	N	S	H	■		▣					See diagram																	?	LCMF 16 F, LCMR 16 F				
	P	M	K	N	S	H																																		
■		▣																																						
	See diagram																																							
																																								
																																								
?	LCMF 16 F, LCMR 16 F																																							
16 M (LCM.)			 	<table><tr><th>P</th><th>M</th><th>K</th><th>N</th><th>S</th><th>H</th></tr><tr><td>■</td><td></td><td>■</td><td></td><td></td><td>▣</td></tr><tr><td></td><td colspan="5">See diagram</td></tr><tr><td colspan="6"></td></tr><tr><td></td><td></td><td></td><td></td><td></td><td></td></tr><tr><td>?</td><td colspan="5">LCMF 16 M, LCMR 16 M</td></tr></table>	P	M	K	N	S	H	■		■			▣		See diagram																	?	LCMF 16 M, LCMR 16 M				
	P	M	K	N	S	H																																		
■		■			▣																																			
	See diagram																																							
																																								
																																								
?	LCMF 16 M, LCMR 16 M																																							
16 MP (LCM.)			 	<table><tr><th>P</th><th>M</th><th>K</th><th>N</th><th>S</th><th>H</th></tr><tr><td>■</td><td></td><td>■</td><td></td><td></td><td></td></tr><tr><td></td><td colspan="5">See diagram</td></tr><tr><td colspan="6"></td></tr><tr><td></td><td></td><td></td><td></td><td></td><td></td></tr><tr><td>?</td><td colspan="5">LCMF 16 MP, LCMR 16 MP</td></tr></table>	P	M	K	N	S	H	■		■					See diagram																	?	LCMF 16 MP, LCMR 16 MP				
	P	M	K	N	S	H																																		
■		■																																						
	See diagram																																							
																																								
																																								
?	LCMF 16 MP, LCMR 16 MP																																							
20 F1 (LCMF)			 	<table><tr><th>P</th><th>M</th><th>K</th><th>N</th><th>S</th><th>H</th></tr><tr><td>■</td><td>▣</td><td>▣</td><td></td><td></td><td></td></tr><tr><td></td><td colspan="5">See diagram</td></tr><tr><td colspan="6"></td></tr><tr><td></td><td></td><td></td><td></td><td></td><td></td></tr><tr><td>?</td><td colspan="5">LCMF</td></tr></table>	P	M	K	N	S	H	■	▣	▣					See diagram																	?	LCMF				
	P	M	K	N	S	H																																		
■	▣	▣																																						
	See diagram																																							
																																								
																																								
?	LCMF																																							

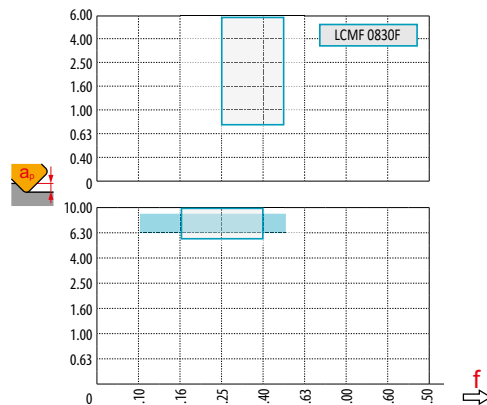
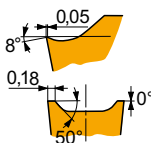
GEOMETRY OF CUTTING GROOVING INSERTS – CLAMPING DESIGNATION ISO X AND G

20 M2 (LCMF)



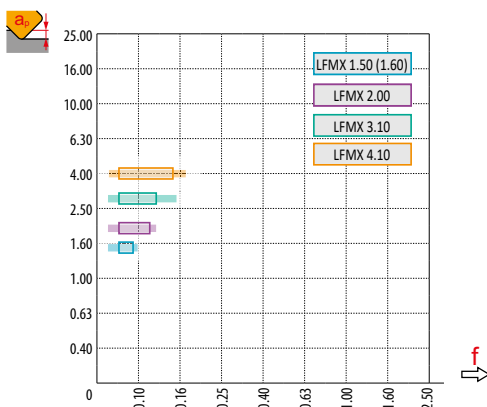
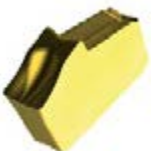
P	M	K	N	S	H
					
	0.09 – 0.23				
	0.3 – 1.5				
					
					
	LCMF				

30 F (LCMF)



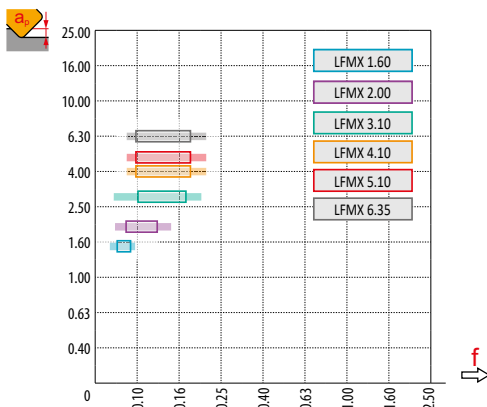
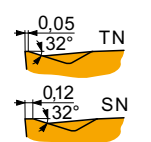
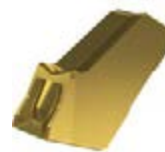
P	M	K	N	S	H
					
	0.1 – 0.5				
	0.8 – 6.0				
					
					
	LCMF 30 F, LCMR 30 F				

F1 (LFMX)



P	M	K	N	S	H
					
	See diagram				
					
					
					
	LFMX				

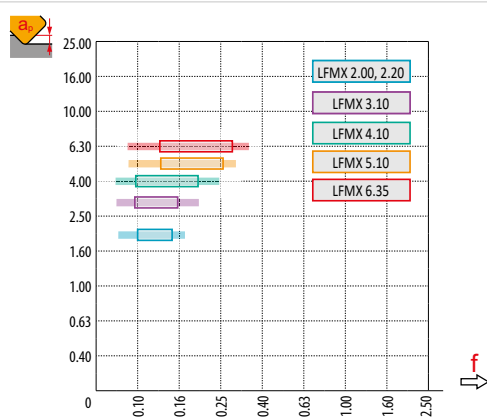
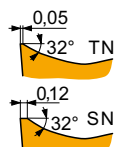
F2 (LFMX)



P	M	K	N	S	H
					
	See diagram				
					
					
					
	LFMX				

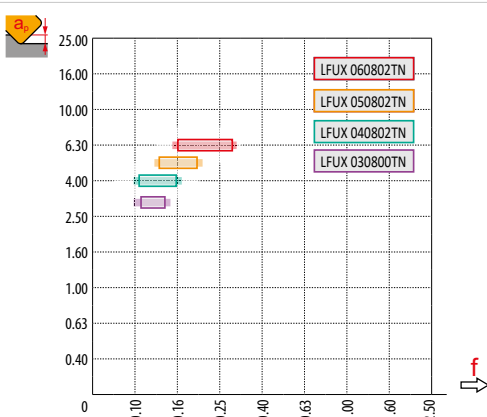
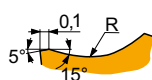
GEOMETRY OF CUTTING GROOVING INSERTS – CLAMPING DESIGNATION ISO X AND G

M2 (LFMX)



P	M	K	N	S	H
	See diagram				
	LFMX				

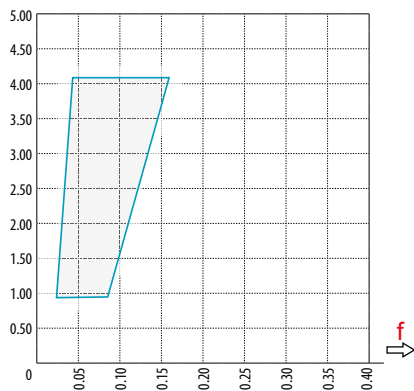
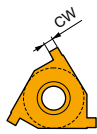
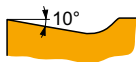
LFUX



P	M	K	N	S	H
	See diagram				
	LFUX				

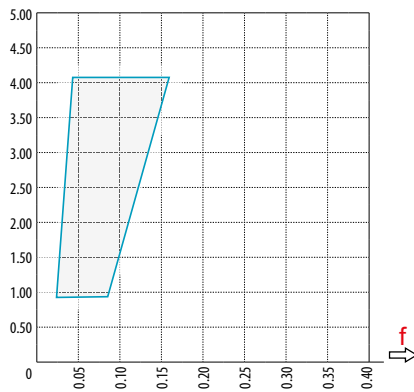
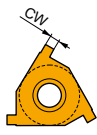
GEOMETRY OF CUTTING GROOVING INSERTS – CLAMPING DESIGNATION ISO S

TN. EXT



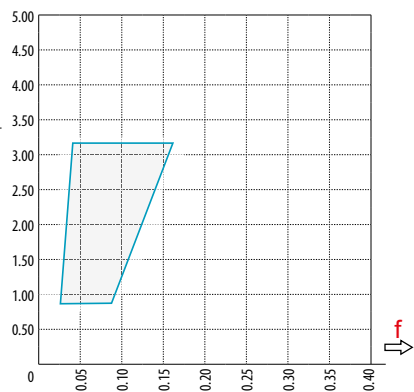
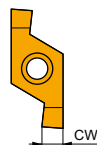
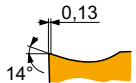
P	M	K	N	S	H
■	▣	▣	■	■	■
	See diagram				
CW					
?	TN R EXT; TN ZZ EXT				

