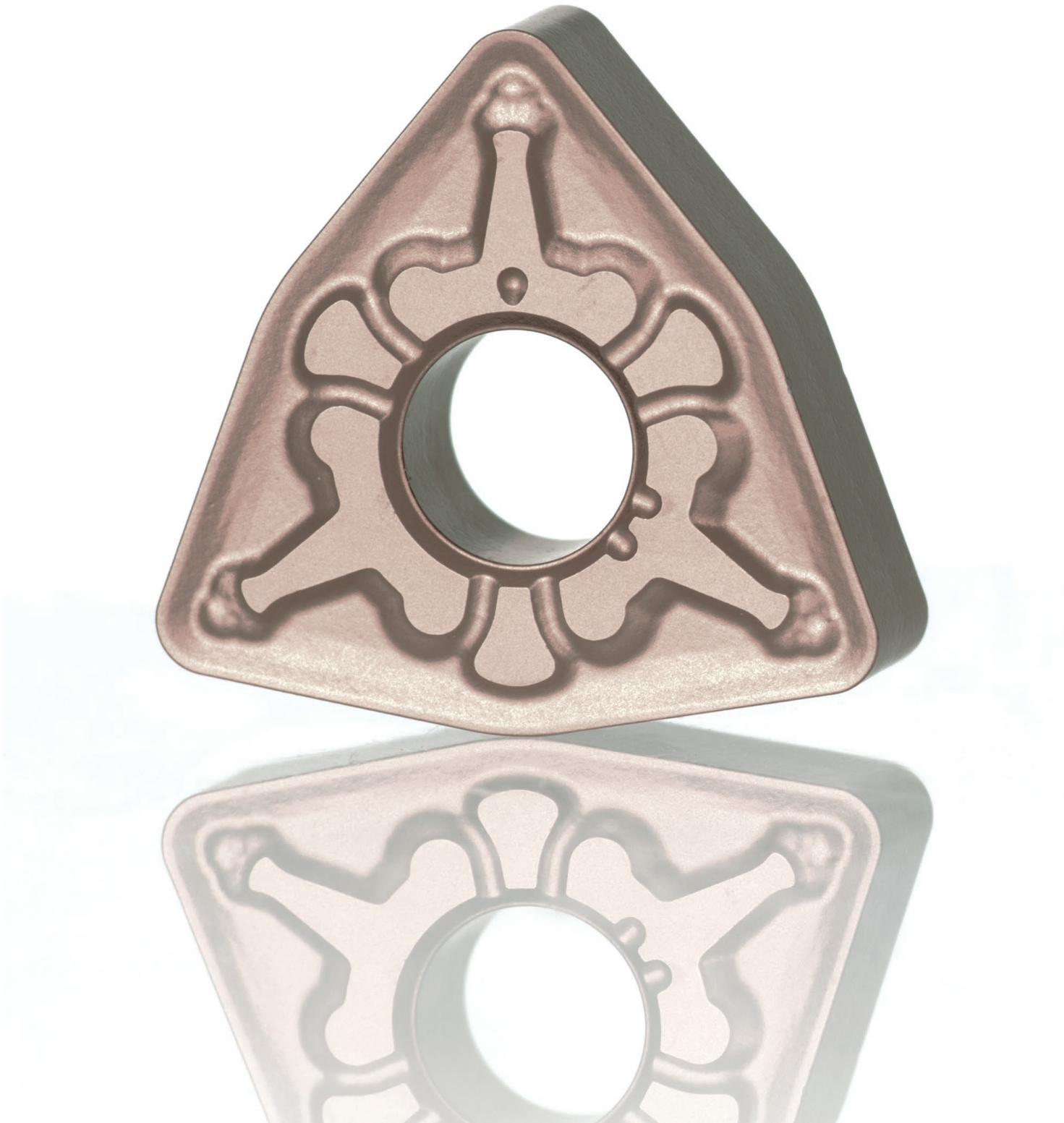
Wendeschneidplatten



Wendeschneidplatten – Kapitelübersicht

- Wendeschneidplatten sind in drei Gruppen unterteilt: Positive, negative und CBN-/PKD-Wendeschneidplatten.
- Die Liste ist alphabetisch sortiert.
- Reihenfolge: C (80°) → D (55°) → R (360°) → S (90°) → T (60°) → V (35°) → W (80°) → Y (25°) → Sonstige
- Reihenfolge der Wendeschneidplatten:
  - Negativ (mit Loch → ohne Loch)
  - Positiv (mit Loch → ohne Loch)
- Reihenfolge der Spanformstufen:
  Vom Feinschlichten bis hin zur Schwerzerspanung, sortiert nach Schnitttiefe und Vorschubgeschwindigkeit.
- Wendeschneidplatten ohne Spanformstufe finden Sie jeweils auf der letzten Seite pro Form.
- Kompatible Wendeschneidplatten nach Art der Werkstoffe aufgeführt.
- Die Standard Schnittdaten für typische Spanformstufen finden Sie jeweils im unteren Teil der Seite.
- Das Symbol ● kennzeichnet Lagerstandards. Das Symbol ▲ weist darauf hin, dass das jeweilige Produkt in Zukunft aus dem Verkauf genommen wird.

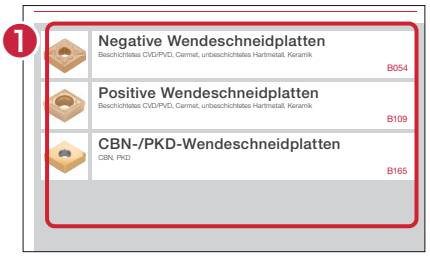
Hinweise zur Verwendung der Seite

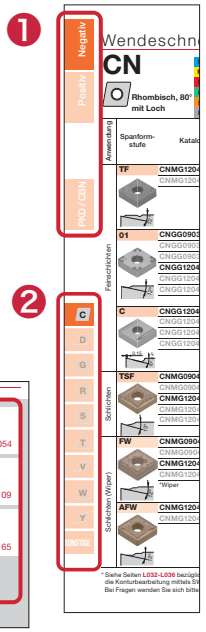
Verfahren ①

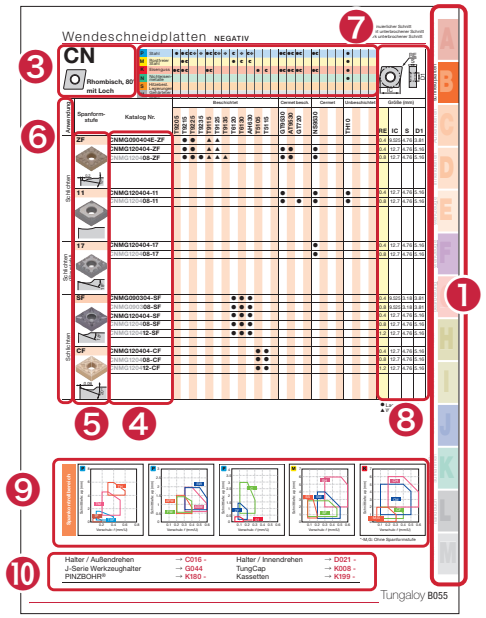
Wählen Sie auf der rechten Seite die gewünschte Produktgruppe und auf der linken Seite die Wendeschneidplattenart (❶) sowie die Form der Wendeschneidplatte (❷) aus.

Verfahren ②

Ermitteln Sie die Detailseite der gewünschten Wendeschneidplattenart mithilfe des Verzeichnisses auf der Seite B003 (❶). Blättern Sie dann zur Produktseite der jeweiligen Wendeschneidplattenform (❷).

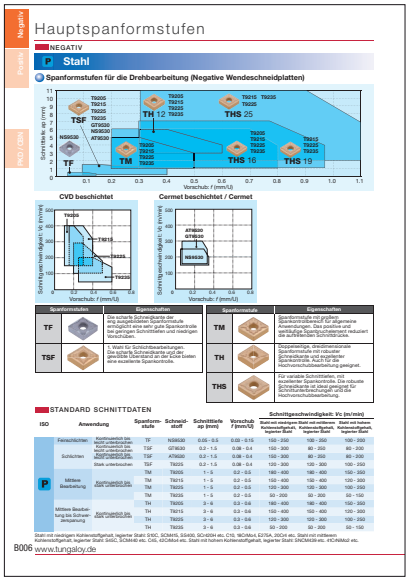


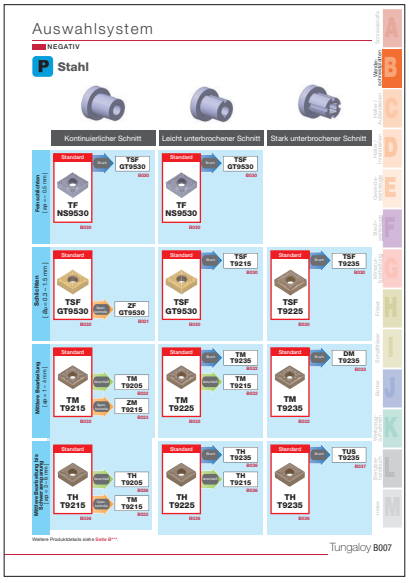




Verfahren ③

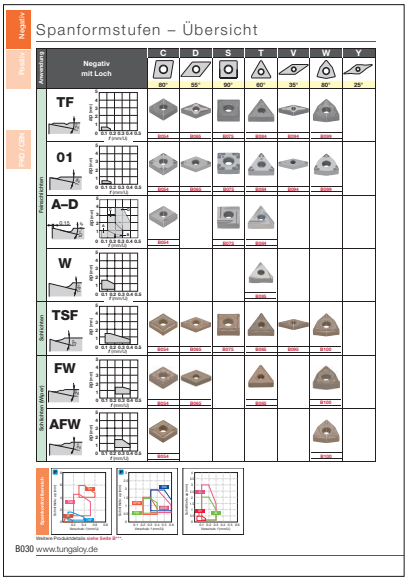
Wählen Sie in der Übersicht und im Auswahlsystem zu Spanformstufen auf den Seiten B006 - B029 die gewünschte Wendeschneidplatte aus und blättern Sie zur jeweiligen Produktseite.





Verfahren ④

Wählen Sie eine Wendeschneidplatte aus der Liste der Spanformstufenformen auf den Seiten B030-B053 aus und blättern Sie zur jeweiligen Produktseite.



Bestellinformationen:

- Bitte geben Sie die Katalog Nr., den Schneidstoff und die gewünschte Anzahl der Wendeschneidplatten an.
  z. B. **CNMG120408-TM T9115 ... 10 Stück** (VE = 10 Stück)
  *Falls die Stückzahl pro Packung nicht 10 beträgt, ist dies jeweils angegeben.

Wendeschneidplatten

Negative Wendeschneidplatten

Beschichtetes CVD/PVD, Cermet, unbeschichtetes Hartmetall, Keramik

B054

Positive Wendeschneidplatten

Beschichtetes CVD/PVD, Cermet, unbeschichtetes Hartmetall, Keramik

B109

CBN-/PKD-Wendeschneidplatten

CBN, PKD

B165

Nomenklatur für Wendeschneidplatten

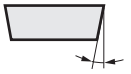
● Nomenklatur für Wendeschneidplatten (gemäß JIS B4120-1998, ISO 1832 / AM1:1998)

Code	Form	Eckenwinkel	Zeichnung
H	Sechseckig	120°	
O	Achteckig	135°	
P	Fünfeckig	108°	
S	Quadratisch	90°	
T	Dreieckig	60°	
C	Rhombisch	80°	
D		55°	
E		75°	
F		50°	
G	Tungaloy Form	70°	
M	Rhombisch	86°	
V		35°	
Y	Tungaloy Form	25°	
W	Trigonal	80°	
L	Rechteckig	90°	
A	Parallelogram	85°	
B		82°	
K		55°	
R	Rund	-	

① Form

Hinweis: Bei rhombisch und parallel geformten Wendeschneidplatten sind kleinere Eckenradien zu bevorzugen.

Code	Freiwinkel
A	3°
B	5°
C	7°
D	15°
E	20°
F	25°
G	30°
N	0°
P	11°
O	Sonstige
X	Spezial



② Freiwinkel

Code (Klasse)	Toleranz (mm)		
	Maß (M)	Dicke (S)	Innenkreis Ø (IK)
A	±0.005	±0.025	±0.025
F	±0.005	±0.025	±0.013
C	±0.013	±0.025	±0.025
H	±0.013	±0.025	±0.013
E	±0.025	±0.025	±0.025
G	±0.025	±0.13	±0.025
J	±0.005	±0.025	±0.005 - ±0.13
K	±0.013	±0.025	±0.05 - ±0.13
L	±0.025	±0.025	±0.05 - ±0.13
M	±0.08 - ±0.18	±0.13	±0.05 - ±0.13
N	±0.08 - ±0.18	±0.025	±0.05 - ±0.13
U	±0.13 - ±0.38	±0.13	±0.08 - ±0.25

③ Toleranz

	①	②	③	④	⑤
[Beispiel]	T	N	M	G	16
[Beispiel]	C	C	G	T	09
	①	②	③	④	⑤

④ Spanformstufe und Befestigung

Symbol	Loch	Lochform	Spanformstufe	Form
N	Ohne	–	Ohne	
R			Einseitig	
F			Doppelseitig	
A	Mit	Zylindrische Löcher	Ohne	
M			Einseitig	
G			Doppelseitig	
W		Teilweise zylindrisches Loch, einseitig 40° - 60° Senkloch	Ohne	
T			Einseitig	
Q		Teilweise zylindrisches Loch, doppelseitig 40° - 60° Senkloch	Ohne	
U			Doppelseitig	
B		Teilweise zylindrisches Loch, einseitig 70° - 90° Senkloch	Ohne	
H			Einseitig	
C		Teilweise zylindrisches Loch, doppelseitig 70° - 90° Senkloch	Ohne	
J			Doppelseitig	
X	Sonderform			

⑤ Größe

* R		S		C		W		T		D		V		K		Innenkreis Ø
Code	Größe	Code	Größe	Code	Größe	Code	Größe	Code	Größe	Code	Größe	Code	Größe	Code	Größe	
		03	3.97	03	4.0			06	6.9	04	4.8					3.97
		04	4.76	04	4.8			08	8.2	05	5.8	08	8.3			4.76
05	5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	5
		05	5.56	05	5.6	03	3.8	09	9.6	06	6.8					5.56
06	6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6
		06	6.35	06	6.5	04	4.3	11	11	07	7.8	11	11.2			6.35
		07	7.94	08	8.1	05	5.4	13	13.8	09	9.7					7.94
08	8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	8
09	9.525	09	9.525	09	9.7	06	6.5	16	16.5	11	11.6	16	16.6	16	19.7	9.525
10	10	–	–	–	–	–	–	–	–	–	–	–	–	–	–	10
12	12	–	–	–	–	–	–	–	–	–	–	–	–	–	–	12
12	12.7	12	12.7	12	12.9	08	8.7	22	22	15	15.5	22	22.1			12.7
15	15.875	15	15.875	16	16.1	10	10.9	27	27.5	19	19.4					15.875
16	16	–	–	–	–	–	–	–	–	–	–	–	–	–	–	16
19	19.05	19	19.05	19	19.3	13	13	33	33	23	23.3					19.05
20	20	–	–	–	–	–	–	–	–	–	–	–	–	–	–	20
		22	22.225	22	22.6			38	38.5	27	27.1					22.225
25	25	–	–	–	–	–	–	–	–	–	–	–	–	–	–	25
25	25.4	25	25.4	25	25.8			44	44	31	31					25.4
31	31.75	31	31.75	32	32.2			55	55	38	38.8					31.75
32	32	–	–	–	–	–	–	–	–	–	–	–	–	–	–	32

* Wenn die Bezeichnung die Angabe M0 enthält, ist der Durchmesser des Innenkreises metrisch. (mm)

● Detailtoleranzen für Klassen J,K,L,M,N und U

Für Wendeschneidplatten mit Eckenwinkeln < 55°

(mm)

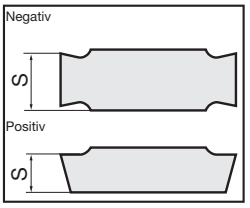
Innenkreis	Innenkreistoleranz (IK)		Prüfmaßtoleranz (M)		Form
	J,K,L,M,N	U	J,K,L,M,N	U	
6.35	±0.05	±0.08	±0.08	±0.13	H W O R P S T C,E,M
9.525					
12.7	±0.08	±0.13	±0.13	±0.2	
15.875	±0.1	±0.18	±0.15	±0.27	
19.05					
25.4	±0.13	±0.25	±0.18	±0.38	
31.75	±0.15	±0.25	±0.2	±0.38	
32					

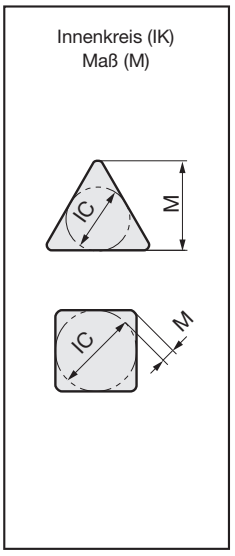
Für Wendeschneidplatten der M-Toleranz mit Spitzenwinkel von 55° (Form: D), 35° (Form: V), 25° (Form: Y)

(mm)

Innenkreis	Innenkreistoleranz (IK)	Prüfmaßtoleranz (M)	Form
6.35	±0.05	±0.11	D
9.525			
12.7	±0.08	±0.15	
15.875	±0.1	±0.18	
19.05			
6.35	±0.05	±0.16	V
9.525			Y

● Dicke
Die Dicke der Wendeschneidplatte (S) ist von der Auflagefläche bis Schneidkante gemessen. Siehe Abbildung rechts.





Code	Dicke (mm)
X1	1.39
01	1.59
T1	1.98(1.79)
02	2.38
T2	2.78
03	3.18
T3	3.97
04	4.76
05	5.56
06	6.35
07	7.94
09	9.52

⑥ Dicke

[Beispiel]

⑥	⑦				⑩
04	08			-	TM
T3	04	F	N	-	JS
⑥	⑦	⑧	⑨		⑩

(Optionaler Code) (Optionaler Code) (Zusätzlicher Code)

⑦ Eckenradius

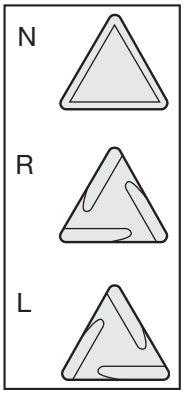
Code	Eckenradius RE (mm)
00	0.03
02	0.2
04	0.4
08	0.8
12	1.2
16	1.6
20	2.0
24	2.4
28	2.8
32	3.2

⑧ Schneidkantenausführungen

Code	Schneidkante	Form
F	Scharfe Schneidkante	
E	Gerundet	
W.T	Gefast	
S	Gefast/ Gerundet	

⑨ Schneidrichtung

Code	Richtung
R	Rechts
L	Links
N	Neutral



⑩ Spanformstufe

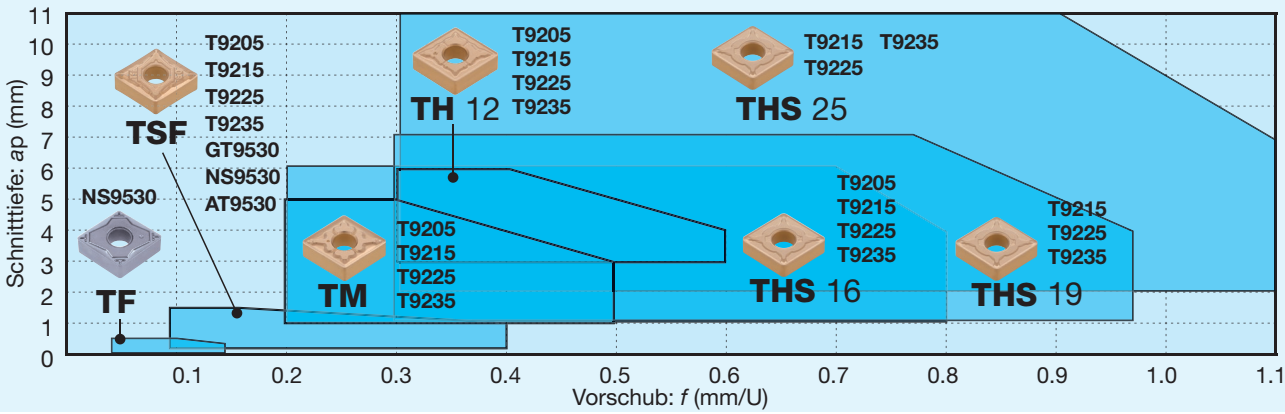
Code	Anwendungen	Code	Anwendungen
01(TF)	Fenschlichten (Hauptspanformstufe)	AFW	Geringe Schnitttiefen und Hochvorschub (Wiper)
TS	Schlichten (Hauptspanformstufe)	ASW	Geringe Schnitttiefen und Hochvorschub (Wiper)
TSF	Schlichten (Hauptspanformstufe)	CB	Mittlere Bearbeitung
TM	Mittl. Bearbeitung (Hauptspanformstufe)	CM	Mittlere Bearbeitung (Eisenguss)
THS	Mittlere Bearbeitung bis Schwerzerspanung (Hauptspanformstufe)	All-round	Mittlere Bearbeitung
TRS	Mittlere Bearbeitung bis Schwerzerspanung	A	Schlichten (Links/Rechts)
TUS	Schwerzerspanung	B	Schlichten (Links/Rechts)
DM	Mittlere Bearbeitung	C	Schlichten (Links/Rechts)
HRF	Schlichten	D	Schlichten (Links/Rechts)
HRM	Schlichten bis mittlere Bearbeitung	P	Schlichten (Aluminium)
HMM	Schlichten bis mittlere Bearbeitung	W	Schlichten (Positiver Spanwinkel)
SF	Schlichten (Rostfreier Stahl)	PSF	Schlichten (Positiv)
SS	Schlichten (Rostfreier u. Baustahl)	PSS	Schlichten (Positiv)
SM	Mittlere Bearbeitung (Rostfreier Stahl)	PS	Schlichten bis mittlere Bearbeitung (Positive Spanformstufe, Hauptspanformstufe)
S	Mittlere Bearbeitung (Rostfreier Stahl)	PM	Mittlere Bearbeitung (Positive Spanformstufe)
SH	Mittlere Bearbeitung bis Schwerzerspanung (Rostfreier Stahl)	AL	Schlichten bis mittlere Bearbeitung (Aluminium)
SA	Hitzebeständige Legierungen und rostfreien Stahl	RS	Mittlere Bearbeitung (runde WSP)
ZF	Schlichten und Kopierdrehen	W□□	Schlichten (Positiver Spanwinkel)
ZM	Schlichten bis mittlere Bearb. und Kopierdrehen	H□□	Schlichten bis mittl. Bearb. (Parallel)
NS	Schlichten und Kopierdrehen	11	Schlichten
NM	Schlichten bis mittlere Bearb. und Kopierdrehen	61	Geringe Schnitttiefen und Hochvorschub (runde WSP)
AS	Geringe Schnitttiefen und Hochvorschub	S1	Schlichten (KNMX-Typ)
TA	Mittlere Bearbeitung	J08,J10	Für kleine Drehmaschinen
TQ	Mittlere Bearbeitung	JS	Für kleine Drehmaschinen
AM	Geringe Schnitttiefen und Hochvorschub	JRP	Für kleine Drehmaschinen
FW	Schlichten (Wiper)	JPP	Für kleine Drehmaschinen
SW	Schlichten bis mittlere Bearbeitung (Wiper)	JSP	Für kleine Drehmaschinen

Hauptspanformstufen

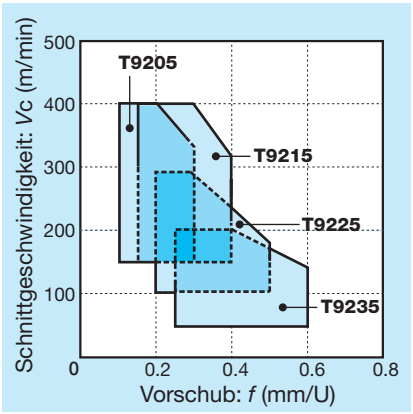
NEGATIV

P Stahl

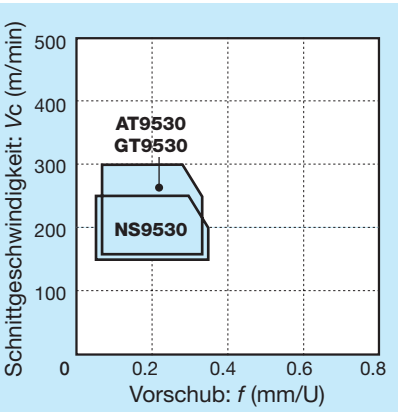
Spanformstufen für die Drehbearbeitung (Negative Wendeschneidplatten)

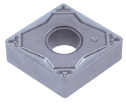


CVD beschichtet



Cermet beschichtet / Cermet



Spanformstufen		Eigenschaften
TF		Die scharfe Schneidkante der eng ausgebildeten Spanformstufe ermöglicht eine sehr gute Spankontrolle bei geringen Schnitttiefen und niedrigen Vorschüben.
TSF		1. Wahl für Schlichtbearbeitungen. Die scharfe Schneidkante und der gewölbte Überstand an der Ecke bieten eine exzellente Spankontrolle.

Spanformstufe		Eigenschaften
TM		Spanformstufe mit großem Spankontrollbereich für allgemeine Anwendungen. Das positive und weitläufige Spanbruchelement reduziert die auftretenden Schnittdrücke.
TH		Doppelseitige, dreidimensionale Spanformstufe mit robuster Schneidkante und exzellenter Spankontrolle. Auch für die Hochvorschubbearbeitung geeignet.
THS		Für variable Schnitttiefen, mit exzellenter Spankontrolle. Die robuste Schneidkante ist ideal geeignet für Schnittunterbrechungen und die Hochvorschubbearbeitung.

STANDARD SCHNITTDATEN

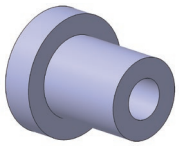
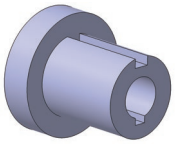
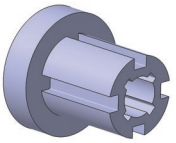
ISO	Anwendung		Spanform-stufe	Schneid-stoff	Schnitttiefe *ap* (mm)	Vorschub *f* (mm/U)	Schnittgeschwindigkeit: *Vc* (m/min)		
							Stahl mit niedrigem Kohlenstoffgehalt, legierter Stahl	Stahl mit mittlerem Kohlenstoffgehalt, legierter Stahl	Stahl mit hohem Kohlenstoffgehalt, legierter Stahl
P	Feinschlichten	Kontinuierlich bis leicht unterbrochen	TF	NS9530	0.05 - 0.5	0.03 - 0.15	150 - 250	100 - 250	100 - 200
	Schlichten	Kontinuierlich bis leicht unterbrochen	TSF	GT9530	0.2 - 1.5	0.08 - 0.4	150 - 300	80 - 250	80 - 200
		Kontinuierlich bis leicht unterbrochen	TSF	AT9530	0.2 - 1.5	0.08 - 0.4	150 - 300	80 - 250	80 - 200
		Stark unterbrochen	TSF	T9225	0.2 - 1.5	0.08 - 0.4	120 - 300	120 - 300	100 - 250
	Mittlere Bearbeitung	Kontinuierlich bis stark unterbrochen	TM	T9205	1 - 5	0.2 - 0.5	180 - 400	180 - 400	150 - 350
			TM	T9215	1 - 5	0.2 - 0.5	150 - 400	150 - 400	120 - 300
			TM	T9225	1 - 5	0.2 - 0.5	120 - 300	120 - 300	100 - 250
			TM	T9235	1 - 5	0.2 - 0.5	50 - 200	50 - 200	50 - 150
	Mittlere Bearbeitung bis Schwerzerspanung	Kontinuierlich bis stark unterbrochen	TH	T9205	3 - 6	0.3 - 0.6	180 - 400	180 - 400	150 - 350
			TH	T9215	3 - 6	0.3 - 0.6	150 - 400	150 - 400	120 - 300
			TH	T9225	3 - 6	0.3 - 0.6	120 - 300	120 - 300	100 - 250
			TH	T9235	3 - 6	0.3 - 0.6	50 - 200	50 - 200	50 - 150

Stahl mit niedrigem Kohlenstoffgehalt, legierter Stahl: S10C, SCM415, SS400, SCr420H etc. C10, 18CrMo4, E275A, 20Cr4 etc. Stahl mit mittlerem Kohlenstoffgehalt, legierter Stahl: S45C, SCM440 etc. C45, 42CrMo4 etc. Stahl mit hohem Kohlenstoffgehalt, legierter Stahl: SNCM439 etc. 41CrNiMo2 etc.

Auswahlsystem

NEGATIV

P Stahl

	Kontinuierlicher Schnitt	Leicht unterbrochener Schnitt	Stark unterbrochener Schnitt
Feinschlichten [ap = – 0.5 mm]	Standard **TF NS9530** B030 → Bruch → **TSF GT9530** B030	Standard **TF NS9530** B030 → Bruch → **TSF GT9530** B030	
Schlichten [ap = 0.3 – 1.5 mm]	Standard **TSF GT9530** B030 → Span-kontrolle → **ZF GT9530** B031	Standard **TSF GT9530** B030 → Bruch → **TSF T9215** B030	Standard **TSF T9225** B030 → Bruch → **TSF T9235** B030
Mittlere Bearbeitung [ap = 1 – 4 mm]	Standard **TM T9215** B032 → Verschleiß → **TM T9205** B032; Span-kontrolle → **ZM T9215** B033	Standard **TM T9225** B032 → Bruch → **TM T9235** B032; Verschleiß → **TM T9215** B032	Standard **TM T9235** B032 → Bruch → **DM T9235** B033
Mittlere Bearbeitung bis Schwerzerspanung [ap = 3 – 6 mm]	Standard **TH T9215** B036 → Verschleiß → **TH T9205** B036; Span-kontrolle → **TM T9215** B032	Standard **TH T9225** B036 → Bruch → **TH T9235** B036; Verschleiß → **TH T9215** B036	Standard **TH T9235** B036 → Bruch → **TUS T9235** B037

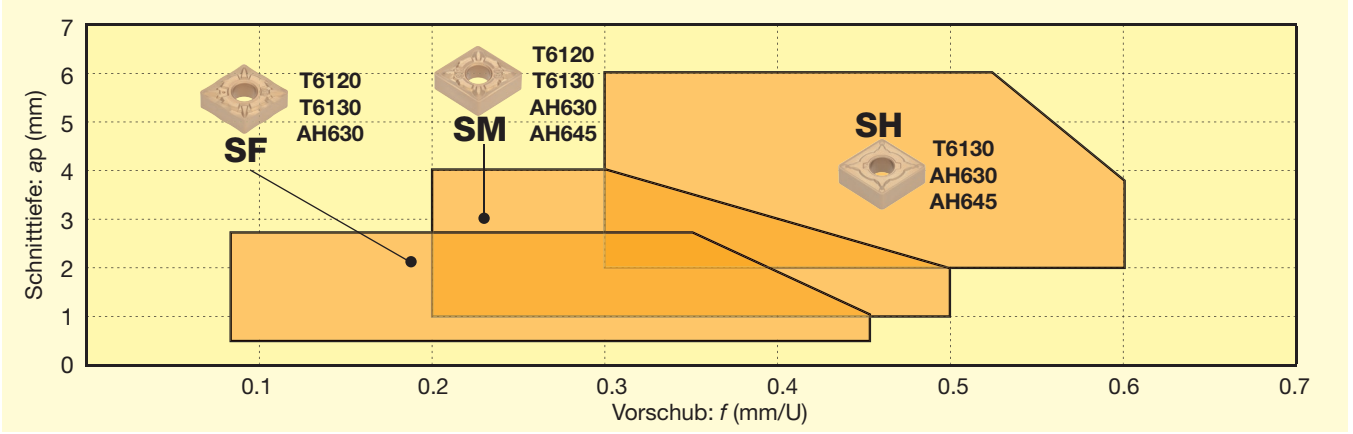
Weitere Produktdetails siehe Seite B***.

Hauptspanformstufen

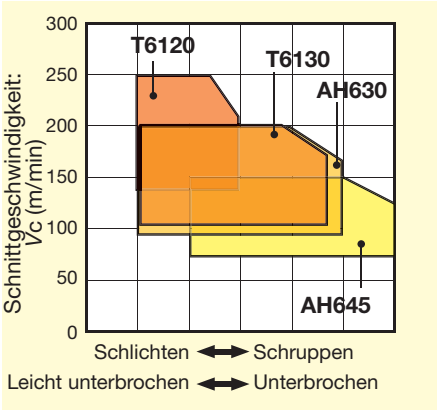
NEGATIV

M Rostfreier Stahl

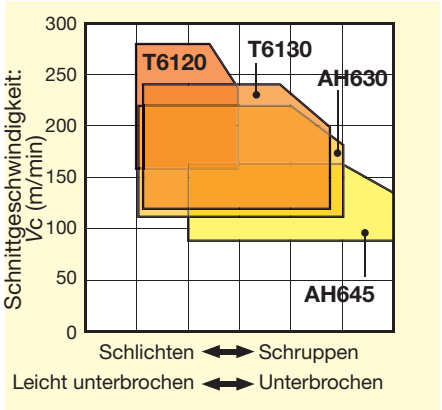
Spanformstufen für die Drehbearbeitung (Negative Wendeschneidplatten)



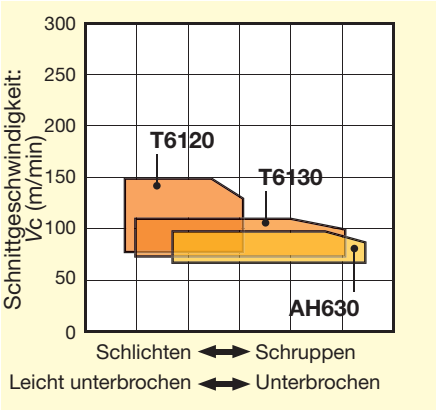
Austenitischer rostfreier Stahl

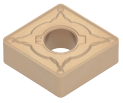


Ferritischer/martensitischer rostfreier Stahl



Vergüteter rostfreier Stahl



Spanformstufe		Eigenschaften
SF		Exzellente Spankontrolle bei geringer Schnitttiefe und Hochvorschub. Für das Schlichten von rostfreiem Stahl.
SH		Geeignet für mittlere Bearbeitung bis Schwerzerspanung. Hohe Bruchfestigkeit dank speziell verstärkter Schneidkante. Ideal für die Schruppbearbeitung und unterbrochenen Schnitt.

Spanformstufe		Eigenschaften
SM		Vielseitig einsetzbare, scharfe Spanformstufe mit guter Spankontrolle. 1. Wahl für rostfreien Stahl.

STANDARD SCHNITTDATEN

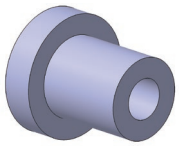
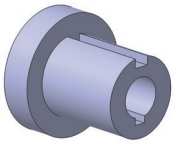
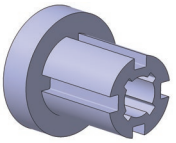
ISO		Anwendung	Spanformstufe	Schneidstoff	Schnitttiefe ap (mm)	Vorschub f (mm/U)	Schnittgeschwindigkeit Vc (m/min)
M	Schlichten	Kontinuierlicher Schnitt	SF	T6120	0.5 - 2.5	0.08 - 0.45	140 - 240
		Kontinuierlich bis leicht unterbrochen	SF	T6130	0.5 - 2.5	0.08 - 0.45	100 - 200
		Stark unterbrochener Schnitt	SF	AH630	0.5 - 2.5	0.08 - 0.45	90 - 190
	Mittlere Bearbeitung	Kontinuierlicher Schnitt	SM	T6120	1 - 4	0.2 - 0.5	140 - 240
		Kontinuierlich bis leicht unterbrochen	SM	T6130	1 - 4	0.2 - 0.5	100 - 200
		Leicht unterbrochener Schnitt	SM	AH630	1 - 4	0.2 - 0.5	90 - 190
		Stark unterbrochener Schnitt	SM	AH645	1 - 4	0.2 - 0.5	70 - 150
	Mittlere Bearbeitung bis Schwerzerspanung	Kontinuierlich bis leicht unterbrochen	SH	T6130	2 - 6	0.3 - 0.6	100 - 200
		Leicht unterbrochener Schnitt	SH	AH630	2 - 6	0.3 - 0.6	90 - 190
		Stark unterbrochener Schnitt	SH	AH645	2 - 6	0.3 - 0.6	70 - 150

Rostfreier Stahl: SUS304, SUS316 etc. X5CrNi18-9, X5CrNiMo17-12-3 etc.

Auswahlsystem

NEGATIV

M Rostfreier Stahl

	Kontinuierlicher Schnitt	Leicht unterbrochener Schnitt	Stark unterbrochener Schnitt
Schlichten [ap = 0.5 – 1.5 mm]	Standard **SF T6120** B031 → Bruch: **SF T6130** B031	Standard **SF T6130** B031 → Bruch: **SF AH630** B031; Verschleiß: **SF T6120** B031	Standard **SF AH630** B031 → Bruch: **SF AH645** B031; Verschleiß: **SF T6130** B031
Mittlere Bearbeitung [ap = 1 – 4 mm]	Standard **SM T6130** B035 → Verschleiß: **SM T6120** B035; Spankontrolle: **SF T6130** B031	Standard **SM AH630** B035 → Bruch: **SM AH645** B035; Verschleiß: **SM T6130** B035	Standard **SM AH645** B035 → Bruch: **SH AH645** B037
Mittlere Bearbeitung bis Schwerzerspanung [ap = 2 – 6 mm]	Standard **SH T6130** B037 → Bruch: **SH AH630** B037; Verschleiß: **SH T6120** B037; Spankontrolle: **SM T6130** B035	Standard **SH AH630** B037 → Bruch: **SH AH645** B037; Verschleiß: **SH T6130** B037	Standard **SH AH645** B037 → Verschleiß: **SH AH630** B037

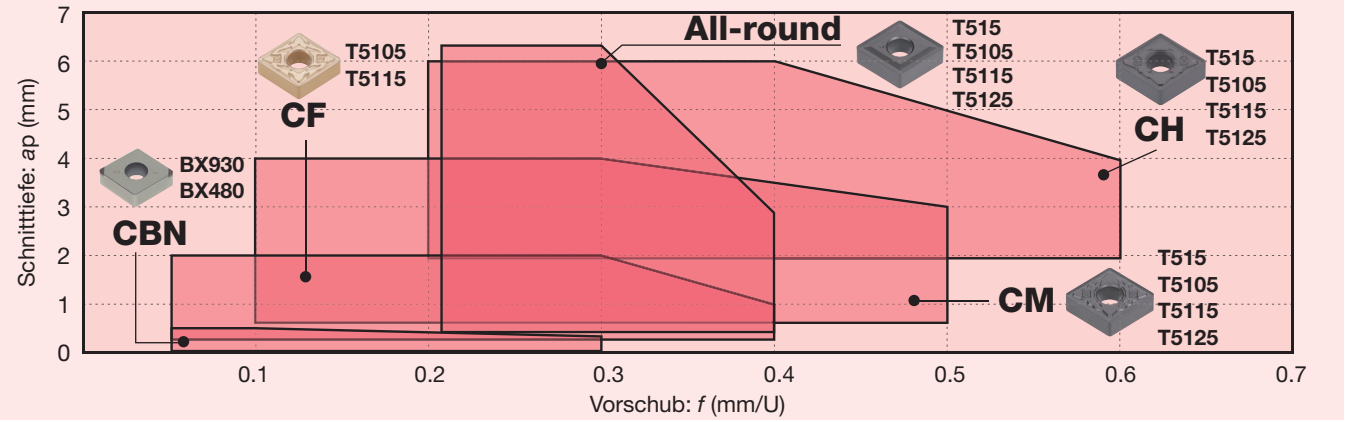
Weitere Produktdetails siehe Seite B***.

