

T505

www.tungaloy.de

Tungaloy Report TG0321-539-D1

T505 - Neuester Schneidstoff mit hervorragender Verschleißfestigkeit für das Drehen von Gusseisen



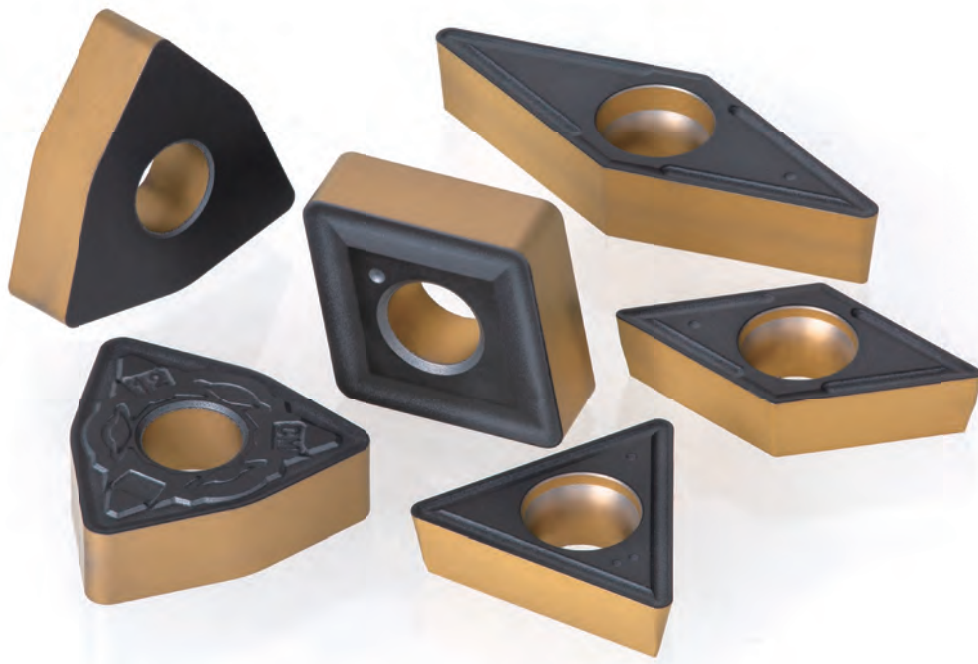


ACCELERATED MACHINING

TurnLine

T505

TUNGALOY

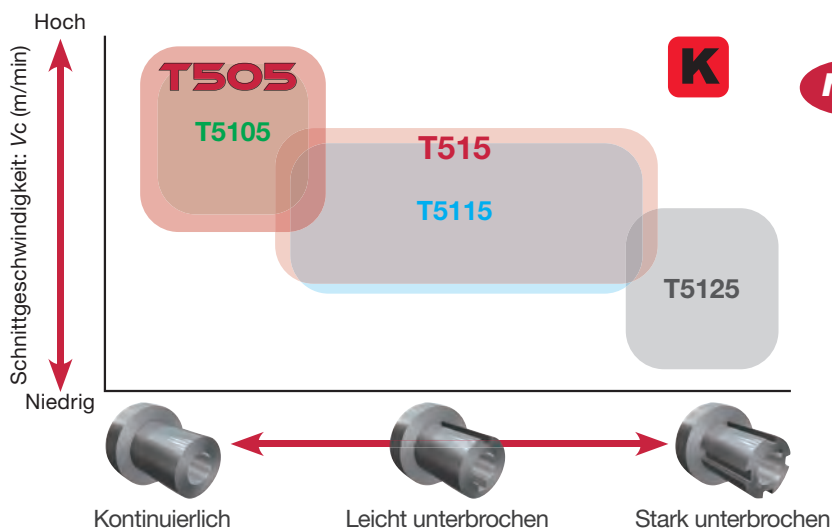


Der neue Schneidstoff T505.

Die Programmerweiterung zum bestehenden
Schneidstoff T515 für das Drehen von Gusseisen.

www.tungaloy.de

NEU T505 - Hervorragender CVD Schneidstoff für die Hochgeschwindigkeitsbearbeitung von Gusseisen

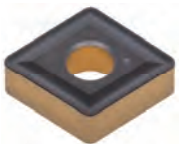


Neu T505

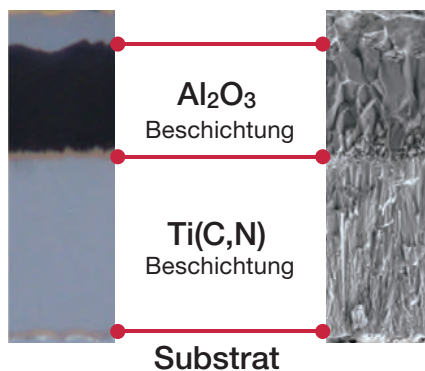
- Programmerweiterung zu Schneidstoff T515
- Sehr hohe Verschleißfestigkeit
- 1. Wahl bei der Hochgeschwindigkeitsbearbeitung von Eisen-gusswerkstoffen

Dickste Beschichtungsschicht aller Tungaloy CVD Schneidstoffe

Neu



Die T505 Beschichtungsschicht ist 1.5 mal so dicker wie konventionelle Schneidstoffe.