TN. INT



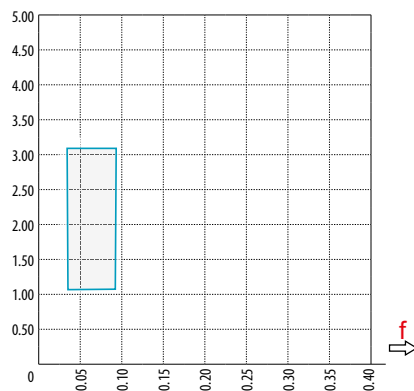
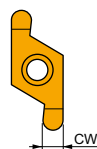
P	M	K	N	S	H
■	▣	▣	■	■	■
	See diagram				
CW					
?	TN R INT; TN ZZ INT				

X61 NEW



P	M	K	N	S	H
■	▣	▣	■	■	■
	See diagram				
CW					
?	X61; X61-1				

X61 R NEW



P	M	K	N	S	H
■	▣	▣	■	■	■
	See diagram				
CW					
?	X61 R; X61 R-1				

T

Operation



D	Boring
M	Fresing
T	Sorvaus
G	Grooving and Parting off

9

Belegg / substrat



0 PVD 1 CVD	Spesialapplikasjon
2 PVD 3 CVD	Fri
4 PVD 5 CVD	Gruppe K, H
6 PVD 7 CVD	Gruppe M, S
8 PVD 9 CVD	Universal
B	CBN
C	Keramisk
D	PCD
T	Cermet

3

Generation

**1 – 9****1****5**

ISO-område



01 – 50	
	01 – 05
	05 – 10
	10 – 20
	20 – 30
	30 – 40
	40 – 50

TURNING GRADES

Grade Identification	Area of Application	Application	Feed	Cutting speed	Resistance to adverse Working Conditions	Coating	Colour	Substrate	Coolant benefit	Grade description
T9226	P15 - P35	■				MT-CVD	Yellow	FGM	+++	Grade designed for heavy roughing applications. A versatile grade with high resistance to mechanical damage and retains very good wear resistance. Usable at lower cutting speeds.
	M10 - M30	■								
	K15 - K35	■								
	S15 - S25	□								
T9310	P01 - P15	■				MT-CVD	Black	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.
	K05 - K20	■								
	H10 - H20	■								
T9315	P05 - P25	■				MT-CVD	Black	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 its well balanced properties this grade can be first choice for a wide range of turning operations. Not suited to low cutting speeds.
	K05 - K25	■								
	H10 - H20	■								
T9316	P10 - P20	■				MT-CVD	Yellow	FGM	+++	Grade designed for railway applications. A versatile grade with excellent wear resistance properties. Usable at lower and high cutting speeds.
	M05 - M15	■								
	K10 - K30	■								
	H15 - H25	■								
T9325	P15 - P35	■				MT-CVD	Black	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.
	M10 - M30	■								
	K15 - K35	■								
	S10 - S20	■								
T9335	P20 - P45	■				MT-CVD	Black	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.
	M15 - M40	■								
	S15 - S25	■								
T7325	P15 - P35	■				MT-CVD	Black	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.
	M10 - M25	■								
	S10 - S25	■								
T7335	P20 - P40	■				MT-CVD	Black	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.
	M20 - M40	■								
	S15 - S25	■								
T5305	P05 - P15	■				MT-CVD	Black	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.
	K01 - K15	■								
	H05 - H15	■								
T5315	P10 - P25	■				MT-CVD	Black	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.
	K10 - K25	■								
	H15 - H25	■								
6640	P20 - P40	■				MT-CVD	Yellow	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.
	M20 - M35	■								
	K25 - K40	■								

TURNING GRADES

Grade Identification	Area of Application	Application	Feed	Cutting speed	Resistance to adverse Working Conditions	Coating	Colour	Substrate	Coolant benefit	Grade description
G8330	P25 - P40	■				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.
	M20 - M35	■								
	K20 - K40	■								
	S15 - S25	■								
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	■				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
	M01 - M15	■								
	K05 - K20	■								
	N05 - N20	■								
	S01 - S15	■								
	H01 - H15	■								
T8010	P05 - P15	■				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
	M05 - M15	■								
	K10 - K20	■								
	S10 - S15	■								
T8030	P25 - P40	■				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.
	M20 - M35	■								
	K20 - K40	■								
	N15 - N30	■								
	S15 - S25	■								
T8315	P05 - P20	■				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.
	M05 - M20	■								
	K05 - K25	■								
	N05 - N25	■								
	S05 - S15	■								
	H05 - H15	■								
T8330	P25 - P40	■				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.
	M20 - M35	■								
	K20 - K40	■								
	N15 - N30	■								
	S15 - S25	■								
	H15 - H25	■								
T8430 NEW	P20 - P40	■				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.
	M20 - M35	■								
	K25 - K40	■								
	N15 - N30	■								
	S15 - S25	■								
	H15 - H25	■								
T8345	P30 - P50	■				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.
	M20 - M40	■								
	K30 - K40	■								
	S20 - S30	■								
HF7	M10 - M20	■				×		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.
	K10 - K25	■								
	N10 - N25	■								

TURNING GRADES

Grade Identification	Area of Application	Application	Feed	Cutting speed	Resistance to adverse Working Conditions	Coating	Colour	Substrate	Coolant benefit	Grade description
H07	M05 - M15	■				×		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.
	K10 - K25	■								
	N10 - N30	■								
	S01 - S20	■								
TT310	P10 - P25	■				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.
	M15 - M25	■								
TT010	P01 - P10	■				×		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.
	M01 - M10	■								
TC100	K01 - K15	■				×		ceramics	--	Ceramic grade for cast iron machining. Suitable for machining with high cutting speed at stable conditions.
TB310	K01 - K10	■				×		CBN	--	CBN grade for machining of hardened materials. Suitable for machining with high cutting speed and small feeds at stable conditions.
	S05 - S10	■								
	H01 - H10	■								
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	■				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.
	M35 - M40	■								
	K35 - K40	■								

Substrat	
H	WC-Co basert substrat
submicron H	WC-Co-basert substrat, finkornet (< 1 µm)
ultra submicron H	WC-Co-basert substrat, svært finkornet (< 0,5 µm)
FGM	Funksjonelt gradert substrat
Cermet	Sementert karbid uten WC
ceramics	Keramisk skær
PCD	Polykrystallinsk diamant
CBN	Kubisk bornitrid
HSS	High speed steel

Belegg	
MT-CVD	Medium-temperatur kjemisk metode for belegging
PVD	Lav-temperatur fysisk metode for belegging
×	Ubelagt grad

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

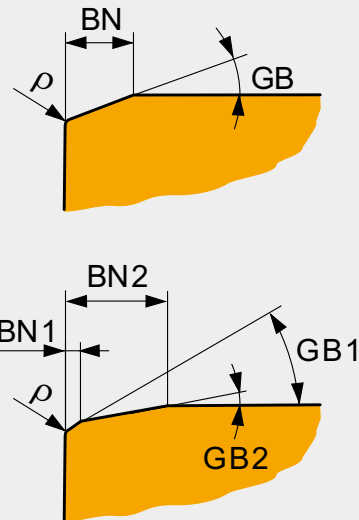
T01020 ⇒

Kant-finishing

BN (BN2)

GB (BN1 × GB1 illustrere BN2 × GB2)

Eksempel: **CNGA 120404 T02020** – skjær CNGA 120404 ned T-land (skjæreggdesign T) bredde 0,2 mm og vinkel -20°

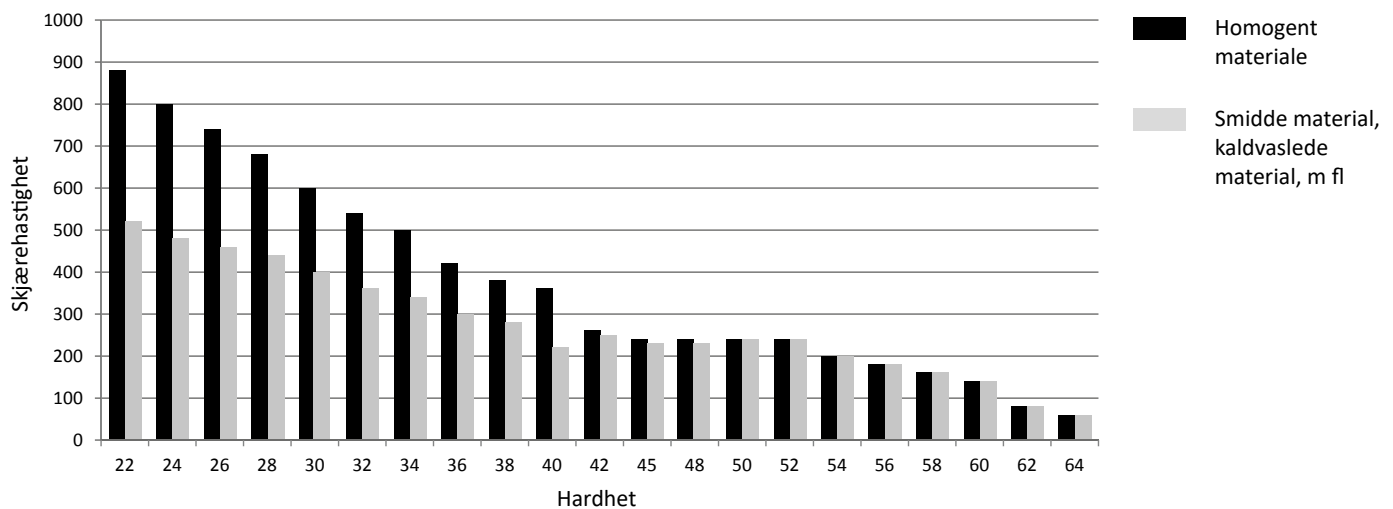


Keramiske skjær for materialer som har ett av de høyeste nivåene av termisk stabilitet.