Hauptspanformstufen

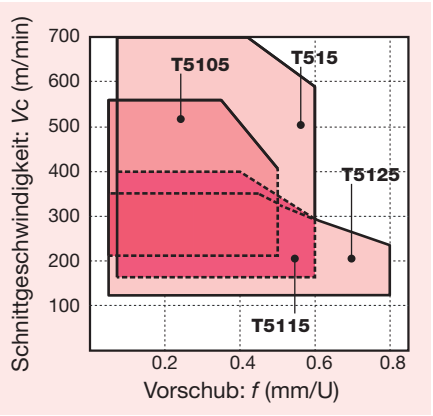
NEGATIV

K Eisenguss

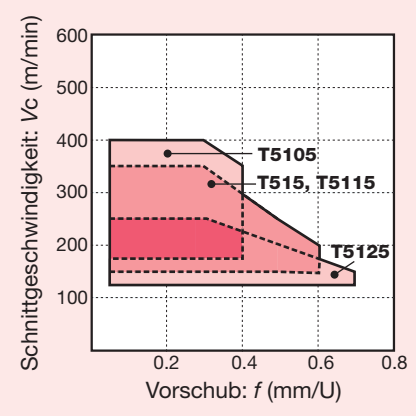
Spanformstufen für die Drehbearbeitung (Negative Wendeschneidplatten)



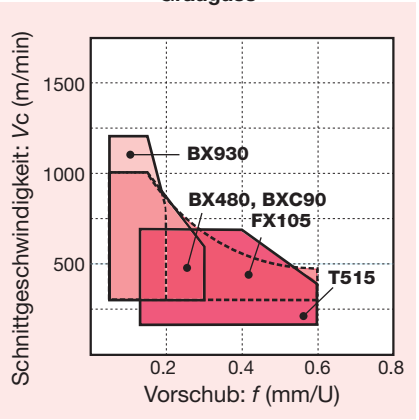
Grauguss

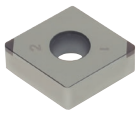
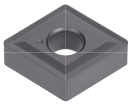


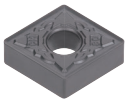
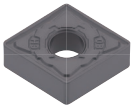
Kugelgraphitguss



Hochgeschwindigkeitszerspanung : Grauguss



Spanformstufe		Eigenschaften
– (CBN)		Für geringe bis hohe Schnitttiefen einsetzbar. Hohe Schneidkantenstabilität bei Schnittunterbrechungen oder Gusshaut.
CF		Für niedrige Schnittkräfte speziell in der Gussbearbeitung. Stark positiv geschwungene Schneidkante (20°) zur Reduzierung der Hauptschnittkräfte. Geringe Gratbildung speziell für dünnwandige Bauteile.
All-round		Hervorragende Leistung bei unterbrochenem Schnitt. Hochzuverlässige Spanformstufe mit hoher Stabilität.

Spanformstufe		Eigenschaften
CM		1. Wahl für die Zerspanung von Gusseisen. Anwendbar für eine Vielzahl von Schnittbedingungen vom kontinuierlichen bis unterbrochenen Schnitt. Positiv-Fase und große Spankammer.
CH		Spanformstufe mit verstärkter Schneidkante. Stabiler Plattensitz und hohe Schneidkantenstabilität durch vorgelagerte negative Fase – kein Bruch selbst bei Schwerzerspanung.

STANDARD SCHNITTDATEN

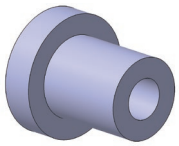
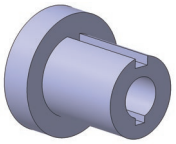
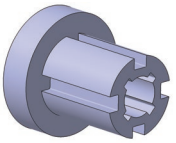
ISO	Anwendung		Spanform-stufe	Schneid-stoff	Schnitttiefe ap (mm)	Vorschub f (mm/U)	Schnittgeschwindigkeit: Vc (m/min)	
							Grauguss	Kugelgraphitguss
K	Hoch-geschwindig-keitsbearbeitung	Kontinuierlicher Schnitt	Ohne	BX930	0.05 - 0.5	0.05 - 0.2	300 - 1200	100 - 500
		Leicht unterbrochen	Ohne	BX480	0.05 - 0.5	0.05 - 0.3	300 - 1000	100 - 300
		Kontinuierlicher Schnitt	Ohne	BXC90	0.08 - 3	0.05 - 0.4	300 - 1000	100 - 300
	Schlichten	Kontinuierlicher Schnitt	All-round	T515	1 - 5	0.1 - 0.5	150 - 700	140 - 370
		Leicht unterbrochen	All-round	T515	1 - 5	0.1 - 0.5	150 - 700	140 - 370
		Stark unterbrochen	All-round	T515	1 - 5	0.1 - 0.5	150 - 700	140 - 370
	Mittlere Bearbeitung	Kontinuierlicher Schnitt	All-round	T515	1 - 5	0.1 - 0.5	150 - 700	140 - 370
		Leicht unterbrochen	All-round	T515	1 - 5	0.1 - 0.5	150 - 700	140 - 370
		Stark unterbrochen	CH	T515	3 - 6	0.2 - 0.6	150 - 700	140 - 370
	Mittlere Bearbeitung bis Schwer-zerspanung	Kontinuierlicher Schnitt	All-round	T515	1 - 5	0.1 - 0.5	150 - 700	140 - 370
		Leicht unterbrochen	All-round	T515	1 - 5	0.1 - 0.5	150 - 700	140 - 370
		Stark unterbrochen	CH	T515	3 - 6	0.2 - 0.6	150 - 700	140 - 370

Eisenguss: FC250 etc. 250 etc. Kugelgraphitguss: FCD450 etc. 450-10S etc.

Auswahlsystem

NEGATIV

K Eisenguss

	Kontinuierlicher Schnitt	Leicht unterbrochener Schnitt	Stark unterbrochener Schnitt
Schlichten [ap = 0.5 – 2 mm]	Standard **All-round T515** B033 → Verschleiß: **All-round T5105** B033; Grat-bildung: **CF T5105** B031	Standard **All-round T515** B033 → Verschleiß: **All-round T5105** B033; Bruch: **CH T515** B037; Grat-bildung: **CF T5115** B031	Standard **CH T515** B037 → Verschleiß: **CH T5105** B037; Bruch: **CH T5125** B037; Grat-bildung: **All-round T515** B033
Mittlere Bearbeitung [ap = 1 – 5 mm]	Standard **All-round T515** B033 → Verschleiß: **All-round T5105** B033; Grat-bildung: **CF T5105** B031	Standard **All-round T515** B033 → Verschleiß: **All-round T5105** B033; Bruch: **CH T515** B037; Grat-bildung: **CF T5115** B031	Standard **CH T515** B037 → Verschleiß: **CH T5105** B037; Bruch: **CH T5125** B037; Grat-bildung: **All-round T515** B033
Mittlere Bearbeitung bis Schwerzerspanung [ap = 3 – 6 mm]	Standard **All-round T515** B033 → Verschleiß: **All-round T5105** B033; Grat-bildung: **CF T5105** B031	Standard **All-round T515** B033 → Verschleiß: **All-round T5105** B033; Bruch: **CH T515** B037; Grat-bildung: **CF T5115** B031	Standard **CH T515** B037 → Verschleiß: **CH T5105** B037; Bruch: **CH T5125** B037; Grat-bildung: **All-round T515** B033

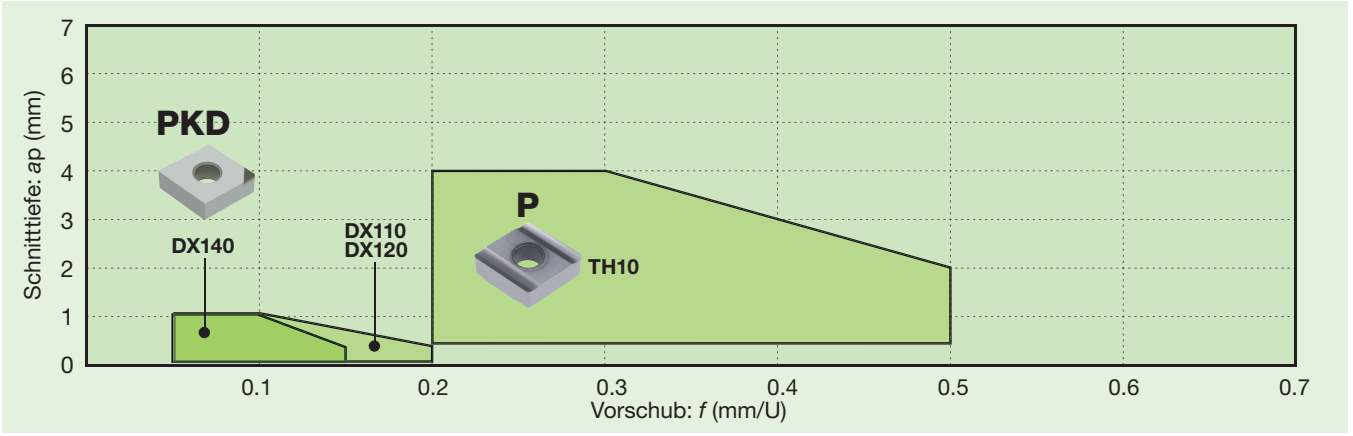
Weitere Produktdetails siehe Seite B***.

Hauptspanformstufen

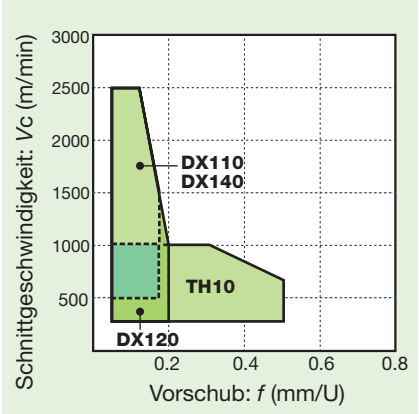
NEGATIV

N Nichteisenmetall

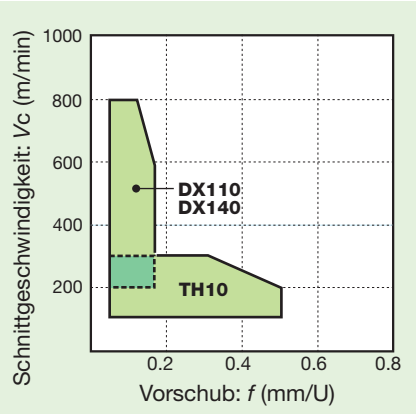
Spanformstufen für die Drehbearbeitung (Negative Wendeschneidplatten)



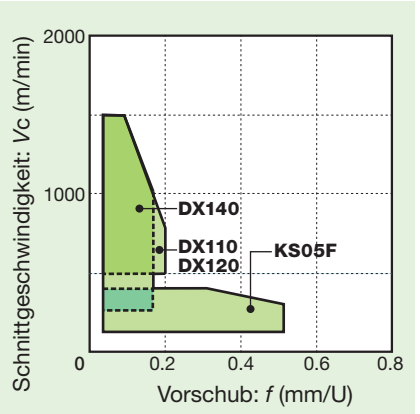
Aluminium (Si < 12 %)

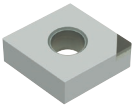
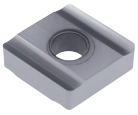


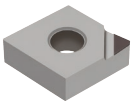
Aluminium (Si ≥ 12 %)



Kupferlegierungen



Spanformstufe		Eigenschaften
–		Optimal geeignet für die HSC-Schlichtbearbeitung von Nichteisenmetallen, wie Aluminium und Kupferlegierungen, mit diamantgesinterter Schneidkante.
P		Extrem scharfe Schneidkantenausbildung für Nichteisenmetalle, wie Aluminium und Kupferlegierungen.

Spanformstufe		Eigenschaften
Mit Spanformstufe		Große Spanfläche für optimale Spankontrolle.

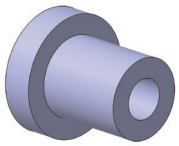
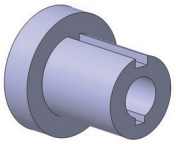
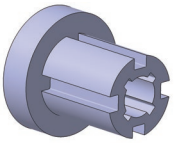
STANDARD SCHNITTDATEN

ISO	Anwendung		Spanformstufe	Schneidstoff	Schnitttiefe *ap* (mm)	Vorschub *f* (mm/U)	Schnittgeschwindigkeit: *Vc* (m/min) Aluminium (Si < 12 %)	Aluminium (Si ≥ 12 %)	Kupferlegierungen
N	Feinschlichten	Kontinuierlicher Schnitt	Mit	DX110	0.05 - 0.5	0.05 - 0.15	500 - 2500	400 - 800	500 - 1500
		Leicht unterbrochen	Ohne	DX140	0.05 - 0.5	0.05 - 0.20	300 - 2500	-	500 - 1500
	Schlichten	Kontinuierlicher Schnitt	Ohne	DX140	0.05 - 2	0.05 - 0.15	500 - 2500	400 - 800	500 - 1500
		Leicht unterbrochen	Ohne	DX140	0.05 - 2	0.05 - 0.15	300 - 1800	400 - 600	400 - 1200
		Stark unterbrochen	P	TH10	0.5 - 4	0.2 - 0.5	100 - 500	100 - 200	100 - 200
	Mittlere Bearbeitung	Kontinuierlich	P	TH10	0.5 - 4	0.2 - 0.5	100 - 1000	100 - 300	100 - 300
		Leicht unterbrochen	P	TH10	0.5 - 4	0.2 - 0.5	100 - 800	100 - 200	100 - 200
		Stark unterbrochen	P	TH10	0.5 - 4	0.2 - 0.5	100 - 500	100 - 200	100 - 200

Auswahlsystem

NEGATIV

N Nichteisenmetall

	Kontinuierlicher Schnitt	Leicht unterbrochener Schnitt	Stark unterbrochener Schnitt
Feinschlichten [ap = – 0.5 mm]	Standard: mit Spanformstufe **DX110** → B192, B194 Verschleiß: **PKD DX140** → B193, B195, B196	Standard: **PKD DX140** → B193, B195, B196 Oberflächengüte: Mit Spanformstufe PKD **DX110** → B192, B194 Verschleiß: **PKD DX160** → B193, B196	
Schlichten [ap = 0.5 –2 mm]	Standard: **PKD DX140** → B193, B195, B196 Oberflächengüte: Mit Spanformstufe PKD **DX110** → B192, B194 Verschleiß: **PKD DX160** → B193, B196	Standard: **PKD DX140** → B193, B195, B196 Bruch: **P TH10** → B035 Verschleiß: **PKD DX160** → B193, B196	Standard: **P TH10** → B035
Mittlere Bearbeitung [ap = 1 – 4 mm]	Standard: **P TH10** → B035 Verschleiß: **PKD DX140** → B193, B195, B196	Standard: **P TH10** → B035 Verschleiß: **PKD DX140** → B193, B195, B196	Standard: **P TH10** → B035

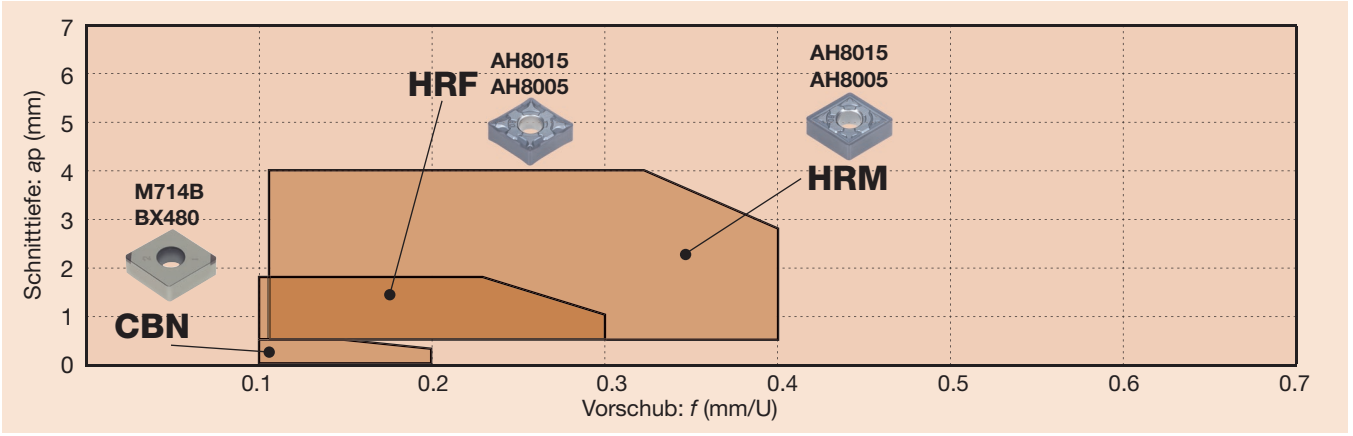
Weitere Produktdetails siehe Seite B***.

Hauptspanformstufen

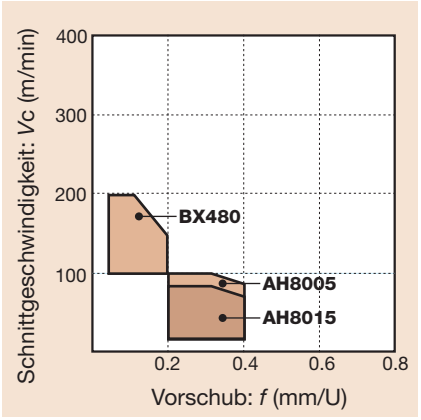
NEGATIV

S Hitzebeständige Legierungen und Titan

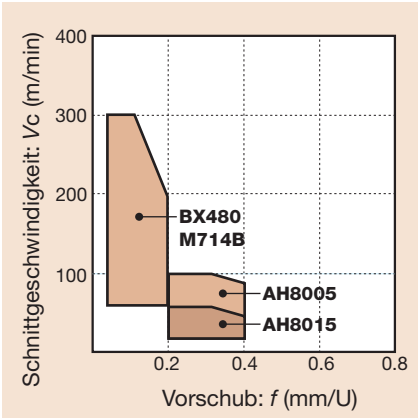
Spanformstufen für die Drehbearbeitung (Negative Wendeschneidplatten)

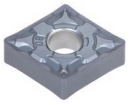
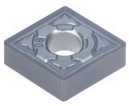


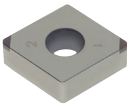
Titanbasis-Legierungen



Nickelbasis-Legierungen



Spanformstufe		Eigenschaften
HRF		Geeignet für die Schlichtbearbeitung von hitzebeständigen Legierungen. Spezieller Vorsprung sorgt für hervorragende Spankontrolle im unteren Schnitttiefenbereich.
HRM		1. Wahl für hitzebeständige Legierungen. Optimierte Spanformstufe für unterschiedliche Schnitttiefen.

Spanformstufe		Eigenschaften
– (CBN)		Außergewöhnliche Zerspanungsleistung bei hitzebeständigen Legierungen oder Titan-Legierungen.

STANDARD SCHNITTDATEN

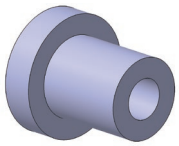
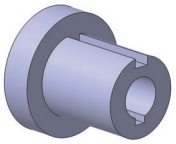
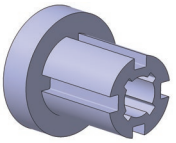
ISO	Anwendung		Spanform-stufe	Schneid-stoff	Schnitttiefe *ap* (mm)	Vorschub *f* (mm/U)	Schnittgeschwindigkeit: *Vc* (m/min)	
							Titanbasis-Legierungen	Nickelbasis-Legierungen
S	Fein-schlichten	Kontinuierlicher Schnitt	Ohne	BX480	0.1 - 0.5	0.05 - 0.2	100 - 200	70 - 300
			Ohne	M714B	0.1 - 0.5	0.05 - 0.2	-	70 - 400
		Leicht unterbrochen	Ohne	BX480	0.1 - 0.5	0.05 - 0.2	100 - 200	-
	Schlichten bis mittlere Bearbeitung	Kontinuierlicher Schnitt	HRF	AH8005	0.5 - 1.5	0.05 - 0.25	20 - 100	20 - 100
		Leicht unterbrochen	HRF	AH8015	0.5 - 1.5	0.05 - 0.25	20 - 80	20 - 50
		Stark unterbrochen	HRF	AH8015	0.5 - 1.5	0.05 - 0.25	10 - 60	10 - 40
	Mittlere Bearbeitung	Kontinuierlicher Schnitt	HRM	AH8005	0.5 - 4	0.1 - 0.4	20 - 100	20 - 100
		Leicht unterbrochen	HRM	AH8015	0.5 - 4	0.1 - 0.4	20 - 80	20 - 50
		Stark unterbrochen	HRM	AH8015	0.5 - 4	0.1 - 0.4	10 - 60	10 - 40

Nickelbasis-Legierungen: INCONEL718 etc. Titanbasis-Legierungen: Ti-6Al-4V, etc.

Auswahlsystem

NEGATIV

S Hitzebeständige Legierungen und Titan

	Kontinuierlicher Schnitt	Leicht unterbrochener Schnitt	Stark unterbrochener Schnitt
Feinschlichten [ap = – 0.5 mm]	Standard: **CBN BX470 M714B** B170 - B190	Standard: **CBN BX470** B170 - B190 — Bruch → Ohne Spanformstufe **TH10** B038	
Schlichten [ap = 0.5 – 1.5 mm]	Standard: **HRF AH8005** B031 — Bruch → **HRF AH8015** B031; Spankontrolle → **28 AH8005** B034	Standard: **HRF AH8015** B031 — Bruch → **HRM AH8015** B035; Verschleiß → **HRF AH8005** B031; Spankontrolle → **28 AH8015** B034	Standard: **HRF AH8015** B031 — Bruch → **HRM AH8015** B035; Verschleiß → **HRF AH8005** B031
Mittlere Bearbeitung [ap = 0.5 – 4 mm]	Standard: **HRM AH8005** B035 — Bruch → **HRM AH8015** B035; Gratbildung → **HRF AH8015** B031; Spankontrolle → **28 AH8005** B034	Standard: **HRM AH8015** B035 — Bruch → **SM AH630** B035; Verschleiß → **HRM AH8005** B035; Spankontrolle → **28 AH8015** B034	Standard: **HRM AH8015** B035 — Bruch → **SM AH630** B035; Verschleiß → **HRF AH8005** B031

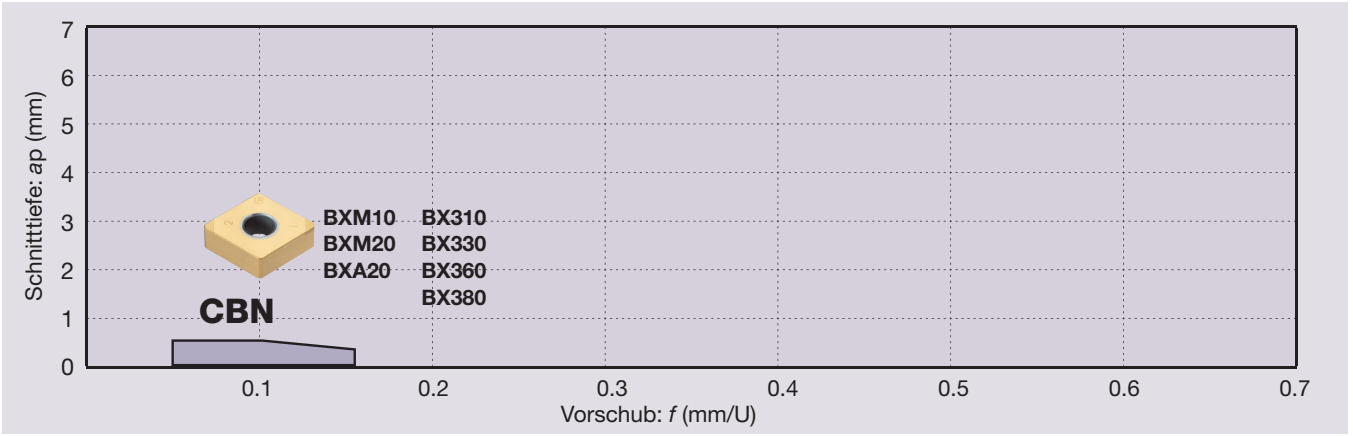
Weitere Produktdetails siehe Seite B***.

Hauptspanformstufen

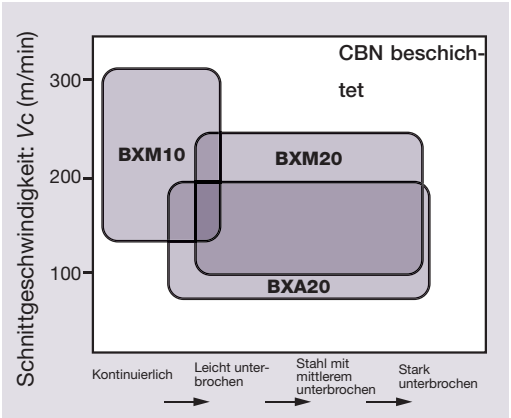
NEGATIV

H Gehärteter Stahl

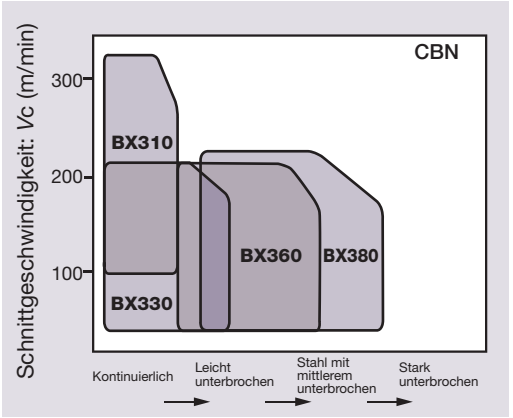
Spanformsystem für die Drehbearbeitung (Negative Wendeschneidplatten)

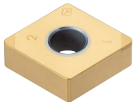


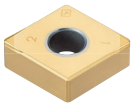
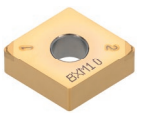
CBN beschichtet



CBN



Spanformstufe		Eigenschaften
– (CBN)		Exzellente Leistung bei der Schlichtbearbeitung von gehärtetem Stahl.

Spanformstufe		Eigenschaften
HF		Exzellente Spankontrolle beim Drehen von randzonengehärteten Werkstücken.
HM		Exzellente Spankontrolle beim Drehen von randzonengehärteten Werkstücken.
HP		Ausgezeichnete Spankontrolle beim Feinschlichten.

STANDARD SCHNITTDATEN

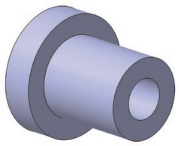
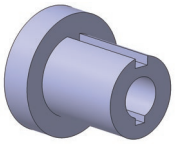
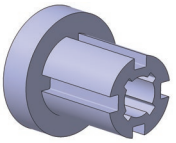
ISO	Anwendung		Spanformstufe	Schneidstoff	Schnitttiefe *ap* (mm)	Vorschub *f* (mm/U)	Schnittgeschwindigkeit *Vc* (m/min)
H	Feinschlichten	Kontinuierlich bis leicht unterbrochen	HP	BXM10 BXA20	0.05 - 0.2	0.03 - 0.18	150 - 350
	Schlichten	Kontinuierlich bis stark unterbrochen	Ohne	BXM10 BXM20 BXA20	0.05 - 0.5	0.05 - 0.25	70 - 220
	Drehen von randzonengehärteten Werkstücken	Kontinuierlicher Schnitt	HF	BXM20	0.2 - 0.75	0.05 - 0.2	70 - 200
		Kontinuierlicher Schnitt	HM	BXM20 BXA20	0.5 - 1	0.05 - 0.2	70 - 200

Gehärteter Stahl, vorvergüteter Stahl: SKD11, SKD61 etc. X153CrMoV12, X40CrMoV5-1 etc.

Auswahlsystem

NEGATIV

H Gehärteter Stahl

	Kontinuierlicher Schnitt	Leicht unterbrochener Schnitt	Stark unterbrochener Schnitt
Feinschlichten [ap = – 0.2 mm]	Standard CBN HP BXM10 B171 - B179	Standard CBN BXA20 B170 - B179 Bruch → -H BXM20, B170 - B179 Verschleiß → CBN BXM10, B170 - B179	
Schlichten [ap = – 0.5 mm]	Standard CBN BXM10 B170 - B179	Standard CBN BXA20 B170 - B179 Bruch → -H BXM20, B170 - B179 Verschleiß → CBN BXM10, B170 - B179	Standard CBN BXM20 B170 - B179 Bruch → -H BXM20, B170 - B179

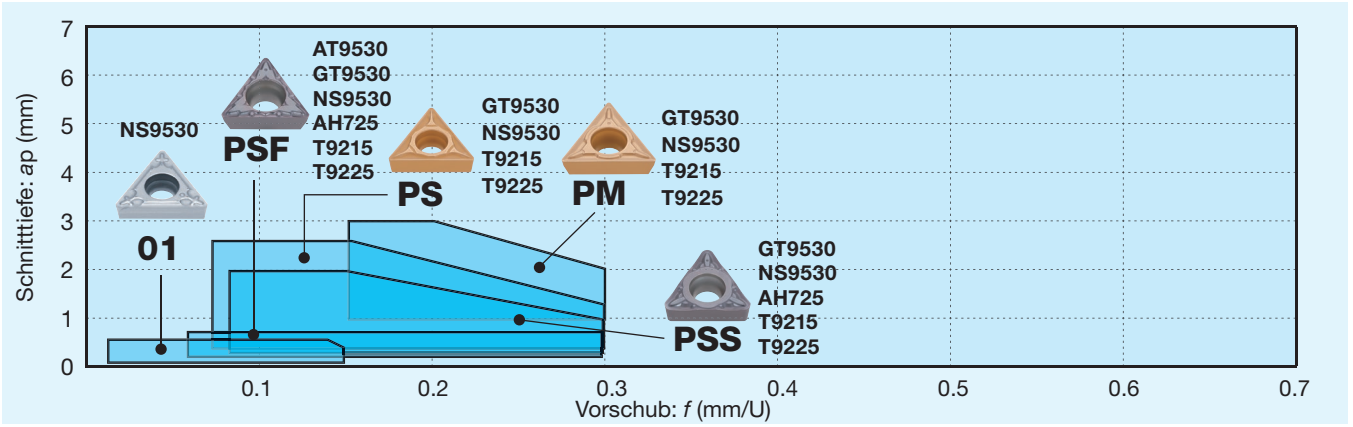
Weitere Produktdetails siehe Seite B***.

Hauptspanformstufen

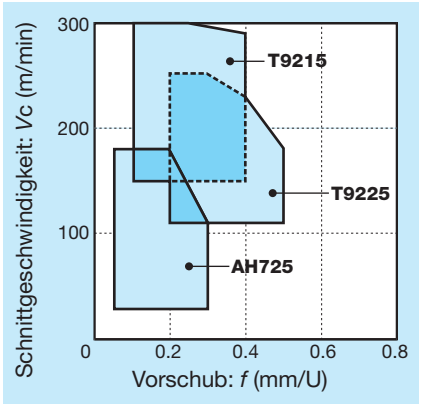
POSITIV

P Stahl

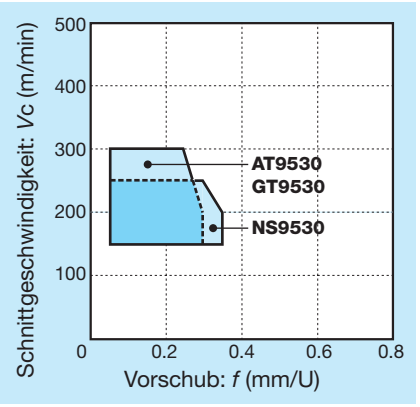
Spanformstufen für die Drehbearbeitung (Positive Wendeschneidplatten)

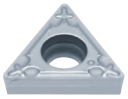
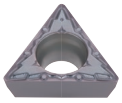
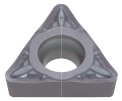


CVD / PVD beschichtet



Cermet beschichtet / Cermet



Spanformstufe		Eigenschaften
01		Präzisionsspanformstufe mit engen Spanbruchelementen für geringste Schnitttiefen und Vorschübe in der Feinschlichtbearbeitung.
PSF		Niedrige Schnittkraft und hohe Verschleißfestigkeit. 1. Wahl für Schlichtbearbeitungen. Hochausgelegtes, vorgelagertes Spanformelement für optimale Spankontrolle.
PSS		Dreidimensionale Spanformstufe für exzellente Spankontrolle bei niedrigen Schnittkräften beim Schlichten bis mittlere Bearbeitung.

Spanformstufe		Eigenschaften
PS		Dreidimensionale Spanformstufe für exzellente Spankontrolle bei geringen Schnittkräften. Wirtschaftliche Wendeschneidplatte der M-Klasse für leistungsstarkes Bohren in unterschiedlichen Anwendungen.
PM		1. Wahl für die mittlere Bearbeitung mit besonders scharfer Schnittkante und guter Spankontrolle. Für die stabile Bearbeitung von rostfreiem Stahl.

STANDARD SCHNITTDATEN

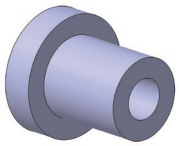
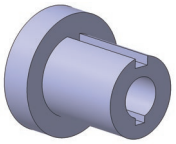
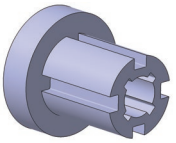
ISO	Anwendung		Spanform-stufe	Schneid-stoff	Schnitttiefe *ap* (mm)	Vorschub *f* (mm/U)	Schnittgeschwindigkeit: *Vc* (m/min)		
							Stahl mit niedrigem Kohlenstoffgehalt, legierter Stahl	Stahl mit mittlerem Kohlenstoffgehalt, legierter Stahl	Stahl mit hohem Kohlenstoffgehalt, legierter Stahl
P	Fein-schlichten	Kontinuierlich	01	NS9530	0.05 - 0.5	0.03 - 0.15	150 - 250	80 - 220	80 - 180
		Leicht unterbrochen	01	NS9530	0.05 - 0.5	0.03 - 0.15	150 - 250	80 - 220	80 - 180
	Schlichten	Kontinuierlich	PSS	NS9530	0.1 - 0.5	0.05 - 0.3	150 - 250	80 - 220	80 - 180
		Leicht unterbrochen	PSS	NS9530	0.1 - 0.5	0.05 - 0.3	150 - 250	80 - 220	80 - 180
		Stark unterbrochen	PSS	NS9530	0.1 - 0.5	0.05 - 0.3	150 - 250	80 - 220	80 - 180
	Schlichten bis leichte Bearbeitung	Kontinuierlich	PS	NS9530	0.3 - 2	0.08 - 0.3	150 - 250	80 - 220	80 - 180
		Leicht unterbrochen	PS	NS9530	0.3 - 2	0.08 - 0.3	150 - 250	80 - 220	80 - 180
		Stark unterbrochen	PS	NS9530	0.3 - 2	0.08 - 0.3	150 - 250	80 - 220	80 - 180
	Schlichten bis mittlere Bearbeitung	Kontinuierlich bis Stark unterbrochen	PS	T9215	0.5 - 2.5	0.08 - 0.3	120 - 350	100 - 350	80 - 250
			PS	T9225	0.5 - 2.5	0.08 - 0.3	100 - 300	80 - 300	80 - 250
	Mittlere Bearbeitung	Kontinuierlich bis Stark unterbrochen	PM	-	1 - 3	0.15 - 0.3	150	100 - 200	80 - 180
			PM	-	1 - 3	0.15 - 0.3	120	80 - 180	80 - 120

Stahl mit niedrigem Kohlenstoffgehalt, legierter Stahl: S10C, SCM415, SS400, SCr420H etc. C10, 18CrMo4, E275A, 20Cr4 etc. Stahl mit mittlerem Kohlenstoffgehalt, legierter Stahl: S45C, SCM440 etc. C45, 42CrMo4 etc. Stahl mit hohem Kohlenstoffgehalt, legierter Stahl: SNCM439 etc. 41CrNiMo2 etc.

Auswahlsystem

POSITIV

P Stahl

	Kontinuierlicher Schnitt	Leicht unterbrochener Schnitt	Stark unterbrochener Schnitt
Feinschlichten [ap = – 0.5 mm]	Standard: **01 NS9530** B040, B045	Standard: **01 NS9530** B040, B045 → Bruch: **PSF NS9530** B040, B045, B049	
Schlichten [ap = 0.1 – 0.5 mm]	Standard: **PSS NS9530** B040, B045, B049 → Verschleiß: **PSS GT9530** B040, B045, B049; Bruch: **PS NS9530** B040, B045, B049; Spankontrolle: **PSF NS9530** B040, B045, B049	Standard: **PSS NS9530** B040, B045, B049 → Verschleiß: **PSS GT9530** B040, B045, B049; Bruch: **PS NS9530** B040, B045, B049; Spankontrolle: **PSF NS9530** B040, B045, B049	Standard: **PSS NS9530** B040, B045, B049 → Verschleiß: **PSS GT9530** B040, B045, B049; Bruch: **PS NS9530** B040, B045, B049; Spankontrolle: **PSF NS9530** B040, B045, B049
Schlichten bis mittlere Bearbeitung [ap = 0.5 – 2.5 mm]	Standard: **PS T9215** B040, B045, B049 → Bruch: **PS T9215** B040, B045, B049; Verschleiß: **PS NS9530** B040, B045, B049	Standard: **PS T9215** B040, B045, B049 → Bruch: **PS T9215** B040, B045, B049; Verschleiß: **PS NS9530** B040, B045, B049	Standard: **PS T9215** B040, B045, B049 → Bruch: **PM T9215** B042, B046; Spankontrolle: **TSF T9215** B040, B045
Mittlere Bearbeitung [ap = 1 – 3 mm]	Standard: **PM T9215** B042, B046 → Verschleiß: **PM NS9530** B042, B046	Standard: **PM T9215** B042, B046 → Bruch: **PM T9215** B042, B046	Standard: **PM T9215** B042, B046 → Spankontrolle: **TM T9215** B041, B045

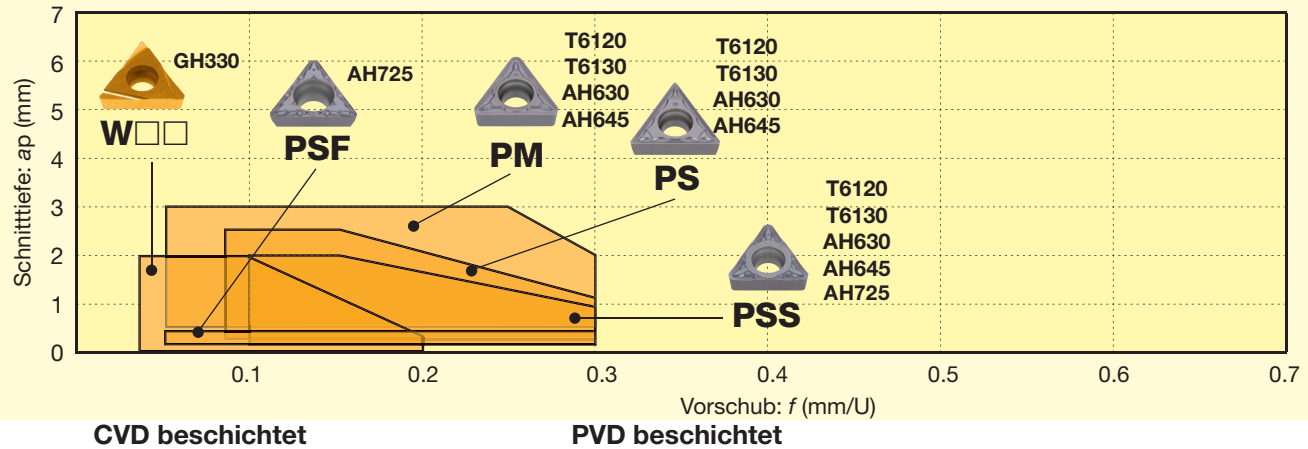
Weitere Details finden Sie auf den folgenden Seiten: B***/7° Freiwinkel, B***/11° Freiwinkel, B***/5° Freiwinkel.