Herausragende Verschleißfestigkeit!!

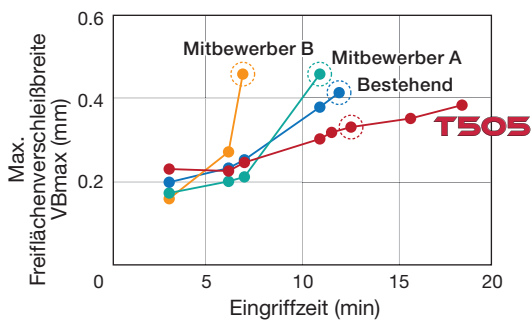
- Die dickste CVD Beschichtung aller Tungaloy Schneidstoffe
- Al₂O₃ Schicht mit sehr hoher Verschleißfestigkeit
- TiCN Schicht mit hohem Kohlenstoffgehalt
- Neu entwickeltes Substrat mit höherer Hitzebeständigkeit.

| ISO | Schneidstoff | Substrat | | | Beschichtungsschicht | |
|-----|--------------|----------------------|-------------|--------------|---------------------------------------|------------|
| | | Spezifisches Gewicht | Härte (HRA) | T.R.S. (GPa) | Hauptbestandteile | Dicke (µm) |
| K | T505 | 15 | 91 | 2.4 | TiCN + Al ₂ O ₃ | 23 |

SCHNITTLEISTUNG

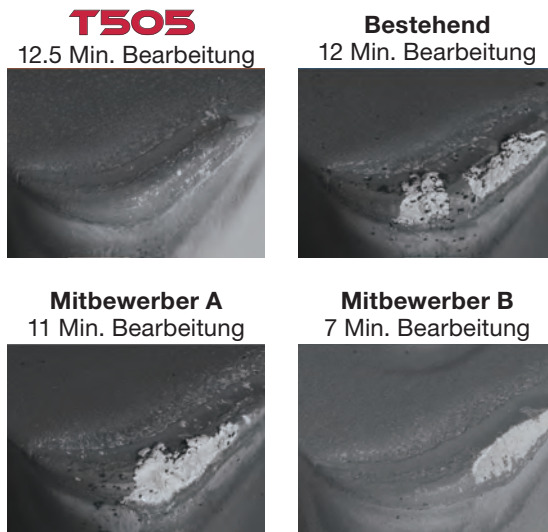
Neuer CVD Schneidstoff – Vielseitige Einsatzmöglichkeiten
beim Drehen von Gusseisen!

K FC200 / GG25

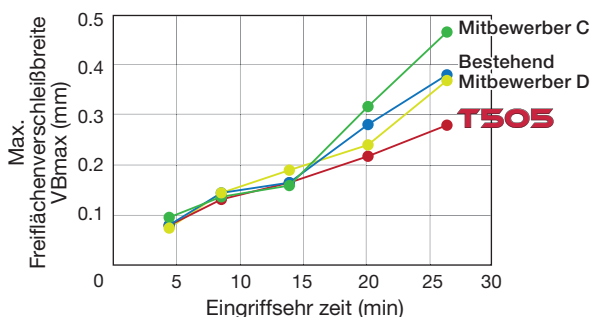


Werkstoff : FC200 / GG25
Schnittgeschwindigkeit : $V_c = 700$ m/min
Vorschub : $f = 0.3$ mm/Z
Schnitttiefe : $a_p = 2$ mm
Bearbeitung : Kontinuierlicher Schnitt
Kühlmittel : Emulsion

T505 zeigt eine exzellente Verschleißfestigkeit bei der Hochgeschwindigkeitsbearbeitung von Eisenguss.