Ved praktisk bruk er det imidlertid nødvendig å redusere skjærehastigheten med hensyn på hardheten til det maskinerte materialet og dets andre karakteristikk.

For å illustrere dette har vi gitt et konkret eksempel på en rundt skjær som brukes til findreiging.

Skjærehastighet for RNGN ($a_p = 1.5$ mm)



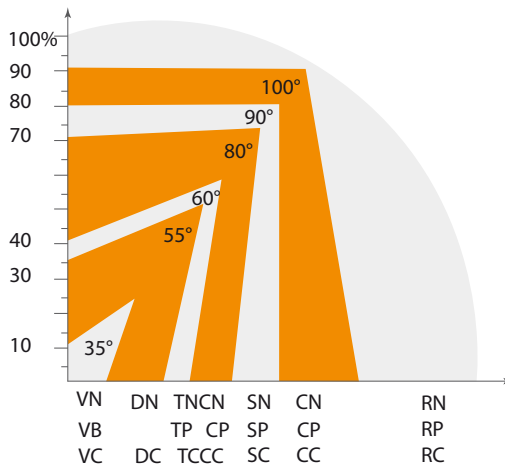
Den følgende tabellen gir ytterligere parametere som det må tas hensyn til ved valg av skjærehastighet som skal brukes.

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 %

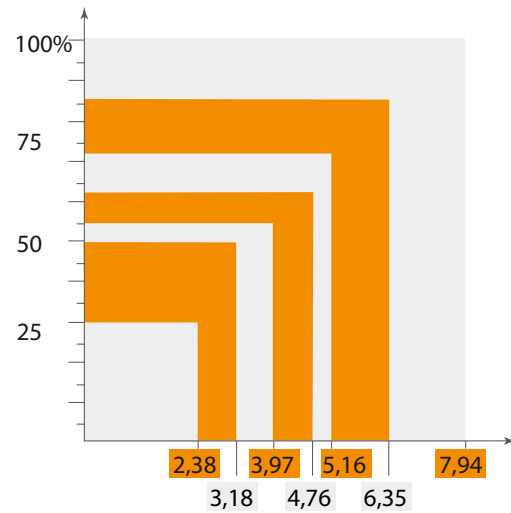
Som tidligere angitt, er keramikk materialer som har ett av de høyeste nivåene av termisk stabilitet, samtidig har de også noen av de laveste nivåene av styrke.

Med hensyn på stivhet, er det derfor også nødvendig å ta hensyn til andre begrensende kriterier ved valg av riktig skjær.

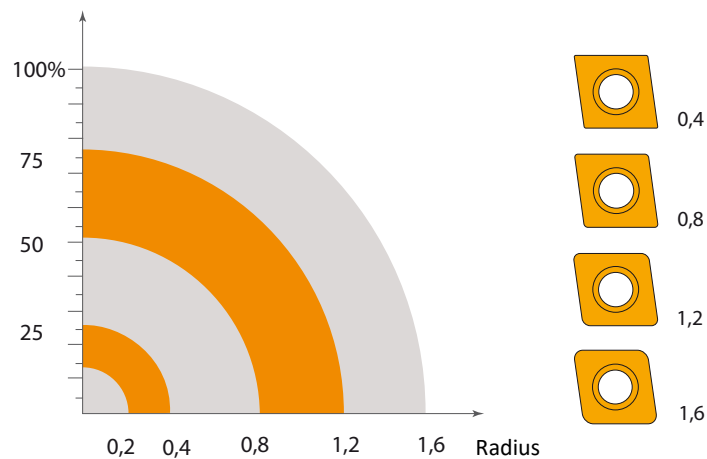
Stivhet i forhold til skjærets form



Stivhet i forhold til skjærets tykkelse

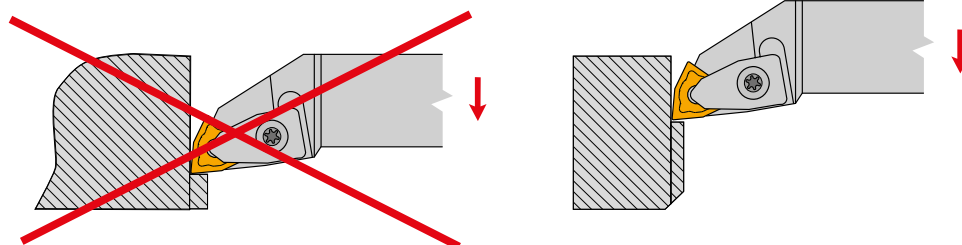


Stivhet i forhold til skjærets neseradius

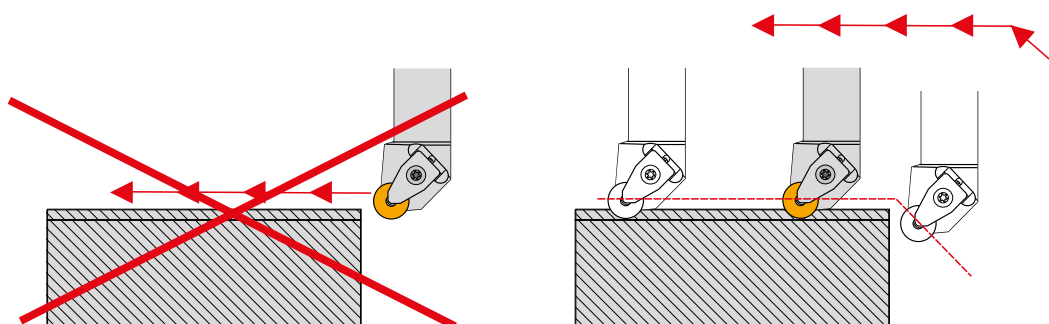


Til slutt vil vi gjerne gi noen praktiske anbefalinger med hensyn på praktisk bruk:

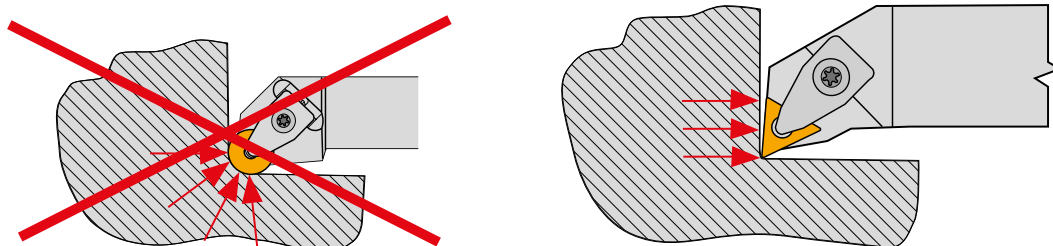
- 1) Grader på utgangen av verktøyet kan resultere i skår i eggene og skade hele skjæret. Det er derfor nødvendig å avgrade kanten for å fjerne grader først.



- 2) Det anbefales å modifisere standardprogrammet (legge til materialet) da dette reduserer dannelsen av grader på kanten, noe som øker bestandigheten til eggen og eliminerer behovet for å avgrade kanten.

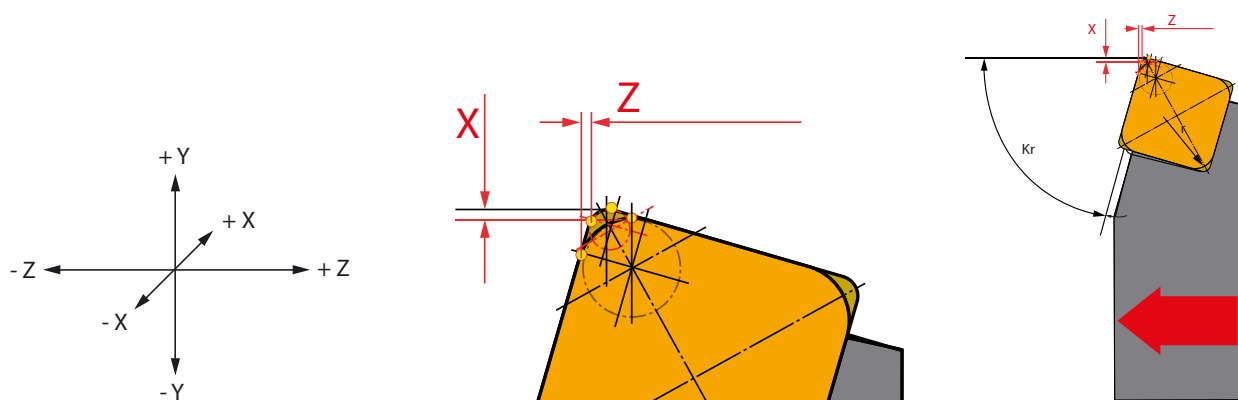


- 3) Hvis det er en fare for at det oppstår problemer på grunn av verktøyvibrasjon, er det bedre å bruke skjær med en mindre radius for å eliminere radialkreftene.