Hauptspanformstufen

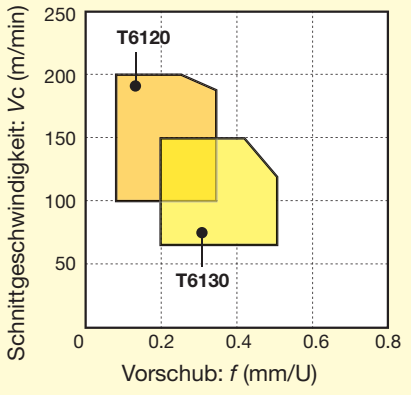
POSITIV

M Rostfreier Stahl

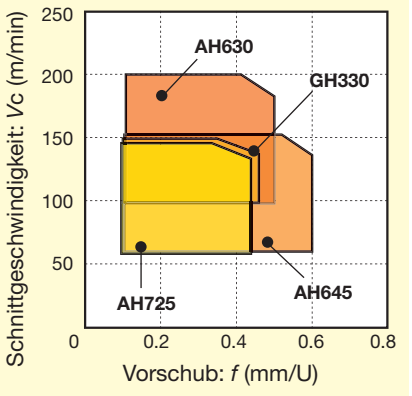
Spanformstufen für die Drehbearbeitung (Positive Wendeschneidplatten)

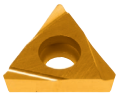
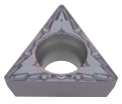


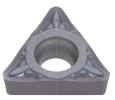
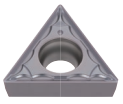
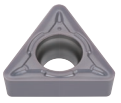
CVD beschichtet



PVD beschichtet



Spanformstufe		Eigenschaften
W□□		Optimaler Spanfluss und exzellente Spankontrolle, dadurch bestens geeignet für hochpräzise Bohrungen.
PSF		Niedrige Schnittkraft und hohe Verschleißfestigkeit. 1. Wahl für Schlichtbearbeitungen. Hochausgelegtes, vorgelagertes Spanformelement für optimale Spankontrolle.

Spanformstufe		Eigenschaften
PSS		Dreidimensionale Spanformstufe für exzellente Spankontrolle bei niedrigen Schnittkräften beim Schlichten bis mittlere Bearbeitung.
PS		Dreidimensionale Spanformstufe für exzellente Spankontrolle bei geringen Schnittkräften. Wirtschaftliche Wendeschneidplatte der M-Klasse für leistungsstarkes Bohren in unterschiedlichen Anwendungen.
PM		1. Wahl für die mittlere Bearbeitung mit besonders scharfer Schnittkante und guter Spankontrolle. Für die stabile Bearbeitung von rostfreiem Stahl.

STANDARD SCHNITTDATEN

ISO	Anwendung		Spanform-stufe	Schneidstoff	Schnitttiefe *ap* (mm)	Vorschub *f* (mm/U)	Schnitt-geschwindigkeit *Vc* (m/min)
M	Feinschlichten	Kontinuierlicher Schnitt	W□□	GH330	0.05 - 2.0	0.03 - 0.2	100 - 150
	Schlichten	Kontinuierlicher Schnitt	PSF	AH725	0.1 - 0.5	0.05 - 0.3	50 - 150
		Leicht unterbrochener Schnitt	PSF	AH725	0.1 - 0.5	0.05 - 0.3	50 - 150
		Stark unterbrochener Schnitt	PSF	AH725	0.1 - 0.5	0.05 - 0.3	50 - 120
	Schlichten bis leichte Bearbeitung	Kontinuierlicher Schnitt	PSS	AH630	0.3 - 2	0.08 - 0.3	90 - 190
		Leicht unterbrochener Schnitt	PSS	AH630	0.3 - 2	0.08 - 0.3	90 - 190
		Stark unterbrochener Schnitt	PSS	AH630	0.3 - 2	0.08 - 0.3	90 - 190
	Schlichten bis mittlere Bearbeitung	Kontinuierlicher Schnitt	PS	T6130	0.5 - 2.5	0.08 - 0.3	100 - 200
		Leicht unterbrochener Schnitt	PS	AH630	0.5 - 2.5	0.08 - 0.3	90 - 190
		Stark unterbrochener Schnitt	PS	AH630	0.5 - 2.5	0.08 - 0.3	90 - 190
	Mittlere Bearbeitung	Kontinuierlicher Schnitt	PM	T6130	1 - 3*	0.15 - 0.3	100 - 200
		Leicht unterbrochener Schnitt	PM	AH630	1 - 3*	0.15 - 0.3	90 - 190
		Stark unterbrochener Schnitt	PM	AH630	1 - 3*	0.15 - 0.3	90 - 190

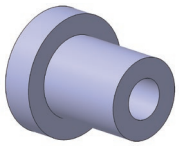
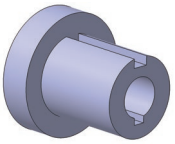
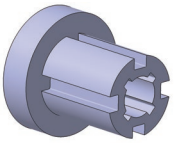
* Für CCMT0602 und DCMT0702 Wendeschneidplatten: *ap* = 0.5 - 2.5

Rostfreier Stahl: SUS304, SUS316 etc. X5CrNi18-9, X5CrNiMo17-12-3 etc.

Auswahlsystem

POSITIV

M Rostfreier Stahl

	Kontinuierlicher Schnitt	Leicht unterbrochener Schnitt	Stark unterbrochener Schnitt
Feinschlichten [ap = – 0.5 mm]	Standard: **W□□ GH330** — B041, B046, B049	Standard: **W□□ GH330** — B041, B046, B049	
Schlichten [ap = 0.3 – 1.5 mm]	Standard: **PSF AH725** — B040, B045, B049 Verschleiß: **PSS T6130** — B040, B045, B049	Standard: **PSF AH725** — B040, B045, B049 Bruch: **PSS AH630** — B040, B045, B049 Verschleiß: **PSS T6130** — B040, B045, B049	Standard: **PSF AH725** — B040, B045, B049 Bruch: **PSS AH630** — B040, B045, B049
Schlichten bis mittlere Bearbeitung [ap = 0.5 – 2.5 mm]	Standard: **PSS AH630** — B040, B045, B049 Verschleiß: **PS T6130** — B040, B045, B049	Standard: **PS AH630** — B040, B045, B049 Bruch: **PM AH645** — B042, B046 Verschleiß: **PS T6130** — B040, B045, B049	Standard: **PS AH630** — B040, B045, B049 Bruch: **PM AH645** — B042, B046 Verschleiß: **PS T6130** — B040, B045, B049
Mittlere Bearbeitung [ap = 1 – 3 mm]	Standard: **PM T6130** — B042, B046	Standard: **PM AH630** — B042, B046 Bruch: **PM AH645** — B042, B046 Verschleiß: **PM T6130** — B042, B046	Standard: **PM AH630** — B042, B046 Bruch: **PM AH645** — B042, B046

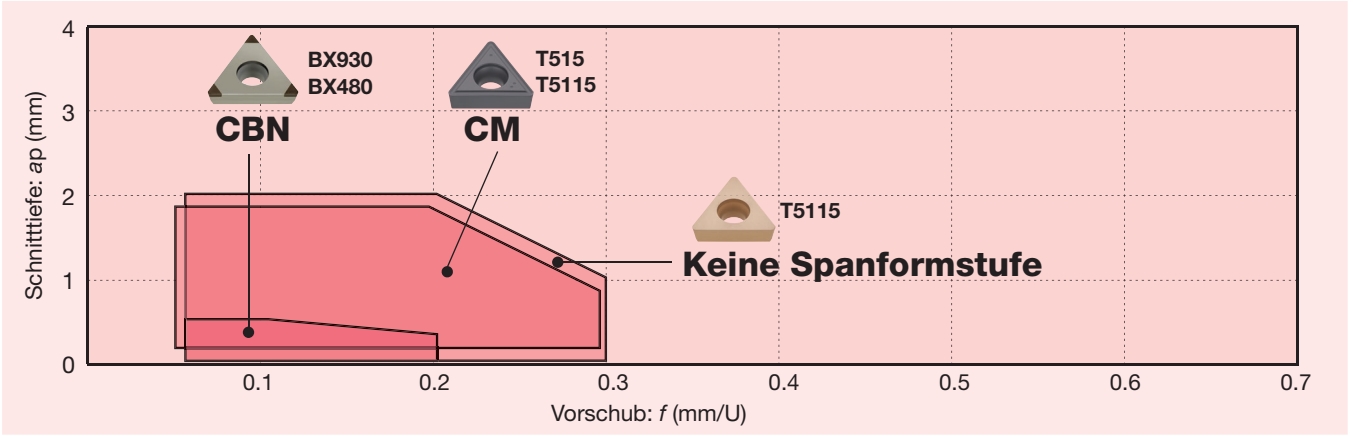
Weitere Details finden Sie auf den folgenden Seiten: B***/7° Freiwinkel, B***/11° Freiwinkel, B***/5° Freiwinkel.

Hauptspanformstufen

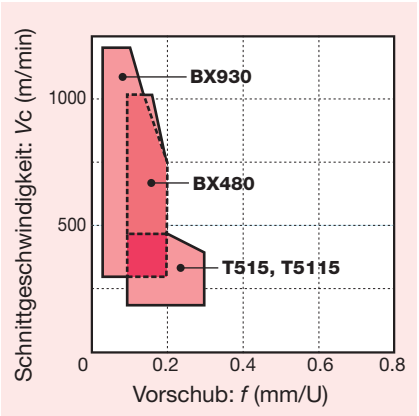
POSITIV

K Eisenguss

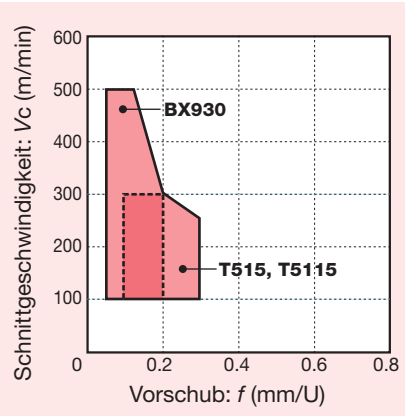
Spanformstufen für die Drehbearbeitung (Positive Wendeschneidplatten)

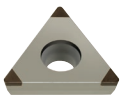


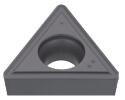
Grauguss



Kugelgraphitguss



Spanformstufe		Eigenschaften
– (CBN)		Für geringe bis hohe Schnitttiefen einsetzbar. Hohe Schneidkantenstabilität bei Schnittunterbrechungen oder Gusshaut.
–		Geeignet für die Schlicht- bis Schruppbearbeitung von Eisenguss. Hohe Schneidkantenstabilität.

Spanformstufe		Eigenschaften
CM		Allround-Spanformstufe für die allgemeine Bearbeitungbei niedrigen Schnittkräften. Schlichten bis mittlere Bearbeitung.

STANDARD SCHNITTDATEN

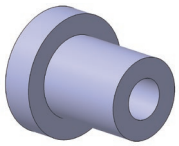
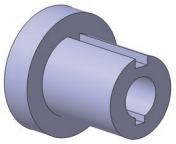
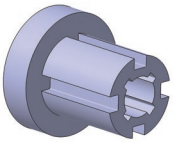
ISO	Anwendung		Spanform-stufe	Schneid-stoff	Schnitttiefe *ap* (mm)	Vorschub *f* (mm/U)	Schnittgeschwindigkeit: *Vc* (m/min)	
							Grauguss	Kugelgraphitguss
K	Fein-schlichten	Kontinuierlicher Schnitt	Ohne	BX930	0.05 - 0.5	0.05 - 0.2	300 - 1200	100 - 500
		Leicht unterbrochener Schnitt	Ohne	BX480	0.05 - 0.5	0.05 - 0.2	300 - 800	100 - 300
		Leicht unterbrochener Schnitt	Ohne	BX470	0.05 - 0.5	0.05 - 0.2	300 - 800	100 - 300
	Schlichten	Kontinuierlicher Schnitt	CM	T515	0.05 - 2	0.05 - 0.3	150 - 700	150 - 300
		Stark unterbrochener Schnitt	CM	T515	0.05 - 2	0.05 - 0.3	100 - 200	100 - 200
	Mittlere Geschwindigkeit	Leicht unterbrochener Schnitt	CM	T515	0.05 - 2	0.05 - 0.3	100 - 300	100 - 250

Grauguss: FC250 etc. 250 etc.
Kugelgraphitguss: FCD450 etc. 450-10S etc.

Auswahlsystem

POSITIV

K Eisenguss

	Kontinuierlicher Schnitt	Leicht unterbrochener Schnitt	Stark unterbrochener Schnitt
Schlichten bis mittlere Bearbeitung [ap = 0.5 – 3 mm]	Standard CM T515 B042, B046, B049 Verschleiß CBN BX930 B184 -	Standard CM T515 B042, B046, B049	Standard CM T515 B042, B046, B049

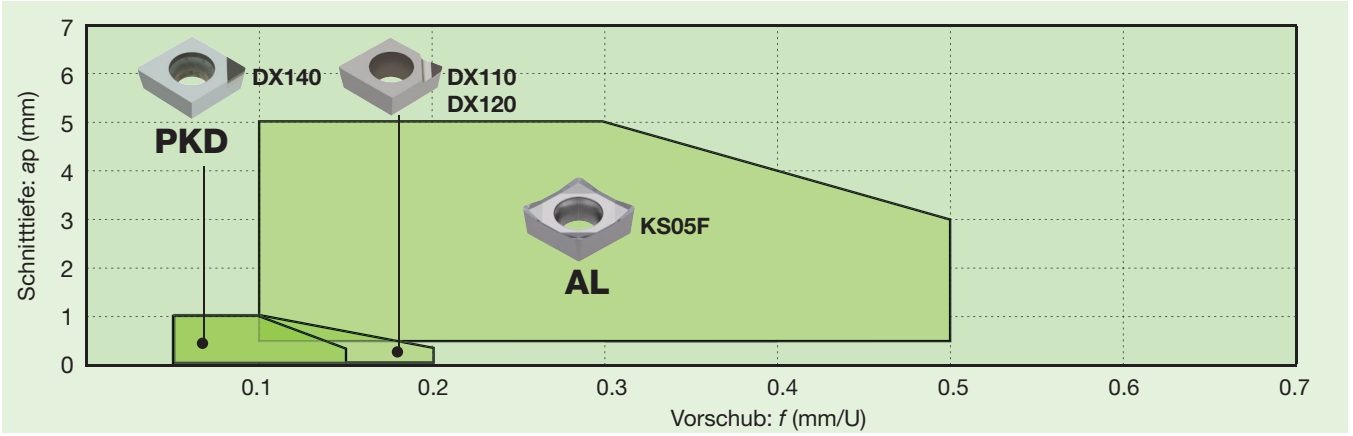
Weitere Details finden Sie auf den folgenden Seiten: B***/7° Freiwinkel, B***/11° Freiwinkel, B***/5° Freiwinkel.

Hauptspanformstufen

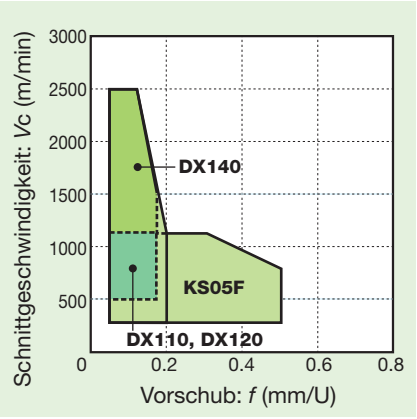
POSITIV

N Nichteisenmetall

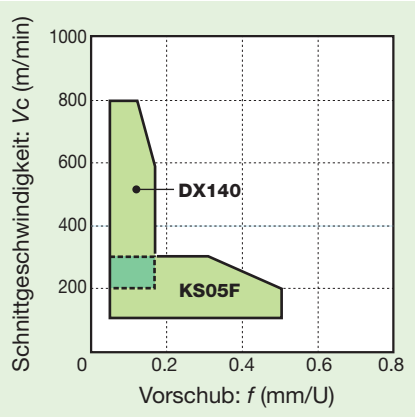
Spanformstufen für die Drehbearbeitung (Positive Wendeschneidplatten)



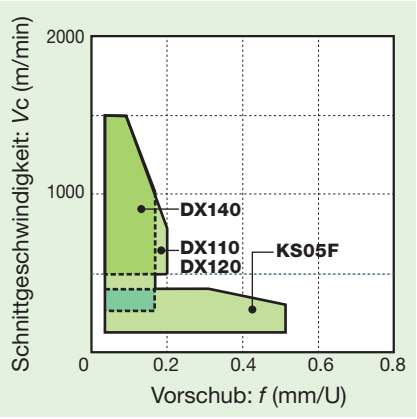
Aluminium (Si < 12 %)

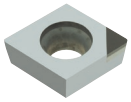
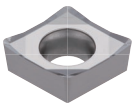


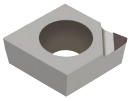
Aluminium (Si ≥ 12%)



Kupferlegierungen



Spanformstufen		Eigenschaften
–		Optimal geeignet für die HSC-Bearbeitung von Nichteisenmetallen, mit diamant-gesinterter Schneidkante.
AL		Großer Spanwinkel und eine scharfe Schneidkante für geringere Schnittkräfte. Polierte Spanflächen. Stark geneigte Schneidkante (Schneidkante in Wellenform) für eine verbesserte Spankontrolle.

Spanformstufe		Eigenschaften
Mit Spanform-stufe		Große Spanfläche für optimale Spankontrolle. Großer Spanwinkel für geringere Schnittkräfte. DIA-Schneidkante für die HSC-Bearbeitung und eine lange Lebensdauer.

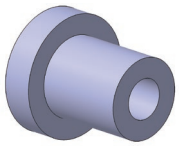
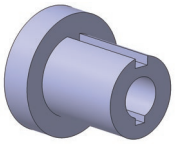
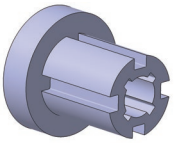
STANDARD SCHNITTDATEN

ISO	Anwendung		Spanform-stufe	Schneid-stoff	Schnitttiefe *ap* (mm)	Vorschub *f* (mm/U)	Schnittgeschwindigkeit: *Vc* (m/min) Aluminium (Si < 12 %)	Aluminium (Si ≥ 12 %)	Kupfer-legierungen
N	Fein-schlichten	Kontinuierlich	Mit	DX110	0.05 - 1	0.05 - 0.15	500 - 2500	400 - 800	500 - 1500
		Leicht unterbrochen	Ohne	DX140	0.05 - 1	0.05 - 0.2	300 - 2500	-	500 - 1500
	Schlichten	Kontinuierlich	Ohne	DX140	0.05 - 1	0.05 - 0.15	500 - 2500	400 - 800	500 - 1500
		Leicht unterbrochen	Ohne	DX140	0.05 - 1	0.05 - 0.15	300 - 1800	400 - 600	400 - 1200
		Stark unterbrochen	AL	KS05F	0.5 - 5	0.1 - 0.5	100 - 600	100 - 200	-
	Mittlere Bearbeitung	Kontinuierlich	AL	KS05F	0.5 - 5	0.1 - 0.5	100 - 1200	100 - 300	100 - 300
		Leicht unterbrochen	AL	KS05F	0.5 - 5	0.1 - 0.5	100 - 900	100 - 200	100 - 200
		Stark unterbrochen	AL	KS05F	0.5 - 5	0.1 - 0.5	100 - 600	100 - 200	-

Auswahlsystem

POSITIV

N Nichteisenmetall

	Kontinuierlicher Schnitt	Leicht unterbrochener Schnitt	Stark unterbrochener Schnitt
Feinschlichten [ap = – 0.5 mm]	Standard: mit Spanformstufe DX110 (B192, B194) → Verschleiß: PKD DX140 (B193, B195, B196)	Standard: mit Spanformstufe DX110 (B192, B194) → Verschleiß: PKD DX140 (B193, B195, B196)	
Schlichten [ap = 0.5 – 2 mm]	Standard: PKD DX140 (B193, B195, B196) → Verschleiß: PKD DX160 (B193, B196); Spankontrolle: mit Spanformstufe PKD DX110 (B192, B194)	Standard: PKD DX140 (B193, B195, B196) → Bruch: AL KS05F (B042); Verschleiß: PKD DX160 (B193, B196)	Standard: AL KS05F (B042)
Mittlere Bearbeitung [ap = 1 – 5 mm]	Standard: AL KS05F (B042) → Verschleiß: mit Spanformstufe PKD DX120 (B192, B194 - B193)	Standard: AL KS05F (B042) → Verschleiß: PKD DX140 (B193, B195, B196)	Standard: AL KS05F (B042)

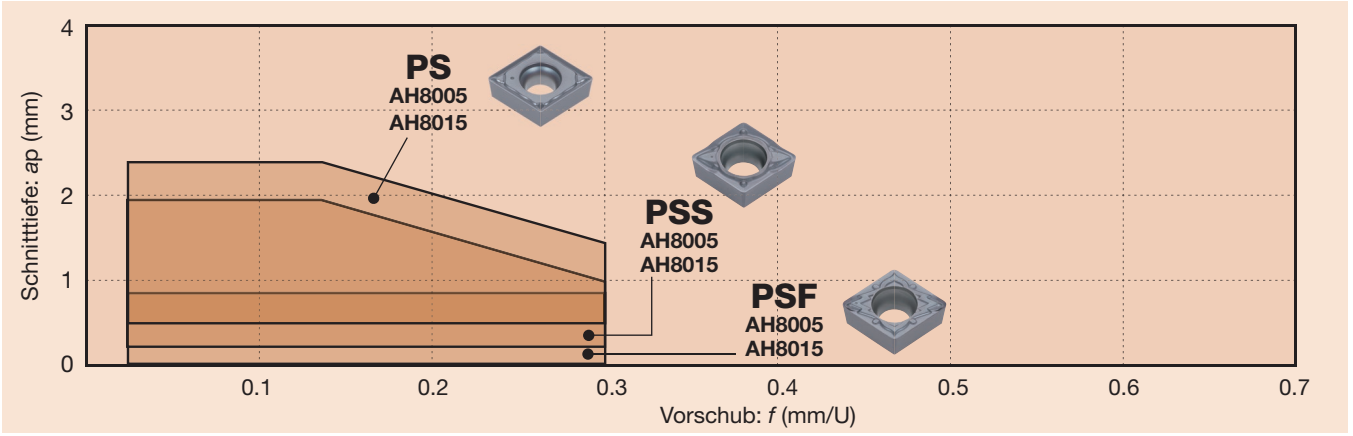
Weitere Details finden Sie auf den folgenden Seiten: B***/7° Freiwinkel, B***/11° Freiwinkel, B***/5° Freiwinkel.

Hauptspanformstufen

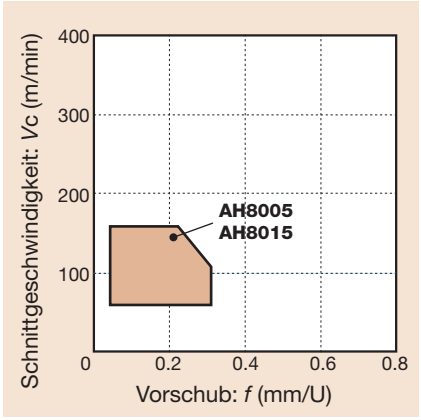
POSITIV

S Hitzebeständige Legierungen und Titan

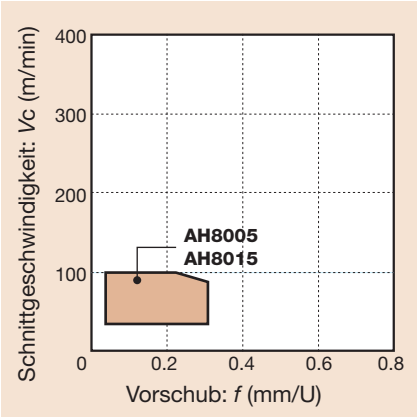
Spanformstufen für die Drehbearbeitung (Positive Wendeschneidplatten)

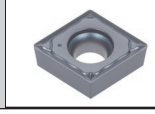


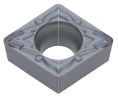
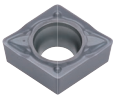
Titanbasis-Legierungen



Nickelbasis-Legierungen



Spanformstufe		Eigenschaften
PS		Dreidimensionale Spanformstufe für exzellente Spankontrolle bei geringen Schnittkräften. Wirtschaftliche Wendeschneidplatte der M-Klasse für leistungsstarkes Bohren in unterschiedlichen Anwendungen.

Spanformstufe		Eigenschaften
PSF		Niedrige Schnittkraft und hohe Verschleißfestigkeit. 1. Wahl für Schlichtbearbeitungen. Hochausgelegtes, vorgelagertes Spanformelement für optimale Spankontrolle.
PSS		Dreidimensionale Spanformstufe für exzellente Spankontrolle bei niedrigen Schnittkräften beim Schlichten bis mittlere Bearbeitung.

STANDARD SCHNITTDATEN

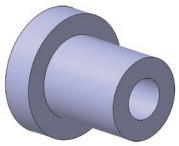
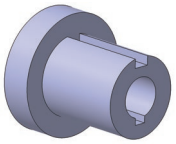
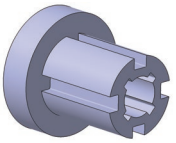
ISO	Anwendung		Spanform-stufe	Schneid-stoff	Schnitttiefe *ap* (mm)	Vorschub *f* (mm/U)	Schnittgeschwindigkeit: *Vc* (m/min)	
							Titanbasis-Legierungen	Nickelbasis-Legierungen
S	Schlichten	Kontinuierlicher Schnitt	PSS	AH8015	0.3 - 2	0.02 - 0.3	20 - 150	20 - 100
		Leicht unterbrochener Schnitt	PSS	AH8015	0.3 - 2	0.02 - 0.3	20 - 150	20 - 100
	Schlichten bis mittlere Bearbeitung	Kontinuierlicher Schnitt	PS	AH8015	0.5 - 2.5	0.02 - 0.3	20 - 150	20 - 100
		Leicht unterbrochener Schnitt	PS	AH8015	0.5 - 2.5	0.02 - 0.3	20 - 150	20 - 100

Nickelbasis-Legierungen: INCONEL718 etc.
Titanbasis-Legierungen: Ti-6Al-4V etc.

Auswahlsystem

POSITIV

S Hitzebeständige Legierungen und Titan

	Kontinuierlicher Schnitt	Leicht unterbrochener Schnitt	Stark unterbrochener Schnitt
Schlichten [ap = 0.3 – 2 mm]	Standard: **PSS AH8015** B040, B045, B049 → Verschleiß: **PSS AH8005** B042, B045, B049	Standard: **PSS AH8015** B040, B045, B049 → Verschleiß: **PSS AH8005** B040, B045, B049; Bruch: **PS AH8015** B040, B045, B049	
Schlichten bis mittlere Bearbeitung [ap = 0.5 – 2.5 mm]	Standard: **PS AH8015** B040, B045, B049 → Verschleiß: **PSS AH8005** B040, B045, B049	Standard: **PS AH8015** B040, B045, B049 → Bruch: **All-round AH8015** B042, B047	Standard: **PS AH8015** B040, B045, B049 → Bruch: **All-round AH8015** B042, B047

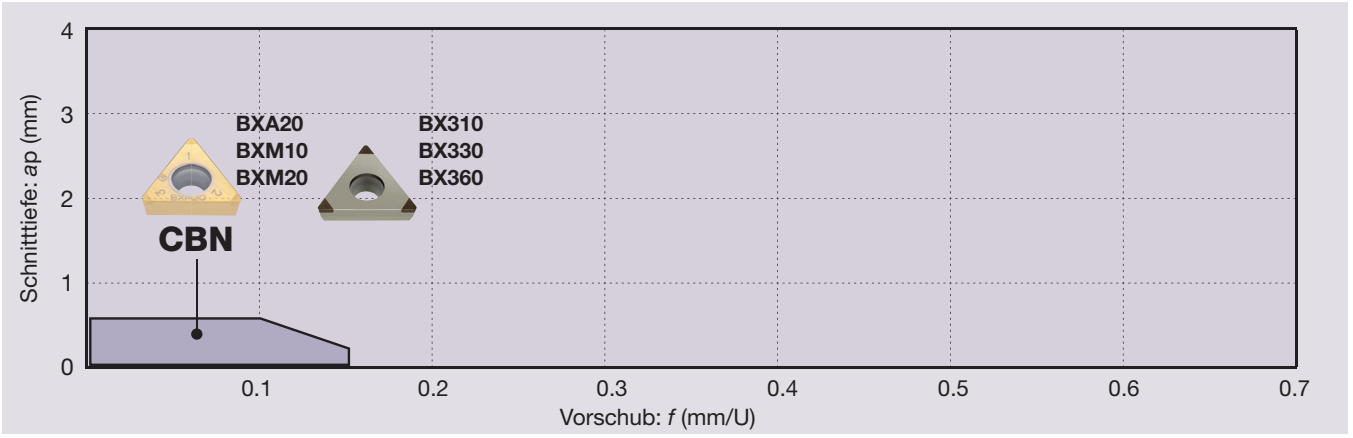
Weitere Details finden Sie auf den folgenden Seiten: B***/7° Freiwinkel, B***/11° Freiwinkel, B***/5° Freiwinkel.

Hauptspanformstufen

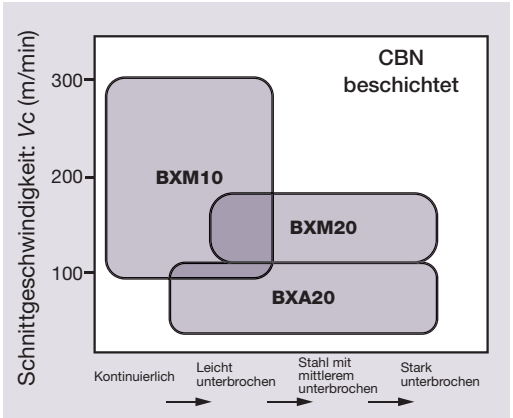
POSITIV

H Gehärteter Stahl

Spanformstufen für die Drehbearbeitung (Positive Wendeschneidplatten)



CBN beschichtet



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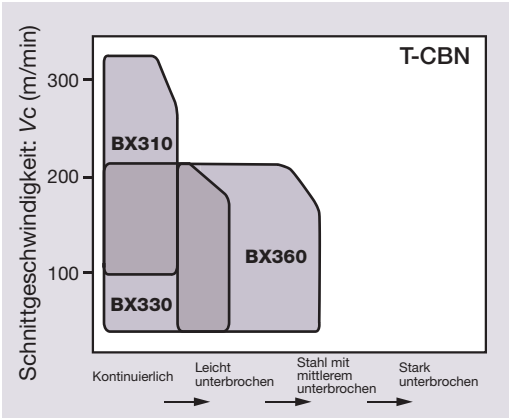


Spanformstufe		Eigenschaften
– (CBN)		Exzellente Leistung beim Hochgeschwindigkeitsschlichten von gehärtetem Stahl dank CBN-gesinterter Schneidkante.

Spanformstufe		Eigenschaften
HP (CBN)		Ausgezeichnete Spankontrolle beim Feinschlichten.

STANDARD SCHNITTDATEN

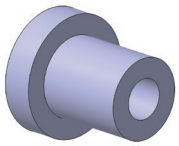
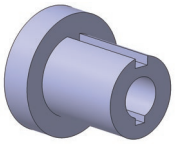
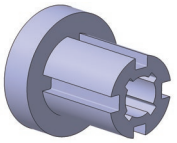
ISO	Anwendung		Spanformstufe	Schneidstoff	Schnitttiefe *ap* (mm)	Vorschub *f* (mm/U)	Schnitt-geschwindig-keit *Vc* (m/min)
H	Feinschlichten	Kontinuierlicher Schnitt	HP	BXM10	0.05 - 0.2	0.03 - 0.15	150 - 350
		Leicht unterbrochener Schnitt	Ohne	BXM20 BXA20	0.05 - 0.2	0.03 - 0.15	70 - 220
	Schlichten	Kontinuierlich bis stark unterbrochen	Ohne	BXM20 BXA20	0.07 - 0.5	0.05 - 0.3	70 - 220

Gehärteter Stahl, vorvergüteter Stahl: SKD11, SKD61 etc. X153CrMoV12, X40CrMoV5-1 etc.

Auswahlsystem

POSITIV

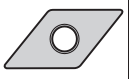
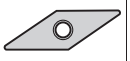
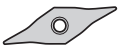
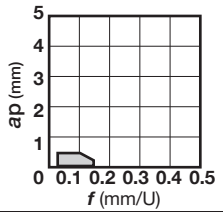
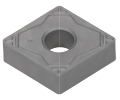
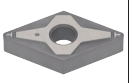
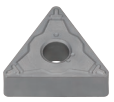
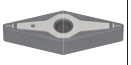
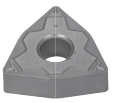
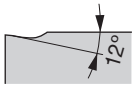
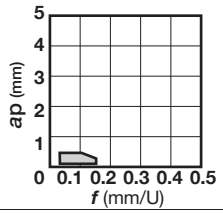
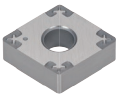
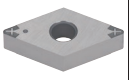
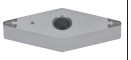
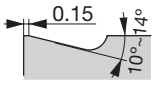
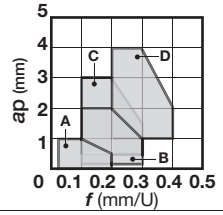
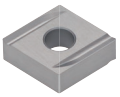
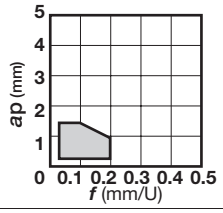
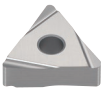
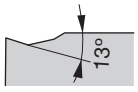
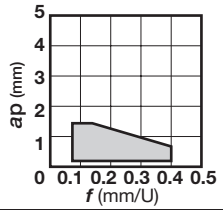
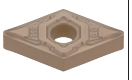
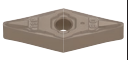
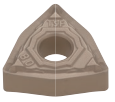
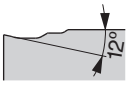
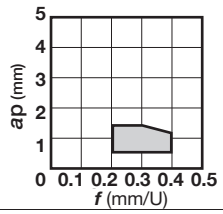
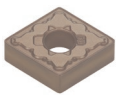
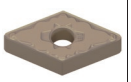
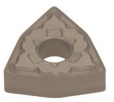
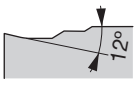
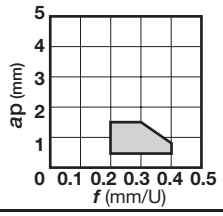
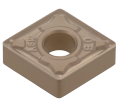
H Gehärteter Stahl

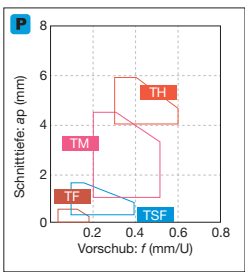
	Kontinuierlicher Schnitt	Leicht unterbrochener Schnitt	Stark unterbrochener Schnitt
Feinschlichten [ap = – 0.3 mm]	Standard CBN HP BXM10 B180 - B190	Standard CBN BXM10 B180 - B190 Bruch CBN BXA20 B180 -	
Schlichten [ap = – 0.5 mm]	Standard CBN BXM10 B180 - B190	Standard CBN BXM10 B180 - B190 Bruch CBN BXA20 B180 - B190	Standard CBN BXM20 B180 - B190 Bruch CBN BXA20 B180 - B190

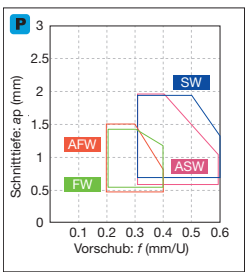
Weitere Details finden Sie auf den folgenden Seiten: B***/7° Freiwinkel, B***/11° Freiwinkel, B***/5° Freiwinkel.