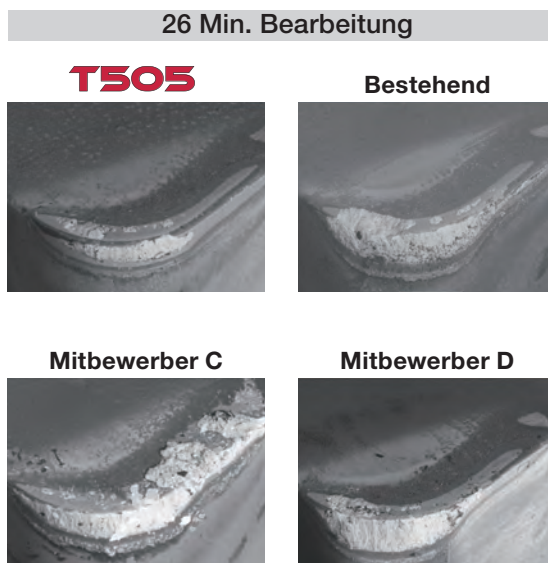


K FCD600 / GGG60



Werkstoff : FCD600 / GGG60
Schnittgeschwindigkeit : $V_c = 150$ m/min
Vorschub : $f = 0.3$ mm/Z
Schnitttiefe : $a_p = 2$ mm
Bearbeitung : Kontinuierlicher Schnitt
Kühlmittel : Emulsion

T505 bietet eine sehr gute Verschleißfestigkeit bei der Bearbeitung von Kugelgraphitguss.



STANDARD SCHNITTDATEN

Negative Wendeschneidplatten

| Spanformstufe | Schneidstoff | Eckenradius RE | Schnitttiefe ap (mm) | Vorschub f (mm/Z) | Schnittgeschwindigkeit: Vc (m/min) | |
|---------------|--------------|-------------------|-------------------------|----------------------|------------------------------------|------------------|
| | | | | | Grauguss | Kugelgraphitguss |
| CM | T505 | 0.4 | 1 - 5 | 0.1 - 0.25 | 180 - 700 | 180 - 400 |
| | T505 | 0.8 | 1 - 5 | 0.15 - 0.4 | 180 - 700 | 180 - 400 |
| | T505 | 1.2 | 1 - 5 | 0.15 - 0.5 | 180 - 700 | 180 - 400 |
| All-Round | T505 | 0.4 | 1 - 6 | 0.2 - 0.3 | 180 - 700 | 180 - 400 |
| | T505 | 0.8 | 1 - 6 | 0.2 - 0.5 | 180 - 700 | 180 - 400 |
| | T505 | 1.2 | 1 - 6 | 0.2 - 0.5 | 180 - 700 | 180 - 400 |
| | T505 | 1.6 | 1 - 6 | 0.3 - 0.5 | 180 - 700 | 180 - 400 |
| Flat-top | T505 | 0.8 | 0.05 - 2 | 0.2 - 0.45 | 180 - 700 | 180 - 400 |
| | T505 | 1.2 | 0.05 - 2 | 0.2 - 0.6 | 180 - 700 | 180 - 400 |

Positiv Wendeschneidplatten

| Spanformstufe | Schneidstoff | Eckenradius RE | Schnitttiefe ap (mm) | Vorschub f (mm/Z) | Schnittgeschwindigkeit: Vc (m/min) | |
|---------------|--------------|-------------------|-------------------------|----------------------|------------------------------------|------------------|
| | | | | | Grauguss | Kugelgraphitguss |
| CM | T505 | 0.4 | 0.05 - 2 | 0.05 - 0.2 | 180 - 700 | 180 - 400 |
| | T505 | 0.8 | 0.05 - 2 | 0.05 - 0.3 | 180 - 700 | 180 - 400 |
| | T505 | 1.2 | 0.05 - 2 | 0.05 - 0.3 | 180 - 700 | 180 - 400 |

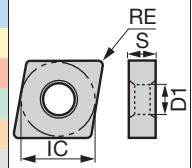
Wendeschnidplatten NEGATIV

- : Kontinuierlicher Schnitt
- : Leicht unterbrochener Schnitt
- ⊛ : Stark unterbrochener Schnitt

CN

Rhombisch,
80° mit Loch

| | | |
|---|------------------------|---|
| P | Stahl | ● |
| M | Rostfr. Stahl | ● |
| K | Eisenguss | ● |
| N | Nichteisenmetalle | ● |
| S | Hitzebest. Legierungen | ● |
| H | Gehärteter Stahl | ● |