KORREKSJON AV X- OG Z-KOORDINATER ETTER RADIUS OG HOLDER

Korreksjon av X- og Z-koordinater etter radius og holder:



OBS – dataene gjelder for høyre sides holdere orientert som vist i bilde. For interne holdere, venstre holdere eller andre orienteringer er det nødvendig å korrigere eller merke +/- (for å substituere verdier X/Z)

Holder		Koordinater	Radius 0,5	Radius 1,0	Radius 1,5				
Ekstern 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
Ekstern 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

KORREKSJON AV X- OG Z-KOORDINATER ETTER RADIUS OG HOLDER

Holder		Koordinater	Radius 02	Radius 04	Radius 08	Radius 12	Radius 16	Radius 24	Radius 32
Intern 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
Ekstern 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
Intern 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

KORREKSJON AV X- OG Z-KOORDINATER ETTER RADIUS OG HOLDER

Holder		Koordinater	Radius 02	Radius 04	Radius 08	Radius 12	Radius 16	Radius 24	Radius 32
Ekstern 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

KORREKSJON AV X- OG Z-KOORDINATER ETTER RADIUS OG HOLDER

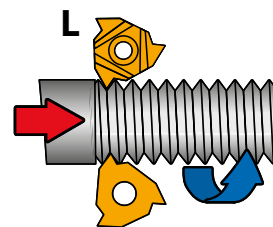
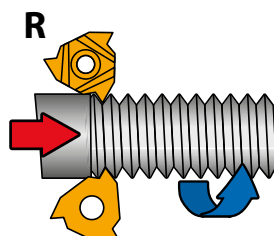
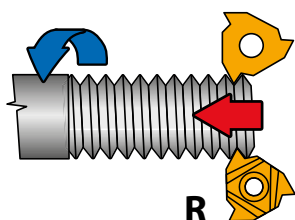
Holder		Koordinater	Radius 02	Radius 04	Radius 08	Radius 12	Radius 16	Radius 24	Radius 32
Intern holder	SCFCR/L	x	-0.420	-0.280	0.000	0.280	0.560	1.121	1.681
		z	0.000	0.000	0.000	0.000	0.000	0.000	0.000
	SCKCR/L	x	-0.040	-0.027	0.000	0.027	0.054	0.108	0.161
		z	0.130	0.087	0.000	-0.087	-0.174	-0.348	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

OBS – dataene gjelder for høyre sides holdere orientert som vist i bilde. For interne holdere, venstre holdere eller andre orienteringer er det nødvendig å korrigere eller merke +/- (for å substituere verdier X/Z)

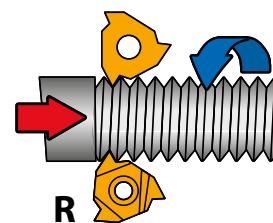
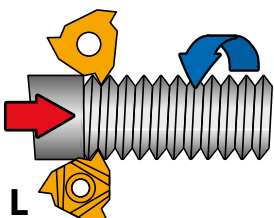
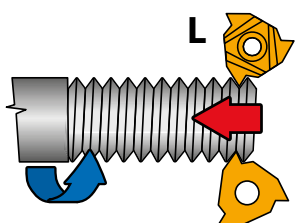
GJENGING

Valg av produksjonsmetode påvirkes av arbeidsstykket og maskinen. Arbeidsstykke – ekstern eller intern gjenger, høyre- eller venstregjenger. Maskin – høyre- eller venstreverktøy. Du kan bruke følgende tabell.

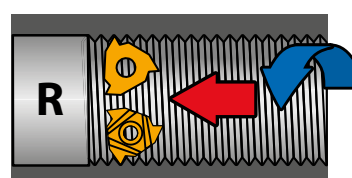
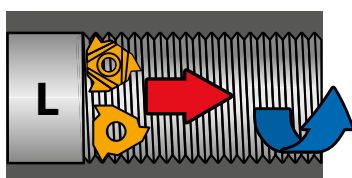
EKSTERNE GJENGER, HØYRE



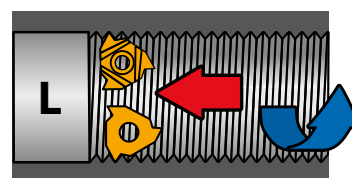
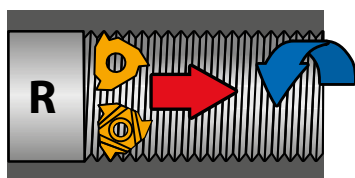
EKSTERNE GJENGER, VENSTRE



INTERNE GJENGER, HØYRE



INTERNE GJENGER, VENSTRE



■ Bevegelse av arbeidsstykket

■ Verktøybevegelse

L / R Skjærdesign

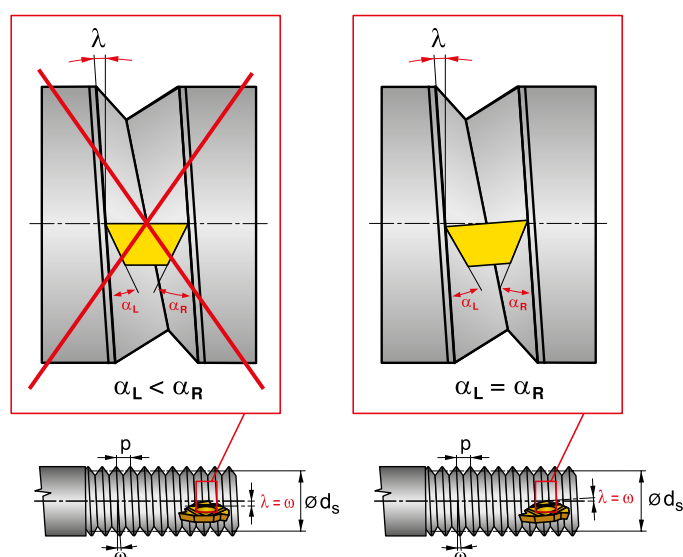
Den følgende formelen kan brukes til å beregne stigningsvinkelen:

$$\tan \omega = \frac{p}{d_s \cdot \pi}$$

ω stigningsvinkel [°]

p Ning [mm]

d_s Stigningsdiameter [mm]



For å generere den korrekte formen på gjengene og jevnt slitasje på skjæret, skal skjæreggens stigningsvinkel være lik gjengenes ledevinkel. Verktøyholderne er vanligvis utstyrt med en stigningsvinkel $\lambda = 1.5^\circ$. En forskjellig stigningsvinkel kan velges ved å skifte undelagsplate. Bruk grafen eller tabellen under til å velge korrekt undelagsplate. Tabell og graf - bilde.

Valg av undelagsplate

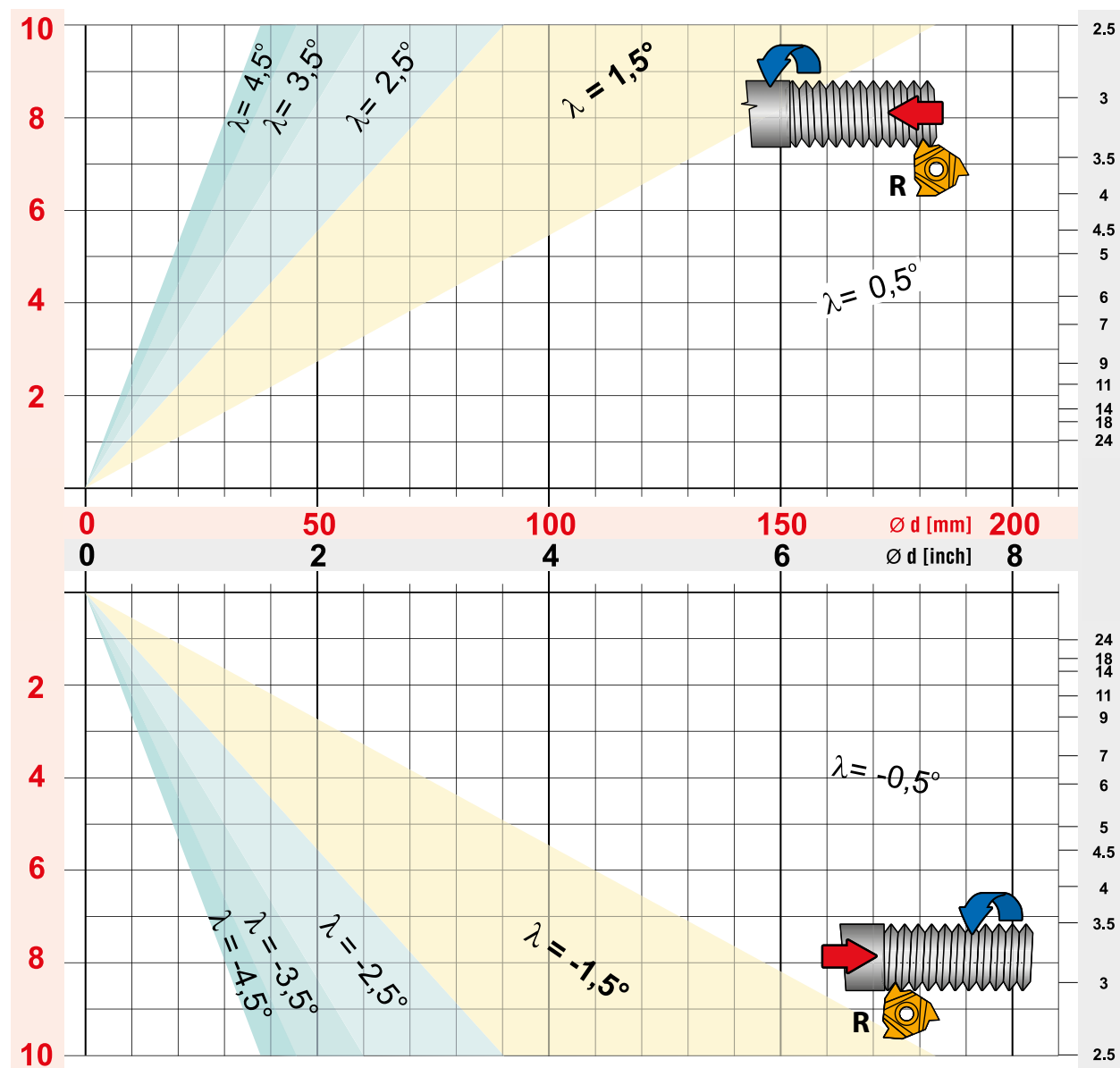
stigningsvinkel λ	Positiv					Negativ		For spordreieskjær TN16.. ... ZZ, TN22... ZZ
	4.5°	3.5°	2.5°	1.5°	0.5°	-0.5°	-1.5°	
Verktøyholder	undelags spesifikasjon							
SER16; SIL16	PE16+4.5	PE16+3.5	PE16+2.5	PE16+1.5	PE16+0.5	PE16-0.5	PE16-1.5	PE16ZZ
SEL16; SIR16	PI16+4.5	PI16+3.5	PI16+2.5	PI16+1.5	PI16+0.5	PI16-0.5	PI16-1.5	PI16ZZ
SER22; SIL22	PE22+4.5	PE22+3.5	PE22+2.5	PE22+1.5	PE22+0.5	PE22-0.5	PE22-1.5	PE22ZZ
SEL22; SIR22	PI22+4.5	PI22+3.5	PI22+2.5	PI22+1.5	PI22+0.5	PI22-0.5	PI22-1.5	PI22ZZ
SER-S22; SIL-S22	PE22S+4.5	PE22S+3.5	PE22S+2.5	PE22S+1.5	PE22S+0.5	PE22S-0.5	PE22S-1.5	-
SEL-S22; SIR-S22	PI22S+4.5	PI22S+3.5	PI22S+2.5	PI22S+1.5	PI22S+0.5	PI22S-0.5	PI22S-1.5	-