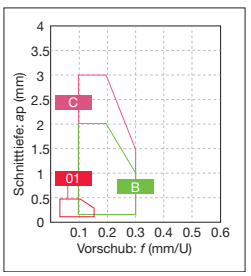
Spanformstufen – Übersicht

Anwendung	Negativ mit Loch	C	D	S	T	V	W	Y
								
		80°	55°	90°	60°	35°	80°	25°
Feinschlichten	TF 	 B054	 B065	B075	 B084	 B094	 B099	
	01  	 B054	 B065	B075	B084	 B094	B099	
	A–D  	 B054		B075	B084			
	W 				 B085			
Schlichten	TSF  	B054	 B065	B075	B085	 B095	 B100	
Schlichten (Wiper)	FW  	 B054	 B065		B085		 B100	
	AFW  	 B054					B100	

Spankontrollbereich

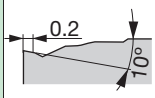
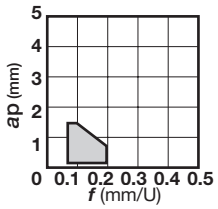
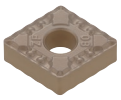
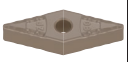
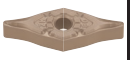
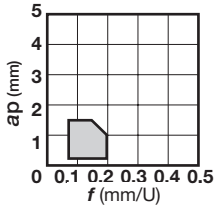
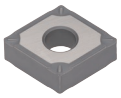
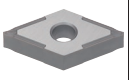
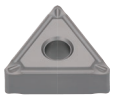
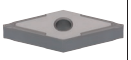
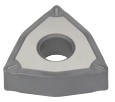
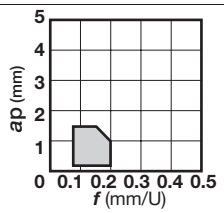
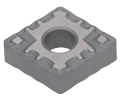
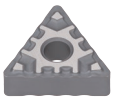
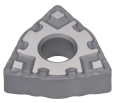
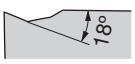
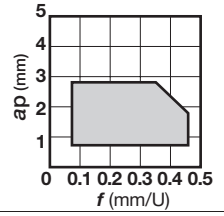
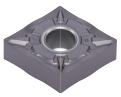
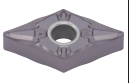
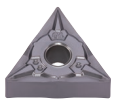
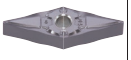
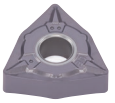
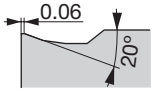
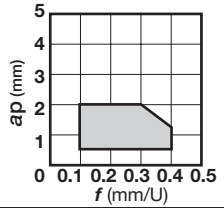
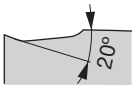
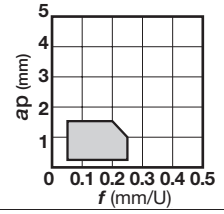
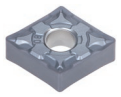
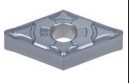
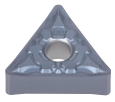
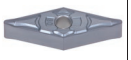
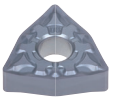
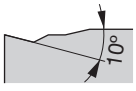
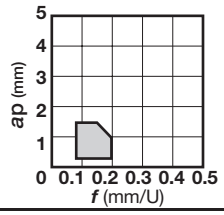
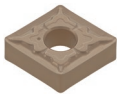
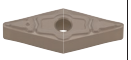
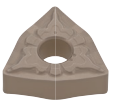




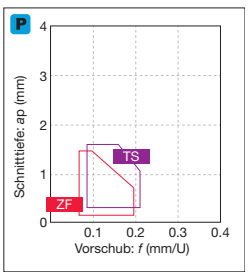


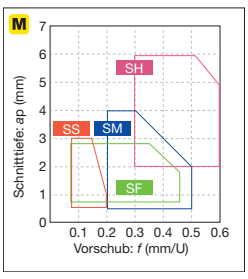
Weitere Produktdetails siehe Seite B***.

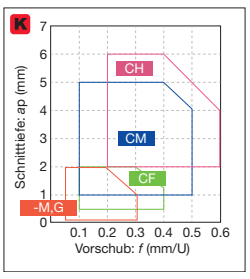
Spanformstufen – Übersicht

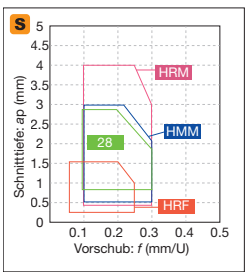
Anwendung	Negativ mit Loch	C 80°	D 55°	S 90°	T 60°	V 35°	W 80°	Y 25°
Schlichten	ZF  	 B055	B066		B085	 B095	B100	 B107
Schlichten von Baustahl	11 	 B055	 B066	B076	 B086	 B095	 B100	
	17 	 B055	B066	B076	 B086		 B100	
Schlichten	SF  	 B055	 B066	B076	 B086	 B095	 B101	
	CF  	B055	B066	B076	B086	B096	B101	
	HRF  	 B056	 B066	B076	 B086	 B096	 B101	
	TS  	 B056	B067	B076	B087	 B096	 B101	

Spankontrollbereich





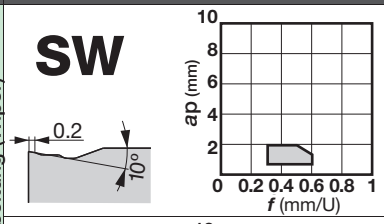
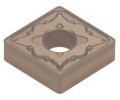
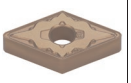
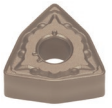
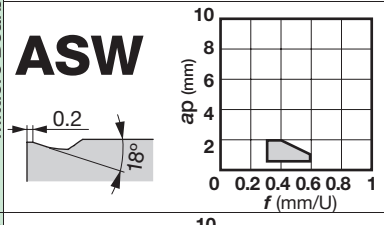
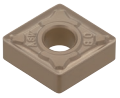
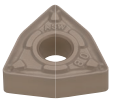
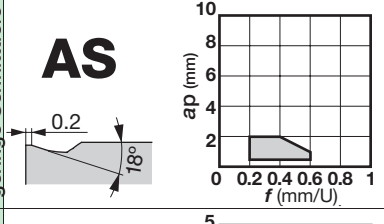
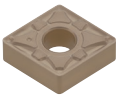
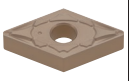
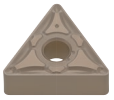
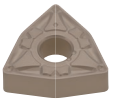
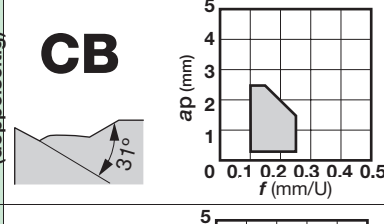
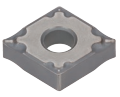
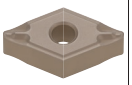
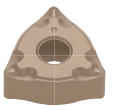
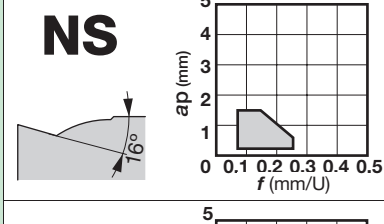
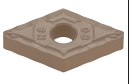
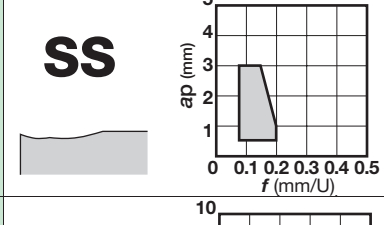
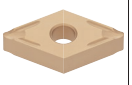
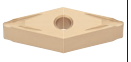
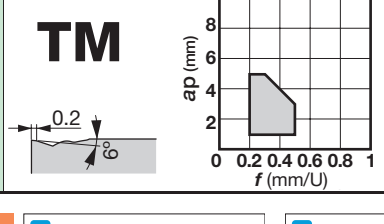
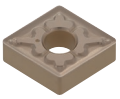
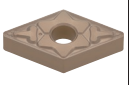
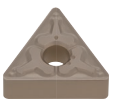
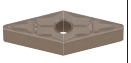
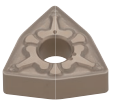




Weitere Produktdetails siehe Seite B***.

*-M,G: Ohne Spanformstufe

Spanformstufen – Übersicht

Anwendung	Negativ mit Loch	C	D	S	T	V	W	Y
		80°	55°	90°	60°	35°	80°	25°
Schlichten bis mittlere Bearbeitung (Wiper)	**SW** 	 B056	 B067		B087		 B102	
	ASW 	 B056					 B102	
Hoher Vorschub, geringe Schnitttiefe	**AS** 	 B056	 B067	B076	 B087		 B102	
Innendrehen (doppelseitig)	**CB** 	 B056	 B067		B087		 B102	
Schlichten	**NS** 	B056	 B067	B077	B087		B102	
	SS 	B057	 B068	B077	B088	 B096	B102	
Mittlere Bearbeitung	**TM** 	 B057	 B068	B077	 B088	 B096	 B103	

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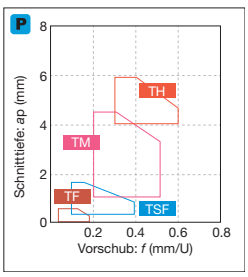
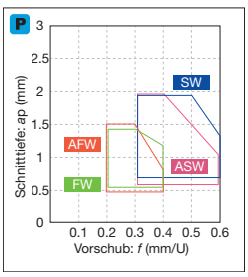
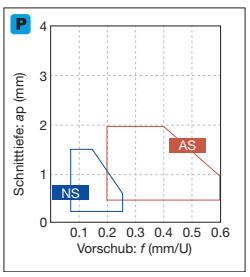
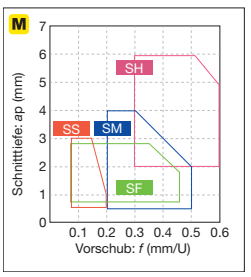


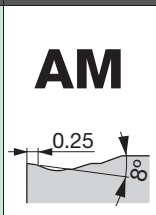
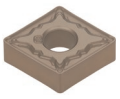
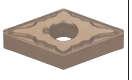
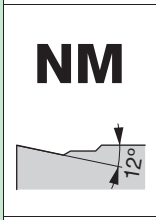
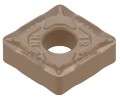
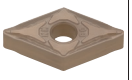
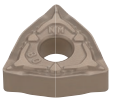
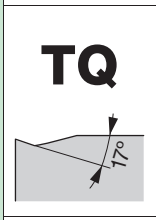
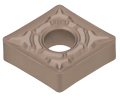
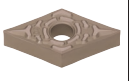
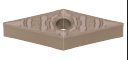
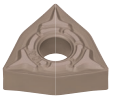
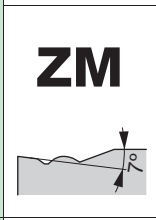
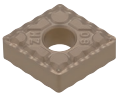
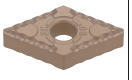
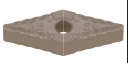
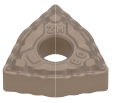
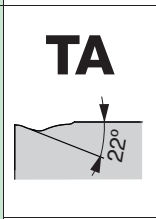
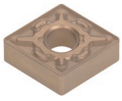
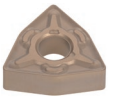
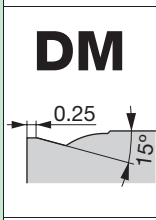
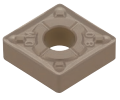
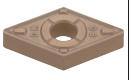
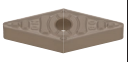
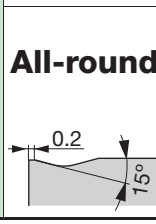
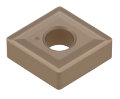
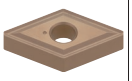
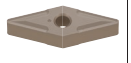
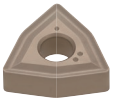




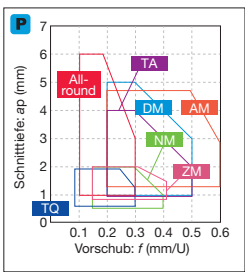


Weitere Produktdetails siehe Seite B***.

Spanformstufen – Übersicht

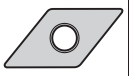
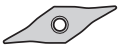
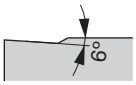
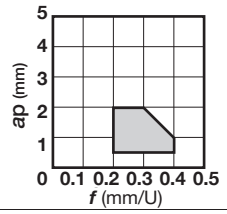
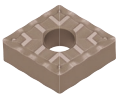
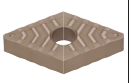
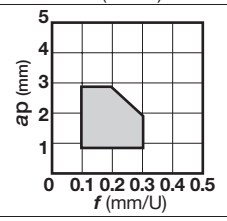
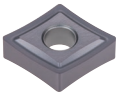
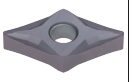
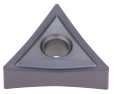
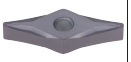
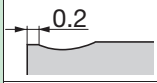
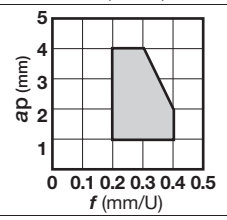
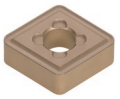
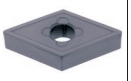
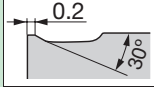
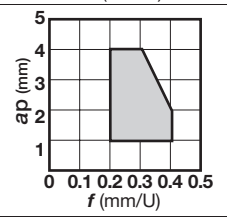
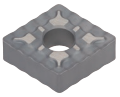
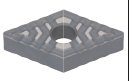
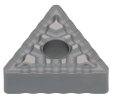
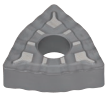
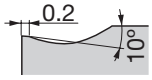
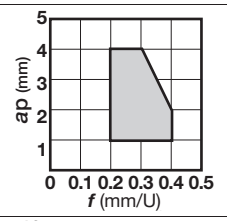
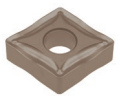
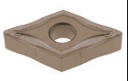
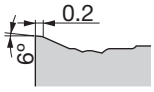
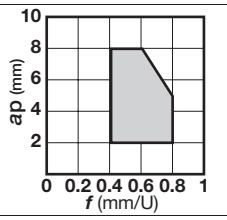
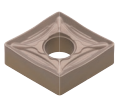
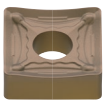
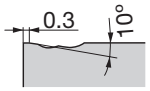
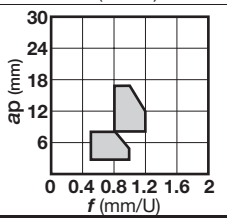
Anwendung	Negativ mit Loch	C	D	S	T	V	W	Y
		80°	55°	90°	60°	35°	80°	25°
Schlichten bis mittlere Bearbeitung	**AM** 	 B057	 B068		B088		B103	
	NM 	 B057	 B068		B088		 B103	
	TQ 	 B058	 B069		B088	 B096	 B103	
	ZM 	 B058	 B069	B077	B089	 B097	 B104	B107
Mittlere Bearbeitung	**TA** 	 B058		B077	B088		 B103	
	DM 	 B058	 B069	B078	B089	 B097	B104	
	All-round 	 B058	 B069	B078	B089	 B097	 B104	

Spankontrollbereich



Weitere Produktdetails siehe Seite B***.

Spanformstufen – Übersicht

Anwendung	Negativ mit Loch		C	D	S	T	V	W	Y
									
			80°	55°	90°	60°	35°	80°	25°
Schlichten bis mittlere Bearbeitung	**27**	 	 B059	 B069	B078	B089		B104	
Mittlere Bearbeitung	**28**		 B059	 B070		 B090	 B097		
	33	 	 B059	 B070	B078	B090	B097	B104	
	37	 	 B059	 B070	B078	 B090		 B104	
	38	 	 B059	 B070		B090			
	57	 	 B061	B072	 B081	B092			
	65	 	B062		B081				

Weitere Produktdetails siehe Seite B***.

Spanformstufen – Übersicht

Anwendung	Negativ mit Loch	C	D	R	S	T	V	W
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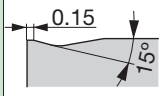
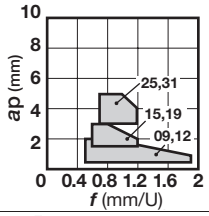
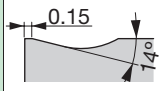
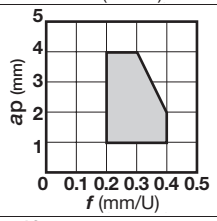
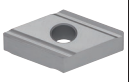
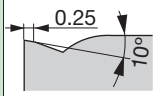
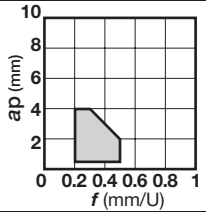
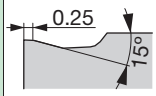
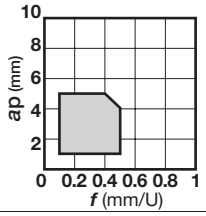
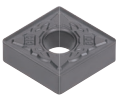
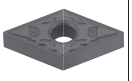
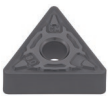
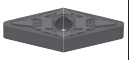
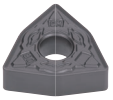
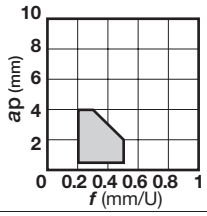
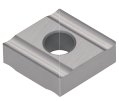
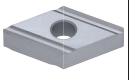
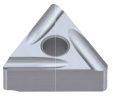
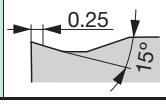
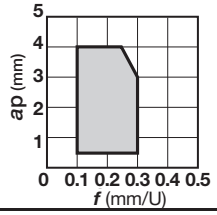
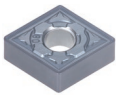
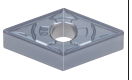
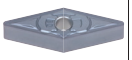
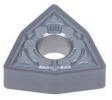
Schwerzerspanung	**61**  			B074				
Mittlere Bearbeitung	**Parallel**  		 B070					
	SM  	B060	B070		B078	B090	B098	B105
	CM  	 B060	 B070		B079	 B090	 B098	 B105
	P 	 B060	 B071		B079	 B091		
Schlichten bis mittlere Bearbeitung	**HRM**  	 B060	 B071		B079	B091	 B098	 B105

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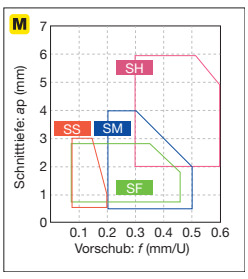
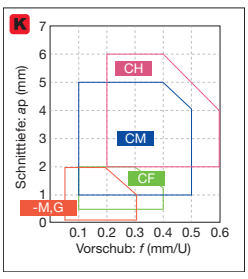
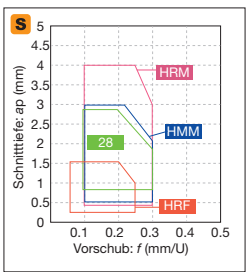
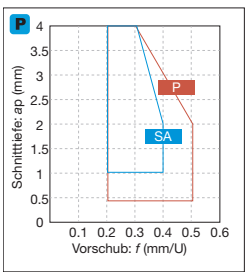
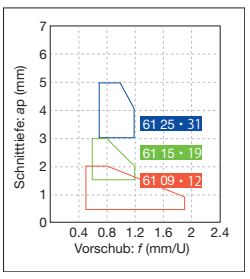








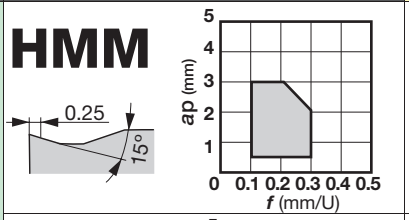


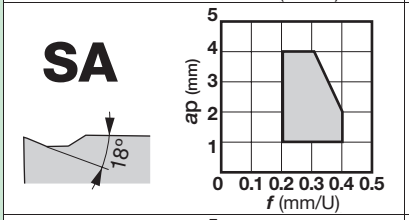
Weitere Produktdetails siehe Seite B***.

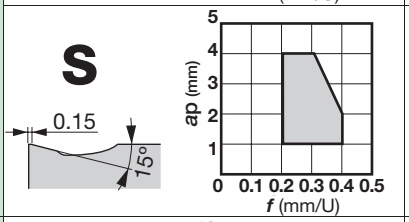
*-M,G: Ohne Spanformstufe

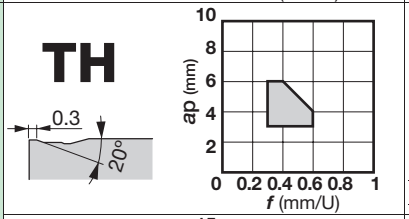
Spanformstufen – Übersicht

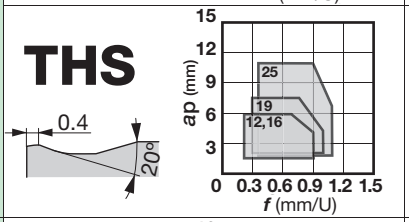
Anwendung	Negativ mit Loch	C	D	R	S	T	V	W
		80°	55°		90°	60°	35°	80°
Mittlere Bearbeitung	HMM	B060	B071		B079	B091	B098	B105
Mittlere Bearbeitung	SA	B060	B071		B079	B091		B105
Mittlere Bearbeitung	S	B060	B071		B080	B092		
Mittlere Bearbeitung bis Schwerzerspanung	TH	B061	B072		B080	B092		B106
Mittlere Bearbeitung bis Schwerzerspanung	THS	B061	B072		B080	B092		B106
Mittlere Bearbeitung bis Schwerzerspanung (einseitig)	TRS	B062			B080			

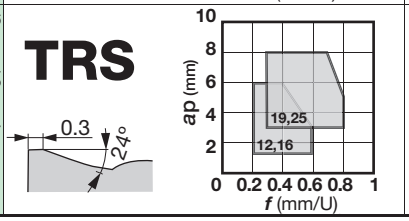




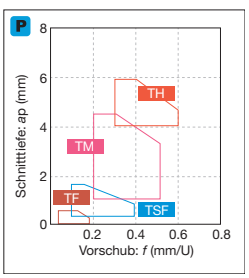


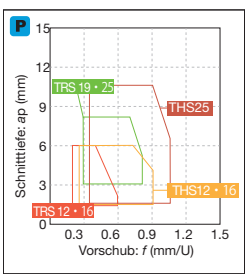


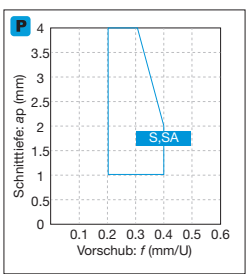


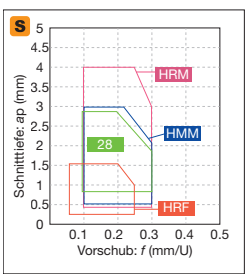


Spankontrollbereich



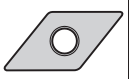
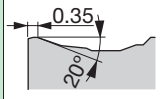
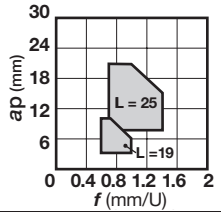
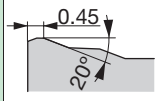
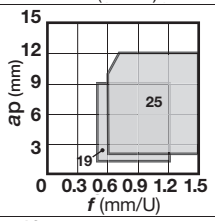
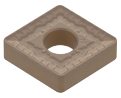
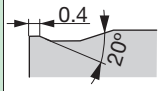
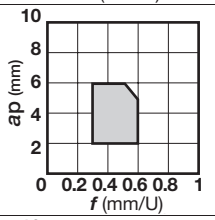
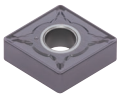
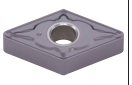
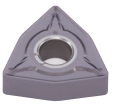
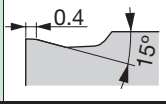
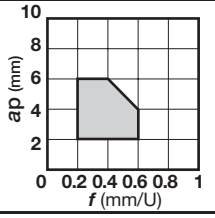
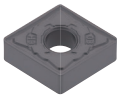
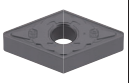
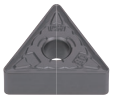






Weitere Produktdetails siehe Seite B***.

Spanformstufen – Übersicht

Anwendung	Negativ mit Loch	C	D	R	S	T	V	W
								
		80°	55°		90°	60°	35°	80°
Schwerzerspanung (einseitig)	**TU**  	B062			B080			
	TUS  	 B062			B081			
Mittlere Bearbeitung bis Schwerzerspanung	**SH**  	 B062	 B072		B081			 B106
	CH  	 B062	 B072		B081	 B092		B106

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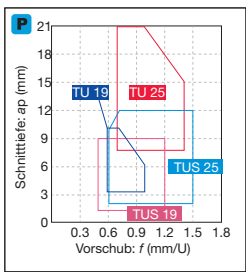
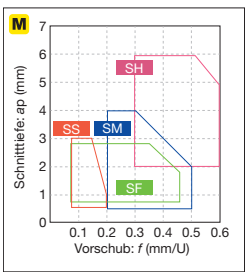
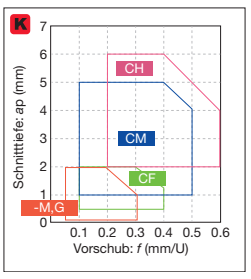


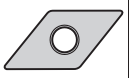
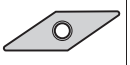
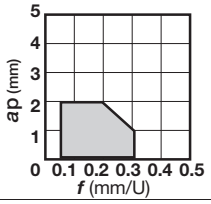
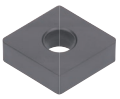
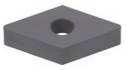
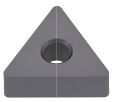
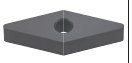
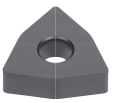
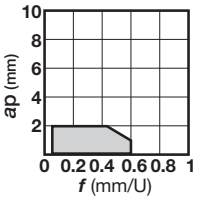
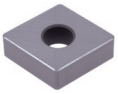


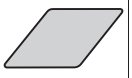
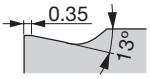
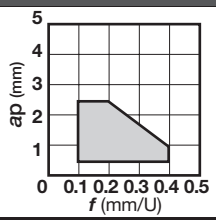


Weitere Produktdetails siehe Seite B***.

*-M,G: Ohne Spanformstufe

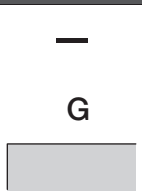
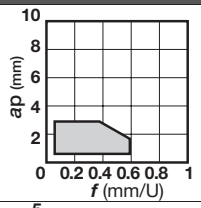
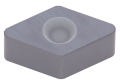
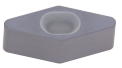
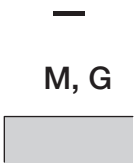
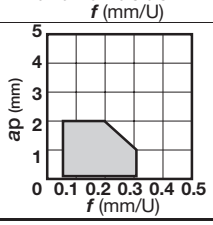
Spanformstufen – Übersicht

Anwendung	Negativ mit Loch	C	D	R	S	T	V	W
								
		80°	55°		90°	60°	35°	80°
Schlichten bis mittlere Bearbeitung	— M, G 	 B063	 B072	B074	B082	 B093	 B098	 B106
	Wiper M 	 B063						

Anwendung	Negativ mit Loch	C	D	KNMX	LNGN	R	S	T
								
		80°	55°	55°	90°		90°	60°
Schlichten	S1  			B108				

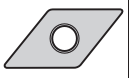
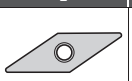
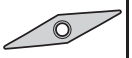
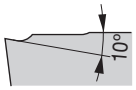
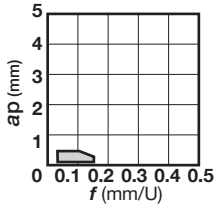
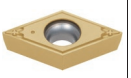
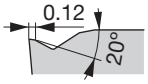
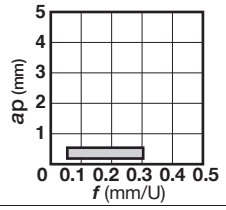
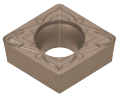
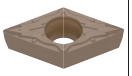
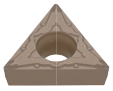
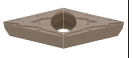
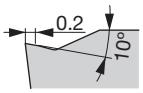
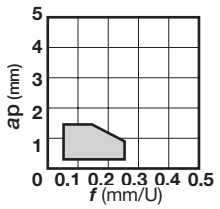
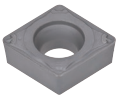
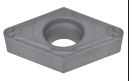
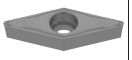
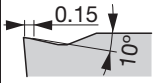
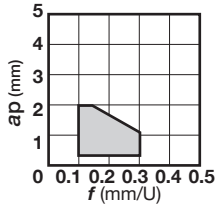
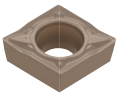
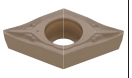
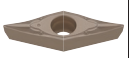
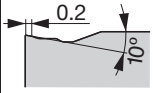
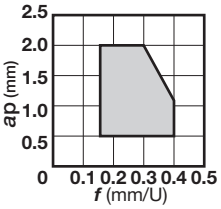
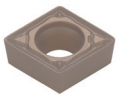
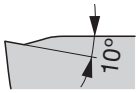
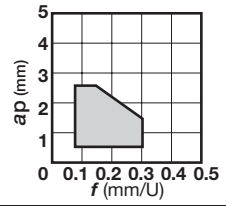
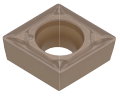
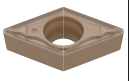
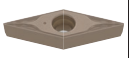
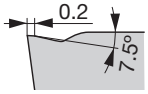
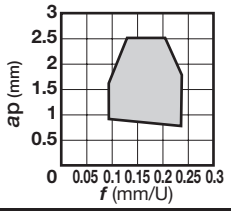
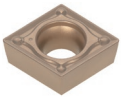
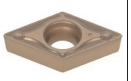
Weitere Produktdetails siehe Seite B***.

Spanformstufen – Übersicht

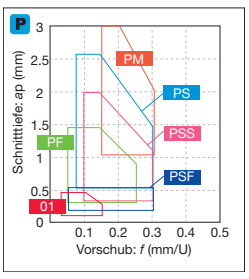
Anwendung	Negativ mit Loch	C	D	H	R	S	T	V
		80°	55°	120°		90°	60°	35°
Schlichten bis mittlere Bearbeitung	G  	B064	 B073	B108		B082		 B099
	M, G  	B064	B073		B074	B082	B094	

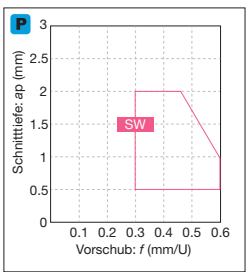
Weitere Produktdetails siehe Seite B***.

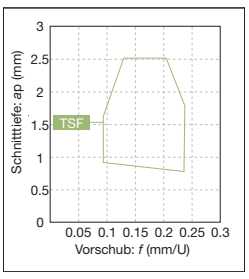
Spanformstufen – Übersicht

Anwendung	Positiv 7° mit Loch	C	D	R	S	T	V	Y
								
		80°	55°		90°	60°	35°	25°
Feinschlichten	01  	B109	 B119			B137		
Schlichten	PSF  	 B109	 B119			 B137	 B153	
	PF  	 B109	 B119				 B153	
Schlichten bis leichte Bearbeitung	PSS  	 B110	 B120			B137	 B153	
Mittlere Bearbeitung (Wiper)	SW  	 B110						
Schlichten bis mittlere Bearbeitung	PS  	 B110	 B120		B133	B138	 B153	
	TSF  	 B110	 B120			B138	B153	

Spankontrollbereich

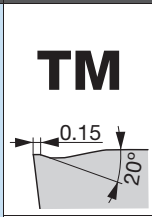
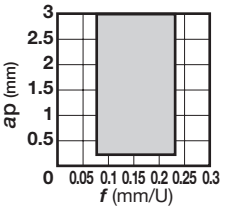
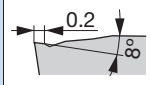
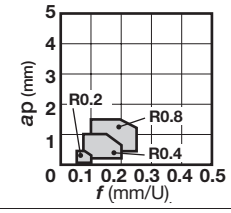
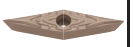
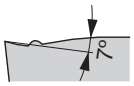
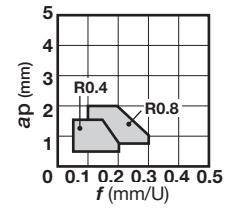
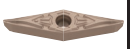
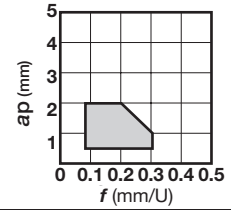
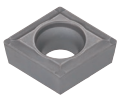
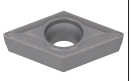
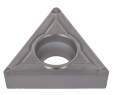
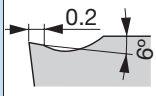
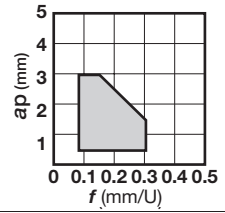
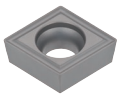
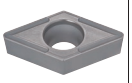
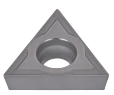
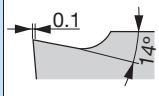
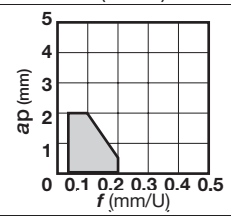
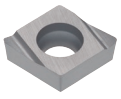
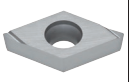
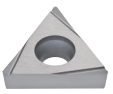
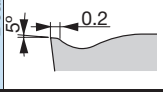
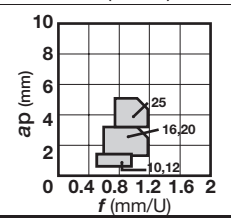




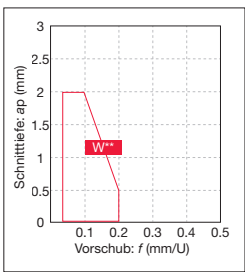


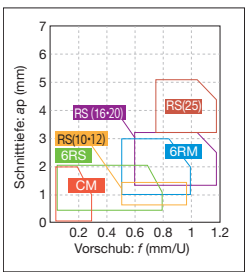
Weitere Produktdetails siehe Seite B***.

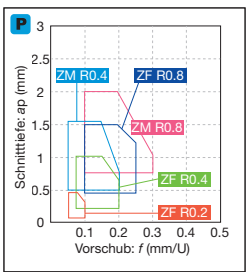
Spanformstufen – Übersicht

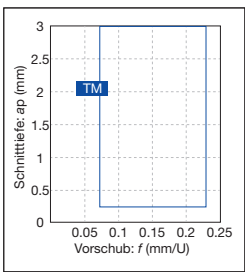
Anwendung	Positiv 7° mit Loch	C	D	R	S	T	V	Y
		80°	55°		90°	60°	35°	25°
Schlichten bis mittlere Bearbeitung	**TM**  	B110	B120			B138	B153	
	ZF  							 B160
	ZM  							 B160
	23 	 B111	 B120		B133	 B138		
Mittlere Bearbeitung	**24**  	 B111	 B120		B133	 B138	B154	
Schlichten	**W****  	 B111, B112	 B121			 B138		
Schlichten bis mittlere Bearbeitung	**RS**  			B129				

Spankontrollbereich



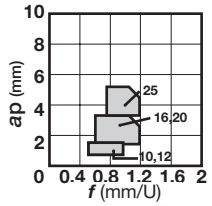
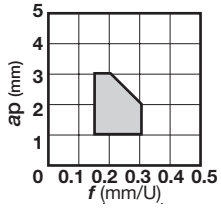
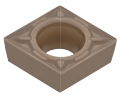
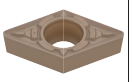
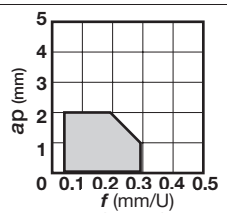
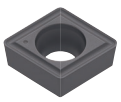
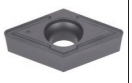
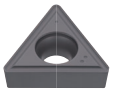
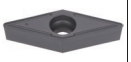
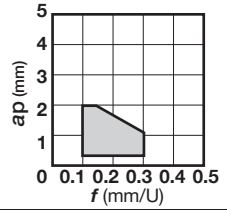
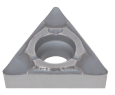
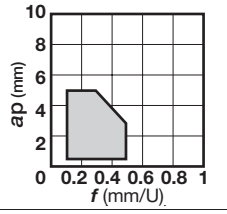
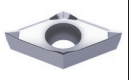
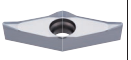
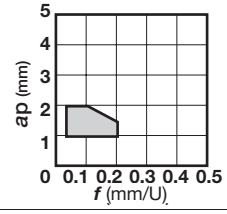
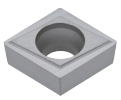
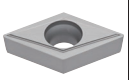
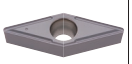
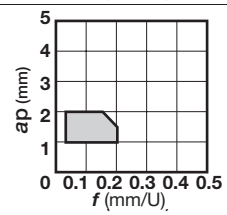
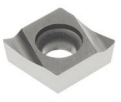
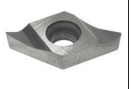




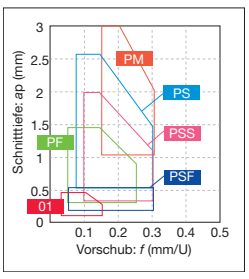


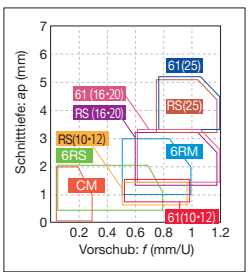
Weitere Produktdetails siehe Seite B***.

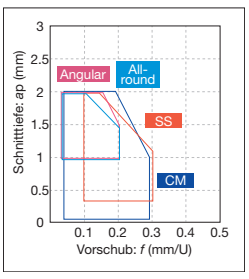
Spanformstufen – Übersicht

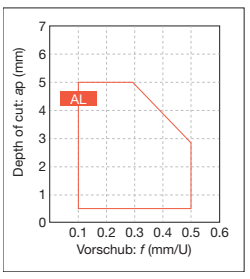
Anwendung	Positiv 7° mit Loch	C	D	R	S	T	V	Y
		80°	55°		90°	60°	35°	25°
Schwerzerspanung	**61** 0.15 / 20° 			B130				
Mittlere Bearbeitung	**PM** 0.15 / 8° 	 B112	 B121		B133	B139		
Schlichten bis mittlere Bearbeitung	**CM** 0.25 / 10° 	 B112	 B121	B129	B133	 B139	 B154	
	SS 					 B139		
	AL 0.2 / 20° 	B113	 B122	B129		B139	 B154	
	All-round 	 B113	 B122				 B154	
	Positiver Spanwinkel 23° 	 B113	 B122					

Spankontrollbereich



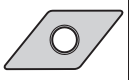
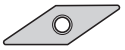
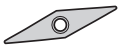
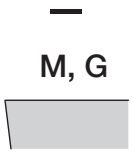
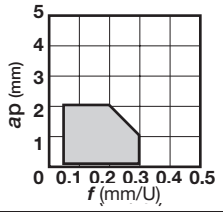
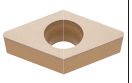
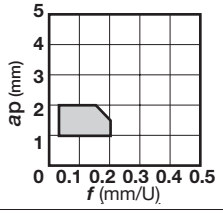
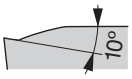
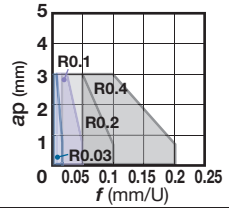
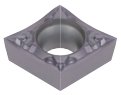
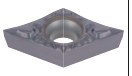
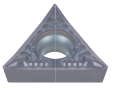
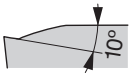
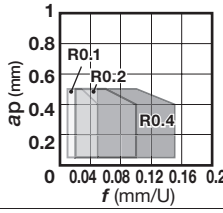
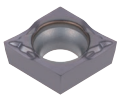
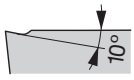
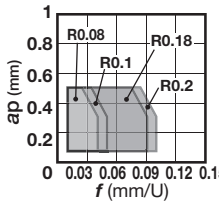
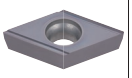
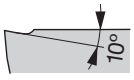
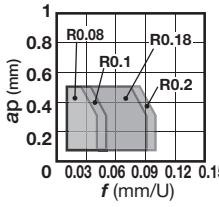
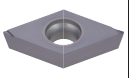




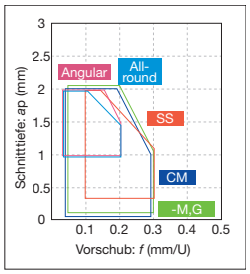


Weitere Produktdetails siehe Seite B***.