| Anwendungen | Spanformstufe | Katalog Nr. | Beschichtet | | Abmessungen (mm) | | | |
|--|---------------|-----------------------------|-------------|------|------------------|--------|------|------|
| | | | T505 | T515 | RE | IC | S | D1 |
| Schlichten | | TSF CNMG120404-TSF | ● | | 0.4 | 12.7 | 4.76 | 5.16 |
| | | CNMG120408-TSF | ● | | 0.8 | 12.7 | 4.76 | 5.16 |
| | | CNMG120412-TSF | ● | | 1.2 | 12.7 | 4.76 | 5.16 |
| Schichten bis mittlere Bearbeitung (Wiper) | | SW CNMG120408-SW | ● | | 0.8 | 12.7 | 4.76 | 5.16 |
| | | CNMG120412-SW | ● | | 1.2 | 12.7 | 4.76 | 5.16 |
| Mittlere Bearbeitung | | TM CNMG090404E-TM | ● | | 0.4 | 9.525 | 4.76 | 3.81 |
| | | CNMG090408E-TM | ● | | 0.8 | 9.525 | 4.76 | 3.81 |
| | | CNMG090412E-TM | ● | | 1.2 | 9.525 | 4.76 | 3.81 |
| | | CNMG120404-TM | ● | | 0.4 | 12.7 | 4.76 | 5.16 |
| | | CNMG120408-TM | ● | | 0.8 | 12.7 | 4.76 | 5.16 |
| | | CNMG120412-TM | ● | | 1.2 | 12.7 | 4.76 | 5.16 |
| | | CNMG120416-TM | ● | | 1.6 | 12.7 | 4.76 | 5.16 |
| | | All-Round CNMG120404 | ● | ● | 0.4 | 12.7 | 4.76 | 5.16 |
| | | CNMG120408 | ● | ● | 0.8 | 12.7 | 4.76 | 5.16 |
| | | CNMG120412 | ● | ● | 1.2 | 12.7 | 4.76 | 5.16 |
| | | CNMG120416 | ● | ● | 1.6 | 12.7 | 4.76 | 5.16 |
| | | CNMG160612 | ● | ● | 1.2 | 15.875 | 6.35 | 6.35 |
| | | CNMG160616 | ● | ● | 1.6 | 15.875 | 6.35 | 6.35 |
| | | CNMG190612 | ● | ● | 1.2 | 19.05 | 6.35 | 7.93 |
| | | CNMG190616 | ● | ● | 1.6 | 19.05 | 6.35 | 7.93 |
| Mittlere Bearbeitung bis Schwerzerspannung | | CM CNMG120404-CM | ● | ● | 0.4 | 12.7 | 4.76 | 5.16 |
| | | CNMG120408-CM | ● | ● | 0.8 | 12.7 | 4.76 | 5.16 |
| | | CNMG120412-CM | ● | ● | 1.2 | 12.7 | 4.76 | 5.16 |
| | | CNMG160612-CM | ● | ● | 1.2 | 15.875 | 6.35 | 6.35 |
| Mittlere Bearbeitung bis Schwerzerspannung | | TH CNMG120408-TH | ● | | 0.8 | 12.7 | 4.76 | 5.16 |
| | | CNMG120412-TH | ● | | 1.2 | 12.7 | 4.76 | 5.16 |
| | | CNMG120416-TH | ● | | 1.6 | 12.7 | 4.76 | 5.16 |

● : Neu
● : Lagerstandard

Wendeschnidplatten NEGATIV

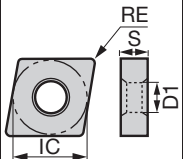
- : Kontinuierlicher Schnitt
- : Leicht unterbrochener Schnitt
- * : Stark unterbrochener Schnitt

CN



Rhombisch,
80° mit Loch

| | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|----------|------------------------|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| P | Stahl | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| M | Rostfr. Stahl | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| K | Eisenguss | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| N | Nichteisenmetalle | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| S | Hitzebest. Legierungen | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| H | Gehärteter Stahl | | | | | | | | | | | | | | | | | | | | | | | | | | | |




| Anwendungen | Spanformstufe | Katalog Nr. | Beschichtet | | Abmessungen (mm) | | | | | | |
|--|---------------|------------------------------------|-------------|------|------------------|-----|-------|-------|--------|------|------|
| | | | T505 | T515 | RE | IC | S | D1 | | | |
| Mittlere Bearbeitung bis Schwerzerspannung | | CH CNMG120408-CH | ● | | | | 0.8 | 12.7 | 4.76 | 5.16 | |
| | | CNMG120412-CH | ● | | | | 1.2 | 12.7 | 4.76 | 5.16 | |
| Schlichten bis mittlere Bearbeitung | | Flat-top CNMA090404E | ● | | | | 0.4 | 9.525 | 4.76 | 3.81 | |
| | | CNMA090408E | ● | | | | 0.8 | 9.525 | 4.76 | 3.81 | |
| | | CNMA090412E | ● | | | | 1.2 | 9.525 | 4.76 | 3.81 | |
| | | CNMA090416E | ● | | | | 1.6 | 9.525 | 4.76 | 3.81 | |
| | | CNMA120408 | ● ● | | | | | 0.8 | 12.7 | 4.76 | 5.16 |
| | | CNMA120412 | ● ● | | | | | 1.2 | 12.7 | 4.76 | 5.16 |
| | | CNMA160612 | ● | | | | | 1.2 | 15.875 | 6.35 | 6.35 |
| | | CNMA160616 | ● | | | | | 1.6 | 15.875 | 6.35 | 6.35 |
| | | CNMA190612 | ● | | | | | 1.2 | 19.05 | 6.35 | 7.93 |
| CNMA190616 | ● | | | | | 1.6 | 19.05 | 6.35 | 7.93 | | |