Verktøyholderne er vanligvis utstyrt med en stigningsvinkel $\lambda = 1.5^\circ$. En forskjellig stigningsvinkel kan velges ved å skifte undelagsplate. Undelagsplate for holdere SER-S , SIR-S er merket med «S»

Graf for valg av undelagsplate

Gjengestigning P [mm]

Ant. gjenger / 1"



Bevegelse av arbeidsstykket

Verktøybevegelse

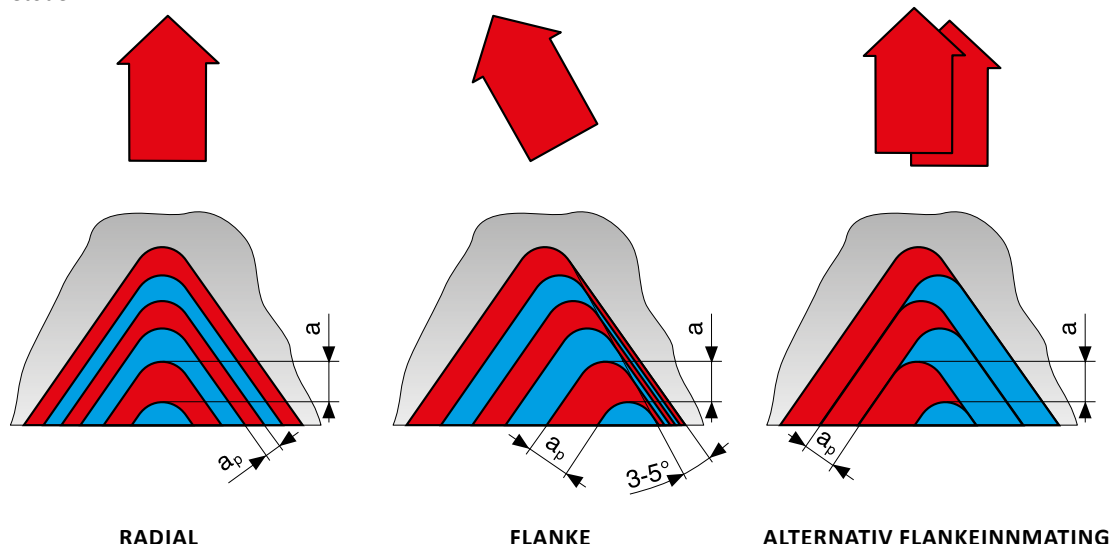
L/R Skjærdesign

Innmatingsmetode og -dybde

Valget av innmatingsmetode er viktigst for materialer som gir lange spon for å sikre god sponkontroll.

↑ Innmatingsmetode

a Innmating



Valget avhenger av maskintype, det maskinerte materialet og stigningen.

Radial innmating – den enkleste og mest brukte. Innmatingen er vinkelrett på rotasjonsaksen til arbeidsstykket. Det bidrar til d god spondannelse og uniform slitasje på skjæreggen. Egnet for gjenger med en liten stigning ($p < 1,5$ mm). Det er en fare for vibrasjon ved høye matinger. Første valg for arbeide på harde materialer (f.eks. austenittisk rustfritt stål, stål med lavt karboninnhold).

Flanke-innmating – reduserer termisk stress på skjæreggen og dermed slitasje.

God sponkontroll. Egnet for gjenger med en stigning på $p > 1,5$ mm for TR-gjenger.

Flankeinnmating med avvik 3-5° eliminerer friksjon på gjengeflanken.

Alternativ flanke-innmating – anbefalt for grove gjenger og materialer med dårlig spondannelse. Lang verktøylevetid. For CNC-maskiner, høyere krav til CNC-programmering.

Innmatingsmetode og antall passasjer avhenger av gjengestigningen. Tabellen gir grunnleggende anbefalinger og gjelder for alle geometrier. Hvis skjæret knekker, skal innmatingsverdien reduseres og antall passasjer skal økes. Innmatingsdybden skal ikke være mindre enn 0,05 mm/passasje. På austenittisk og mykt stål skal innmating-sdybden

per passasje være større enn 0,08 mm.

TUBULÆR SYLINDRISK GJENGEPROFIL KORRESPONDERER MED W (WHITWORTH 55°)

Gjengemerking	Ant. gjenger/ 1"	Gjengestigning P [mm]	Nominell diameter av gjengene [mm]	Liten diameter av gjengene [mm]	Gjengeskjærbetegnelse
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 høyre, eksterne gjenger på rør 1 1/2" bruk gjengeskjær TN 16ER110W; 8030

INNMATINGSDYBDE

M - metrisk 60° - ekstern

Antall passasjer	REDUSERE SKJÆRHASTIGHETEN PROPORSJONALT MED ØKNING AV GJENGESTIGNINGEN														
	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													
Total innmatingsdybde	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

M - metrisk 60° - intern

Antall passasjer	REDUSERE SKJÆRHASTIGHETEN PROPORSJONALT MED ØKNING AV GJENGESTIGNINGEN														
	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													
Total innmatingsdybde	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° - ekstern og intern

Antall passasjer	REDUSERE SKJÆRHASTIGHETEN PROPORSJONALT MED ØKNING AV GJENGESTIGNINGEN																
	Stigning [antall gjenger/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															
Total innmatingsdybde	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° - ekstern

Antall passasjer	REDUSERE SKJÆRHASTIGHETEN PROPORSJONALT MED ØKNING AV GJENGESTIGNINGEN																	
	Stigning [antall gjenger/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																
Total innmatingsdybde	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° intern

Antall passasjer	REDUSERE SKJÆRHASTIGHETEN PROPORSJONALT MED ØKNING AV GJENGESTIGNINGEN																	
	Stigning [antall gjenger/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																
Total innmatingsdybde	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° - interne og eksterne

Antall passasjer	REDUSERE SKJÆRHASTIGHETEN PROPORSJONALT MED ØKNING AV GJENGESTIGNINGEN					
	Stigning [antall gjenger/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					
Total innmatingsdybde	2.54	1.76	1.45	1.12	0.75	

RD - RD 30° - ekstern

Antall passasjer	REDUSERE SKJÆRHASTIGHETEN PROPORSJONALT MED ØKNING AV GJENGESTIGNINGEN			
	Stigning [antall gjenger/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			
Total innmatingsdybde	3.43	2.23	1.73	1.40

RD - RD 30° - intern

Antall passasjer	REDUSERE SKJÆRHASTIGHETEN PROPORSJONALT MED ØKNING AV GJENGESTIGNINGEN			
	Stigning [antall gjenger/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			
Total innmatingsdybde	3.59	2.44	1.66	1.49

TR 30° intern

Antall passasjer	REDUSERE SKJÆRHASTIGHETEN PROPORSJONALT MED ØKNING AV GJENGESTIGNINGEN											
	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											
Total innmatingsdybde	8.2	6.72	5.7	5.16	4.68	4.17	3.66	2.89	2.38	1.83	1.33	0.97

INNMATINGSDYBDE

TR - TR 30° - intern

Antall passasjer	REDUSERE SKJÆRHASTIGHETEN PROPORSJONALT MED ØKNING AV GJENGESTIGNINGEN											
	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											
Total innmatingsdybde	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° - interne og eksterne

Antall passasjer	REDUSERE SKJÆRHASTIGHETEN PROPORSJONALT MED ØKNING AV GJENGESTIGNINGEN			
	Stigning [antall gjenger/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			
Total innmatingsdybde	1.52	1.19	0.90	0.62

ACME - ACME 29° - ekstern

Antall passasjer	REDUSERE SKJÆRHASTIGHETEN PROPORSJONALT MED ØKNING AV GJENGESTIGNINGEN							
	Stigning [antall gjenger/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							
Total innmatingsdybde	3.46	2.83	2.41	1.88	1.57	1.22	1.07	0.96

ACME - ACME 29° - intern

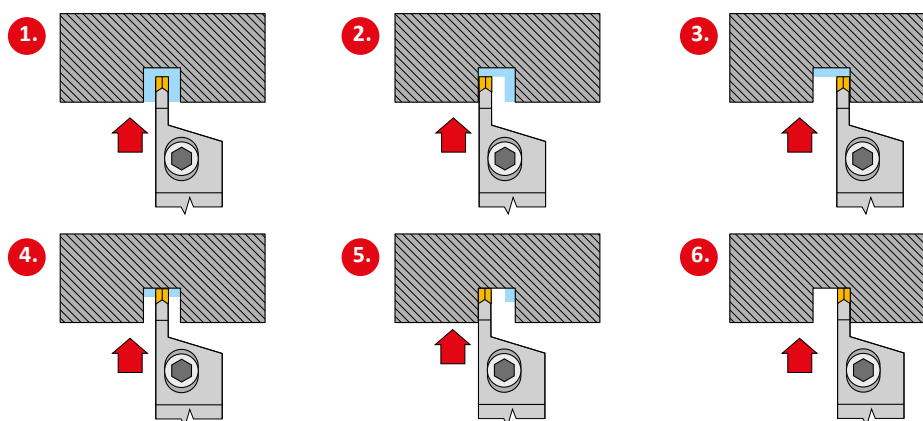
Antall passasjer	REDUSERE SKJÆRHASTIGHETEN PROPORSJONALT MED ØKNING AV GJENGESTIGNINGEN							
	Stigning [antall gjenger/tomme]							
	4	5	6	8	10	12	14	16
1	0.37	0.34	0.32	0.29	0.27	0.25	0.22	0.23
2	0.33	0.31	0.27	0.25	0.23	0.22	0.20	0.21
3	0.30	0.25	0.23	0.21	0.20	0.17	0.18	0.17
4	0.27	0.23	0.20	0.17	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							
Total innmatingsdybde	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.