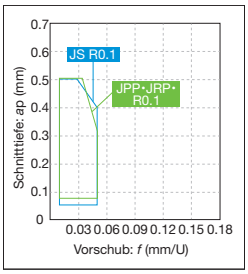
Spanformstufen – Übersicht

Anwendung	Positiv 7° mit Loch	C	D	R	S	T	V	Y
								
		80°	55°		90°	60°	35°	25°
Schlichten bis mittlere Bearbeitung	M, G  	B113	 B122					
Schlichten	(R/L) 					B140		
Außendrehen auf Langdrehautomaten (scharfkantig)	JS  	 B114	 B123			 B140		
	JS  	 B114						
Außendrehen auf Langdrehautomaten (scharfkantig)	JPP  		 B123					
	JRP  		 B124					

Spankontrollbereich



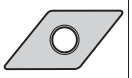
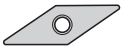
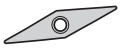
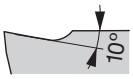
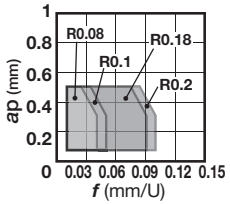
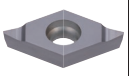
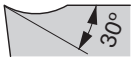
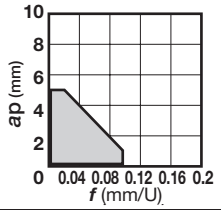
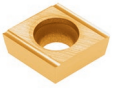
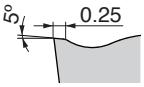
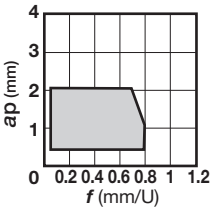
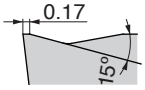
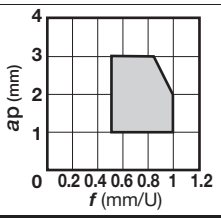
*-M,G: Ohne Spanformstufe



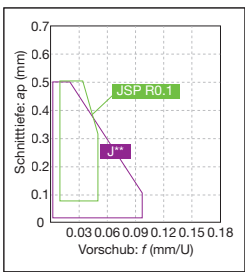
*Spankontrolle mit typ. R0.1

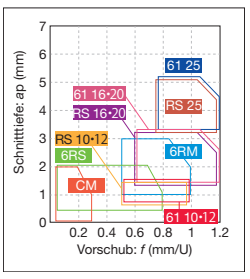
Weitere Produktdetails siehe Seite B***.

Spanformstufen – Übersicht

Anwendung	Positiv 7° mit Loch	C	D	R	S	T	V	Y
								
		80°	55°		90°	60°	35°	25°
Außendrehen auf Langdrehautomaten (scharfkantig)	**JSP**  		 B124					
	J**  	 B115	B124			B140, B141		
Niedrige Schnittkraft	**6RS**  			B129				
Mittlere Bearbeitung	**6RM**  			B129				

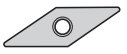
Spankontrollbereich





Weitere Produktdetails siehe Seite B***.

Spanformstufen – Übersicht

Anwendung	Positiv 7° mit Loch	C	E	S	T	V
						
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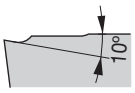
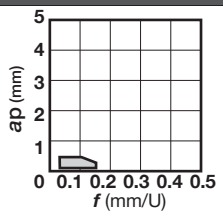
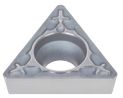
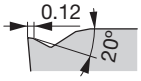
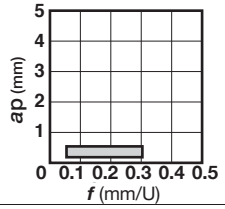
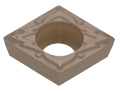
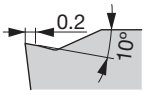
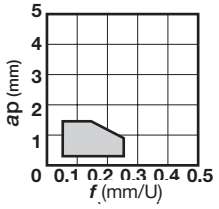
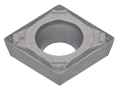
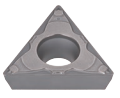
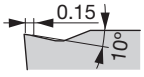
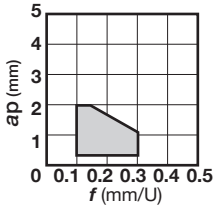
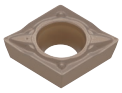
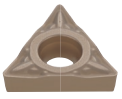
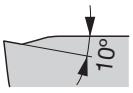
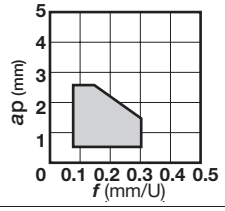
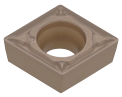
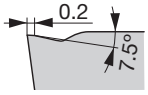
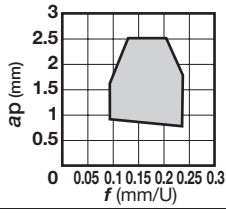
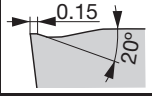
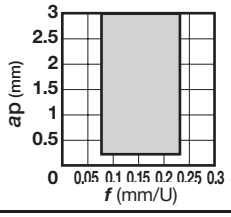
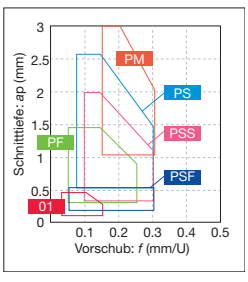
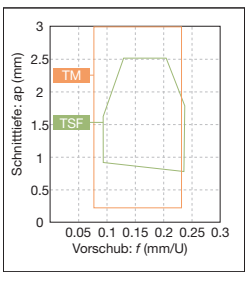
Feinschlichten	01  				 B142	
Schlichten	PSF  	 B116			B142	
	PF  	 B116			 B142	
Schlichten bis leichte Bearbeitung	PSS  	 B116			 B143	
Schlichten bis mittlere Bearbeitung	PS  	 B116		B134	B143	
	TSF  	B116			B143	
	TM  	B116			B144	

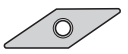
Spankontrollbereich





Weitere Produktdetails siehe Seite B***.

Spanformstufen – Übersicht

Anwendung	Positiv 11° mit Loch	C	E	S	T	V
						
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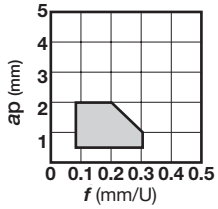
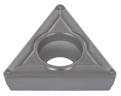
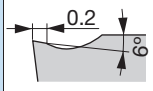
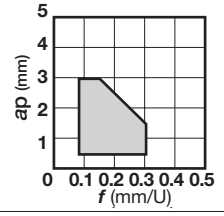
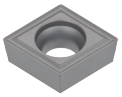
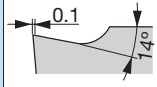
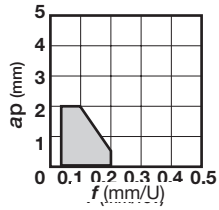
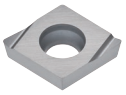
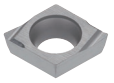
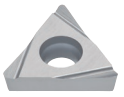
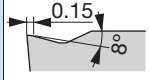
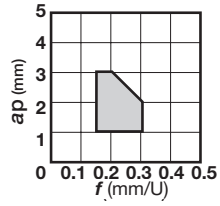
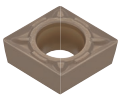
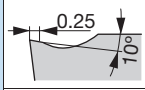
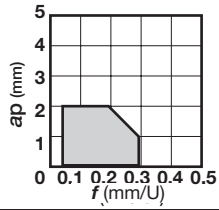
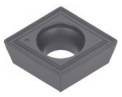
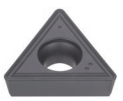
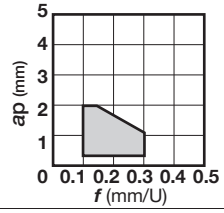
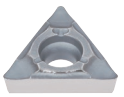
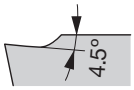
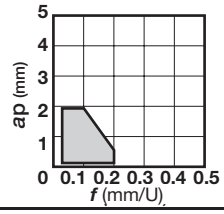
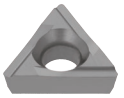
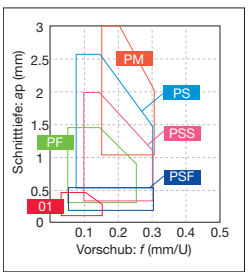
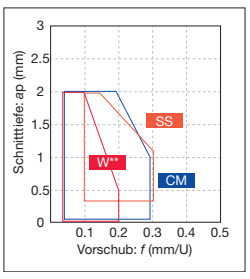
Schlichten bis mittlere Bearbeitung	**23** 			B134	 B144	
Mittlere Bearbeitung	**24**  	 B117		B134	B144	
Schlichten	**W****  	 B117	 B127	B134	 B144, B145	
Mittlere Bearbeitung	**PM**  	 B118			B146	
Schlichten bis mittlere Bearbeitung	**CM**  	 B118		B135	 B146	
	SS 				 B146	
	H**  				 B146	

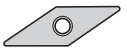
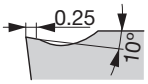
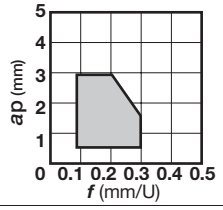
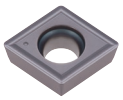
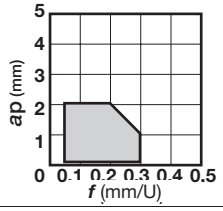
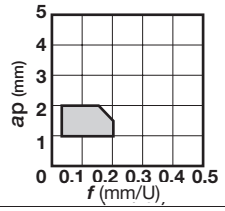
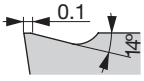
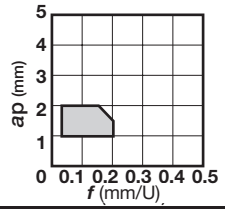
Spankontrollbereich



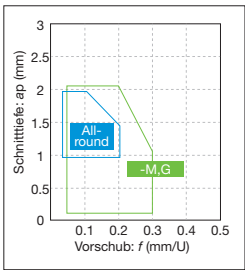


Weitere Produktdetails siehe Seite B***.

Spanformstufen – Übersicht

Anwendung	Positiv 11° mit Loch	C	E	S	T	V
						
		80°	75°	90°	60°	35°
Mittlere Bearbeitung	**All-round**  	 B118				
Schlichten bis mittlere Bearbeitung	— **M, G** 	 B118		 B135	 B147, B148	
Schlichten bis mittlere Bearbeitung	— (R/L) 			 (Tungaloy-Standardloch-spezifikation) Nicht ISO-konform B135		
Schlichten bis mittlere Bearbeitung	— (R/L) 0.1  				 (Tungaloy-Standardloch-spezifikation) Nicht ISO-konform B147	

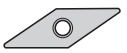
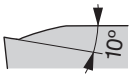
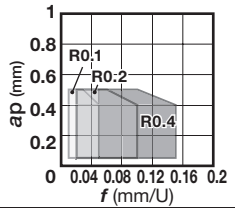
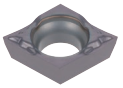
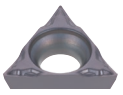
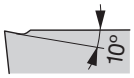
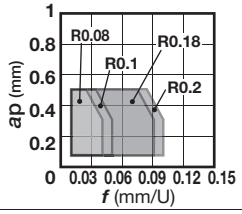
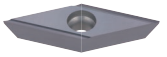
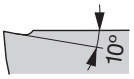
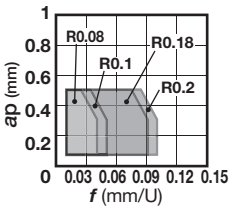
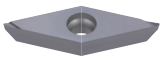
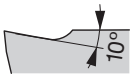
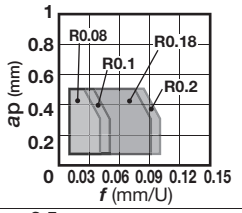
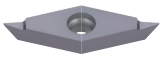
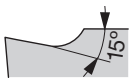
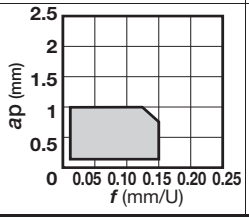
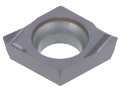
Spankontrollbereich

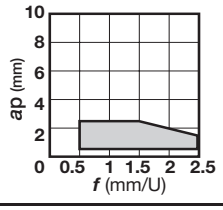


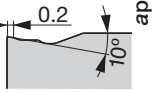
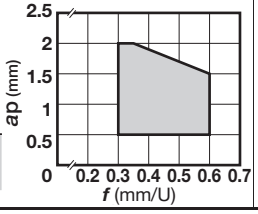
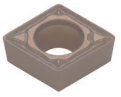
*-M,G: Ohne Spanformstufe

Weitere Produktdetails siehe Seite B***.

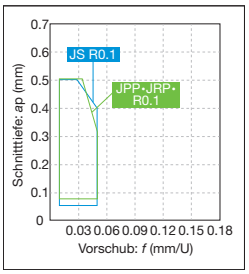
Spanformstufen – Übersicht

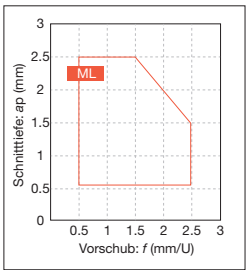
Anwendung	Positiv 11° mit Loch	C	E	S	T	V
						
		80°	75°	90°	60°	35°
Innendrehen auf Langdrehautomaten	**JS**  		 B128		 B148	
Außendrehen auf Langdrehautomaten (scharfkantig)	**JPP**  					 B155
	JRP  					 B155
	JSP  					 B156
Schlichten	**J08**  		 B128			

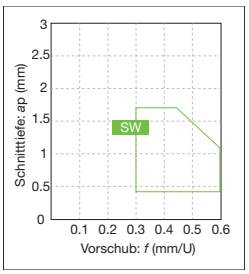
Anwendung	Positiv 11° mit Loch	W
		80°
Schwerzerspanung	**ML** 	B156

Anwendung	Positiv 7° mit Loch	C
		80°
Mittlere Bearbeitung (Wiper)	**SW**  	 B110

Spankontrollbereich



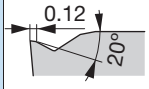
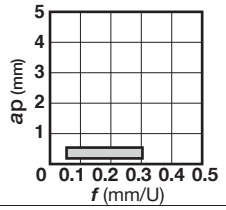
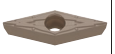
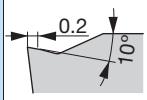
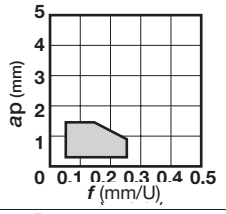
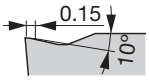
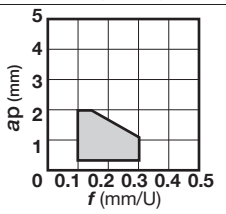
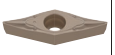
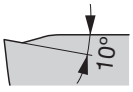
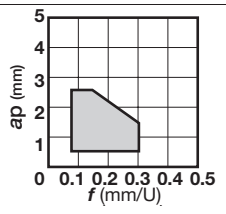
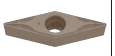
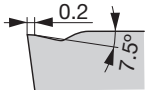
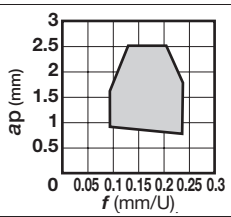
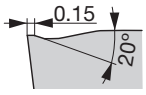
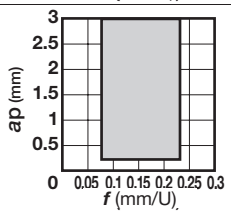
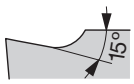
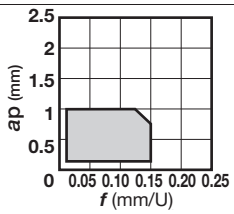
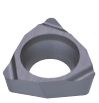


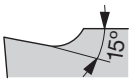
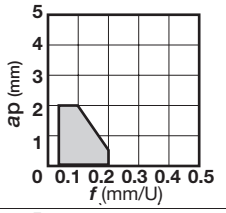
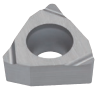
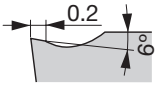
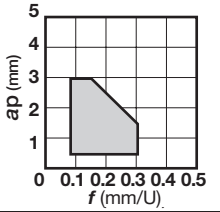
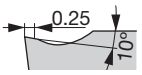
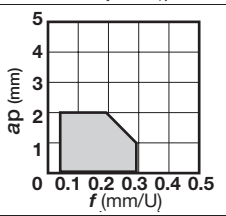
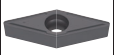
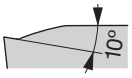
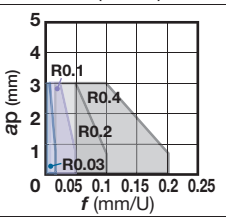
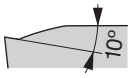
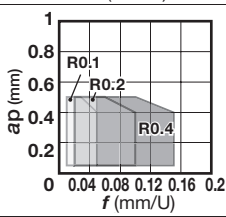
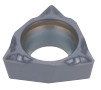
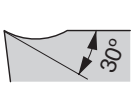
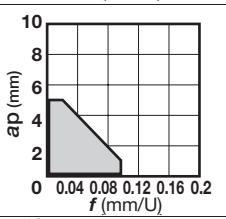
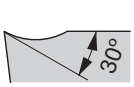
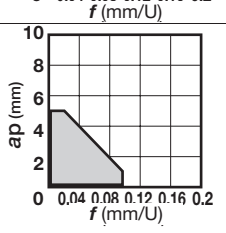


*Spankontrolle mit typ. R0.1

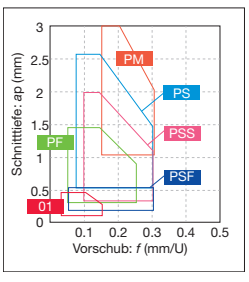
Weitere Produktdetails siehe Seite B***.

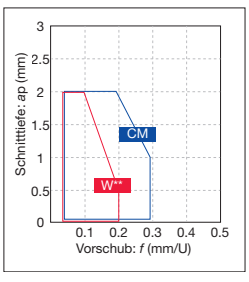
Spanformstufen – Übersicht

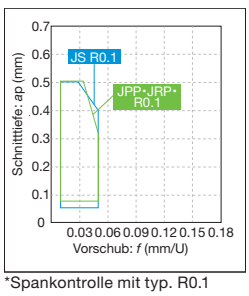
Anwendung	Positiv 5° mit Loch	V 35°	W 80°
Schlichten	**PSF**  	 B150	
Schlichten	**PF**  	B151	
Schlichten bis leichte Bearbeitung	**PSS**  	 B151	
Schlichten bis mittlere Bearbeitung	**PS**  	 B151	
Schlichten bis mittlere Bearbeitung	**TSF**  	B151	
Schlichten bis mittlere Bearbeitung	**TM**  	B151	
Schlichten	**W08**  		 B157

Anwendung	Positiv 5° mit Loch	V 35°	W 80°
Schlichten	**W11**  		 B158
Mittlere Bearbeitung	**24**  	B152	
Schlichten bis mittlere Bearbeitung	**CM**  	 B152	
Außendrehen auf Langdreh-automaten (scharfkantig)	**JS**  	B152	
Innendrehen auf Langdrehautomaten	**JS**  		 B158
Außendrehen auf Langdreh-automaten (scharfkantig)	**J10**  	B152	
Außendrehen auf Lang-drehautomaten (geschliffen)	**J10**  	B152	

Spankontrollbereich



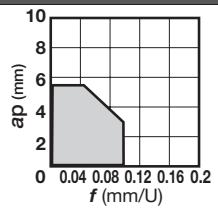
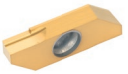


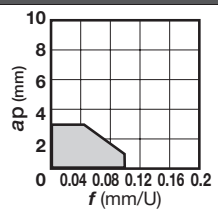


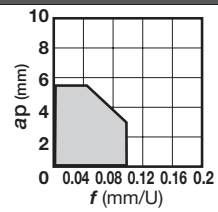
*Spankontrolle mit typ. R0.1

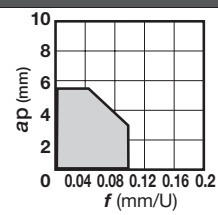
Weitere Produktdetails siehe Seite B***.

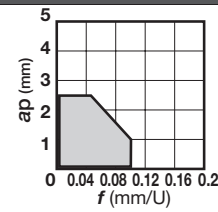
Spanformstufen – Übersicht

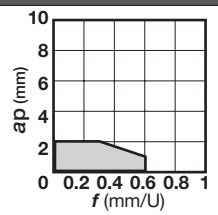
Anwendung	Positiv mit Loch	JXF
Vorwärtsdrehen	— 	 B160

Anwendung	Positiv mit Loch	J10E
Rückwärtsdrehen	— 	B162, B163

Anwendung	Positiv mit Loch	JXB
Rückwärtsdrehen	— 	B161

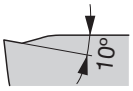
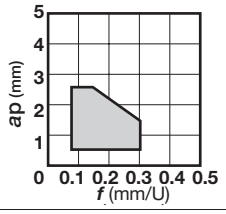
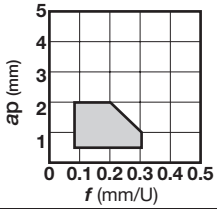
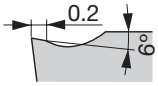
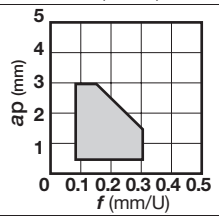
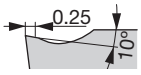
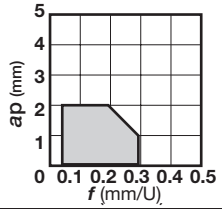
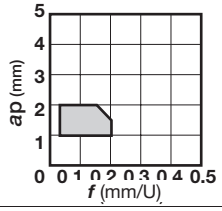
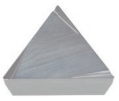
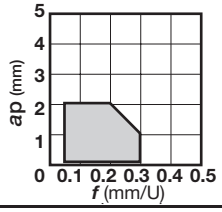
Anwendung	Positiv mit Loch	JXR
Rückwärtsdrehen	— 	B161

Anwendung	Positiv mit Loch	JTB
Rückwärtsdrehen	— 	B162

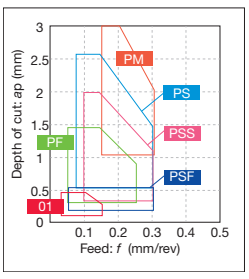
Anwendung	Rund	RT
Mittlere Bearbeitung	— 	Special round insert B130

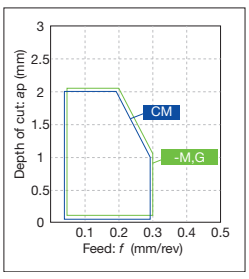
Weitere Produktdetails siehe Seite B***.

Spanformstufen – Übersicht

Anwendung	Positiv 11° ohne Loch	R	S	T
			90°	60°
Schlichten bis mittlere Bearbeitung	**PS**  			B149
	23 		B136	B149
Mittlere Bearbeitung	**24**  			B149
Schlichten bis mittlere Bearbeitung	**CM**  		B136	B149
	— (R/L) 		B136	 B150
	— M, G 		B136	B150

Chip control range





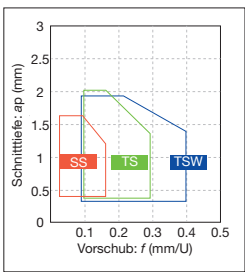
Weitere Produktdetails siehe Seite B***.

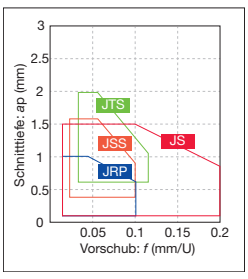
*-M,G: Without chipbreaker

Spanformstufen – Übersicht

Anwendung	Doppelseitig, positive mit Loch	D	V	W
		55°	35°	80°
Schlichten (Niedrige Schnittkräfte)	SS	B126		B159
Schlichten (Wiper)	TSW			B159
Schlichten bis mittlere Bearbeitung	TS	B126		B159
Schlichten (Niedrige Schnittkräfte, scharfkantig)	JSS	B126		B159
Schlichten bis mittlere Bearbeitung (scharfkantig)	JS	B125	B156	B158
Schlichten bis mittlere Bearbeitung (scharfkantig)	JTS	B126		B158
Schlichten (scharfkantig)	JRP	B125	B156	

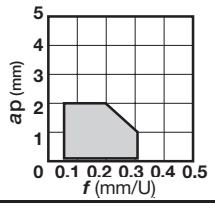
Schlichten (scharfkantig)





Weitere Produktdetails siehe Seite B***.

Spanformstufen – Übersicht

Anwendung	Positiv 7° ohne Loch	RCGX
		Spezielle runde WSP
Mittlere Bearbeitung	– 	B131

Weitere Produktdetails siehe Seite B***.

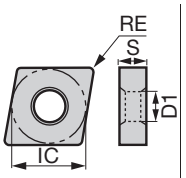
Wendeschneidplatten NEGATIV

● : Kontinuierlicher Schnitt
ɔ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

CN

Rhombisch, 80° mit Loch

		T9205	T9215	T9225	T9235	T9105	T9115	T9125	T9135	AH120	GH110	GT9530	AT9530	NS9530	NS520	TH10
P	Stahl	●	●ɔ	●✣	✣	●	●ɔ	●✣	✣	●ɔ	●	●ɔ	●ɔ	●ɔ	●ɔ	●
M	Rostfreier Stahl		●ɔ							●ɔ	●					●
K	Eisenguss	●ɔ	●ɔ			●ɔ	●ɔ			●ɔ	●	●ɔ	●ɔ	●ɔ	●ɔ	●
N	Nichteisen-metalle															●
S	Hitzebest. Legierungen									●ɔ	●					
H	Gehärteter Stahl															



Anwendung	Spanform-stufe	Katalog Nr.	RE	IC	S	D1
Feinschlichten	TF	CNMG120404-TF	0.4	12.7	4.76	5.16
		CNMG120408-TF	0.8	12.7	4.76	5.16
	01	CNGG090302-01	0.2	9.525	3.18	3.81
		CNGG090304-01	0.4	9.525	3.18	3.81
		CNGG090308-01	0.8	9.525	3.18	3.81
		CNGG120402-01	0.2	12.7	4.76	5.16
		CNGG120404-01	0.4	12.7	4.76	5.16
		CNGG120408-01	0.8	12.7	4.76	5.16
	C	CNGG120404R-C	0.4	12.7	4.76	5.16
		CNGG120404L-C	0.4	12.7	4.76	5.16
		CNGG120408R-C	0.8	12.7	4.76	5.16
		CNGG120408L-C	0.8	12.7	4.76	5.16
Schlichten	TSF	CNMG090404E-TSF	0.4	9.525	4.76	3.81
		CNMG090408E-TSF	0.8	9.525	4.76	3.81
		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
Schlichten (Wiper)	FW	CNMG090404E-FW	0.4	9.525	4.76	3.81
		CNMG090408E-FW	0.8	9.525	4.76	3.81
		CNMG120404-FW	0.4	12.7	4.76	5.16
		CNMG120408-FW	0.8	12.7	4.76	5.16
		*Wiper				
	AFW	CNMG120404-AFW	0.4	12.7	4.76	5.16
		CNMG120408-AFW	0.8	12.7	4.76	5.16

* Siehe Seiten **L032-L036** bezüglich der Anpassung des Bearbeitungsprogramms für die Konturbearbeitung mittels SW/FW.
Bei Fragen wenden Sie sich bitte an unsere Vertriebsmitarbeiter.

● Lagerstandard
▲ Wird eingestellt

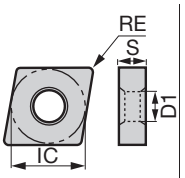
Halter / Außendrehen	→ C016 -	Halter / Innendrehen	→ D021 -
J-Serie Werkzeughalter	→ G044	TungCap	→ K008 -
PINZBOHR®	→ K180 -	Kassetten	→ K199 -

● : Kontinuierlicher Schnitt
ɔ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

CN

Rhombisch, 80° mit Loch

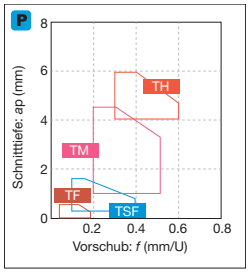
P	Stahl	●	●ɔ	ɔ✣	✣	●ɔ	ɔ✣	✣	ɔ	✣	ɔ✣				●ɔ	●ɔ	●ɔ		●ɔ				●									
M	Rostfreier Stahl		●ɔ						●	ɔ	ɔ												●								
K	Eisenguss	●ɔ	●ɔ			●ɔ						●	ɔ		●ɔ	●ɔ	●ɔ		●ɔ				●								
N	Nichteisen-metalle																						●								
S	Hitzebest. Legierungen																														
H	Gehärteter Stahl																														

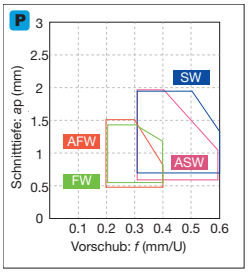


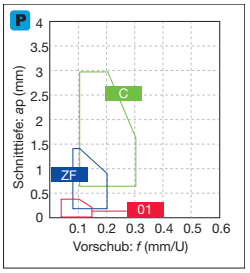
Anwendung	Spanform-stufe	Katalog Nr.	Beschichtet											Cermet besch.			Cermet		Unbeschichtet		Größe (mm)			
			T9205	T9215	T9225	T9235	T9115	T9125	T9135	T6120	T6130	AH630	T5105	T5115	GT9530	AT9530	GT720	NS9530		TH10		RE	IC	S	D1
Schlichten	ZF	CNMG090404E-ZF		●	●		▲	▲														0.4	9.525	4.76	3.81
		CNMG120404-ZF		●	●		▲	▲							●	●		●				0.4	12.7	4.76	5.16
		CNMG12040**8**-ZF		●	●	●	▲	▲	▲						●	●		●				0.8	12.7	4.76	5.16
	11	CNMG120404-11													●			●		●		0.4	12.7	4.76	5.16
		CNMG12040**8**-11													●		●	●		●		0.8	12.7	4.76	5.16
Schlichten (Baustahl)	17	CNMG120404-17																●				0.4	12.7	4.76	5.16
		CNMG12040**8**-17																●				0.8	12.7	4.76	5.16
Schlichten	SF	CNMG090304-SF								●	●	●										0.4	9.525	3.18	3.81
		CNMG090308-SF								●	●	●										0.8	9.525	3.18	3.81
		CNMG120404-SF								●	●	●										0.4	12.7	4.76	5.16
		CNMG12040**8**-SF								●	●	●										0.8	12.7	4.76	5.16
		CNMG12041**2**-SF								●	●	●										1.2	12.7	4.76	5.16
	CF	CNMG120404-CF											●	●								0.4	12.7	4.76	5.16
		CNMG12040**8**-CF											●	●								0.8	12.7	4.76	5.16
		CNMG12041**2**-CF											●	●								1.2	12.7	4.76	5.16

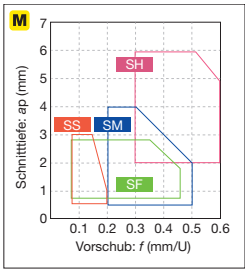
● Lagerstandard
▲ Wird eingestellt

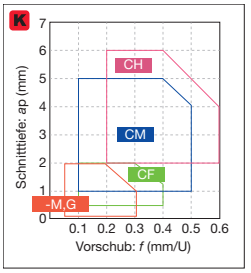
Spankontrollbereich











*-M,G: Ohne Spanformstufe

Halter / Außendrehen	→ C016 -	Halter / Innendrehen	→ D021 -
J-Serie Werkzeughalter	→ G044	TungCap	→ K008 -
PINZBOHR®	→ K180 -	Kassetten	→ K199 -

Wendeschneidplatten NEGATIV

● : Kontinuierlicher Schnitt
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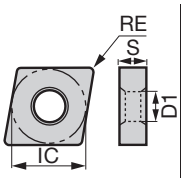
✣ : Stark unterbrochener Schnitt

CN

Rhombisch, 80° mit Loch

		T9205	T9215	T9225	T9235	T9105	T9115	T9125	T9135	T6130	T515	T5115	AH8005	AH8015	GT9530	AT9530	NS9530	NS520
P	Stahl	●	●ɔ	●✣	✣	●	●ɔ	●✣	✣	✣					●ɔ	●ɔ	●ɔ	●ɔ
M	Rostfreier Stahl		●ɔ							ɔ			●	ɔ				
K	Eisenguss	●ɔ	●ɔ			●ɔ	●ɔ				●ɔ	ɔ			●ɔ	●ɔ	●ɔ	●ɔ
N	Nichteisenmetalle																	
S	Hitzebest. Legierungen												●	ɔ				
H	Gehärteter Stahl																	



Anwendung	Spanformstufe	Katalog Nr.	Beschichtet												Cermet besch.		Cermet		Größe (mm)			
			T9205	T9215	T9225	T9235	T9105	T9115	T9125	T9135	T6130	T515	T5115	AH8005	AH8015	GT9530	AT9530	NS9530	NS520	RE	IC	S	D1
Schlichten	**HRF**	**CNMG120404-HRF**												●	●					0.4	12.7	4.76	5.16
		CNMG12040**8-HRF**												●	●					0.8	12.7	4.76	5.16
		CNMG12041**2-HRF**												●	●					1.2	12.7	4.76	5.16
	TS	**CNMG120404-TS**		●	●	●		▲	▲	▲						●	●	●	●	0.4	12.7	4.76	5.16
		CNMG12040**8-TS**	●	●	●	●	▲	▲	▲	▲	●					●	●	●	●	0.8	12.7	4.76	5.16
		CNMG12041**2-TS**		●	●	●		▲	▲	▲										1.2	12.7	4.76	5.16
Schlichten bis mittlere Bearbeitung (Wiper)	**SW**	**CNMG090408E-SW**	●	●	●		▲	▲	▲				●							0.8	9.525	4.76	3.81
		CNMG09041**2E-SW**	●	●	●		▲	▲	▲				●							1.2	9.525	4.76	3.81
		CNMG120408-SW	●	●	●		▲	▲	▲			●	●							0.8	12.7	4.76	5.16
		CNMG12041**2-SW**	●	●	●		▲	▲	▲			●	●							1.2	12.7	4.76	5.16
		*Wiper																					
	ASW	**CNMG120408-ASW**		●	●		▲	▲	▲									●		0.8	12.7	4.76	5.16
		CNMG12041**2-ASW**		●	●		▲	▲	▲											1.2	12.7	4.76	5.16
Hoher Vorschub, geringe Schnitttiefe	**AS**	**CNMG120404-AS**		●	●		▲	▲	▲									●		0.4	12.7	4.76	5.16
		CNMG12040**8-AS**		●	●		▲	▲	▲	▲								●		0.8	12.7	4.76	5.16
		CNMG12041**2-AS**		●	●			▲	▲	▲										1.2	12.7	4.76	5.16
Innendrehen (doppelseitig)	**CB**	**CNMG090304-CB**																●		0.4	9.525	3.18	3.81
		CNMG09030**8-CB**																●		0.8	9.525	3.18	3.81
Schlichten	**NS**	**CNMG120404-NS**																●		0.4	12.7	4.76	5.16
		CNMG12040**8-NS**		●	●			▲	▲									●		0.8	12.7	4.76	5.16

* Siehe Seiten **L032-L036** bezüglich der Anpassung des Bearbeitungsprogramms für die Konturbearbeitung mittels SW/FW.
Bei Fragen wenden Sie sich bitte an unsere Vertriebsmitarbeiter.