● : Neu
● : Lagerstandard

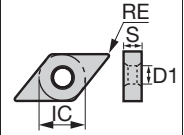
Wendeschneidplatten NEGATIV

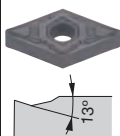
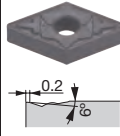
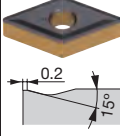
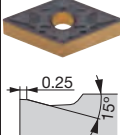
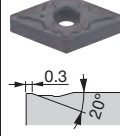
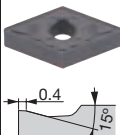
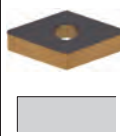
- : Kontinuierlicher Schnitt
- ◐ : Leicht unterbrochener Schnitt
- ◑ : Stark unterbrochener Schnitt

DN

 **Rhombisch,
55° mit Loch**

| | | | | | | | | | | | | | | | | | | | | |
|----------|------------------------|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| P | Stahl | | | | | | | | | | | | | | | | | | | |
| M | Rostfr. Stahl | | | | | | | | | | | | | | | | | | | |
| K | Eisenguss | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| N | Nichteisenmetalle | | | | | | | | | | | | | | | | | | | |
| S | Hitzebest. Legierungen | | | | | | | | | | | | | | | | | | | |
| H | Gehärteter Stahl | | | | | | | | | | | | | | | | | | | |



| Anwendungen | Spanformstufe | Katalog Nr. | Beschichtet | | Abmessungen (mm) | | | | | |
|--|---|------------------------------------|-------------|------|------------------|-----|-------|------|------|--|
| | | | T505 | T515 | RE | IC | S | D1 | | |
| Schlichten |  | TSF DNMG150404-TSF | ● | ● | | 0.4 | 12.7 | 4.76 | 5.16 | |
| | | DNMG150408-TSF | ● | ● | | 0.8 | 12.7 | 4.76 | 5.16 | |
| | | DNMG150412-TSF | ● | ● | | 1.2 | 12.7 | 4.76 | 5.16 | |
| | | | | | | | | | | |
| Mittlere Bearbeitung |  | TM DNMG150404-TM | ● | ● | | 0.4 | 12.7 | 4.76 | 5.16 | |
| | | DNMG150408-TM | ● | ● | | 0.8 | 12.7 | 4.76 | 5.16 | |
| | | DNMG150412-TM | ● | ● | | 1.2 | 12.7 | 4.76 | 5.16 | |
| | | DNMG150416-TM | ● | ● | | 1.6 | 12.7 | 4.76 | 5.16 | |
| | | | | | | | | | | |
| Mittlere Bearbeitung |  | All-Round DNMG150408 | ● | ● | | 0.8 | 12.7 | 4.76 | 5.16 | |
| | | DNMG150412 | ● | ● | | 1.2 | 12.7 | 4.76 | 5.16 | |
| | | DNMG150608 | ● | ● | | 0.8 | 12.7 | 6.35 | 5.16 | |
| | | DNMG150612 | ● | ● | | 1.2 | 12.7 | 6.35 | 5.16 | |
| | | | | | | | | | | |
| Mittlere Bearbeitung |  | CM DNMG150404-CM | ● | ● | | 0.4 | 12.7 | 4.76 | 5.16 | |
| | | DNMG150408-CM | ● | ● | | 0.8 | 12.7 | 4.76 | 5.16 | |
| | | DNMG150412-CM | ● | ● | | 1.2 | 12.7 | 4.76 | 5.16 | |
| | | | | | | | | | | |
| Mittlere Bearbeitung bis Schwerzerspannung |  | TH DNMG150408-TH | ● | ● | | 0.8 | 12.7 | 4.76 | 5.16 | |
| | | DNMG150412-TH | ● | ● | | 1.2 | 12.7 | 4.76 | 5.16 | |
| | | | | | | | | | | |
| | | | | | | | | | | |
| Mittlere Bearbeitung bis Schwerzerspannung |  | CH DNMG150408-CH | ● | ● | | 0.8 | 12.7 | 4.76 | 5.16 | |
| | | DNMG150412-CH | ● | ● | | 1.2 | 12.7 | 4.76 | 5.16 | |
| | | | | | | | | | | |
| Schichten bis mittlere Bearbeitung |  | Flat-top DNMA110404E | ● | ● | | 0.4 | 9.525 | 4.76 | 3.81 | |
| | | DNMA110408E | ● | ● | | 0.8 | 9.525 | 4.76 | 3.81 | |
| | | DNMA110412E | ● | ● | | 1.2 | 9.525 | 4.76 | 3.81 | |
| | | DNMA150404 | ● | ● | | 0.4 | 12.7 | 4.76 | 5.16 | |
| | | DNMA150408 | ● | ● | | 0.8 | 12.7 | 4.76 | 5.16 | |
| | | DNMA150604 | ● | ● | | 0.4 | 12.7 | 6.35 | 5.16 | |
| | | DNMA150608 | ● | ● | | 0.8 | 12.7 | 6.35 | 5.16 | |