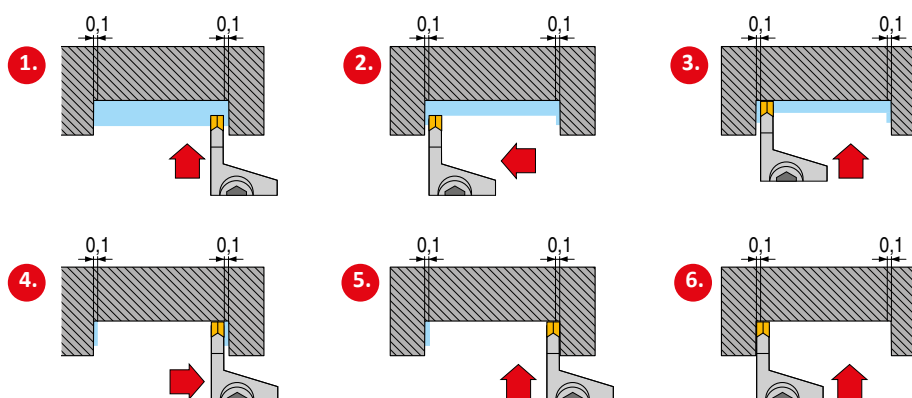
Recommendation for practical usage:

The procedure for turning a recess (deepening and widening) is shown in the following illustration.

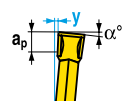


Note: To create a flat seating surface, use insert type **GL** with chip breaker **GM** or **LCMF** with chipbreaker **F**. The outboard radial grooving passes should overlap the central pass by two times the insert corner radius.

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":

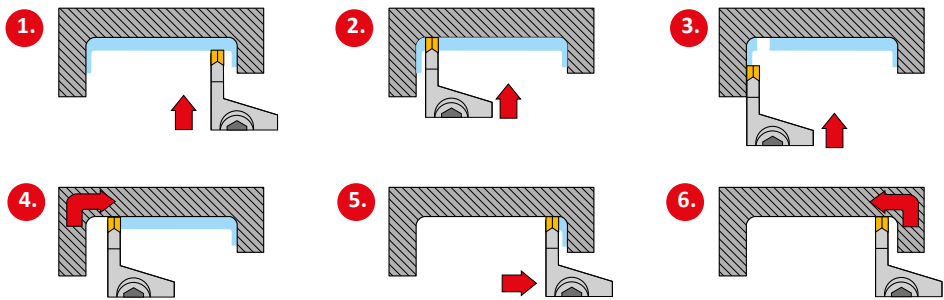


– for $f=0,15$ mm/rev;	$a_p = 3$ mm
– for $f=0,25$ mm/rev;	$a_p = 3$ mm
– for $f=0,35$ mm/rev;	$a_p = 3$ mm

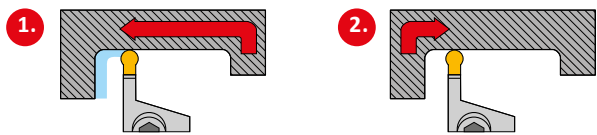
$y = 0,07$ mm
$y = 0,08$ mm
$y = 0,10$ mm

RECESSES, PARTING AND COPY TURNING

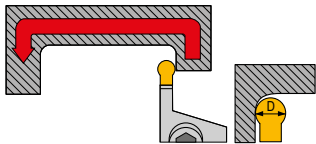
When opening up or deepening a contour using side turning, use the procedure shown in the following illustration.



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

RECESSES, PARTING AND COPY TURNING

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).

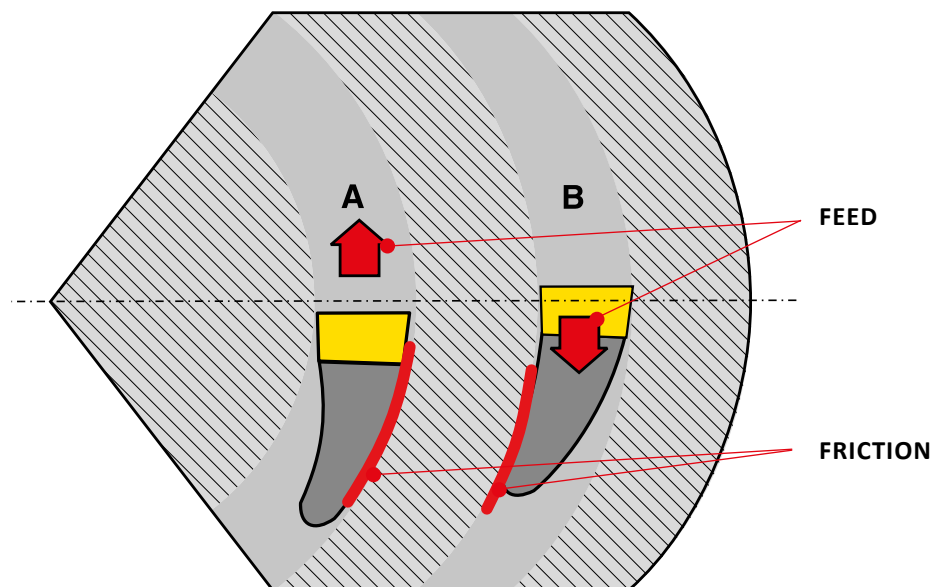
The cutting edge must be on centerline within a tolerance of $\pm 0,1$ mm

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).

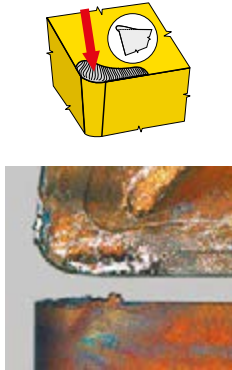
When face grooving, the tool must be set to be perpendicular to the face of the workpiece with high accuracy, otherwise the side of the tool will rub against the groove being created.



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.

TYPER SLITASJE PÅ VENDESKJÆRET

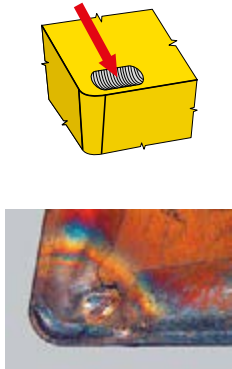
OPPBYGD EGG

			Det har ikke noen innvirkning
	(MT)CVD PVD	++	Ethvert belegg (avgjørende faktor er anti-adhesjonseffekt)
		↑	Jo høyere matehastighet, jo mindre sannsynlighet for dannelse av oppbygd egg.
		↓ ↑	Endre (vanligvis øke) skjærhastigheten
			Det har ikke noen innvirkning
		↓ ↑	Bruk mer positiv geometri (oppbygd egg dannes ikke når flisvinkelen er mer enn 40°)
		-	Bruk et kjølemiddel med mer effektiv anti-klebende egenskaper (eller ikke noe kjølemiddel)

FLANKESLITASJE

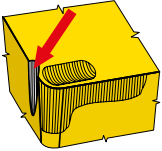
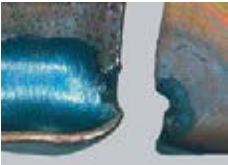
		↑	Bruk et mer slitasjebestandig substrat (S)
	(MT)CVD PVD	++	Ethvert belegg (avgjørende faktor er oksidasjonsmotstand - α Al_2O_3)
		↑	Matingen har innvirkning på form og posisjon til spor
		↓	Reduser skjærhastighet
		↑	Minimal effekt
		+	Bruk en annen (mer positiv) skjærgeometri
		+	Bruk kjølemiddel eller øk dets intensitet

KRATERDANNELSE

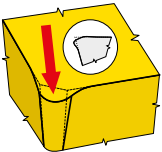
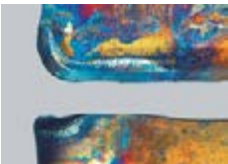
		↑	Bruk et mer slitasjebestandig substrat (S)
	(MT)CVD PVD	++	Ethvert belegg (avgjørende faktor er termisk motstand - α Al_2O_3)
		↑	Matingen har innvirkning på form og posisjon til krater
		↓	Reduser skjærehastighet
		↓	Minimal effekt
		↑	Bruk en mer positiv skjærgeometri
		++	Bruk kjølemiddel eller øk dets intensitet