● Lagerstandard
▲ Wird eingestellt

Halter / Außendrehen	→ C016 -	Halter / Innendrehen	→ D021 -
J-Serie Werkzeughalter	→ G044	TungCap	→ K008 -
PINZBOHR®	→ K180 -	Kassetten	→ K199 -

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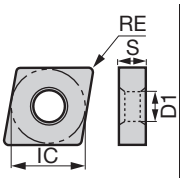
CN

Rhombisch, 80° mit Loch

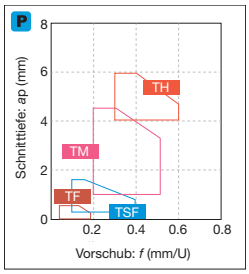
P	Stahl	●	●ɔ	●✣	✣	●	●ɔ	●✣	✣	ɔ	✣	ɔ✣	✣		●	●ɔ	ɔ		●ɔ			●ɔ										
M	Rostfreier Stahl		●ɔ							●	ɔ	ɔ	✣		●	●ɔ	ɔ	ɔ	●ɔ													
K	Eisenguss	●ɔ	●ɔ			●ɔ	●ɔ							●ɔ	●	●ɔ	ɔ		●ɔ			●ɔ										
N	Nichteisen-metalle																														
S	Hitzebest. Legierungen														●	●ɔ	●	ɔ													
H	Gehärteter Stahl																														

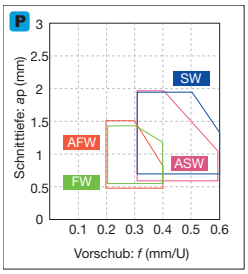


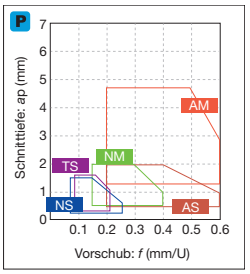
Anwendung	Spanform-stufe	Katalog Nr.	Beschichtet																		Cermet				Größe (mm)			
			T9205	T9215	T9225	T9235	T9105	T9115	T9125	T9135	T6120	T6130	AH630	AH645	T515	AH110	AH120	AH725	AH8015	GH330	NS9530				RE	IC	S	D1
Schlichten	**SS**	**CNMG090404E-SS**											●	●											0.4	9.525	4.76	3.81
		CNMG090408E-SS											●	●											0.8	9.525	4.76	3.81
		CNMG120404-SS									●	●	●	●			●			●					0.4	12.7	4.76	5.16
		CNMG120408-SS									●	●	●	●			●			●					0.8	12.7	4.76	5.16
		CNMG120412-SS									●	●	●	●						●					1.2	12.7	4.76	5.16
Mittlere Bearbeitung	**TM**	**CNMG090304-TM**		●	●			▲	▲																0.4	9.525	3.18	3.81
		CNMG090308-TM		●	●	●		▲	▲	▲															0.8	9.525	3.18	3.81
		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
		CNMG160612-TM	●	●	●	●	▲	▲	▲	▲							●								1.2	15.875	6.35	6.35
		CNMG190608-TM	●	●	●	●	▲	▲	▲	▲							●								0.8	19.05	6.35	7.93
		CNMG190612-TM	●	●	●	●	▲	▲	▲	▲							●								1.2	19.05	6.35	7.93
Schlichten bis mittlere Bearbeitung	**AM**	**CNMG120408-AM**		●	●			▲	▲																0.8	12.7	4.76	5.16
		CNMG120412-AM		●	●			▲	▲																1.2	12.7	4.76	5.16
		CNMG120416-AM		●	●			▲	▲																1.6	12.7	4.76	5.16
	NM	**CNMG120408-NM**	●	●	●	●	▲	▲	▲	▲											●				0.8	12.7	4.76	5.16
		CNMG120412-NM		●	●	●		▲	▲	▲															1.2	12.7	4.76	5.16

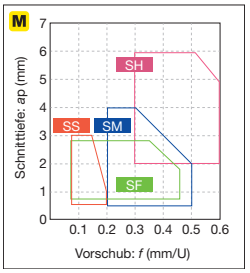
● Lagerstandard
▲ Wird eingestellt

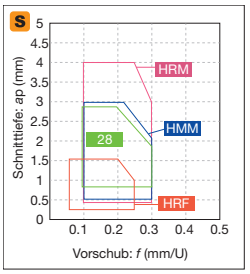
Spankontrollbereich











Halter / Außendrehen	→ C016 -	Halter / Innendrehen	→ D021 -
J-Serie Werkzeughalter	→ G044	TungCap	→ K008 -
PINZBOHR®	→ K180 -	Kassetten	→ K199 -

Wendeschneidplatten NEGATIV

● : Kontinuierlicher Schnitt
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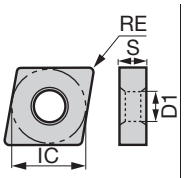
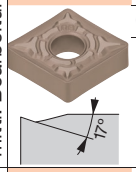
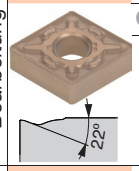
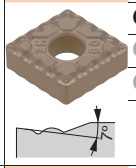
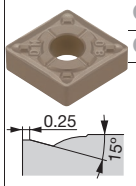
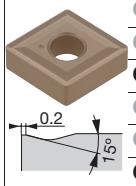
✣ : Stark unterbrochener Schnitt

CN

Rhombisch, 80° mit Loch

P	Stahl	●	●ɔ	●✣	✣	●	●ɔ	●✣	✣						●	●ɔ		●ɔ	●ɔ	●ɔ		●ɔ	●ɔ			●								
M	Rostfreier Stahl		●ɔ												●	●ɔ										●								
K	Eisenguss	●ɔ	●ɔ			●ɔ	●ɔ			●ɔ	●	ɔ	✣		●	●ɔ		●ɔ	●ɔ	●ɔ		●ɔ	●ɔ			●								
N	Nichteisen-metalle																									●								
S	Hitzebest. Legierungen														●	●ɔ																		
H	Gehärteter Stahl																																	



Anwendung	Spanform-stufe	Katalog Nr.	Beschichtet														Cermet besch.			Cermet		Unbe-schichtet	Größe (mm)			
			T9205	T9215	T9225	T9235	T9105	T9115	T9125	T9135	T515	T5105	T5115	T5125	AH110	AH120	GT9530	AT9530	GT720	NS9530	NS520	TH10	RE	IC	S	D1
Schlichten bis mittl. Bearbeitung	**TQ**	**CNMG120404-TQ**		●	●												●	●		●			0.4	12.7	4.76	5.16
		CNMG12040**8-TQ**		●	●												●	●		●			0.8	12.7	4.76	5.16
Mittlere Bearbeitung	**TA**	**CNMG120408-TA**		●	●																		0.8	12.7	4.76	5.16
		CNMG12041**2-TA**		●	●																		1.2	12.7	4.76	5.16
Schlichten bis mittl. Bearbeitung	**ZM**	**CNMG090408E-ZM**		●	●			▲	▲														0.8	9.525	4.76	3.81
		**CNMG120408-ZM**		●	●	●		▲	▲	▲							●			●			0.8	12.7	4.76	5.16
		CNMG12041**2-ZM**		●	●	●		▲	▲	▲							●						1.2	12.7	4.76	5.16
		CNMG12041**6-ZM**		●	●			▲	▲														1.6	12.7	4.76	5.16
Mittlere Bearbeitung	**DM**	**CNMG120404-DM**		●	●			▲	▲														0.4	12.7	4.76	5.16
		CNMG12040**8-DM**	●	●	●	●	▲	▲	▲	▲													0.8	12.7	4.76	5.16
		CNMG12041**2-DM**	●	●	●	●	▲	▲	▲	▲													1.2	12.7	4.76	5.16
	All-round	**CNMG090304**		●	●			▲	▲											●			0.4	9.525	3.18	3.81
		CNMG09030**8**	●	●	●	●	▲	▲	▲	▲									●	●			0.8	9.525	3.18	3.81
		CNMG120404	●	●	●	●	▲	▲	▲	▲	●	●	●	●	●	●	●			●		●	0.4	12.7	4.76	5.16
		CNMG12040**8**	●	●	●	●	▲	▲	▲	▲	●	●	●	●	●	●	●			●	●	●	0.8	12.7	4.76	5.16
		CNMG12041**2**	●	●	●	●	▲	▲	▲	▲	●	●	●	●	●	●					●	●	1.2	12.7	4.76	5.16
		CNMG12041**6**	●	●	●	●	▲	▲	▲	▲	●	●	●	●									1.6	12.7	4.76	5.16
		CNMG160608	●	●	●	●	▲	▲	▲	▲		●	●	●		●							0.8	15.875	6.35	6.35
		CNMG160612	●	●	●	●	▲	▲	▲	▲	●	●	●	●		●							1.2	15.875	6.35	6.35
		CNMG160616	●	●	●	●	▲	▲	▲	▲	●	●	●	●									1.6	15.875	6.35	6.35
		CNMG190608		●	●	●		▲	▲	▲													0.8	19.05	6.35	7.93
		CNMG190612	●	●	●	●	▲	▲	▲	▲	●	●	●	●		●							1.2	19.05	6.35	7.93
		CNMG190616		●	●	●		▲	▲	▲	●	●	●	●		●							1.6	19.05	6.35	7.93

● Lagerstandard
▲ Wird eingestellt

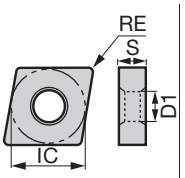
Halter / Außendrehen	→ C016 -	Halter / Innendrehen	→ D021 -
J-Serie Werkzeughalter	→ G044	TungCap	→ K008 -
PINZBOHR®	→ K180 -	Kassetten	→ K199 -

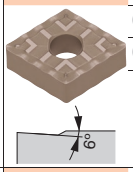
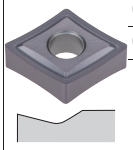
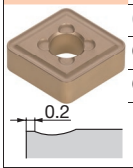
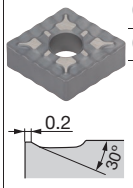
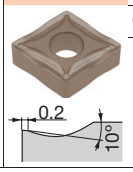
● : Kontinuierlicher Schnitt
ɔ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

CN

Rhombisch, 80° mit Loch

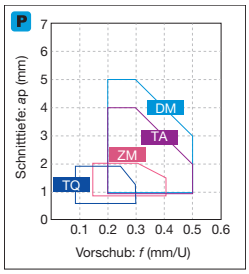
P	Stahl	●	●ɔ	●✣	✣	●ɔ	●✣	✣	●	●ɔ	ɔ			●ɔ		●ɔ				●ɔ				●							
M	Rostfreier Stahl		●ɔ						●	●ɔ	ɔ	●	ɔ	●ɔ										●							
K	Eisenguss	●ɔ	●ɔ			●ɔ			●	●ɔ	ɔ			●ɔ		●ɔ				●ɔ				●							
N	Nichteisen-metalle																							●							
S	Hitzebest. Legierungen								●	●ɔ	ɔ	●	ɔ																		
H	Gehärteter Stahl																														

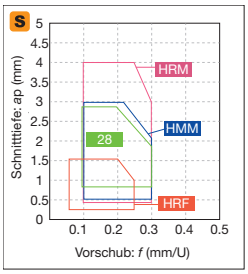


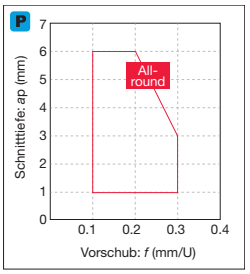
Anwendung	Spanform-stufe	Katalog Nr.	Beschichtet												Cermet besch.				Cermet				Unbe-schichtet				Größe (mm)			
			T9205	T9215	T9225	T9235	T9115	T9125	T9135	AH110	AH120	AH725	AH8005	AH8015	GH330	GT720				NS9530				TH10				RE	IC	S	D1
Schlichten bis mittl. Bearbeitung	27	**CNMG120404-27**		●	●		▲	▲												●								0.4	12.7	4.76	5.16
		CNMG120408-27		●	●	●	▲	▲	▲											●								0.8	12.7	4.76	5.16
		CNMG120412-27			●			▲																				1.2	12.7	4.76	5.16
Mittlere Bearbeitung	28	**CNMG120404-28**			●			▲		●	●		●	●														0.4	12.7	4.76	5.16
		CNMG120408-28								●	●		●	●														0.8	12.7	4.76	5.16
		CNMG120412-28											●	●														1.2	12.7	4.76	5.16
	33	**CNMG120408-33**								●						●												0.8	12.7	4.76	5.16
		CNMG120416-33		●			▲																					1.6	12.7	4.76	5.16
		CNMG160612-33		●			▲																					1.2	15.875	6.35	6.35
		CNMG190612-33		●			▲																					1.2	19.05	6.35	7.93
	37	**CNMG120404-37**		●			▲													●								0.4	12.7	4.76	5.16
		CNMG120408-37		●			▲								●					●				●				0.8	12.7	4.76	5.16
		CNMG120412-37		●			▲																					1.2	12.7	4.76	5.16
	38	**CNMG120404-38**													●													0.4	12.7	4.76	5.16
		CNMG120408-38		●			▲					●			●													0.8	12.7	4.76	5.16

● Lagerstandard
▲ Wird eingestellt

Spankontrollbereich







Halter / Außendrehen	→ C018 -	Halter / Innendrehen	→ D023 -
J-Serie Werkzeughalter	→ G044	TungCap	→ K008 -
PINZBOHR®	→ K180 -	Kassetten	→ K199 -

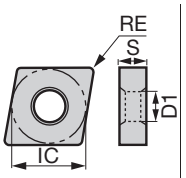
Wendeschneidplatten NEGATIV

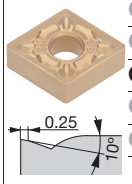
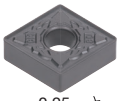
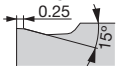
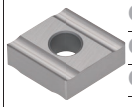
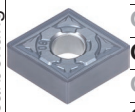
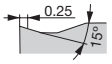
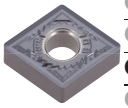
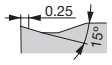
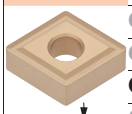
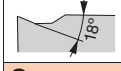
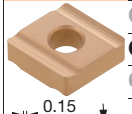
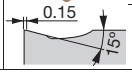
● : Kontinuierlicher Schnitt
ɔ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

CN

Rhombisch, 80° mit Loch

P	Stahl	ɔ✣ ✣ ɔ✣ ✣ ɔ ✣ ɔ✣ ✣ ● ●ɔ ɔ ● ɔ
M	Rostfreier Stahl	● ɔ ɔ ✣ ● ●ɔ ɔ ● ● ɔ ● ●ɔ ●
K	Eisenguss	● ●ɔ ●ɔ ● ɔ ✣ ɔ ● ●ɔ ●ɔ ●ɔ ● ● ɔ✣
N	Nichteisen-metalle	● ● ɔ✣
S	Hitzebest. Legierungen	● ●ɔ ● ● ɔ ɔ ● ● ● ɔ✣
H	Gehärteter Stahl	



Anwendung	Spanform-stufe	Katalog Nr.	Beschichtet T9225	T9235	T9125	T9135	T6120	T6130	AH630	AH645	AH110	AH120	T515	T5105	T5115	T5125	AH725	AH8005	AH8015	AH905	GH110	GH330	Cermet besch. GT720	Cermet NS9530	Unbeschichtet TH10	KS05F	KS20	Größe (mm) RE	IC	S	D1
Mittlere Bearbeitung	**SM**	**CNMG090404E-SM**					●	●	●																			0.4	9.525	4.76	3.81
		CNMG090408E-SM					●	●	●																			0.8	9.525	4.76	3.81
		CNMG090412E-SM					●	●	●																			1.2	9.525	4.76	3.81
		CNMG120404-SM					●	●	●	●							●											0.4	12.7	4.76	5.16
		CNMG120408-SM					●	●	●	●							●			●								0.8	12.7	4.76	5.16
		CNMG120412-SM					●	●	●	●							●											1.2	12.7	4.76	5.16
	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
		CNMG160608-CM												●	●	●												0.8	15.875	6.35	6.35
		CNMG160612-CM											●	●	●	●												1.2	15.875	6.35	6.35
	P	**CNGG120404R-P**																			●			●	●			0.4	12.7	4.76	5.16
		CNGG120404L-P																			●			●	●			0.4	12.7	4.76	5.16
		CNGG120408R-P																			●				●			0.8	12.7	4.76	5.16
		CNGG120408L-P																			●				●			0.8	12.7	4.76	5.16
Schlichten bis mittlere Bearbeitung	**HRM**	**CNMG120404-HRM**																●	●									0.4	12.7	4.76	5.16
		CNMG120408-HRM																●	●									0.8	12.7	4.76	5.16
		CNMG120412-HRM																●	●									1.2	12.7	4.76	5.16
		CNMG160608-HRM																●	●									0.8	15.875	6.35	6.35
		CNMG160612-HRM																●	●									1.2	15.875	6.35	6.35
		CNMG190612-HRM																●	●									1.2	19.05	6.35	7.93
		CNMG190616-HRM																●	●									1.6	19.05	6.35	7.93
Mittlere Bearbeitung	**HMM**	**CNMG120404-HMM**																		●								0.4	12.7	4.76	5.16
		CNMG120408-HMM																		●						●		0.8	12.7	4.76	5.16
		CNMG120412-HMM																		●								1.2	12.7	4.76	5.16
		CNMG160608-HMM																		●								0.8	15.875	6.35	6.35
		CNMG160612-HMM																		●								1.2	15.875	6.35	6.35
		CNMG160616-HMM																		●								1.6	15.875	6.35	6.35
	SA	**CNMG120404-SA**					●	●	●	●		●																0.4	12.7	4.76	5.16
		CNMG120408-SA					●	●	●	●	●	●															●	0.8	12.7	4.76	5.16
		CNMG120412-SA					●	●	●	●		●															●	1.2	12.7	4.76	5.16
		CNMG190612-SA										●															●	1.2	19.05	6.35	7.93
		CNMG190616-SA										●															●	1.6	19.05	6.35	7.93
	S	**CNMG120404R-S**	●	●	▲	▲		●	●	●												●	●		●			0.4	12.7	4.76	5.16
		CNMG120404L-S	●	●	▲	▲		●	●	●												●			●			0.4	12.7	4.76	5.16
		CNMG120408R-S	●	●	▲	▲		●	●	●												●	●		●			0.8	12.7	4.76	5.16
		CNMG120408L-S	●	●	▲	▲		●	●	●												●			●			0.8	12.7	4.76	5.16
																															

● Lagerstandard
▲ Wird eingestellt

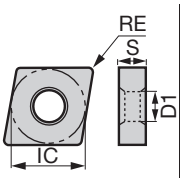
Halter / Außendrehen	→ C016 -	Halter / Innendrehen	→ D021 -
J-Serie Werkzeughalter	→ G044	TungCap	→ K008 -
PINZBOHR®	→ K180 -	Kassetten	→ K199 -

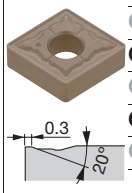
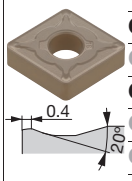
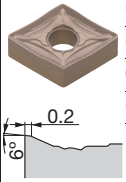
● : Kontinuierlicher Schnitt
ɔ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

CN

Rhombisch, 80° mit Loch

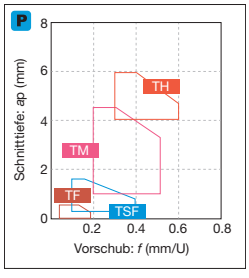
P	Stahl	● ɔ ✣ ✣ ● ɔ ✣ ✣ ɔ
M	Rostfreier Stahl	ɔ ɔ ɔ
K	Eisenguss	ɔ ɔ ɔ ɔ ɔ
N	Nichteisenmetalle	
S	Hitzebest. Legierungen	ɔ
H	Gehärteter Stahl	

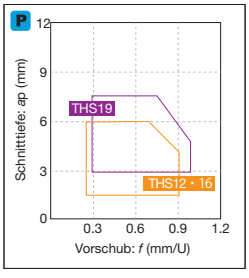


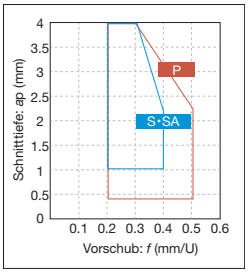
Anwendung	Spanformstufe	Katalog Nr.	Beschichtet T9205	T9215	T9225	T9235	T9105	T9115	T9125	T9135	T6130	AH120	Größe (mm) RE	IC	S	D1
Mittlere Bearbeitung bis Schwerzerspanung	**TH**	**CNMG120408-TH**	●	●	●	●	▲	▲	▲	▲	●	●	0.8	12.7	4.76	5.16
		**CNMG12012-TH**	●	●	●	●	▲	▲	▲	▲	●	●	1.2	12.7	4.76	5.16
		CNMG12016-TH	●	●	●	●	▲	▲	▲	▲			1.6	12.7	4.76	5.16
		CNMG160612-TH	●	●	●	●	▲	▲	▲	▲		●	1.2	15.875	6.35	6.35
		CNMG16016-TH	●	●	●	●	▲	▲	▲	▲		●	1.6	15.875	6.35	6.35
		CNMG190612-TH	●	●	●	●	▲	▲	▲	▲		●	1.2	19.05	6.35	7.93
		CNMG19016-TH	●	●	●	●	▲	▲	▲	▲		●	1.6	19.05	6.35	7.93
	THS	**CNMG120408-THS**	●	●	●	●	▲	▲	▲	▲			0.8	12.7	4.76	5.16
		CNMG12012-THS	●	●	●	●	▲	▲	▲	▲			1.2	12.7	4.76	5.16
		**CNMG12016-THS**	●	●	●	●	▲	▲	▲	▲			1.6	12.7	4.76	5.16
		CNMG160612-THS	●	●	●	●	▲	▲	▲	▲			1.2	15.875	6.35	6.35
		CNMG16016-THS	●	●	●	●	▲	▲	▲	▲			1.6	15.875	6.35	6.35
		CNMG190612-THS		●	●	●		▲	▲	▲			1.2	19.05	6.35	7.93
		CNMG19016-THS		●	●	●		▲	▲	▲			1.6	19.05	6.35	7.93
		CNMG19024-THS		●	●	●		▲	▲	▲			2.4	19.05	6.35	7.93
		CNMG250924-THS		●	●	●		▲	▲	▲			2.4	25.4	9.52	9.12
Mittl. Bearb. bis Schwerzerspanung (einseitig)	**57**	**CNMM120404-57**			●				▲				0.4	12.7	4.76	5.16
		**CNMM12040 8-57**		●	●			▲	▲				0.8	12.7	4.76	5.16
		CNMM12041 2-57			●				▲				1.2	12.7	4.76	5.16
		CNMM190612-57			●				▲				1.2	12.7	4.76	5.16
		CNMM19061 6-57			●				▲				1.6	12.7	4.76	5.16

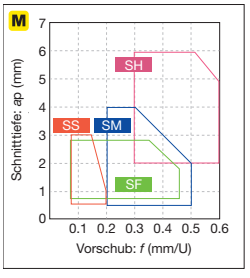
● Lagerstandard
▲ Wird eingestellt

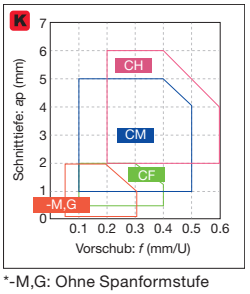
Spankontrollbereich



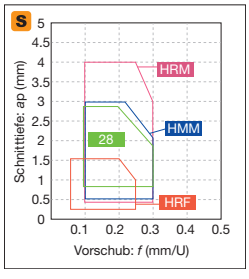








*-M,G: Ohne Spanformstufe

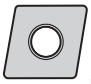


Halter / Außendrehen	→ C018 -	Halter / Innendrehen	→ D023 -
J-Serie Werkzeughalter	→ G044	TungCap	→ K008 -
PINZBOHR®	→ K180 -	Kassetten	→ K199 -

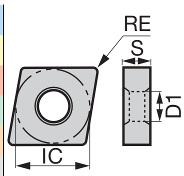
Wendeschneidplatten NEGATIV

● : Kontinuierlicher Schnitt
◐ : Leicht unterbrochener Schnitt
✠ : Stark unterbrochener Schnitt

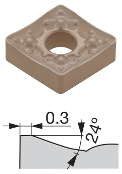
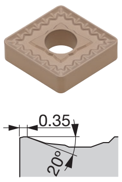
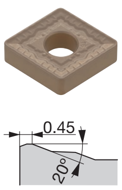
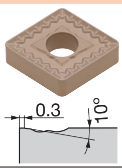
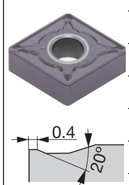
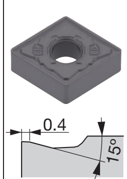
CN



Rhombisch, 80° mit Loch



	T9205	T9215	T9225	T9235	T9115	T9125	T9135	T6130	AH630	AH645	T515	T5105	T5115	T5125
P Stahl	●	●◐	◐✠	✠	●◐	◐✠	✠	✠	◐✠	✠				
M Rostfreier Stahl		●◐						◐	◐	✠				
K Eisenguss	●◐	●◐			●◐						●◐	●	◐	✠
N Nichteisen-metalle														
S Hitzebest. Legierungen														
H Gehärteter Stahl														

Anwendung	Spanform-stufe	Katalog Nr.	T9205	T9215	T9225	T9235	T9115	T9125	T9135	T6130	AH630	AH645	T515	T5105	T5115	T5125	RE	IC	S	D1
			Beschichtet														Größe (mm)			
Mittl. Bearbeitung bis Schwer-zerspanung (einseitig)	TRS	CNMM120408-TRS		●	●	●	▲	▲	▲								0.8	12.7	4.76	5.16
		CNMM120412-TRS		●	●	●	▲	▲	▲								1.2	12.7	4.76	5.16
		CNMM160612-TRS		●	●	●	▲	▲	▲								1.2	15.875	6.35	6.35
		CNMM160616-TRS		●	●	●	▲	▲	▲								1.6	15.875	6.35	6.35
		CNMM190616-TRS		●	●	●	▲	▲	▲								1.6	19.05	6.35	7.93
		CNMM190624-TRS		●	●	●	▲	▲	▲								2.4	19.05	6.35	7.93
		CNMM250924-TRS		●	●	●	▲	▲	▲								2.4	25.4	9.52	9.12
Schwerzerspanung (einseitig)	TU	CNMM190612-TU			●	●		▲	▲								1.2	19.05	6.35	7.93
		CNMM190616-TU			●	●		▲	▲								1.6	19.05	6.35	7.93
		CNMM190624-TU		●	●	●	▲	▲	▲								2.4	19.05	6.35	7.93
		CNMM250924-TU			●	●		▲	▲								2.4	25.4	9.52	9.12
	TUS	CNMM190608-TUS		●	●		▲	▲									0.8	19.05	6.35	7.93
		CNMM190612-TUS		●	●	●	▲	▲	▲								1.2	19.05	6.35	7.93
		CNMM190616-TUS		●	●	●	▲	▲	▲								1.6	19.05	6.35	7.93
		CNMM190624-TUS		●	●	●	▲	▲	▲								2.4	19.05	6.35	7.93
		CNMM190632-TUS		●	●		▲	▲									3.2	19.05	6.35	7.93
		CNMM250916-TUS		●	●	●	▲	▲	▲								1.6	25.4	9.52	9.12
		CNMM250924-TUS		●	●	●	▲	▲	▲								2.4	25.4	9.52	9.12
		CNMM250932-TUS		●	●		▲	▲									3.2	25.4	9.52	9.12
Mittl. Bearb. bis Schwer-zerspanung (einseitig)	65 	CNMM120412-65			●			▲									1.2	12.7	4.76	5.16
Mittlere Bearbeitung bis Schwerzerspanung	SH	CNMG120408-SH								●	●	●					0.8	12.7	4.76	5.16
		CNMG120412-SH								●	●	●					1.2	12.7	4.76	5.16
		CNMG120416-SH								●	●	●					1.6	12.7	4.76	5.16
		CNMG160612-SH								●	●	●					1.2	15.875	6.35	6.35
		CNMG160616-SH								●	●	●					1.6	15.875	6.35	6.35
		CNMG190612-SH								●	●	●					1.2	19.05	6.35	7.93
		CNMG190616-SH								●	●	●					1.6	19.05	6.35	7.93
	CH	CNMG120404-CH												●	●	●	0.4	12.7	4.76	5.16
		CNMG120408-CH											●	●	●	●	0.8	12.7	4.76	5.16
		CNMG120412-CH											●	●	●	●	1.2	12.7	4.76	5.16
		CNMG160612-CH												●	●	●	1.2	15.875	6.35	6.35
		CNMG160616-CH												●	●	●	1.6	15.875	6.35	6.35
		CNMG190612-CH												●	●	●	1.2	19.05	6.35	7.93
		CNMG190616-CH												●	●	●	1.6	19.05	6.35	7.93

● Lagerstandard
▲ Wird eingestellt

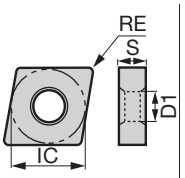
Halter / Außendrehen → C018 -
J-Serie Werkzeughalter → G044
PINZBOHR® → K180 -
Halter / Innendrehen → D023 -
TungCap → K008 -
Kassetten → K199 -

● : Kontinuierlicher Schnitt
ⓒ : Leicht unterbrochener Schnitt
✠ : Stark unterbrochener Schnitt

CN

Rhombisch, 80° mit Loch

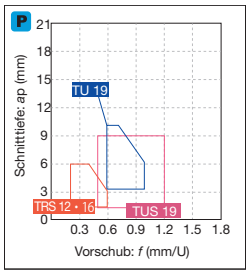
P	Stahl	●	●									●ⓒ				●													
M	Rostfreier Stahl															●													
K	Eisenguss	●ⓒ	●ⓒ	●ⓒ	●	ⓒ	✠					●ⓒ				●					●ⓒ	●							
N	Nichteisen-metalle															●													
S	Hitzebest. Legierungen																												
H	Gehärteter Stahl																					●							

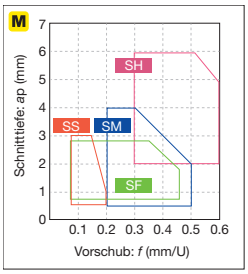


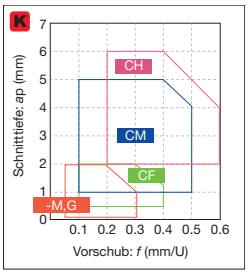
Anwendung	Spanform-stufe	Katalog Nr.	Beschichtet							Cermet			Unbeschichtet			Keramik				Größe (mm)			
			T9205	T9105	T515	T5105	T5115	T5125		NS520			TH10			FX105	LX21	LX11			RE	IC	S	D1
Schlichten bis mittlere Bearbeitung	-	CNMA090404E			●																0.4	9.525	4.76	3.81
		CNMA090408E			●																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
		CNMA120404				●	●	●					●								0.4	12.7	4.76	5.16
		CNMA120408	●	▲	●	●	●	●		●			●			●					0.8	12.7	4.76	5.16
		CNMA120412	●	▲	●	●	●	●					●			●					1.2	12.7	4.76	5.16
		CNMA120416	●	▲		●	●	●					●			●					1.6	12.7	4.76	5.16
		CNMA160608				●	●	●													0.8	15.875	6.35	6.35
		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
	Wiper	CNMA120408W														●					0.8	12.7	4.76	5.16
		CNMA120412W														●		●			1.2	12.7	4.76	5.16
		CNMA120416W														●					1.6	12.7	4.76	5.16
	-	CNGA120404															●	●			0.4	12.7	4.76	5.16
		CNGA120408								●						●	●	●			0.8	12.7	4.76	5.16
		CNGA120412														●	●	●			1.2	12.7	4.76	5.16
		CNGA120416														●		●			1.6	12.7	4.76	5.16
		CNGA120420																●			2	12.7	4.76	5.16

● Lagerstandard
▲ Wird eingestellt

Spankontrollbereich







*-M,G: Ohne Spanformstufe

Halter / Außendrehen	→ C018 -	Halter / Innendrehen	→ D021 -
J-Serie Werkzeughalter	→ G044	TungCap	→ K008 -
PINZBOHR®	→ K180 -	Kassetten	→ K199 -

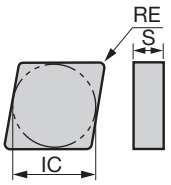
Wendeschneidplatten NEGATIV

● : Kontinuierlicher Schnitt
c : Leicht unterbrochener Schnitt
✠ : Stark unterbrochener Schnitt

CN

Rhombisch, 80°
ohne Loch

P	Stahl	
M	Rostfreier Stahl	
K	Eisenguss	●c ● ●c
N	Nichteisen-metalle	
S	Hitzebest. Legierungen	
H	Gehärteter Stahl	●



Anwendung	Spanform-stufe	Katalog Nr.	Keramik FX105	LX21	LX11	CX710	Größe (mm) RE	IC	S	D1
Schlichten bis mittlere Bearbeitung	-	**CNGD120712**	●				1.2	12.7	7.94	-
		CNGD120716	●				1.6	12.7	7.94	-
	-	**CNMN120408**	●				0.8	12.7	4.76	-
		CNMN120412	●				1.2	12.7	4.76	-
	-	**CNGN120404**			●		0.4	12.7	4.76	-
		CNGN120408	●		●		0.8	12.7	4.76	-
		CNGN120412	●		●	●	1.2	12.7	4.76	-
		CNGN120416	●	●	●		1.6	12.7	4.76	-
		CNGN120420	●				2	12.7	4.76	-
		CNGN120708	●		●		0.8	12.7	7.94	-
		CNGN120712	●		●		1.2	12.7	7.94	-
		CNGN120716	●		●		1.6	12.7	7.94	-
		CNGN120720			●		2	12.7	7.94	-

● Lagerstandard

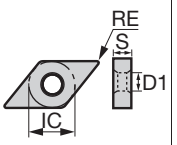
CNGD...: Halter / Außendrehen → C022

● : Kontinuierlicher Schnitt
◐ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

DN

Rhombisch, 55° mit Loch

P	Stahl	●	◐	◐	✣	✣	●	◐	◐	✣	✣	◐	●		◐	◐	◐		◐	◐				●								
M	Rostfreier Stahl		◐									◐	●											●								
K	Eisenguss	◐	◐				◐	◐				◐	●		◐	◐	◐		◐	◐				●								
N	Nichteisen-metalle																							●								
S	Hitzebest. Legierungen											◐	●																			
H	Gehärteter Stahl																															

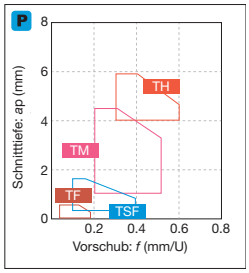


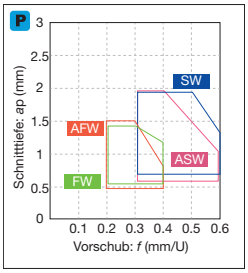
Anwendung	Spanform-stufe	Katalog Nr.	Beschichtet										Cermet besch.			Cermet		Unbeschichtet			Größe (mm)			
			T9205	T9215	T9225	T9235	T9105	T9115	T9125	T9135	AH120	GH110	GT9530	AT9530	GT720	NS9530	NS520	TH10			RE	IC	S	D1
Feinschlichten	TF	DNMG150404-TF														●		●			0.4	12.7	4.76	5.16
		DNMG150408-TF														●					0.8	12.7	4.76	5.16
	01	DNGG110402-01														●					0.2	9.525	4.76	3.81
		DNGG110404-01														●	●				0.4	9.525	4.76	3.81
		DNGG110408-01													●	●					0.8	9.525	4.76	3.81
		DNGG150402-01														●	●	●			0.2	12.7	4.76	5.16
		DNGG150404-01										●				●	●	●			0.4	12.7	4.76	5.16
		DNGG150408-01										●				●	●	●			0.8	12.7	4.76	5.16
Schlichten	TSF	DNMG110404E-TSF		●	●			▲	▲				●	●		●					0.4	9.525	4.76	3.81
		DNMG110408E-TSF		●	●			▲	▲				●	●		●					0.8	9.525	4.76	3.81
		DNMG110412E-TSF		●	●			▲	▲				●	●		●					1.2	9.525	4.76	3.81
		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
		DNMG150604-TSF		●	●			▲	▲				●	●		●					0.4	12.7	6.35	5.16
		DNMG150608-TSF	●	●	●	●	▲	▲	▲	▲			●	●		●					0.8	12.7	6.35	5.16
		DNMG150612-TSF	●	●	●	●	▲	▲	▲	▲											1.2	12.7	6.35	5.16
Schlichten (Wiper)	FW	DNMG110404E-FW		●				▲													0.4	9.525	4.76	3.81
		DNMG110408E-FW		●				▲													0.8	9.525	4.76	3.81
		DNMG150404-FW		●				▲													0.4	12.7	4.76	5.16
		DNMG150408-FW		●				▲													0.8	12.7	4.76	5.16
		DNMG150604-FW		●				▲													0.4	12.7	6.35	5.16
		DNMG150608-FW		●				▲													0.8	12.7	6.35	5.16
		*Wiper																						

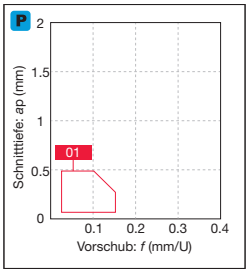
* Siehe Seiten **L032-L036** bezüglich der Anpassung des Bearbeitungsprogramms für die Konturbearbeitung mittels SW/FW.
Bei Fragen wenden Sie sich bitte an unsere Vertriebsmitarbeiter.

● Lagerstandard
▲ Wird eingestellt

Spankontrollbereich







Halter / Außendrehen	→ C037 -	Halter / Innendrehen	→ D052 -
J-Serie Werkzeughalter	→ G046	TungCap	→ C045, K012 -

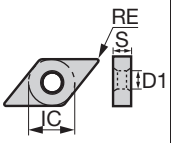
Wendeschneidplatten NEGATIV

● : Kontinuierlicher Schnitt
ɔ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

DN

Rhombisch, 55° mit Loch

		T9205	T9215	T9225	T9235	T9115	T9125	T9135	T6120	T6130	AH630	T5105	T5115	AH8005	AH8015	GH330	GT9530	AT9530	NS9530	NS520	TH10
P	Stahl	●	●ɔ	ɔ✣	✣	●ɔ	ɔ✣	✣	ɔ	✣	ɔ✣					●ɔ	●ɔ	●ɔ	●ɔ	●ɔ	●
M	Rostfreier Stahl		●ɔ						●	ɔ	ɔ			●	ɔ	●ɔ					●
K	Eisenguss	●ɔ	●ɔ			●ɔ						●	ɔ			●ɔ	●ɔ	●ɔ	●ɔ	●ɔ	●
N	Nichteisenmetalle																				●
S	Hitzebest. Legierungen													●	ɔ						
H	Gehärteter Stahl																				



Anwendung	Spanformstufe	Katalog Nr.	RE	IC	S	D1
Schlichten	ZF	DNMG110404E-ZF	0.4	9.525	4.76	3.81
		DNMG150404-ZF	0.4	12.7	4.76	5.16
		DNMG150408-ZF	0.8	12.7	4.76	5.16
		DNMG150412-ZF	1.2	12.7	4.76	5.16
		DNMG150604-ZF	0.4	12.7	6.35	5.16
		DNMG150608-ZF	0.8	12.7	6.35	5.16
		DNMG150612-ZF	1.2	12.7	6.35	5.16
Schlichten	11	DNMG110404-11	0.4	9.525	4.76	3.81
		DNMG110408-11	0.8	9.525	4.76	3.81
		DNMG150404-11	0.4	12.7	4.76	5.16
		DNMG150408-11	0.8	12.7	4.76	5.16
Schlichten (Baustahl)	17	DNMG150404-17	0.4	12.7	4.76	5.16
		DNMG150408-17	0.8	12.7	4.76	5.16
Schlichten	SF	DNMG150404-SF	0.4	12.7	4.76	5.16
		DNMG150408-SF	0.8	12.7	4.76	5.16
		DNMG150604-SF	0.4	12.7	6.35	5.16
		DNMG150608-SF	0.8	12.7	6.35	5.16
	CF	DNMG150404-CF	0.4	12.7	4.76	5.16
		DNMG150408-CF	0.8	12.7	4.76	5.16
		DNMG150412-CF	1.2	12.7	4.76	5.16
		DNMG150604-CF	0.4	12.7	6.35	5.16
		DNMG150608-CF	0.8	12.7	6.35	5.16
		DNMG150612-CF	1.2	12.7	6.35	5.16
	HRF	DNMG150404-HRF	0.4	12.7	4.76	5.16
		DNMG150408-HRF	0.8	12.7	4.76	5.16
		DNMG150604-HRF	0.4	12.7	6.35	5.16
		DNMG150608-HRF	0.8	12.7	6.35	5.16

● Lagerstandard
▲ Wird eingestellt

Halter / Außendrehen → C037 -
J-Serie Werkzeughalter → G046
Halter / Innendrehen → D052 -
TungCap → C045, K012 -

● : Kontinuierlicher Schnitt
ɔ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

DN

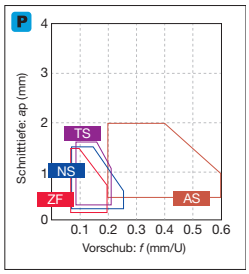
Rhombisch, 55° mit Loch

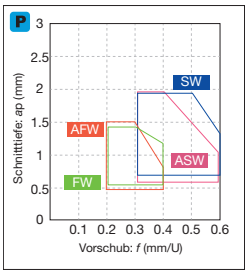
		Beschichtet								Cermet besch.		Cermet			Größe (mm)			
Anwendung	Spanform-stufe	Katalog Nr.	T9205	T9215	T9225	T9235	T9105	T9115	T9125	T9135	GT9530	AT9530	NS9530	NS520		RE	IC	S	D1
Schlichten	TS	DNMG150404-TS		●	●	●		▲	▲	▲	●	●	●	●		0.4	12.7	4.76	5.16
		DNMG150408-TS	●	●	●	●	▲	▲	▲	▲	●	●	●	●		0.8	12.7	4.76	5.16
		DNMG150412-TS	●	●	●	●	▲	▲	▲	▲						1.2	12.7	4.76	5.16
		DNMG150604-TS									●	●	●	●		0.4	12.7	6.35	5.16
		DNMG150608-TS		●	●			▲	▲		●	●	●	●		0.8	12.7	6.35	5.16
		DNMG150612-TS		●	●			▲	▲							1.2	12.7	6.35	5.16
Schlichten bis mittlere Bearbeitung (Wiper)	SW	DNMG110408E-SW		●				▲								0.8	9.525	4.76	3.81
		DNMG110412E-SW		●				▲								1.2	9.525	4.76	3.81
		DNMG150408-SW		●				▲								0.8	12.7	4.76	5.16
		DNMG150412-SW		●				▲								1.2	12.7	4.76	5.16
		DNMG150608-SW		●				▲								0.8	12.7	6.35	5.16
		DNMG150612-SW		●				▲								1.2	12.7	6.35	5.16
		*Wiper																	
Hoher Vorschub, geringe Schnitttiefe	AS	DNMG150404-AS		●		●		▲		▲			●			0.4	12.7	4.76	5.16
		DNMG150408-AS		●	●	●		▲	▲	▲			●			0.8	12.7	4.76	5.16
		DNMG150412-AS		●	●	●		▲	▲	▲						1.2	12.7	4.76	5.16
		DNMG150604-AS		●				▲								0.4	12.7	6.35	5.16
		DNMG150608-AS		●	●			▲	▲							0.8	12.7	6.35	5.16
		DNMG150612-AS		●				▲								1.2	12.7	6.35	5.16
Innendrehen (doppelseitig)	CB	DNMG110404-CB									●		●			0.4	9.525	4.76	3.81
		DNMG110408-CB		●				▲			●		●			0.8	9.525	4.76	3.81
Schlichten	NS	DNMG150404-NS			●				▲				●			0.4	12.7	4.76	5.16
		DNMG150408-NS	●	●	●		▲	▲	▲				●			0.8	12.7	4.76	5.16

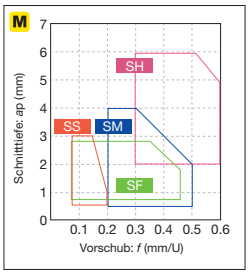
* Siehe Seiten **L032-L036** bezüglich der Anpassung des Bearbeitungsprogramms für die Konturbearbeitung mittels SW/FW.
Bei Fragen wenden Sie sich bitte an unsere Vertriebsmitarbeiter.