- : Neu
- : Lagerstandard

Wendeschneidplatten NEGATIV

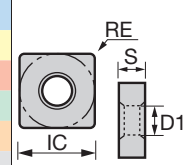
- : Kontinuierlicher Schnitt
- ◐ : Leicht unterbrochener Schnitt
- ✱ : Stark unterbrochener Schnitt

SN



Quadratisch,
90° mit Loch

| | | | | | | | | | | | | | | | | | | | | | | |
|---|------------------------|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| P | Stahl | | | | | | | | | | | | | | | | | | | | | |
| M | Rostfr. Stahl | | | | | | | | | | | | | | | | | | | | | |
| K | Eisenguss | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| N | Nichteisenmetalle | | | | | | | | | | | | | | | | | | | | | |
| S | Hitzebest. Legierungen | | | | | | | | | | | | | | | | | | | | | |
| H | Gehärteter Stahl | | | | | | | | | | | | | | | | | | | | | |



| Anwendungen | Spanformstufe | Katalog Nr. | Beschichtet | | Abmessungen (mm) | | | | | |
|-------------------------------------|----------------------|----------------------|-------------|------|------------------|-----|-------|-------|------|------|
| | | | T505 | T515 | RE | IC | S | D1 | | |
| Mittlere Bearbeitung | All-Round | SNMG090304 | ● | | | | 0.4 | 9.525 | 3.18 | 3.81 |
| | | SNMG090308 | ● | | | | 0.8 | 9.525 | 3.18 | 3.81 |
| | SNMG120404 | ● | | | | 0.4 | 12.7 | 4.76 | 5.16 | |
| | SNMG120408 | ● | ● | | | 0.8 | 12.7 | 4.76 | 5.16 | |
| | SNMG120412 | ● | ● | | | 1.2 | 12.7 | 4.76 | 5.16 | |
| | SNMG120416 | ● | ● | | | 1.6 | 19.05 | 6.35 | 7.93 | |
| | CM | SNMG120408-CM | ● | ● | | | 0.8 | 12.7 | 4.76 | 5.16 |
| | | SNMG120412-CM | ● | ● | | | 1.2 | 12.7 | 4.76 | 5.16 |
| Schlichten bis mittlere Bearbeitung | Flat-top | SNMA120408 | ● | ● | | | 0.8 | 12.7 | 4.76 | 5.16 |
| | | SNMA120412 | ● | ● | | | 1.2 | 12.7 | 4.76 | 5.16 |
| | | | | | | | | | | |

● : Neu
● : Lagerstandard

Wendeschneidplatten NEGATIV

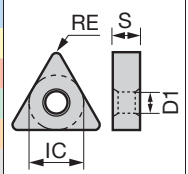
- : Kontinuierlicher Schnitt
- : Leicht unterbrochener Schnitt
- * : Stark unterbrochener Schnitt

TN



**Dreieckig,
60° mit Loch**

| | | | | | | | | | | | | | | | | | | | | | | |
|---------------------------------|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| P Stahl | | | | | | | | | | | | | | | | | | | | | | |
| M Rostfr. Stahl | | | | | | | | | | | | | | | | | | | | | | |
| K Eisenguss | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| N Nichteisenmetalle | | | | | | | | | | | | | | | | | | | | | | |
| S Hitzebest. Legierungen | | | | | | | | | | | | | | | | | | | | | | |
| H Gehärteter Stahl | | | | | | | | | | | | | | | | | | | | | | |