TYPER SLITASJE PÅ VENDESKJÆRET

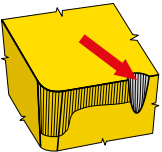
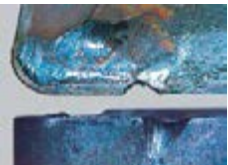
OKSIDERINGSSPOR PÅ MINDRE EGG

 		↑	Bruk et mer slitasjebestandig substrat (H)
	(MT)CVD PVD	++	Eethvert belegg (avgjørende faktor er hardhet - TiC, TiCN)
		↓	Øk matingen (spesielt hvis den er under 0,1 mm)
		↓	Reduser kuttehastighet
		↓	Det har ikke noen innvirkning
		↑	Det viktigste er å øke klaringsvinkelen
		++	Bruk et kjølemiddel eller øk dets intensitet

PLASTISK DEFORMERING

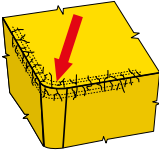
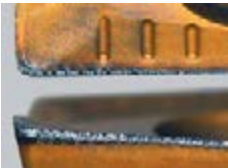
 		↑	Bruk en mer slitasjebestandig gradering (avgjørende er innholdet av Co)
	(MT)CVD PVD	+	Ethvert belegg (avgjørende faktor er friksjon)
		↓	Reduser matehastighet
		↓	Reduser skjærhastighet
		↓	Minimal effekt
		↑	Bruk en annen (mer positiv) kuttegeometri
		++	Bruk kjølemiddel eller øk dets intensitet

SIDEFLANKESPOR - RETTING

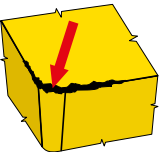
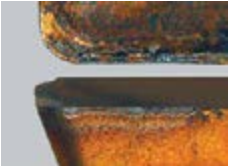
 		↑ ↓	Det avhenger av karakteren til skaden (slitasje - bruk et mer slitasjebestandig substrat; brudd - bruk sterkere substrat)
	(MT)CVD PVD	++	CVD-belegg (avgjørende faktor er oksidasjonsmotstand - α Al ₂ O ₃)
		↓	Matingen har innvirkning på intensitet, men mindre enn skjærhastigheten
		↓	Reduser skjærhastigheten
		↑ ↓	Bruk ulik dybde til kutt
		↓	Bruk en mindre positiv skjærgeometri
		+	Bruk kjølemiddel eller øk dets intensitet
			Bruk verktøy med mindre innstillingsvinkel

TYPER SLITASJE PÅ VENDESKJÆRET

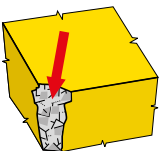
DANNELSE AV HYLLESPREKKER

 		↓	(H)-korning spiller en stor rolle
	(MT)CVD PVD	++	PVD-belegg anbefales
		↓	Matingen har innvirkning på intensitet, men mindre enn skjærhastigheten
		↓	Lavere hastighet betyr lavere temperatur
			Det har ikke noen innvirkning
		↓	Bruk en mindre positiv skjærgeometri
		---	Ikke noe kjølemiddel (det er mulig å bruke luft til å fjerne spon fra kutteområdet)

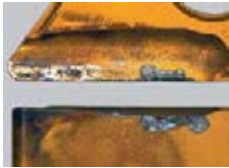
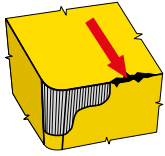
SKØRE REVNER VED SKÆRET

 		↓	(H)-korning spiller en stor rolle
	(MT)CVD PVD	+	PVD-belegg anbefales
		↓	Svært viktig er god sponbryting
		↑ ↓	Det handler om sponbryting og vibrasjoner
		↓	Reduserer belastningen (viktig for maskinbearbeidning med lang overlappning)
		↓	Bruk en mindre positiv skjærgeometri
			Det har ikke noen innvirkning
			Bruk bedre arbeidsbetingelser, reduser matingen ved ingang i materialet

INNSATS FRAKTUR

 		↓	(H)-korning spiller en stor rolle
	(MT)CVD PVD	+	PVD-belegg anbefales
		↓	Reduserer kraftbelastningen
		↑ ↓	Det handler om sponbryting og vibrasjoner
		↓	Reduserer kraftbelastningen
		↓	Bruk en mindre positiv skjærgeometri
			Det har ikke noen innvirkning
			Bruk bedre arbeidsbetingelser

SVIKT TIL KUTTEEGGEN



(H)-korning spiller en stor rolle



PVD-belegg anbefales



Svært viktig er god sponbryting



Det handler om sponbryting og vibrasjoner



Svært viktig er god sponbryting



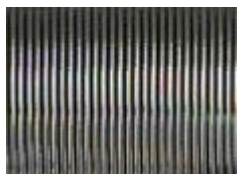
Bruke en mindre positiv kuttegeometri



Det har ikke noen innvirkning

Problemet er dårlig sponbryting, evakuering av spon eller fjerning av spon

DÅRLIG OVERFLATEKVALITET

**Beskrivelse og årsak:**

Forskjellige årsaker avhengig av arbeidsstykkematerialet, skjærgeometri (matehastighet og skjærhastighet), tilstanden til kutteeggen, omfanget og type slitasje og tilstanden og stivheten til maskin/verktøy/arbeidsstykke-enhet.

- feil verktøy valgt
- feil spontykkelse
- feil skjærhastighet
- kjølemiddel trengs
- høy matehastighet

Korrigerende tiltak:

- bruke en avtørkerinnsats
- bruke en kutteinnsats med riktig geometri
- reduser matehastigheten
- endre (vanligvis øke) kuttehastigheten
- bruk et kjølemiddel
- forbedre stabiliteten til verktøyet og arbeidsstykket
- endre spontverrsnittet
- velg en mer lett-kuttende sponbryter
- øke nesaradiusen

VIBRASJONER

**Beskrivelse og årsak:**

Dette er et svært vanlig problem, som i hovedsak skyldes et ubalansert arbeidsstykke eller verktøy, ustabil feste av arbeidsstykke, høye skjærekrefter eller verktøyoverheng.

Korrigerende tiltak:

- forbedre stabiliteten til verktøyet og arbeidsstykket
- reduser dybde til kutt
- minimerer verktøyoverheng
- redusere skjærhastigheten
- bruk et verktøy med mindre innstillingsvinkel
- redusere spontverrsnittet
- bruk et verktøy med en lav kuttemotstand
- øker matehastigheten
- velg en mer lett-kuttende sponbryter
- øke nesaradiusen

GRADER

**Beskrivelse og årsak:**

Dette inntreer vanligvis på mykt stål og plastiske materialer.

Korrigerende tiltak:

- bruke en et skjær med en skarp skjær
- bruke en kutteinnsats med positiv geometri
- bruk et verktøy med en mindre innstillingsvinkel

FORMFEIL

**Beskrivelse og årsak:**

Avhenger av mange faktorer.

Korrigerende tiltak:

- bruk et mere slitesterkt skjær
- forbedre stabiliteten til kutteren og arbeidsstykket
- minimerer verktøyoverheng
- bruk et arbeidsstykke med egnet maskinringsmonn

UTILSTREKKELIG SPONDANNELSE

**Beskrivelse og årsak:**

Bruke en spon med en egnet form er viktig for bestandigheten (levetiden til verktøyet). Arbeidsstykkematerialet, matehastigheten, kuttedybden og skjærgeometrien har alle en effekt på spondannelsen. En spon som er for lang er uakseptabelt av forskjellige årsaker, mens en spon som er for kort er uønskelig, da den overbelaster skjæreggen og fører til vibrasjoner.

Korrigerende tiltak:

- endre matehastigheten og dybden til kuttet
- bruk en mer egnet skjærgeometri
- endre skjærbetingelsene

SJEKK SETETILSTANDEN TIL KUTTEINNSATSEN

Før fastklemming av et nytt skjær, skifte av eggen, er det nødvendig å rengjøre setet og sjekke tilstanden til underlagsplaten og kilen (spesielt skaden under hjørnet til vebdeskjæret).

KONTROLLER OG UTFØR SERVICE PÅ KLEMMEDELENE

Det er også viktig å sjekke klemmedelene, inkludert klemmer, skruer, kiler og klemmer. Bruk kun originale, uskadede deler (finnes i katalogen). Smør gjengene og bindeflatene til skruer regelmessig, for eksempel med varmebestandig smøremiddel (Molykote G.). For montering og demontering, bruk kun skrutrekkere og skrunøkler spesifisert i vår katalog eller anbefalt av verktøyprodusenten. Pass på korrekt tiltrekking (proporsjonal) – det anbefales å bruke en momentnøkkel.

SJEKK TILTREKKINGEN

Før tiltrekking, sjekk tilpasningen av kutteinnsatsen med hele bindeoverflaten og i radiale og aksiale retninger. Kutteinnsatser og verktøy må alltid være rene og uskadede.



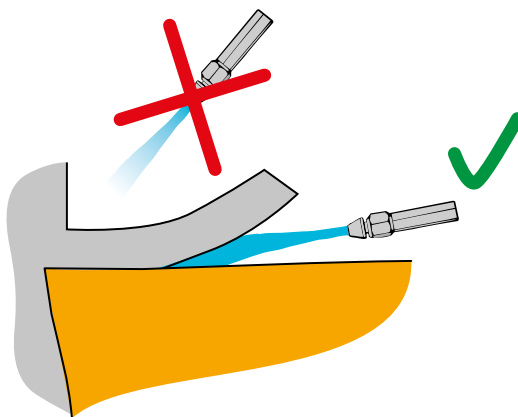
Machined material – the influence of the cutting environment increases with worsening machinability of the workpiece material.

