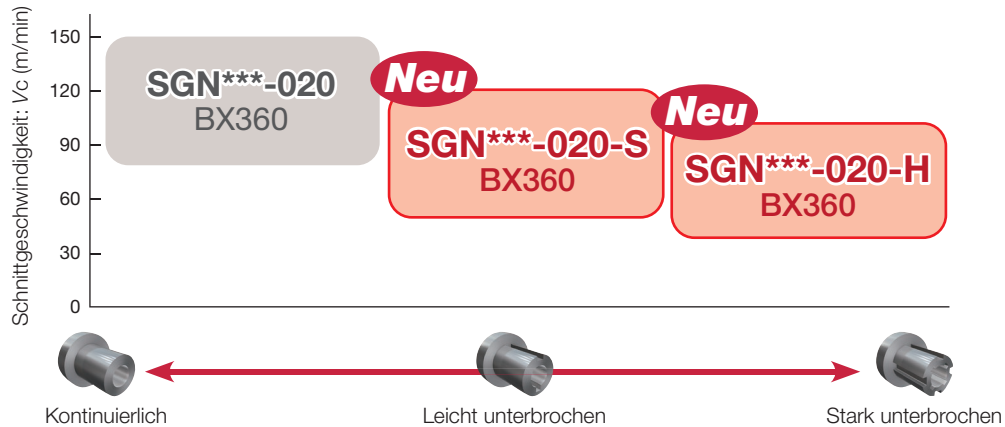


Programmerweiterung für CBN Stechplatten zur Bearbeitung von gehärtetem Stahl im unterbrochenem Schnitt

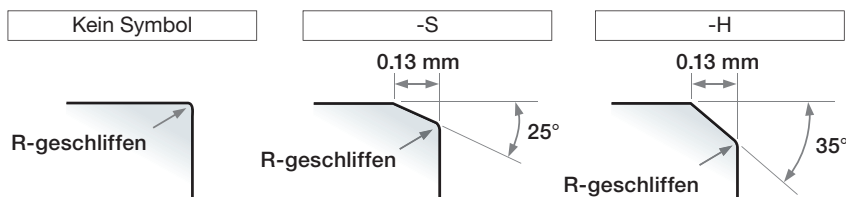




Zwei neue Schneidenausführungen für das Einstechen von gehärtetem Stahl

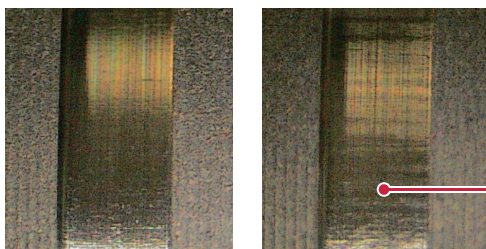


Schneidenausführung



SCHNITTLEISTUNG

Kontinuierliches Einstechen



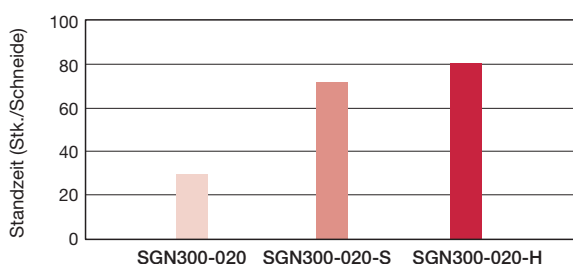
SGN300-020
BX360

SGN300-020-S
BX360

| | | |
|----------|------------------------|---------------------|
| H | Halter | : CTEL2525-3T |
| | Werkstoff | : SCM420 (58HRC) |
| | Schnittgeschwindigkeit | : $V_c = 150$ m/min |
| | Vorschub | : $f = 0.05$ mm/U |
| | Kühlmittel | : Emulsion |

Stechplatten ohne Zusatzbuchstaben für den kontinuierlichen Schnitt

Stark unterbrochenes Einstechen

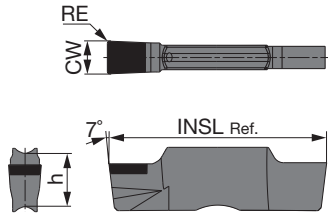


| | | |
|----------|------------------------|---------------------|
| H | Halter | : CTEL2525-3T |
| | Werkstoff | : SCM435 (58HRC) |
| | Schnittgeschwindigkeit | : $V_c = 100$ m/min |
| | Vorschub | : $f = 0.05$ mm/U |
| | Kühlmittel | : ohne |

-H Typ Schneidenausführung empfohlen für den unterbrochenen Schnitt

SGN

Externes Einstecken von gehärtetem Stahl



| | | | | | | | | | | | | |
|----------|---------------------|---|--|--|--|--|--|--|--|--|--|--|
| P | Stahl | | | | | | | | | | | |
| M | Rostfr. Stahl | | | | | | | | | | | |
| K | Eisenguss | | | | | | | | | | | |
| N | Nichteisenmetalle | | | | | | | | | | | |
| S | Hitzeb. Legierungen | | | | | | | | | | | |
| H | Gehärteter Stahl | ★ | | | | | | | | | | |

★ : 1. Wahl
☆ : 2. Wahl

| Katalog Nr. | Plattensitz | CW±0.025 | RE | CBN | | | | | | | | INSL | h | Edge prep. | | |
|--------------|-------------|----------|-----|-------|--|--|--|--|--|--|----|------|---|-------------|---|---|
| | | | | BX360 | | | | | | | | | | Kein Symbol | S | H |
| SGN200-020 | 2 | 2 | 0.2 | ● | | | | | | | 20 | 5 | ○ | | | |
| SGN200-020-S | 2 | 2 | 0.2 | ● | | | | | | | 20 | 5 | | ○ | | |
| SGN200-020-H | 2 | 2 | 0.2 | ● | | | | | | | 20 | 5 | | | ○ | |
| SGN300-020 | 3 | 3 | 0.2 | ● | | | | | | | 20 | 5 | ○ | | | |
| SGN300-020-S | 3 | 3 | 0.2 | ● | | | | | | | 20 | 5 | | ○ | | |
| SGN300-020-H | 3 | 3 | 0.2 | ● | | | | | | | 20 | 5 | | | ○ | |
| SGN400-020 | 4 | 4 | 0.2 | ● | | | | | | | 20 | 5 | ○ | | | |
| SGN400-020-S | 4 | 4 | 0.2 | ● | | | | | | | 20 | 5 | | ○ | | |
| SGN400-020-H | 4 | 4 | 0.2 | ● | | | | | | | 20 | 5 | | | ○ | |
| SGN500-020-S | 5 | 5 | 0.2 | ● | | | | | | | 25 | 5.5 | | ○ | | |
| SGN500-020-H | 5 | 5 | 0.2 | ● | | | | | | | 25 | 5.5 | | | ○ | |

● Neu

STANDARD SCHNITTBEDINGUNGEN

| ISO | Schneidstoff | Schneiden- ausführung | Werkstück | Schnittge- schwindigkeit Vc (m/min) | Vorschub f (mm/U) |
|----------|--------------|--------------------------|---------------------|---|----------------------|
| H | BX360 | No symbol | Kontinuierlich | 80 - 150 | 0.03 - 0.08 |
| | | -S | Leicht unterbrochen | 50 - 120 | 0.03 - 0.08 |
| | | -H | Stark unterbrochen | 40 - 100 | 0.03 - 0.06 |

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