| Anwendungen | Spanformstufe | Katalog Nr. | Beschichtet | | Abmessungen (mm) | | | |
|--|----------------------|----------------------|-------------|------|------------------|-------|------|------|
| | | | T505 | T515 | RE | IC | S | D1 |
| Mittlere Bearbeitung | All-Round | TNMG160404 | ● | ● | 0.4 | 9.525 | 4.76 | 3.81 |
| | | TNMG160408 | ● | ● | 0.8 | 9.525 | 4.76 | 3.81 |
| | | TNMG160412 | ● | ● | 1.2 | 9.525 | 4.76 | 3.81 |
| | CM | TNMG160404-CM | ● | ● | 0.4 | 9.525 | 4.76 | 3.81 |
| | | TNMG160408-CM | ● | ● | 0.8 | 9.525 | 4.76 | 3.81 |
| | | TNMG160412-CM | ● | ● | 1.2 | 9.525 | 4.76 | 3.81 |
| Mittlere Bearbeitung bis Schwerverspannung | CH | TNMG160404-CH | | ● | 0.4 | 9.525 | 4.76 | 3.81 |
| | | TNMG160408-CH | | ● | 0.8 | 9.525 | 4.76 | 3.81 |
| | | TNMG160412-CH | | ● | 1.2 | 9.525 | 4.76 | 3.81 |
| Schichten bis mittlere Bearbeitung | Flat-top | TNMA110404E | | ● | 0.4 | 6.35 | 4.76 | 2.26 |
| | | TNMA110408E | | ● | 0.8 | 6.35 | 4.76 | 2.26 |
| | | TNMA110412E | | ● | 1.2 | 6.35 | 4.76 | 2.26 |
| | | TNMA160404 | ● | ● | 0.4 | 9.525 | 4.76 | 3.81 |
| | | TNMA160408 | ● | ● | 0.8 | 9.525 | 4.76 | 3.81 |
| | | TNMA160412 | ● | ● | 1.2 | 9.525 | 4.76 | 3.81 |

- : Neu
- : Lagerstandard

Wendeschneidplatten NEGATIV

- : Kontinuierlicher Schnitt
- : Leicht unterbrochener Schnitt
- ✱ : Stark unterbrochener Schnitt

| Anwendungen | | Spanformstufe | Katalog Nr. | Beschichtet | | Abmessungen (mm) | | | |
|------------------------------------|--|-----------------|--------------------|-------------|------|------------------|-------|------|------|
| | | | | T505 | T515 | RE | IC | S | D1 |
| Schichten bis mittlere Bearbeitung | | Flat-top | WNMA060404E | ● | ● | 0.4 | 9.525 | 4.76 | 3.81 |
| | | | WNMA060408E | ● | ● | 0.8 | 9.525 | 4.76 | 3.81 |
| | | | WNMA060412E | ● | ● | 1.2 | 9.525 | 4.76 | 3.81 |
| | | | WNMA060416E | ● | ● | 1.6 | 9.525 | 4.76 | 3.81 |
| | | | WNMA080408 | ● | ● | 0.8 | 12.7 | 4.76 | 5.16 |
| | | | WNMA080412 | ● | ● | 1.2 | 12.7 | 4.76 | 5.16 |
| | | | WNMA080416 | ● | ● | 1.6 | 12.7 | 4.76 | 5.16 |

| Anwendungen | | Spanformstufe | Katalog Nr. | Beschichtet | | Abmessungen (mm) | | | | |
|----------------------|---|------------------|------------------------------------|---------------|-----------------|--------------------|-------|-------|------|------|
| | | | | T505 | T515 | RE | IC | S | D1 | |
| Mittlere Bearbeitung | | All-Round | VNMG160404 | ● | ● | 0.4 | 9.525 | 4.76 | 3.81 | |
| | | | VNMG160408 | ● | ● | 0.8 | 9.525 | 4.76 | 3.81 | |
| | | | VNMG160412 | ● | ● | 1.2 | 9.525 | 4.76 | 3.81 | |
| | | | CM | VNMG160408-CM | ● | ● | 0.8 | 9.525 | 4.76 | 3.81 |
| | | | Schichten bis mittlere Bearbeitung | | Flat-top | VNMA120404E | ● | ● | 0.4 | 7.15 |
| VNMA120408E | ● | ● | | | | 0.8 | 7.15 | 4.76 | 3.81 | |
| | | | | | | | | | | |

- : Neu
- : Lagerstandard

Wendeschnidplatten POSITIV

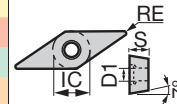
- : Kontinuierlicher Schnitt
- : Leicht unterbrochener Schnitt
- ✱ : Stark unterbrochener Schnitt