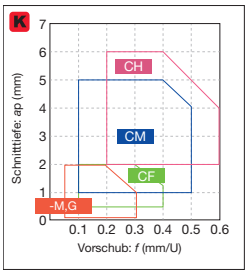
● Lagerstandard
▲ Wird eingestellt

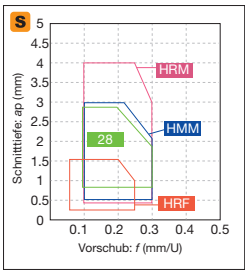
Spankontrollbereich











*-M,G: Ohne Spanformstufe

Halter / Außendrehen	→ C037 -	Halter / Innendrehen	→ D052 -
J-Serie Werkzeughalter	→ G046	TungCap	→ C045, K012 -

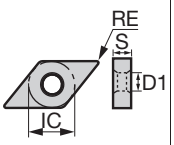
Wendeschneidplatten NEGATIV

● : Kontinuierlicher Schnitt
c : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

DN

Rhombisch, 55° mit Loch

		T9205	T9215	T9225	T9235	T9105	T9115	T9125	T9135	T6120	T6130	AH630	AH645	AH110	AH120	GH330	GT9530	NS9530	KS20
P	Stahl	●	●c	c✣	✣	●	●c	c✣	✣	c	✣	c✣	✣	●	●c	●c	●c	●c	
M	Rostfreier Stahl		●c				●	c		●	c	c	✣	●	●c	●c			
K	Eisenguss	●c	●c			●c	●c							●	●c	●c	●c	●c	c✣
N	Nichteisenmetalle																		c✣
S	Hitzebest. Legierungen													●	●c				c✣
H	Gehärteter Stahl																		



Anwendung	Spanformstufe	Katalog Nr.	RE	IC	S	D1
Schlichten	SS	DNMG110404E-SS	0.4	9.525	4.76	3.81
		DNMG110408E-SS	0.8	9.525	4.76	3.81
		DNMG150404-SS	0.4	12.7	4.76	5.16
		DNMG150408-SS	0.8	12.7	4.76	5.16
		DNMG150412-SS	1.2	12.7	4.76	5.16
		DNMG150604-SS	0.4	12.7	6.35	5.16
		DNMG150608-SS	0.8	12.7	6.35	5.16
		DNMG150612-SS	1.2	12.7	6.35	5.16
Mittlere Bearbeitung	TM	DNMG110404E-TM	0.4	9.525	4.76	3.81
		DNMG110408E-TM	0.8	9.525	4.76	3.81
		DNMG110412E-TM	1.2	9.525	4.76	3.81
		DNMG110404-TM	0.4	9.525	4.76	3.81
		DNMG110408-TM	0.8	9.525	4.76	3.81
		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
		DNMG150604-TM	0.4	12.7	6.35	5.16
		DNMG150608-TM	0.8	12.7	6.35	5.16
		DNMG150612-TM	1.2	12.7	6.35	5.16
		DNMG150616-TM	1.6	12.7	6.35	5.16
Schlichten bis mittlere Bearbeitung	AM	DNMG150408-AM	0.8	12.7	4.76	5.16
		DNMG150412-AM	1.2	12.7	4.76	5.16
		DNMG150416-AM	1.6	12.7	4.76	5.16
		DNMG150608-AM	0.8	12.7	6.35	5.16
		DNMG150612-AM	1.2	12.7	6.35	5.16
		DNMG150616-AM	1.6	12.7	6.35	5.16
	NM	DNMG150408-NM	0.8	12.7	4.76	5.16
		DNMG150412-NM	1.2	12.7	4.76	5.16
		DNMG150608-NM	0.8	12.7	6.35	5.16

● Lagerstandard
▲ Wird eingestellt

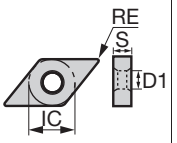
Halter / Außendrehen → C037 -
J-Serie Werkzeughalter → G046
-
Halter / Innendrehen → D052 -
TungCap → C045, K012

● : Kontinuierlicher Schnitt
ɔ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

DN

Rhombisch, 55° mit Loch

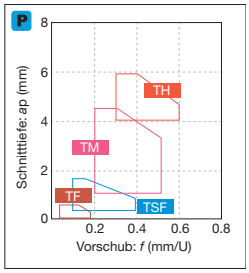
P	Stahl	● ɔ ✣ ✣ ● ɔ ✣ ✣ ● ɔ ✣ ✣
M	Rostfreier Stahl	ɔ ● ɔ ● ɔ
K	Eisenguss	ɔ ɔ ɔ ɔ ɔ ● ɔ ✣ ● ɔ ✣ ✣ ● ɔ ✣ ✣ ●
N	Nichteisenmetalle	●
S	Hitzebest. Legierungen	● ɔ
H	Gehärteter Stahl	

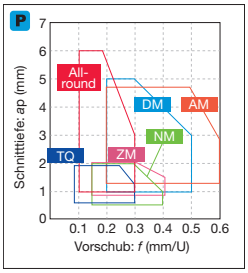


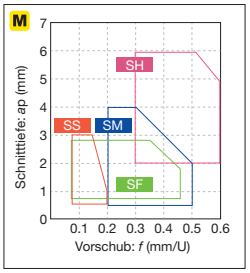
Anwendung	Spanformstufe	Katalog Nr.	Beschichtet														Cermet besch.		Cermet		Unbeschichtet	Größe (mm)			
			T9205	T9215	T9225	T9235	T9105	T9115	T9125	T9135	T515	T5105	T5115	T5125	AH110	AH120	GT9530	AT9530	NS9530	NS520	TH10	RE	IC	S	D1
Schlichten bis mittlere Bearbeitung	**TQ**	**DNMG150404-TQ**			●												●	●	●			0.4	12.7	4.76	5.16
		DNMG150408-TQ			●												●	●	●			0.8	12.7	4.76	5.16
	ZM	**DNMG110408E-ZM**		●	●			▲	▲													0.8	9.525	4.76	3.81
		DNMG150408-ZM		●	●	●		▲	▲	▲							●		●			0.8	12.7	4.76	5.16
		DNMG150412-ZM		●	●	●		▲	▲	▲												1.2	12.7	4.76	5.16
		DNMG150608-ZM		●	●	●		▲	▲	▲												0.8	12.7	6.35	5.16
		DNMG150612-ZM		●	●			▲	▲													1.2	12.7	6.35	5.16
Mittlere Bearbeitung	**DM**	**DNMG150408-DM**		●	●	●		▲	▲	▲												0.8	12.7	4.76	5.16
		DNMG150412-DM	●	●	●	●	▲	▲	▲	▲												1.2	12.7	4.76	5.16
		DNMG150604-DM		●				▲														0.4	12.7	6.35	5.16
		DNMG150608-DM		●	●	●		▲	▲	▲												0.8	12.7	6.35	5.16
		DNMG150612-DM	●	●	●	●	▲	▲	▲	▲												1.2	12.7	6.35	5.16
		DNMG150616-DM	●				▲															1.6	12.7	6.35	5.16
	All-round	**DNMG110404**		●	●			▲	▲			●	●	●			●		●			0.4	9.525	4.76	3.81
		DNMG110408	●	●	●	●	▲	▲	▲	▲		●	●	●			●		●			0.8	9.525	4.76	3.81
		DNMG150404		●	●	●		▲	▲	▲		●	●	●	●	●	●		●	●	●	0.4	12.7	4.76	5.16
		DNMG150408	●	●	●	●	▲	▲	▲	▲	●	●	●	●	●	●	●		●	●	●	0.8	12.7	4.76	5.16
		DNMG150412	●	●	●	●	▲	▲	▲	▲	●	●	●	●	●	●			●	●	●	1.2	12.7	4.76	5.16
		DNMG150416		●	●			▲	▲			●	●	●								1.6	12.7	4.76	5.16
		DNMG150604		●	●			▲	▲			●	●	●							●	0.4	12.7	6.35	5.16
		DNMG150608	●	●	●	●	▲	▲	▲	▲	●	●	●	●							●	0.8	12.7	6.35	5.16
		DNMG150612	●	●	●	●	▲	▲	▲	▲	●	●	●	●							●	1.2	12.7	6.35	5.16
		DNMG150616		●	●			▲	▲													1.6	12.7	6.35	5.16
Schlichten bis mittl. Bearbeitung	**27**	**DNMG150404-27**			●				▲										●			0.4	12.7	4.76	5.16
		DNMG150408-27		●	●			▲	▲										●			0.8	12.7	4.76	5.16
		DNMG150412-27			●				▲													1.2	12.7	4.76	5.16

● Lagerstandard
▲ Wird eingestellt

Spankontrollbereich







Halter / Außendrehen	→ C037 -	Halter / Innendrehen	→ D052 -
J-Serie Werkzeughalter	→ G046	TungCap	→ C045, K012 -

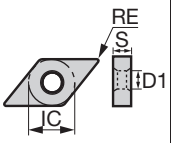
Wendeschneidplatten NEGATIV

● : Kontinuierlicher Schnitt
c : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

DN

Rhombisch, 55°
mit Loch

		T9215	T9115	T6120	T6130	T515	T5105	T5115	T5125	AH630	AH645	AH8005	AH8015	AH110	AH120	GH330	GT9530	NS9530	TH10
P	Stahl	●c	●c	c	✣					c✣	✣			●	●c	●c	●c		●
M	Rostfreier Stahl	●c		●	c					c	✣	●	c	●	●c	●c			●
K	Eisenguss	●c	●c			●c	●	c	✣					●	●c	●c	●c	●c	●
N	Nichteisen-metalle																		●
S	Hitzebest. Legierungen											●	c	●	●c				
H	Gehärteter Stahl																		



Anwendung	Spanform-stufe	Katalog Nr.	RE	IC	S	D1
Mittlere Bearbeitung	28	DNMG150404-28	0.4	12.7	4.76	5.16
		DNMG150408-28	0.8	12.7	4.76	5.16
		DNMG150604-28	0.4	12.7	6.35	5.16
		DNMG150608-28	0.8	12.7	6.35	5.16
	33	DNMG150404-33	0.4	12.7	4.76	5.16
		DNMG150408-33	0.8	12.7	4.76	5.16
	37	DNMG150404-37	0.4	12.7	4.76	5.16
		DNMG150408-37	0.8	12.7	4.76	5.16
		DNMG150608-37	0.8	12.7	6.35	5.16
	38	DNMG150412-38	1.2	12.7	4.76	5.16
	Parallel	DNGG150404R	0.4	12.7	4.76	5.16
		DNGG150404L	0.4	12.7	4.76	5.16
		DNGG150408R	0.8	12.7	4.76	5.16
		DNGG150408L	0.8	12.7	4.76	5.16
	SM	DNMG110404E-SM	0.4	9.525	4.76	3.81
		DNMG110408E-SM	0.8	9.525	4.76	3.81
		DNMG150404-SM	0.4	12.7	4.76	5.16
		DNMG150408-SM	0.8	12.7	4.76	5.16
		DNMG150412-SM	1.2	12.7	4.76	5.16
		DNMG150604-SM	0.4	12.7	6.35	5.16
		DNMG150608-SM	0.8	12.7	6.35	5.16
		DNMG150612-SM	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
		DNMG150604-CM	0.4	12.7	6.35	5.16
		DNMG150608-CM	0.8	12.7	6.35	5.16
		DNMG150612-CM	1.2	12.7	6.35	5.16

● Lagerstandard
▲ Wird eingestellt

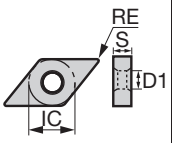
Halter / Außendrehen → C037 -
J-Serie Werkzeughalter → G046
Halter / Innendrehen → D052 -
TungCap → C045, K012 -

● : Kontinuierlicher Schnitt
ɔ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

DN

Rhombisch, 55° mit Loch

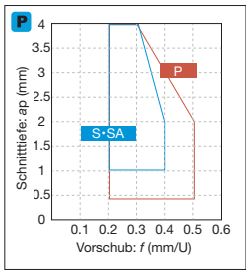
		T9225	T9235	T9125	T9135	T6130	AH630	AH645	AH120	AH8005	AH8015	AH905	GH110	GH330	NS9530	TH10
P	Stahl	ɔ✣	✣	ɔ✣	✣	✣	ɔ✣	✣	●ɔ				●	●ɔ	●ɔ	●
M	Rostfreier Stahl					ɔ	ɔ	✣	●ɔ	●	ɔ		●	●ɔ		●
K	Eisenguss								●ɔ				●	●ɔ	●ɔ	●
N	Nichteisenmetalle															●
S	Hitzebest. Legierungen								●ɔ	●	ɔ	ɔ	●			
H	Gehärteter Stahl															

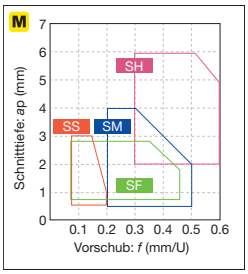


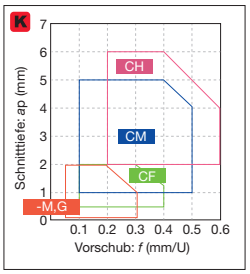
Anwendung	Spanformstufe	Katalog Nr.	RE	IC	S	D1
Mittlere Bearbeitung	P	DNGG150402R-P	0.2	12.7	4.76	5.16
		DNGG150402L-P	0.2	12.7	4.76	5.16
		DNGG150404R-P	0.4	12.7	4.76	5.16
		DNGG150404L-P	0.4	12.7	4.76	5.16
		DNGG150408R-P	0.8	12.7	4.76	5.16
		DNGG150408L-P	0.8	12.7	4.76	5.16
Schlichten bis mittlere Bearbeitung	HRM	DNMG150404-HRM	0.4	12.7	4.76	5.16
		DNMG150408-HRM	0.8	12.7	4.76	5.16
		DNMG150412-HRM	1.2	12.7	4.76	5.16
		DNMG150604-HRM	0.4	12.7	6.35	5.16
		DNMG150608-HRM	0.8	12.7	6.35	5.16
		DNMG150612-HRM	1.2	12.7	6.35	5.16
Mittlere Bearbeitung	HMM	DNMG150404-HMM	0.4	12.7	4.76	5.16
		DNMG150408-HMM	0.8	12.7	4.76	5.16
		DNMG150412-HMM	1.2	12.7	4.76	5.16
	SA	DNMG150404-SA	0.4	12.7	4.76	5.16
		DNMG150408-SA	0.8	12.7	4.76	5.16
		DNMG150604-SA	0.4	12.7	6.35	5.16
		DNMG150608-SA	0.8	12.7	6.35	5.16
	S	DNMG150404R-S	0.4	12.7	4.76	5.16
		DNMG150404L-S	0.4	12.7	4.76	5.16
		DNMG150408R-S	0.8	12.7	4.76	5.16
		DNMG150408L-S	0.8	12.7	4.76	5.16
		DNMG150604R-S	0.4	12.7	6.35	5.16
		DNMG150604L-S	0.4	12.7	6.35	5.16
		DNMG150608R-S	0.8	12.7	6.35	5.16
		DNMG150608L-S	0.8	12.7	6.35	5.16

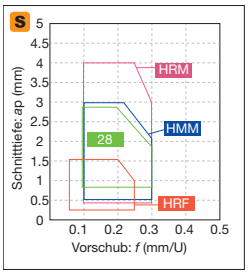
● Lagerstandard
▲ Wird eingestellt

Spankontrollbereich









*-M,G: Ohne Spanformstufe

Halter / Außendrehen	→ C042 -	Halter / Innendrehen	→ D052 -
J-Serie Werkzeughalter	→ G046	TungCap	→ C045, K012 -

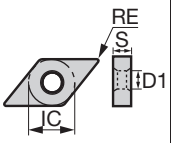
Wendeschneidplatten NEGATIV

● : Kontinuierlicher Schnitt
c : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

DN

Rhombisch, 55° mit Loch

		T9205	T9215	T9225	T9235	T9115	T9125	T9135	T6130	AH630	AH645	T515	T5105	T5115	T5125	AH120	GT720	NS520	TH10
P	Stahl	●	●c	●✣	✣	●c	c✣	✣	✣	c✣	✣					●c	●c		●c	●
M	Rostfreier Stahl		●c						c	c	✣					●c				●
K	Eisenguss	●c	●c			●c						●c	●	c	✣	●c	●c		●c	●
N	Nichteisenmetalle																			●
S	Hitzebest. Legierungen															●c				
H	Gehärteter Stahl																			



Anwendung	Spanformstufe	Katalog Nr.	RE	IC	S	D1
Mittl. Bearb. bis Schwerzerspanung (einseitig)	57	DNMM150608-57	0.8	12.7	6.35	5.16
		DNMM150612-57	1.2	12.7	6.35	5.16
Mittlere Bearbeitung bis Schwerzerspanung	TH	DNMG150408-TH	0.8	12.7	4.76	5.16
		DNMG150412-TH	1.2	12.7	4.76	5.16
		DNMG150416-TH	1.6	12.7	4.76	5.16
		DNMG150608-TH	0.8	12.7	6.35	5.16
		DNMG150612-TH	1.2	12.7	6.35	5.16
		DNMG150616-TH	1.6	12.7	6.35	5.16
	THS	DNMG150408-THS	0.8	12.7	4.76	5.16
		DNMG150412-THS	1.2	12.7	4.76	5.16
		DNMG150416-THS	1.6	12.7	4.76	5.16
		DNMG150608-THS	0.8	12.7	6.35	5.16
		DNMG150612-THS	1.2	12.7	6.35	5.16
		DNMG150616-THS	1.6	12.7	6.35	5.16
	SH	DNMG150408-SH	0.8	12.7	4.76	5.16
		DNMG150412-SH	1.2	12.7	4.76	5.16
		DNMG150416-SH	1.6	12.7	4.76	5.16
		DNMG150608-SH	0.8	12.7	6.35	5.16
		DNMG150612-SH	1.2	12.7	6.35	5.16
	CH	DNMG150404-CH	0.4	12.7	4.76	5.16
		DNMG150408-CH	0.8	12.7	4.76	5.16
		DNMG150412-CH	1.2	12.7	4.76	5.16
		DNMG150604-CH	0.4	12.7	6.35	5.16
		DNMG150608-CH	0.8	12.7	6.35	5.16
		DNMG150612-CH	1.2	12.7	6.35	5.16
Schlichten bis mittlere Bearbeitung	-	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
		DNMA150412	1.2	12.7	4.76	5.16
		DNMA150604	0.4	12.7	6.35	5.16
		DNMA150608	0.8	12.7	6.35	5.16
		DNMA150612	1.2	12.7	6.35	5.16

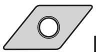
● Lagerstandard
▲ Wird eingestellt

Halter / Außendrehen → C037 -
J-Serie Werkzeughalter → G046
Halter / Innendrehen → D052 -
TungCap → C045, K012 -

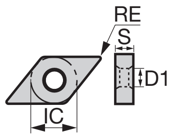
●: Kontinuierlicher Schnitt
◐: Leicht unterbrochener Schnitt
✣: Stark unterbrochener Schnitt

Wendeschneidplatten NEGATIV

DN



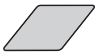
Rhombisch, 55° mit Loch



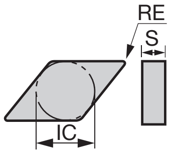
	NS520	TH10	FX105	LX21	LX11
P Stahl	●◐	●			
M Rostfreier Stahl		●			
K Eisenguss	●◐	●	●◐	●	
N Nichteisenmetalle		●			
S Hitzebest. Legierungen					
H Gehärteter Stahl					●

Anwendung	Spanformstufe	Katalog Nr.	NS520 (Cermet)	TH10 (Unbeschichtet)	FX105 (Keramik)	LX21 (Keramik)	LX11 (Keramik)	RE	IC	S	D1
Schlichten bis mittlere Bearbeitung	-	DNGA150404	●	●		●	●	0.4	12.7	4.76	5.16
		DNGA150408	●	●	●	●	●	0.8	12.7	4.76	5.16
		DNGA150412			●	●	●	1.2	12.7	4.76	5.16
		DNGA150416			●			1.6	12.7	4.76	5.16
		DNGA150604					●	-	-	-	-
		DNGA150608					●	0.8	12.7	6.35	5.16
		DNGA150612					●	1.2	12.7	6.35	5.16
		DNGA150616					●	1.6	12.7	6.35	5.16
		DNGA150620					●	2	12.7	6.35	5.16

DN

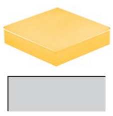


Rhombisch, 55° ohne Loch



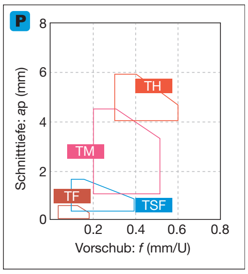
	FX105	LX11
P Stahl		
M Rostfreier Stahl		
K Eisenguss	◐	
N Nichteisenmetalle		
S Hitzebest. Legierungen		
H Gehärteter Stahl		●

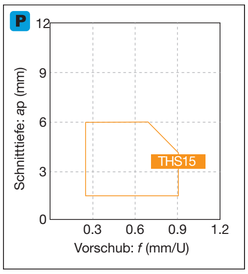
Anwendung	Spanformstufe	Katalog Nr.	FX105 (Keramik)	LX11 (Keramik)	RE	IC	S	D1
Schlichten bis mittlere Bearbeitung	-	DNGD150708	●		0.8	12.7	7.94	-
		DNGD150712	●		1.2	12.7	7.94	-
		DNGD150716	●		1.6	12.7	7.94	-
	-	DNGN150404		●	0.4	12.7	4.76	-
		DNGN150408		●	0.8	12.7	4.76	-
		DNGN150412	●	●	1.2	12.7	4.76	-
		DNGN150416	●		1.6	12.7	4.76	-
		DNGN150708		●	0.8	12.7	7.94	-
		DNGN150712		●	1.2	12.7	7.94	-
		DNGN150716		●	1.6	12.7	7.94	-

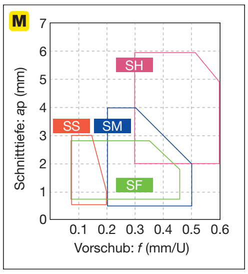


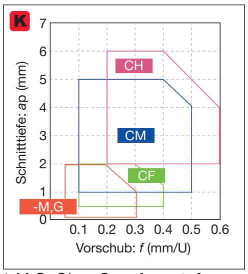
● Lagerstandard

Spankontrollbereich









*-M,G: Ohne Spanformstufe

DNGA...: Halter / Außendrehen → C042 -, Halter / Innendrehen → D052 -, J-Serie Werkzeughalter → G046, TungCap → C045, K012 - DNGD...: Halter / Außendrehen → C046 -

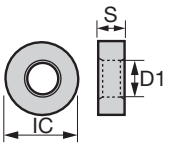
Wendeschneidplatten NEGATIV

● : Kontinuierlicher Schnitt
◐ : Leicht unterbrochener Schnitt
✠ : Stark unterbrochener Schnitt

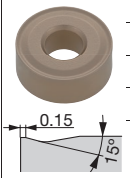
RN

Rund, mit Loch

		T9205	T9215	T9225	T9235	T9105	T9115	T9125	T9135	AH120	TH10	LX11
P	Stahl	●	●◐	◐✠	✠	●	●◐	◐✠	✠	●◐	●	
M	Rostfreier Stahl		●◐							●◐	●	
K	Eisenguss	●◐	●◐			●◐	●◐			●◐	●	
N	Nichteisen-metalle										●	
S	Hitzebest. Legierungen									●◐		
H	Gehärteter Stahl											●



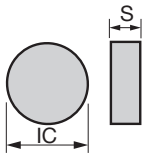
Anwendung	Spanform-stufe	Katalog Nr.	Beschichtet T9205	T9215	T9225	T9235	T9105	T9115	T9125	T9135	AH120	Unbeschichtet TH10	Keramik LX11	Größe (mm) RE	IC	S	D1
Schwerzerspanung	61	RNMG090300-61		●	●			▲	▲					-	9.525	3.18	3.81
		RNMG120400-61	●	●	●	●	▲	▲	▲	▲	●	●		-	12.7	4.76	5.16
		RNMG150600-61		●	●			▲	▲					-	15.875	6.35	6.43
		RNMG190600-61		●	●	●		▲	▲	▲				-	19.05	6.35	7.93
		RNMG250900-61		●	●			▲	▲					-	25.4	9.52	9.22
Schlichten bis mittl. Bearbeitung	-	RNGA120400											●	-	12.7	4.76	5.16



RN

Rund, ohne Loch

		FX105	LX11	WG300
P	Stahl			
M	Rostfreier Stahl			
K	Eisenguss	●◐		
N	Nichteisen-metalle			
S	Hitzebest. Legierungen			●◐
H	Gehärteter Stahl		●	



Anwendung	Spanform-stufe	Katalog Nr.	Keramik FX105	LX11	WG300	Größe (mm) RE	IC	S	D1
Schlichten bis mittl. Bearbeitung	-	RNGN120400	●	●		-	12.7	4.76	-
		RNGN120700	●	●		-	12.7	7.94	-

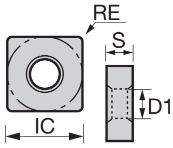
● Lagerstandard
▲ Wird eingestellt

RNMG..., RNGA...: Halter / Außendrehen → C080 -

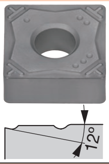
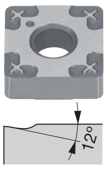
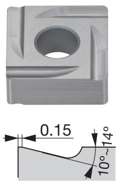
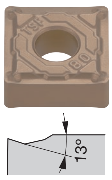
● : Kontinuierlicher Schnitt
◖ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

SN

Quadratisch, 90° mit Loch

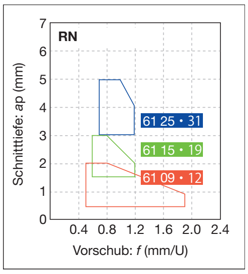


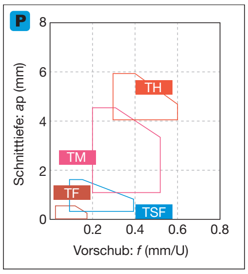
	P Stahl	M Rostfreier Stahl	K Eisenguss	N Nichteisenmetalle	S Hitzebest. Legierungen	H Gehärteter Stahl
T9215	●◖	●◖	●◖			
T9225	◖✣					
T9115	●◖		●◖			
T9125	◖✣					
GT9530	●◖		●◖			
AT9530	●◖		●◖			
NS9530	●◖		●◖			
NS520	●◖		●◖			
X407	●		●			

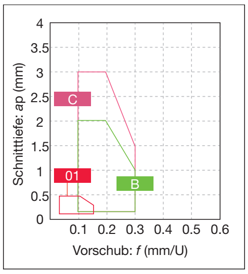
Anwendung	Spanformstufe	Katalog Nr.	Beschichtet T9215	Beschichtet T9225	Beschichtet T9115	Beschichtet T9125	Cermet besch. GT9530	Cermet besch. AT9530	Cermet NS9530	Cermet NS520	Cermet X407	Größe (mm) RE	IC	S	D1
Feinschlichten	TF 	SNMG120404-TF							●			0.4	12.7	4.76	5.16
		SNMG120408-TF							●			0.8	12.7	4.76	5.16
	01 	SNGG090302-01							●	●		0.2	9.525	3.18	3.81
		SNGG090304-01							●			0.4	9.525	3.18	3.81
		SNGG090308-01							●	●		0.8	9.525	3.18	3.81
		SNGG120402-01							●			0.2	12.7	4.76	5.16
		SNGG120404-01							●			0.4	12.7	4.76	5.16
		SNGG120408-01							●	●		0.8	12.7	4.76	5.16
	B – D 	SNGG090304R-B					●		●		●	0.4	9.525	3.18	3.81
		SNGG090304L-B					●		●		●	0.4	9.525	3.18	3.81
		SNGG090308R-B							●		●	0.8	9.525	3.18	3.81
		SNGG090308L-B							●		●	0.8	9.525	3.18	3.81
		SNGG120404R-C					●		●			0.4	12.7	4.76	5.16
		SNGG120404L-C					●		●		●	0.4	12.7	4.76	5.16
		SNGG120408R-C							●			0.8	12.7	4.76	5.16
		SNGG120408L-C							●		●	0.8	12.7	4.76	5.16
		SNGG120408R-D							●			0.8	12.7	4.76	5.16
		SNGG120408L-D							●			0.8	12.7	4.76	5.16
Schlichten	TSF 	SNMG120404-TSF	●	●	▲	▲	●	●	●			0.4	12.7	4.76	5.16
		SNMG120408-TSF	●	●	▲	▲	●	●	●			0.8	12.7	4.76	5.16
		SNMG120412-TSF	●	●	▲	▲						1.2	12.7	4.76	5.16

● Lagerstandard
▲ Wird eingestellt

Spankontrollbereich







Halter / Außendrehen → C093 -
Kassetten → K197
Halter / Innendrehen → D040 -

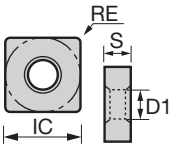
Wendeschneidplatten NEGATIV

● : Kontinuierlicher Schnitt
ɔ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

SN

Quadratisch, 90° mit Loch

		T9205	T9215	T9225	T9235	T9105	T9115	T9125	T9135	T6120	T6130	AH630	T5105	T5115	AH8005	AH8015	GT9530	AT9530	NS9530	TH10
P	Stahl	●	●ɔ	●✣	✣	●	●ɔ	●✣	✣	ɔ	✣	ɔ✣					●ɔ	●ɔ	●ɔ	●
M	Rostfreier Stahl		●ɔ							●	ɔ	ɔ			●	ɔ				●
K	Eisenguss	●ɔ	●ɔ			●ɔ	●ɔ						●	ɔ			●ɔ	●ɔ	●ɔ	●
N	Nichteisenmetalle																			●
S	Hitzebest. Legierungen														●	ɔ				
H	Gehärteter Stahl																			



Anwendung	Spanformstufe	Katalog Nr.	RE	IC	S	D1
Schlichten	11	SNMG120404-11	0.4	12.7	4.76	5.16
		SNMG12040**8-11**	0.8	12.7	4.76	5.16
Schlichten (Baustahl)	17	SNMG120408-17	0.8	12.7	4.76	5.16
Schlichten	SF	SNMG120404-SF	0.4	12.7	4.76	5.16
		SNMG12040**8-SF**	0.8	12.7	4.76	5.16
	CF	SNMG120408-CF	0.8	12.7	4.76	5.16
		SNMG12041**2-CF**	1.2	12.7	4.76	5.16
	HRF	SNMG120408-HRF	0.8	12.7	4.76	5.16
		SNMG12041**2-HRF**	1.2	12.7	4.76	5.16
Schlichten	TS	SNMG120404-TS	0.4	12.7	4.76	5.16
		SNMG12040**8-TS**	0.8	12.7	4.76	5.16
		SNMG12041**2-TS**	1.2	12.7	4.76	5.16
Hoher Vorschub, geringe Schnitttiefe	AS	SNMG120404-AS	0.4	12.7	4.76	5.16
		SNMG12040**8-AS**	0.8	12.7	4.76	5.16

● Lagerstandard
▲ Wird eingestellt

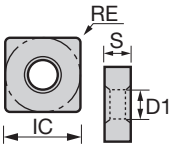
Halter / Außendrehen → C093 -
Kassetten → K197
Halter / Innendrehen → D040 -

● : Kontinuierlicher Schnitt
ɔ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

SN

Quadratisch, 90° mit Loch

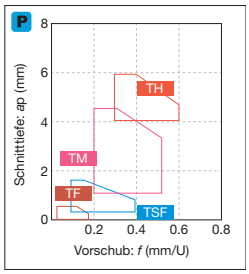
		T9205	T9215	T9225	T9235	T9105	T9115	T9125	T9135	T6120	T6130	AH630	AH645	AH120	GH330
P	Stahl	●	●ɔ	ɔ✣	✣	●	●ɔ	ɔ✣	✣	ɔ	✣	ɔ✣	✣	●ɔ	●ɔ
M	Rostfreier Stahl		●ɔ							●	ɔ	ɔ	✣	●ɔ	●ɔ
K	Eisenguss	●ɔ	●ɔ			●ɔ	●ɔ							●ɔ	●ɔ
N	Nichteisen-metalle														
S	Hitzebest. Legierungen													●ɔ	
H	Gehärteter Stahl														

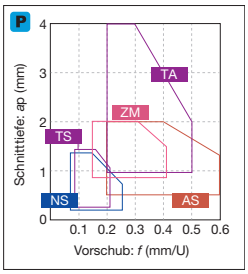


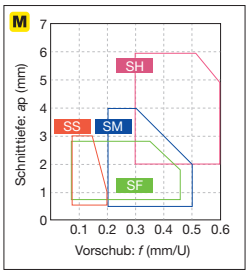
Anwendung	Spanform-stufe	Katalog Nr.	RE	IC	S	D1
Schlichten	NS	SNMG120408-NS	0.8	12.7	4.76	5.16
	SS	SNMG120404-SS	0.4	12.7	4.76	5.16
		SNMG120408-SS	0.8	12.7	4.76	5.16
		SNMG120412-SS	1.2	12.7	4.76	5.16
Mittlere Bearbeitung	TM	SNMG090304-TM	0.4	9.525	3.18	3.81
		SNMG090308-TM	0.8	9.525	3.18	3.81
		SNMG120404-TM	0.4	12.7	4.76	5.16
		SNMG120408-TM	0.8	12.7	4.76	5.16
		SNMG120412-TM	1.2	12.7	4.76	5.16
		SNMG120416-TM	1.6	12.7	4.76	5.16
		SNMG150608-TM	0.8	15.875	6.35	6.35
		SNMG150612-TM	1.2	15.875	6.35	6.35
		SNMG190608-TM	0.8	19.05	6.35	7.93
		SNMG190612-TM	1.2	19.05	6.35	7.93
Mittlere Bearbeitung	TA	SNMG120408-TA	0.8	12.7	4.76	5.16
		SNMG120412-TA	1.2	12.7	4.76	5.16
Schlichten bis mittl. Bearbeitung	ZM	SNMG120408-ZM	0.8	12.7	4.76	5.16
		SNMG120412-ZM	1.2	12.7	4.76	5.16

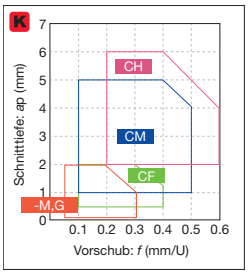
● Lagerstandard
▲ Wird eingestellt

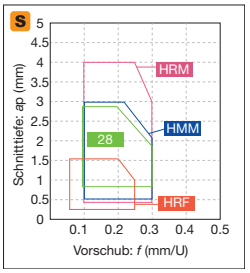
Spankontrollbereich











*-M,G: Ohne Spanformstufe

Halter / Außendrehen → C093 -
Kassetten → K197
Halter / Innendrehen → D040 -

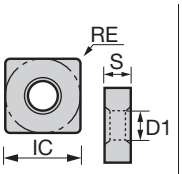
Wendeschneidplatten NEGATIV

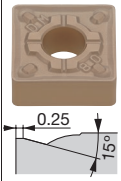
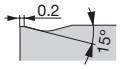
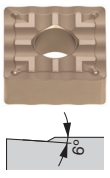
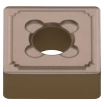
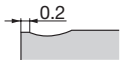
● : Kontinuierlicher Schnitt
ɔ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

SN

Quadratisch, 90° mit Loch

P	Stahl	●	●ɔ	ɔ✣	✣	●	●ɔ	ɔ✣	✣	ɔ	✣	ɔ✣	✣					ɔ	●	●ɔ	●ɔ	●ɔ		●ɔ	●ɔ	●
M	Rostfreier Stahl		●ɔ							●	ɔ	ɔ	✣					ɔ	●	●ɔ	●ɔ					●
K	Eisenguss	●ɔ	●ɔ			●ɔ	●ɔ							●ɔ	●	ɔ	✣	ɔ	●	●ɔ	●ɔ	●ɔ		●ɔ	●ɔ	●
N	Nichteisen-metalle																									●
S	Hitzebest. Legierungen																	●	●	●ɔ						
H	Gehärteter Stahl																									