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).



FORMEL FOR BEREGNING AV KUTTEDATA

Verdi	Formel	Enhet	Merk	
Antall omdreininger	$n = \frac{v_c \cdot 1000}{D \cdot \pi}$	(1/min)	n	Antall omdreininger [1/min]
Skjærhastighet	$v_c = \frac{\pi \cdot D \cdot n}{1000}$	(m/min)	D	Diameter (til verktøy eller arbeidsstykke) [mm]
Mating per omdreining	$f_{rev} = \frac{f_{min}}{n}$	(mm/rev)	v_c	Skjærhastigheten [m/min]
Mating per minutt (lineær matehastighet)	$f_{min} = v_f = f_{rev} \cdot n$	(mm/min)	f_{rev}	Mating per omdreining [mm/rev]
Maks. høyde på profil R_{max}	$R_{max} = \frac{125 \cdot f_{rev}^2}{RE}$	(mm)	f_{min}	Mating per minutt (Lineær matehastighet) [mm/min]
Overflatefinish R_a	$R_a = \frac{43,9 \cdot f_{rev}^{1,88}}{RE^{0,97}}$	(mm)	R_{max}	Maks. høyde på profil [mm]
Spontversnitt	$A = f_{rev} \cdot a_p$	(mm ²)	R_a	Overflatefinish [mm]
Spontykkelse (for innsats med rett egg)	$h = f_{rev} \cdot \sin \kappa_r$	(mm)	f_{rev}	Mating per omdreining [mm/rev]
Spontykkelse (For rund kutteinnsats)	$h = f_{rev} \cdot \sqrt{\frac{a_p}{INSD}}$	(mm)	a_p	Aksial dybde til kutt [mm]
Metallfjerningsrate	$Q = a_p \cdot f_{rev} \cdot v_c$	(cm ³ /min)	κ_r	Primæregg settvinkel [°]
Effektbehov	$P_c = \frac{a_p \cdot f_{rev}^{1-c} \cdot k_{cl} \cdot v_c \cdot k\kappa_r}{6 \cdot 10^4 \cdot \eta}$	(kW)	h	Spontykkelse [mm]
Tilnærmet effektbehov	$P_c = \frac{a_p \cdot f_{rev} \cdot v_c}{x}$	(kW)	v_c	Skjærhastigheten [m/min]
			f_{min}	Mating per minutt (Lineær matehastighet) [mm/min]
			Q	Materialfjerningsrate per minutt [cm ³ /min]
			$INSD$	Insert diameter (mm)
			P_c	Effektbehov [kW]
			a_p	Dybde til kutt [mm]
			f_{rev}	Mating [mm/rev]
			c	Konstant KTV [1]
			k_c	Spesifikk kuttekraft [MPa]
			k_{κ_r}	κ_r vinkel konstant [1]
			η	Virkningsgrad (vanligvis $\eta = 0,75$) [1]
			x	Maskinert materialkonstant [1]

Materiale	Stål	Støpejern	Al
Koeffisient x	20	25	100

ANBEFALTE SKRUEMOMENTER

KLEMMESKRUE

Skruebetegnelse	Skrutrekker	Moment (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	HXX 3	5
HS 0520C	HXX 4	5
HS 0616C	HXX 5	8
HS 0620	HXX 5	6
HS 0620C	HXX 5	6
HS 0625	HXX 5	6
HS 0625C	HXX 5	6
HS 0630	HXX 5	6
HS 0825	HXX 6	10
HS 0830	HXX 6	10
HS 0835	HXX 6	10
HS 0840	HXX 8	11
HS 1030	HXX 8	8
HS 1060	HXX 6	10
HS 93	HXX 5	8
HS 94	HXX 5	8
HSI 1020	HXX 6	8
PS 0512	HXX 2	2
PS 0512-A	HXX 2	2
PS 0616	HXX 2,5	4
PS 12040	HXX 5	8
PS 6026-709P	SRD T09P	2

KLEMMESKRUE

Skruebetegnelse	Skrutrekker	Moment (Nm)*
PS 8290	HXX 2	2
SR 14	HXX 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	HXX 3	5
US 35	HXX 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	HXX 4	6
US 38	HXX 5	8
US 39	HXX 5	8
US 40	HXX 4	6
US 4008-T15P	SDR T15P	3.5
US 4011-T15P	SDR T15P	3.5
US 41	HXX 4	6
US 42	HXX 4	6
US 45013-T20P	SDR T20P	5
US 4512-T15P	SDR T15P	5
US 4514A-T20	SDR T20	5
US 46	HXX 3	5
US 46017-T20P	SDR T20P	5
US 47	HXX 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	HXX 4	6
US 95	HXX 4	10

MOMENTSKRUTREKKERE

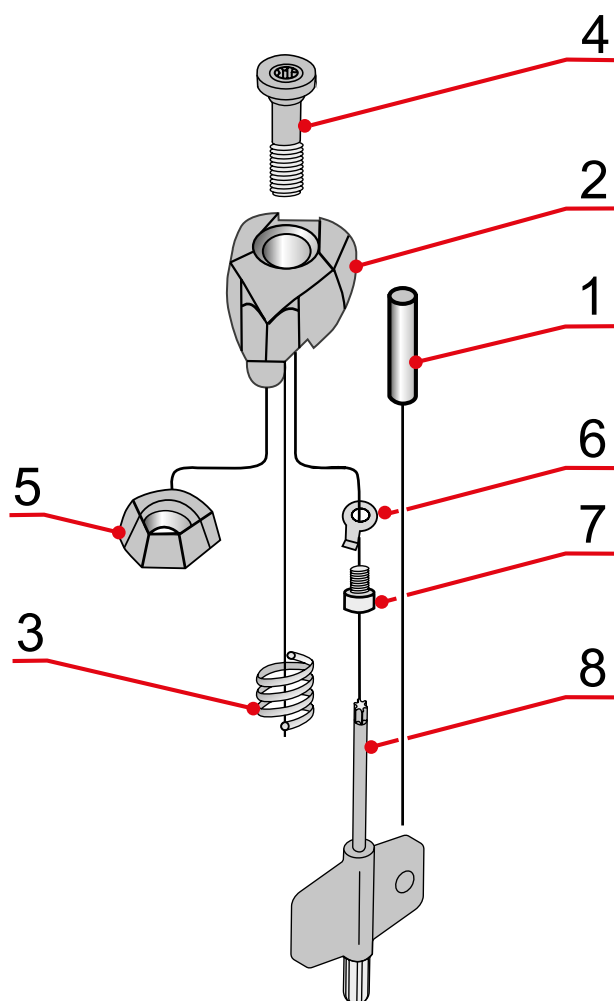
Momenthåndtak	Moment (Nm)	Klemmeskruegjenger
MR-0.8-2.0 vario	0.5 – 2.0	M 2 – M 3
MR-1.0-5.0 vario	0.8 – 5.0	M 2.5 – M 5
MR-0.9 fix	0.9	M 2
MR-2.0 fix	2.0	M 3
MR-3.0 fix	3.0	M 3.5
MR-3.5 fix	3.5	M 4
MR-5.0 fix	5.0	M 5

UTSKIFTBARE SKAFT

Utskiftbare skaft		
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

Innsatsklemmeskrueene er utsatt for høyt termisk stress. Det anbefales at alle skruene smøres med en høykvalitets pasta som MOLYCOTE 1000.



	1	2	3	4		5	6	7	8
									
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

TECHNICAL INFORMATION ON INSERT BOX

TEKNISK INFORMASJON OM INNSATSBOKS

Opphavsland → Made in Czech Republic

Strekkode → 3 603602 118990 57

Produktnummer → 80016674 6754539

CNMG 120408-M
CNMG 432-M
Grade T9315

ANSI-kode → CNMG 120408-M
CNMG 432-M
Grade T9315

Intern kode (batchnummer) → 4443-2208499 80015589 QTY 10

Kolonne med metriske parametere

Klassifisering av sorter

Gradering applikasjonsfelt

Valgprioritet

Skjærhastighet

Mating

Dybde til kutt

Startverdi skjærhastighet [metrisk]

Matingsområdet [metrisk]

Kuttdybde [metrisk]

Skjærmerking

Gradering

Mengde

Kolonne med tommeparametere

Startverdi skjærhastighet [tommer]

Matingsområdet [tommer]

Kuttdybde [tommer]

Varemerke-etikett

	[metric]	[inch]
P10-P30	v_c 325-205 f_z 0,17-0,60 a_p 0,8-6,0	1065-675 .007-.024 .031-.236
M10-M25	v_c 305-190 f_z 0,17-0,60 a_p 0,8-6,0	1000-625 .007-.024 .031-.236
S5-S15	v_c 65-40 f_z 0,10-0,20 a_p 0,3-1,5	215-130 .004-.008 .012-.059

WARNING! Product may break or shatter in use. Grinding this product produces dust or mist that, at levels above the occupational exposure limit, could cause permanent respiratory disease, and can irritate nose, throat, skin and eyes. Contains one or more of: tungsten carbide, cobalt, nickel, lead. Safety Data Sheet, Safety Information Sheet or contact your sales representative. To avoid injury, use personal protective equipment, including eye protection. Use machine guards and take appropriate safety measures to contain dust and to prevent the radiation of sparks. This product contains or produces chemicals which are known to the state of California to cause cancer. (Proposition 65, REV. 3/10/14)

PRAMET

SIMPLY RELIABLE

Som fagarbeider kan du bedømme kvalitete på arbeidet gjennom bare å se på sponet. Sponet har en ukomplisert form noe som forteller en historie. Det er derfor vi bruker dette symbolet for å illustrere vår politlighet, «Simply Reliable».

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