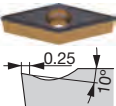
VC

Rhombisch,
35° mit Loch
Positiv 7°




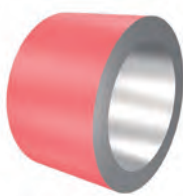
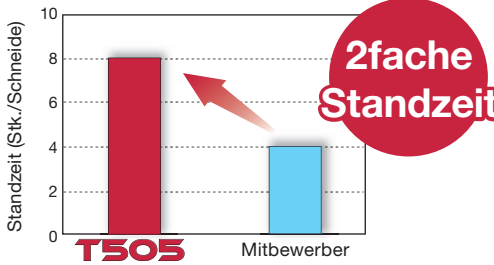
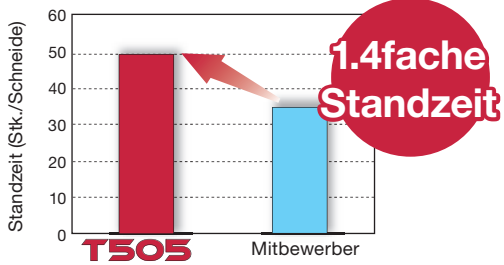
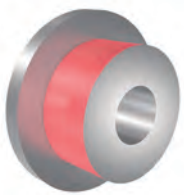
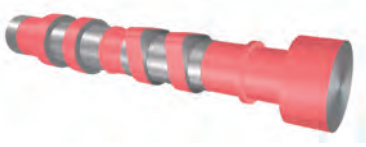
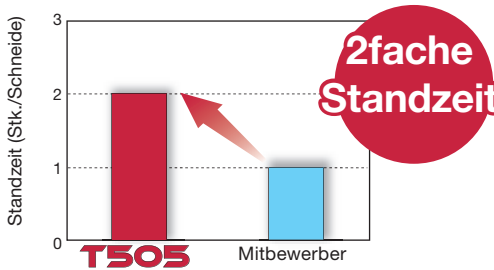
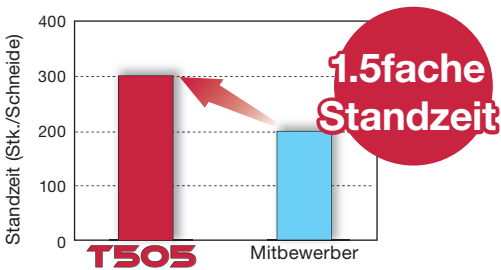
| | | | | | | | | | | | |
|---------------------------------|---|---|--|--|--|--|--|--|--|--|--|
| P Stahl | | | | | | | | | | | |
| M Rostfr. Stahl | | | | | | | | | | | |
| K Eisenguss | ● | ● | | | | | | | | | |
| N Nichtisenmetalle | | | | | | | | | | | |
| S Hitzebest. Legierungen | | | | | | | | | | | |
| H Gehärteter Stahl | | | | | | | | | | | |



| Anwendungen | Spanformstufe | Katalog Nr. | Beschichtet | | | | | | | | | | Abmessungen (mm) | | | | | |
|--|---------------|----------------------|-------------|------|--|--|--|--|--|--|--|--|------------------|----|-----|-------|------|-----|
| | | | T505 | T515 | | | | | | | | | RE | IC | S | D1 | | |
| Schlichten bis mittlere Bearbeitung  | CM | VCMT160404-CM | ● | ● | | | | | | | | | | | 0.4 | 9.525 | 4.76 | 4.4 |
| | | VCMT160408-CM | ● | ● | | | | | | | | | | | 0.8 | 9.525 | 4.76 | 4.4 |

● : Neu
● : Lagerstandard

PRAKTISCHE BEISPIELE

| Werkstück | | Schwungrad | Maschinenteil |
|--------------------|---------------------------------------|---|--|
| Wendeschnidplatte | | CNMG120408 | CNMG120408-CM |
| Schneidstoff | | T505 | T505 |
| | | FC300 / GG30 / 300 | FCD500 |
| Werkstoff | |  K |  K |
| Schnittbedingungen | Schnittgeschwindigkeit: V_c (m/min) | 200 | 100 |
| | Vorschub : f (mm/Z) | 0.25 | 0.5 |
| | Schnitttiefe : a_p (mm) | 3 | 2 |
| | Bearbeitung | Innen- und Plandrehen | Drehen / Außen |
| | Kühlmittel | Emulsion | Ohne |
| Resultat | |  2fache Standzeit |  1.4fache Standzeit |
| Werkstück | | Automobilteil | Nockenwelle |
| Wendeschnidplatte | | CNMA120408 | DNMG150408 |
| Schneidstoff | | T505 | T505 |
| | | FCD500 | FCD700 |
| Werkstoff | |  K |  K |
| Schnittbedingungen | Schnittgeschwindigkeit: V_c (m/min) | 426 | 150 - 200 |
| | Vorschub : f (mm/Z) | 0.3 | 0.2 - 0.35 |
| | Schnitttiefe : a_p (mm) | 3 | 1 |
| | Bearbeitung | Drehen / Außen | Außen- und Plandrehen |
| | Kühlmittel | Emulsion | Ohne |
| Resultat | |  2fache Standzeit |  1.5fache Standzeit |

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