Anwendung	Spanform-stufe	Katalog Nr.	Beschichtet																				Cermet besch.		Cermet		Unbe-schich.	Größe (mm)			
			T9205	T9215	T9225	T9235	T9105	T9115	T9125	T9135	T6120	T6130	AH630	AH645	T515	T5105	T5115	T5125	AH725	AH110	AH120	GH330	GT720		NS9530	NS520	TH10	RE	IC	S	D1
Mittlere Bearbeitung	**DM**	**SNMG120408-DM**		●	●			▲	▲																			0.8	12.7	4.76	5.16
		SNMG120412-DM		●	●	●		▲	▲	▲																		1.2	12.7	4.76	5.16
	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	12.7	4.76	5.16
		SNMG120420		●	●	●		▲	▲	▲						●	●	●										2	12.7	4.76	5.16
		SNMG150612		●	●	●		▲	▲	▲		●			●													1.2	15.875	6.35	6.35
		SNMG150616		●	●			▲	▲						●													1.6	15.875	6.35	6.35
		SNMG190612		●	●	●		▲	▲	▲		●			●	●	●	●			●							1.2	19.05	6.35	7.93
		SNMG190616		●	●	●		▲	▲	▲					●	●	●	●			●							1.6	19.05	6.35	7.93
		SNMG250724		●	●	●		▲	▲	▲																		2.4	25.4	7.94	9.12
Schlichten bis mittlere Bearbeitung	**27**	**SNMG120408-27**			●				▲																●			0.8	12.7	4.76	5.16
		SNMG120412-27			●				▲																			1.2	12.7	4.76	5.16
Mittlere Bearbeitung	**33**	**SNMG120408-33**		●	●			▲	▲																			0.8	12.7	4.76	5.16
		SNMG120412-33			●				▲																			1.2	12.7	4.76	5.16
		SNMG150612-33		●	●			▲	▲																			1.2	15.875	6.35	6.35
		SNMG190616-33			●	●			▲	▲																		1.6	19.05	6.35	7.93
	37	**SNMG120408-37**		●				▲														●			●			0.8	12.7	4.76	5.16
		SNMG120412-37		●				▲																				1.2	12.7	4.76	5.16
	SM	**SNMG120408-SM**									●	●	●	●					●									0.8	12.7	4.76	5.16
		SNMG120412-SM									●	●	●	●														1.2	12.7	4.76	5.16

● Lagerstandard
▲ Wird eingestellt

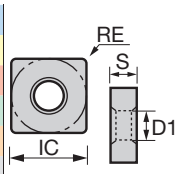
Halter / Außendrehen → C093 -
Kassetten → K197
Halter / Innendrehen → D040 -

● : Kontinuierlicher Schnitt
ɔ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

SN

Quadratisch, 90° mit Loch

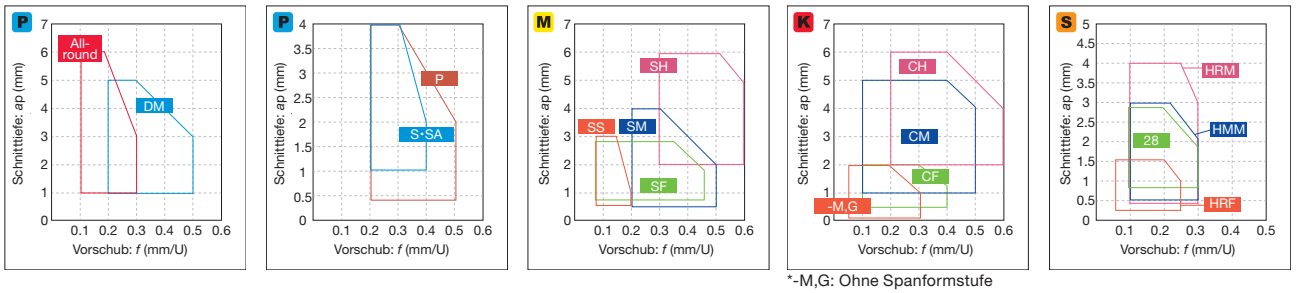
P	Stahl	ɔ ✣ ɔ✣ ✣ ●ɔ
M	Rostfreier Stahl	● ɔ ɔ ✣ ●ɔ
K	Eisenguss	●ɔ ●ɔ ● ɔ ✣
N	Nichteisen-metalle	
S	Hitzebest. Legierungen	●ɔ
H	Gehärteter Stahl	



Anwendung	Spanform-stufe	Katalog Nr.	Beschichtet														Unbeschichtet				Größe (mm)			
			T6120	T6130	AH630	AH645	AH120	T515	T5105	T5115	T5125	AH8005	AH8015	GH110	AH905	GH330	TH10	KS20			RE	IC	S	D1
Mittlere Bearbeitung	CM	SNMG120408-CM						●	●	●	●										0.8	12.7	4.76	5.16
		SNMG12012-CM						●	●	●	●										1.2	12.7	4.76	5.16
	P	SNGG090304R-P												●			●				0.4	9.525	3.18	3.81
		SNGG09030 4L-P												●			●				0.4	9.525	3.18	3.81
		SNGG09030 8R-P												●		●	●				0.8	9.525	3.18	3.81
		SNGG09030 8L-P															●				0.8	9.525	3.18	3.81
		SNGG120404R-P												●			●				0.4	12.7	4.76	5.16
		SNGG12040 4L-P												●			●				0.4	12.7	4.76	5.16
		SNGG12040 8R-P												●			●				0.8	12.7	4.76	5.16
		SNGG12040 8L-P												●			●				0.8	12.7	4.76	5.16
Schlichten bis mittlere Bearbeitung	HRM	SNMG120408-HRM										●	●								0.8	12.7	4.76	5.16
		SNMG12012-HRM										●	●								1.2	12.7	4.76	5.16
		SNMG150608-HRM										●	●								0.8	15.875	6.35	6.35
		SNMG15061 2-HRM										●	●								1.2	15.875	6.35	6.35
		SNMG190612-HRM										●	●								1.2	19.05	6.35	7.93
		SNMG19061 6-HRM										●	●								1.6	19.05	6.35	7.93
Mittlere Bearbeitung	HMM	SNMG120408-HMM													●						0.8	12.7	4.76	5.16
		SNMG12012-HMM													●						1.2	12.7	4.76	5.16
	SA	SNMG120404-SA	●	●	●	●	●														0.4	12.7	4.76	5.16
		SNMG12040 8-SA	●	●	●	●	●											●			0.8	12.7	4.76	5.16
		SNMG12012-SA	●	●	●	●	●														1.2	12.7	4.76	5.16
		SNMG190612-SA					●											●			1.2	19.05	6.35	7.93

● Lagerstandard

Spankontrollbereich



*-M,G: Ohne Spanformstufe

Halter / Außendrehen → C093 -
Kassetten → K197
Halter / Innendrehen → D040 -

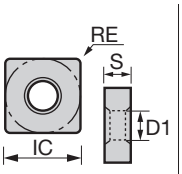
Wendeschneidplatten NEGATIV

● : Kontinuierlicher Schnitt
ɔ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

SN

Quadratisch, 90° mit Loch

		T9205	T9215	T9225	T9235	T9105	T9115	T9125	T9135	T6130	AH630	AH645	AH120	GH330	NS9530
P	Stahl	●	●ɔ	ɔ✣	✣	●	●ɔ	ɔ✣	✣	✣	ɔ✣	✣	●ɔ	●ɔ	●ɔ
M	Rostfreier Stahl		●ɔ							ɔ	ɔ	✣	●ɔ	●ɔ	
K	Eisenguss	●ɔ	●ɔ			●ɔ	●ɔ						●ɔ	●ɔ	●ɔ
N	Nichteisenmetalle														
S	Hitzebest. Legierungen												●ɔ		
H	Gehärteter Stahl														



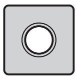
Anwendung	Spanformstufe	Katalog Nr.	Beschichtet													Cermet		Größe (mm)			
			T9205	T9215	T9225	T9235	T9105	T9115	T9125	T9135	T6130	AH630	AH645	AH120	GH330	NS9530		RE	IC	S	D1
Mittlere Bearbeitung	S	SNMG120404R-S			●	●			▲	▲	●	●	●			●		0.4	12.7	4.76	5.16
		SNMG120404L-S			●	●			▲	▲	●	●	●			●		0.4	12.7	4.76	5.16
		SNMG120408R-S			●	●			▲	▲	●	●	●		●	●		0.8	12.7	4.76	5.16
		SNMG120408L-S			●	●			▲	▲	●	●	●		●	●		0.8	12.7	4.76	5.16
Mittlere Bearbeitung bis Schwerzerspanung	TH	SNMG120408-TH		●	●	●		▲	▲	▲				●				0.8	12.7	4.76	5.16
		SNMG120412-TH		●	●	●		▲	▲	▲				●				1.2	12.7	4.76	5.16
		SNMG150612-TH	●	●	●		▲	▲	▲					●				1.2	15.875	6.35	6.35
		SNMG150616-TH	●	●	●		▲	▲	▲					●				1.6	15.875	6.35	6.35
		SNMG190612-TH	●	●	●	●	▲	▲	▲	▲				●				1.2	19.05	6.35	7.93
		SNMG190616-TH	●	●	●	●	▲	▲	▲	▲				●				1.6	19.05	6.35	7.93
	THS	SNMG120408-THS		●	●	●		▲	▲	▲								0.8	12.7	4.76	5.16
		SNMG120412-THS		●	●	●		▲	▲	▲								1.2	12.7	4.76	5.16
		SNMG150612-THS		●	●			▲	▲									1.2	15.875	6.35	6.35
		SNMG150616-THS		●	●			▲	▲									1.6	15.875	6.35	6.35
		SNMG190608-THS		●	●	●		▲	▲	▲								0.8	19.05	6.35	7.93
		SNMG190612-THS		●	●	●		▲	▲	▲								1.2	19.05	6.35	7.93
		SNMG190616-THS		●	●	●		▲	▲	▲								1.6	19.05	6.35	7.93
		SNMG190624-THS		●	●	●		▲	▲	▲								2.4	19.05	6.35	7.93
		SNMG250716-THS		●	●	●		▲	▲	▲								1.6	25.4	7.94	9.12
		SNMG250724-THS		●	●	●		▲	▲	▲								2.4	25.4	7.94	9.12
Mittl. Bearb. bis Schwerzerspanung (einseitig)	TRS	SNMM150612-TRS		●	●	●		▲	▲	▲								1.2	15.875	6.35	6.35
		SNMM150616-TRS		●	●	●		▲	▲	▲								1.6	15.875	6.35	6.35
		SNMM190616-TRS		●	●	●		▲	▲	▲								1.6	19.05	6.35	7.93
		SNMM190624-TRS		●	●	●		▲	▲	▲								2.4	19.05	6.35	7.93
		SNMM250924-TRS		●	●	●		▲	▲	▲								2.4	25.4	9.52	9.12
Schwerzerspanung (einseitig)	TU	SNMM190616-TU				●				▲								1.6	19.05	6.35	7.93
		SNMM190624-TU			●	●			▲	▲								2.4	19.05	6.35	7.93
		SNMM250724-TU			●	●			▲	▲								2.4	25.4	7.94	9.12
		SNMM250924-TU		●	●			▲	▲									2.4	25.4	9.52	9.12

● Lagerstandard
▲ Wird eingestellt

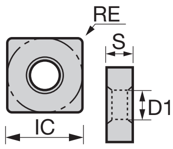
Halter / Außendrehen → C093 -
Kassetten → K197
Halter / Innendrehen → D040 -

● : Kontinuierlicher Schnitt
◐ : Leicht unterbrochener Schnitt
✠ : Stark unterbrochener Schnitt

SN



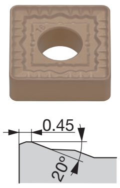
Quadratisch, 90° mit Loch



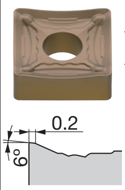
Werkstoff	T9205	T9215	T9225	T9235	T9115	T9125	T9135	T6130	AH630	AH645	T5105	T5115	T5125
P Stahl	●	●◐	◐✠	✠	●◐	◐✠	✠	✠	◐✠	✠			
M Rostfreier Stahl		●◐						◐	◐	✠			
K Eisenguss	●◐	●◐			●◐						●	◐	✠
N Nichteisen-metalle													
S Hitzebest. Legierungen													
H Gehärteter Stahl													

Anwendung	Spanform-stufe	Katalog Nr.	T9205	T9215	T9225	T9235	T9115	T9125	T9135	T6130	AH630	AH645	T5105	T5115	T5125	RE	IC	S	D1
			Beschichtet													Größe (mm)			
Schwerzerspanung (einseitig)	TUS	SNMM190612-TUS		●	●	●	▲	▲	▲							1.2	19.05	6.35	7.93
		SNMM190616-TUS		●	●	●	▲	▲	▲							1.6	19.05	6.35	7.93
		SNMM190624-TUS		●	●	●	▲	▲	▲							2.4	19.05	6.35	7.93
		SNMM250724-TUS		●	●	●	▲	▲	▲							2.4	25.4	7.94	9.12
		SNMM250732-TUS		●	●		▲	▲								3.2	25.4	7.94	9.12
		SNMM250924-TUS		●	●	●	▲	▲	▲							2.4	25.4	9.52	9.12
		SNMM250932-TUS		●	●		▲	▲								3.2	25.4	9.52	9.12
	57	SNMM120408-57		●	●		▲	▲								0.8	12.7	4.76	5.16
		SNMM150616-57			●											1.6	15.875	6.35	6.35
		SNMM190612-57			●											1.2	19.05	6.35	7.93
Mittl. Bearb. bis Schwer-zerspanung (einseitig)	65	SNMM190612-65			●			▲								1.2	19.05	6.35	7.93
		SNMM310924-65			●			▲								2.4	31.75	9.52	8.8
Mittlere Bearbeitung bis Schwerzerspanung	SH	SNMG120408-SH								●	●	●				0.8	12.7	4.76	5.16
		SNMG120412-SH								●	●	●				1.2	12.7	4.76	5.16
		SNMG150612-SH								●	●	●				1.2	15.875	6.35	6.35
		SNMG150616-SH								●	●	●				1.6	15.875	6.35	6.35
		SNMG190612-SH								●	●	●				1.2	19.05	6.35	7.93
		SNMG190616-SH								●	●	●				1.6	19.05	6.35	7.93
	CH	SNMG120408-CH											●	●	●	0.8	12.7	4.76	5.16
		SNMG120412-CH											●	●	●	1.2	12.7	4.76	5.16
		SNMG120416-CH											●	●	●	1.6	12.7	4.76	5.16

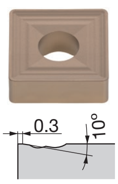
Spanformstufe TUS:



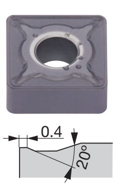
Spanformstufe 57:



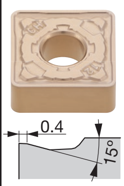
Spanformstufe 65:



Spanformstufe SH:

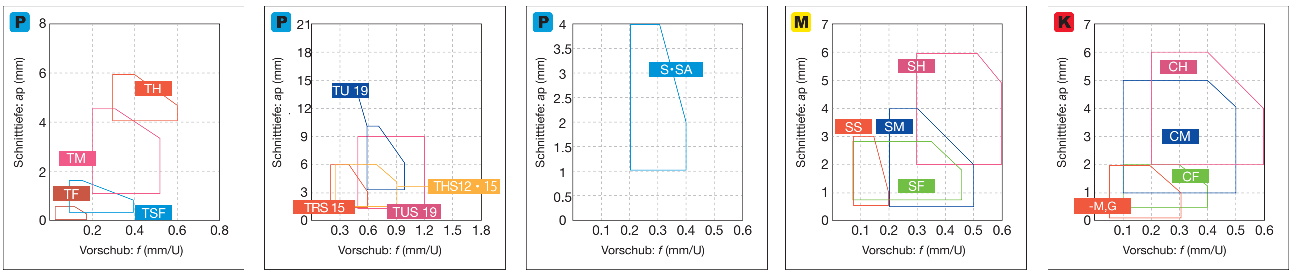


Spanformstufe CH:



● Lagerstandard
▲ Wird eingestellt

Spankontrollbereich



*-M,G: Ohne Spanformstufe

Halter / Außendrehen → C093 -
Kassetten → K197
Halter / Innendrehen → D040 -

Wendeschneidplatten NEGATIV

● : Kontinuierlicher Schnitt
ⓒ : Leicht unterbrochener Schnitt
✠ : Stark unterbrochener Schnitt

SN

Quadratisch, 90° mit Loch

		T515	T5105	T5115	T5125	GT720	NS520	TH10	FX105	LX21	LX11	RE	IC	S	D1
		Beschichtet				Cermet besch.	Cermet	Unbeschichtet	Keramik			Größe (mm)			
P	Stahl					●ⓒ	●ⓒ	●							
M	Rostfreier Stahl							●							
K	Eisenguss	●ⓒ	●	ⓒ	✠	●ⓒ	●ⓒ	●		●ⓒ	●				
N	Nichteisenmetalle							●							
S	Hitzebest. Legierungen														
H	Gehärteter Stahl										●				
Anwendung	Spanformstufe	Katalog Nr.													
Schlichten bis mittlere Bearbeitung	-	SNMA090308		●				●				0.8	9.525	3.18	3.81
		SNMA120404		●	●	●						0.4	12.7	4.76	5.16
		SNMA120408	●	●	●	●		●		●		0.8	12.7	4.76	5.16
		SNMA120412	●	●	●	●		●		●		1.2	12.7	4.76	5.16
		SNMA120416		●	●	●						1.6	12.7	4.76	5.16
	-	SNGA090304						●				0.4	9.525	3.18	3.81
		SNGA120404				●		●			●	0.4	12.7	4.76	5.16
		SNGA120408					●	●		●	●	0.8	12.7	4.76	5.16
		SNGA120412						●		●	●	1.2	12.7	4.76	5.16
		SNGA120416								●	●	1.6	12.7	4.76	5.16

● Lagerstandard

SN

Quadratisch, 90° ohne Loch

		TH10	FX105	LX21	LX11	RE	IC	S	D1
		Unbeschichtet	Keramik			Größe (mm)			
P	Stahl	●							
M	Rostfreier Stahl	●							
K	Eisenguss	●	●ⓒ	●					
N	Nichteisenmetalle	●							
S	Hitzebest. Legierungen								
H	Gehärteter Stahl				●				
Anwendung	Spanformstufe	Katalog Nr.							
Schlichten bis mittlere Bearbeitung	-	SNGD120712	●			1.2	12.7	7.94	-
		SNGD120716	●			1.6	12.7	7.94	-
	-	SNGN090308		●	●	0.8	9.525	3.18	-
		SNGN120304			●	0.4	12.7	3.18	-
		SNGN120312			●	1.2	12.7	3.18	-
		SNGN120404			●	0.4	12.7	4.76	-
		SNGN120408	●	●	●	0.8	12.7	4.76	-
		SNGN120412		●	●	1.2	12.7	4.76	-
		SNGN120416		●	●	1.6	12.7	4.76	-
		SNGN120420		●		2	12.7	4.76	-
		SNGN120424		●		2.4	12.7	4.76	-
		SNGN120708			●	0.8	12.7	7.94	-
		SNGN120712		●	●	1.2	12.7	7.94	-
		SNGN120716		●	●	1.6	12.7	7.94	-
		SNGN120720			●	2	12.7	7.94	-

● Lagerstandard

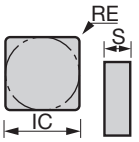
Halter / Außendrehen → C093 - Kassetten → K197
SNGD...: Halter / Außendrehen → C108

● : Kontinuierlicher Schnitt
ᑕ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

SN

Quadratisch, 90° ohne Loch

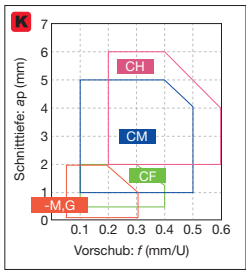
P	Stahl	●ᑕ
M	Rostfreier Stahl	●ᑕ
K	Eisenguss	●ᑕ
N	Nichteisen-metalle	●
S	Hitzebest. Legierungen	●ᑕ
H	Gehärteter Stahl	



Anwendung	Spanform-stufe	Katalog Nr.	Beschichtet AH120	Unbeschichtet TH10	Größe (mm) RE	IC	S	D1
Schlichten bis mittl. Bearbeitung	-	**SNMN120408**		●	0.8	12.7	4.76	-
		SNMN1204**12**	●		1.2	12.7	4.76	-

● Lagerstandard

Spankontrollbereich



*-M,G: Ohne Spanformstufe

SNMN...: Halter / Außendrehen → C093 -

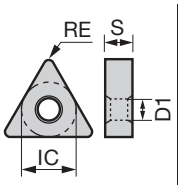
Wendeschneidplatten NEGATIV

● : Kontinuierlicher Schnitt
ɔ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

TN

Dreieckig, 60° mit Loch

		GH110	GH330	SH725	GT9530	GT720	NS9530	NS520	X407	TH10
P	Stahl	●	ɔ	ɔ	ɔ	ɔ	ɔ	ɔ	●	●
M	Rostfreier Stahl	●	ɔ	ɔ						●
K	Eisenguss	●	ɔ		ɔ	ɔ	ɔ	ɔ	●	●
N	Nichteisen-metalle									●
S	Hitzebest. Legierungen	●								
H	Gehärteter Stahl									



Anwendung	Spanform-stufe	Katalog Nr.	Beschichtet			Cermet besch.		Cermet			Unbeschichtet	Größe (mm)			
			GH110	GH330	SH725	GT9530	GT720	NS9530	NS520	X407	TH10	RE	IC	S	D1
Feinschlichten	TF	TNMG160404-TF						●	●		●	0.4	9.525	4.76	3.81
		TNMG160408-TF						●	●			0.8	9.525	4.76	3.81
	01	TNGG110302-01						●				0.2	6.35	3.18	2.26
		TNGG110304-01						●				0.4	6.35	3.18	2.26
		TNGG110308-01						●	●			0.8	6.35	3.18	2.26
		TNGG160402-01	●					●	●		●	0.2	9.525	4.76	3.81
		TNGG160404-01	●					●	●		●	0.4	9.525	4.76	3.81
		TNGG160408-01	●					●	●			0.8	9.525	4.76	3.81
		TNGG160412-01					●	●				1.2	9.525	4.76	3.81
Feinschlichten (scharfkantig)	01	TNGG160402F-01			●							0.2	9.525	4.76	3.81
		TNGG160404F-01			●							0.4	9.525	4.76	3.81
		TNGG160408F-01			●							0.8	9.525	4.76	3.81
Feinschlichten	A, C	TNGG110304R-A				●		●				0.4	6.35	3.18	2.26
		TNGG110304L-A				●		●				0.4	6.35	3.18	2.26
		TNGG110308R-A				●		●				0.8	6.35	3.18	2.26
		TNGG110308L-A				●		●				0.8	6.35	3.18	2.26
		TNGG160304R-C						●		●		0.4	9.525	3.18	3.81
		TNGG160304L-C						●				0.4	9.525	3.18	3.81
		TNGG160308R-C						●				0.8	9.525	3.18	3.81
		TNGG160308L-C						●				0.8	9.525	3.18	3.81
		TNGG160400R-C						●				0.03	9.525	4.76	3.81
		TNGG160400L-C						●				0.03	9.525	4.76	3.81
		TNGG160402R-C				●		●		●	●	0.2	9.525	4.76	3.81
		TNGG160402L-C				●		●				0.2	9.525	4.76	3.81
		TNGG160404R-C	●	●		●		●	●	●	●	0.4	9.525	4.76	3.81
		TNGG160404L-C	●	●		●		●		●	●	0.4	9.525	4.76	3.81
		TNGG160408R-C	●	●		●		●	●	●	●	0.8	9.525	4.76	3.81
		TNGG160408L-C	●	●		●		●		●	●	0.8	9.525	4.76	3.81
	D	TNGG220404R-D						●		●		0.4	12.7	4.76	5.16
		TNGG220404L-D						●				0.4	12.7	4.76	5.16
		TNGG220408R-D						●		●		0.8	12.7	4.76	5.16
		TNGG220408L-D						●				0.8	12.7	4.76	5.16

● Lagerstandard

Halter / Außendrehen → C027 -
J-Serie Werkzeughalter → G045 -
Halter / Innendrehen → D046 -
Kassetten → K193 -

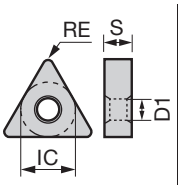
Wendeschneidplatten NEGATIV

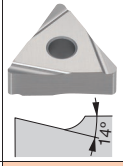
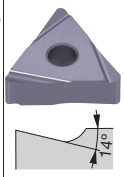
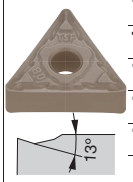
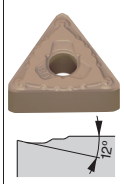
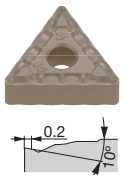
● : Kontinuierlicher Schnitt
ɔ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

TN

Dreieckig, 60° mit Loch

P	Stahl	●	●ɔ	●✣	✣	●	●ɔ	●✣	✣	●ɔ	●ɔ			●ɔ	●ɔ			●ɔ				●									
M	Rostfreier Stahl		●ɔ							●ɔ	●ɔ											●									
K	Eisenguss	●ɔ	●ɔ			●ɔ	●ɔ			●ɔ				●ɔ	●ɔ			●ɔ				●									
N	Nichteisen-metalle																					●									
S	Hitzebest. Legierungen									●ɔ																					
H	Gehärteter Stahl																														

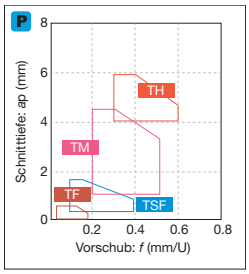


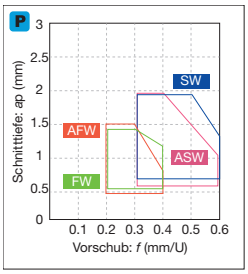
Anwendung	Spanform-stufe	Katalog Nr.	Beschichtet										Cermet besch.		Cermet	Unbeschichtet	Größe (mm)			
			T9205	T9215	T9225	T9235	T9105	T9115	T9125	T9135	AH120	SH725	GT9530	AT9530	NS9530	TH10	RE	IC	S	D1
Feinschlichten	W	TNGG160404R-W													●	●	0.4	9.525	4.76	3.81
		TNGG160404L-W													●	●	0.4	9.525	4.76	3.81
		TNGG160408R-W													●		0.8	9.525	4.76	3.81
		TNGG160408L-W													●		0.8	9.525	4.76	3.81
Feinschlichten (scharfkantig)	W	TNGG160402FR-W										●					0.2	9.525	4.76	3.81
		TNGG160402FL-W										●					0.2	9.525	4.76	3.81
		TNGG160404FR-W										●					0.4	9.525	4.76	3.81
		TNGG160404FL-W										●					0.4	9.525	4.76	3.81
		TNGG160408FR-W										●					0.8	9.525	4.76	3.81
		TNGG160408FL-W										●					0.8	9.525	4.76	3.81
Schlichten	TSF	TNMG110404E-TSF		●	●			▲	▲				●	●	●		0.4	6.35	4.76	2.26
		TNMG110408E-TSF		●	●			▲	▲				●	●	●		0.8	6.35	4.76	2.26
		TNMG160402-TSF									●		●	●	●		0.2	9.525	4.76	3.81
		TNMG160404-TSF		●	●	●		▲	▲	▲	●		●	●	●		0.4	9.525	4.76	3.81
		TNMG160408-TSF	●	●	●	●	▲	▲	▲	▲	●		●	●	●		0.8	9.525	4.76	3.81
		TNMG160412-TSF		●	●	●		▲	▲	▲			●				1.2	9.525	4.76	3.81
Schlichten (Wiper)	FW	TNMG110404E-FW		●				▲									0.4	6.35	4.76	2.26
		TNMG110408E-FW		●				▲									0.8	6.35	4.76	2.26
		TNMG160404-FW		●				▲									0.4	9.525	4.76	3.81
		TNMG160408-FW		●				▲									0.8	9.525	4.76	3.81
		*Wiper																		
Schlichten	ZF	TNMG160404-ZF		●	●	●		▲	▲	▲			●	●	●		0.4	9.525	4.76	3.81
		TNMG160408-ZF		●	●	●		▲	▲	▲			●	●	●		0.8	9.525	4.76	3.81
		TNMG160412-ZF			●				▲								1.2	9.525	4.76	3.81

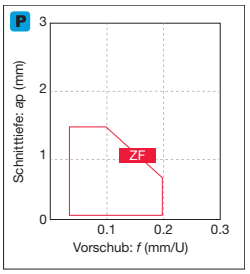
* Siehe Seiten **L032-L036** bezüglich der Anpassung des Bearbeitungsprogramms für die Konturbearbeitung mittels SW/FW.
Bei Fragen wenden Sie sich bitte an unsere Vertriebsmitarbeiter.

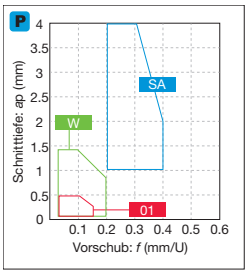
● Lagerstandard
▲ Wird eingestellt

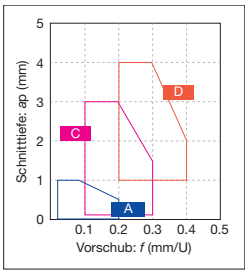
Spankontrollbereich











Halter / Außendrehen	→ C027 -	Halter / Innendrehen	→ D046 -
J-Serie Werkzeughalter	→ G045 -	Kassetten	→ K193 -

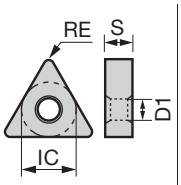
Wendeschneidplatten NEGATIV

● : Kontinuierlicher Schnitt
ᑕ : Leicht unterbrochener Schnitt
✠ : Stark unterbrochener Schnitt

TN

Dreieckig, 60° mit Loch

		T9125	T9225	T6120	T6130	AH630	T5105	T5115	AH8005	AH8015	GH330	NS9530	TH10
P	Stahl	ᑕ✠	ᑕ✠	ᑕ	✠	ᑕ✠					●ᑕ	●ᑕ	●
M	Rostfreier Stahl			●	ᑕ	ᑕ			●	ᑕ	●ᑕ		●
K	Eisenguss						●	ᑕ			●ᑕ	●ᑕ	●
N	Nichteisen-metalle												●
S	Hitzebest. Legierungen								●	ᑕ			
H	Gehärteter Stahl												



Anwendung	Spanform-stufe	Katalog Nr.	RE	IC	S	D1
Schlichten	11	TNMG110304-11	0.4	6.35	3.18	2.26
		TNMG110308-11	0.8	6.35	3.18	2.26
		TNMG160402-11	0.2	9.525	4.76	3.81
		TNMG160404-11	0.4	9.525	4.76	3.81
		TNMG160408-11	0.8	9.525	4.76	3.81
		TNMG220404-11	0.4	12.7	4.76	5.16
		TNMG220408-11	0.8	12.7	4.76	5.16
Schlichten (Baustahl)	17	TNMG160404-17	0.4	9.525	4.76	3.81
		TNMG160408-17	0.8	9.525	4.76	3.81
Schlichten	SF	TNMG160404-SF	0.4	9.525	4.76	3.81
		TNMG160408-SF	0.8	9.525	4.76	3.81
		TNMG160412-SF	1.2	9.525	4.76	3.81
	CF	TNMG160404-CF	0.4	9.525	4.76	3.81
		TNMG160408-CF	0.8	9.525	4.76	3.81
	HRF	TNMG160404-HRF	0.4	9.525	4.76	3.81
		TNMG160408-HRF	0.8	9.525	4.76	3.81

● Lagerstandard
▲ Wird eingestellt

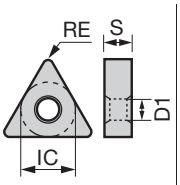
Halter / Außendrehen → C027 -
J-Serie Werkzeughalter → G045 -
Halter / Innendrehen → D046 -
Kassetten → K193 -

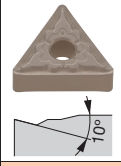
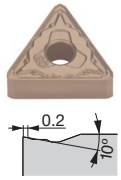
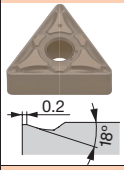
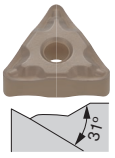
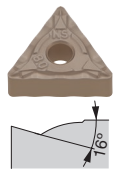
● : Kontinuierlicher Schnitt
ɔ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

TN

Dreieckig, 60° mit Loch

P	Stahl	● ɔ ✣ ✣ ● ɔ ✣ ✣ ɔ ɔ ɔ ɔ
M	Rostfreier Stahl	ɔ
K	Eisenguss	ɔ ɔ ɔ ɔ ɔ ɔ
N	Nichteisenmetalle	
S	Hitzebest. Legierungen	
H	Gehärteter Stahl	

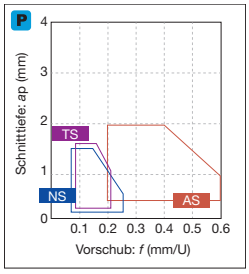


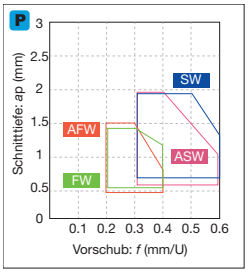
Anwendung	Spanformstufe	Katalog Nr.	Beschichtet T9205	T9215	T9225	T9235	T9105	T9115	T9125	T9135	Cermet besch. GT9530	AT9530	Cermet NS9530	NS520	Größe (mm) RE	IC	S	D1
Schlichten	TS	TNMG160404-TS		●	●	●		▲	▲	▲	●	●	●	●	0.4	9.525	4.76	3.81
		TNMG160408-TS	●	●	●	●	▲	▲	▲	▲	●	●	●	●	0.8	9.525	4.76	3.81
		TNMG160412-TS	●	●	●	●	▲	▲	▲	▲					1.2	9.525	4.76	3.81
Schlichten bis mittlere Bearbeitung (Wiper)	SW	TNMG110408E-SW		●				▲							0.8	6.35	4.76	2.26
		TNMG110412E-SW		●				▲							1.2	6.35	4.76	2.26
		TNMG160408-SW		●				▲							0.8	9.525	4.76	3.81
		TNMG160412-SW		●				▲							1.2	9.525	4.76	3.81
		*Wiper																
Hoher Vorschub, geringe Schnitttiefe	AS	TNMG160404-AS			●	●			▲	▲			●		0.4	9.525	4.76	3.81
		TNMG160408-AS	●	●	●	●	▲	▲	▲	▲			●		0.8	9.525	4.76	3.81
		TNMG160412-AS	●	●	●		▲	▲	▲						1.2	9.525	4.76	3.81
Ausdrehen (doppelseitig)	CB	TNMG110304-CB		●				▲					●		0.4	6.35	3.18	2.26
		TNMG110308-CB		●				▲					●		0.8	6.35	3.18	2.26
Schlichten	NS	TNMG160404-NS		●	●			▲	▲				●		0.4	9.525	4.76	3.81
		TNMG160408-NS	●	●	●		▲	▲	▲				●		0.8	9.525	4.76	3.81

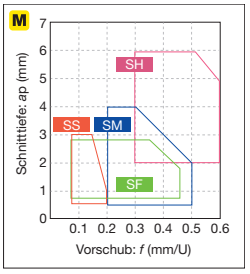
* Siehe Seiten **L032-L036** bezüglich der Anpassung des Bearbeitungsprogramms für die Konturbearbeitung mittels SW/FW.
Bei Fragen wenden Sie sich bitte an unsere Vertriebsmitarbeiter.

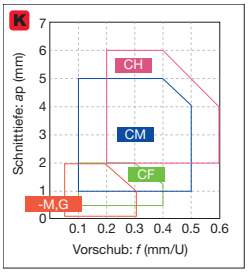
● Lagerstandard
▲ Wird eingestellt

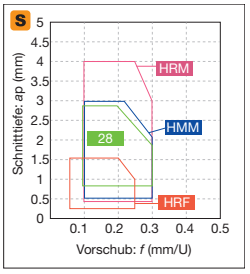
Spankontrollbereich











*-M,G: Ohne Spanformstufe

Halter / Außendrehen	→ C027 -	Halter / Innendrehen	→ D046 -
J-Serie Werkzeughalter	→ G045 -	Kassetten	→ K193 -

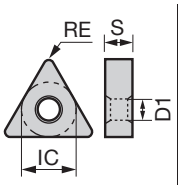
Wendeschneidplatten NEGATIV

● : Kontinuierlicher Schnitt
ɔ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

TN

Dreieckig, 60° mit Loch

		T9205	T9215	T9225	T9235	T9105	T9115	T9125	T9135	T6120	T6130	AH630	AH645	AH120	AH725	GH330	GT9530	AT9530	NS9530	KS20
P	Stahl	●	●ɔ	●✣	✣	●	●ɔ	●✣	✣	ɔ	✣	ɔ✣	✣	●ɔ	ɔ	●ɔ	●ɔ	●ɔ	●ɔ	
M	Rostfreier Stahl		●ɔ							●	ɔ	ɔ	✣	●ɔ	ɔ	●ɔ				
K	Eisenguss	●ɔ	●ɔ			●ɔ	●ɔ							●ɔ	ɔ	●ɔ	●ɔ	●ɔ	●ɔ	ɔ✣
N	Nichteisenmetalle																			ɔ✣
S	Hitzebest. Legierungen													●ɔ	●					ɔ✣
H	Gehärteter Stahl																			



Anwendung	Spanformstufe	Katalog Nr.	RE	IC	S	D1
Schlichten	SS	TNMG110404E-SS	0.4	6.35	4.76	2.26
		TNMG110408E-SS	0.8	6.35	4.76	2.26
		TNMG160404-SS	0.4	9.525	4.76	3.81
		TNMG160408-SS	0.8	9.525	4.76	3.81
		TNMG160412-SS	1.2	9.525	4.76	3.81
		TNMG220404-SS	0.4	12.7	4.76	5.16
		TNMG220408-SS	0.8	12.7	4.76	5.16
		TNMG220412-SS	1.2	12.7	4.76	5.16
Mittlere Bearbeitung	TM	TNMG110304-TM	0.4	6.35	3.18	2.26
		TNMG110308-TM	0.8	6.35	3.18	2.26
		TNMG110404E-TM	0.4	6.35	4.76	2.26
		TNMG110408E-TM	0.8	6.35	4.76	2.26
		TNMG110412E-TM	1.2	6.35	4.76	2.26
		TNMG160404-TM	0.4	9.525	4.76	3.81
		TNMG160408-TM	0.8	9.525	4.76	3.81
		TNMG160412-TM	1.2	9.525	4.76	3.81
		TNMG220404-TM	0.4	12.7	4.76	5.16
		TNMG220408-TM	0.8	12.7	4.76	5.16
		TNMG220412-TM	1.2	12.7	4.76	5.16
		TNMG220416-TM	1.6	12.7	4.76	5.16
Schlichten bis mittlere Bearbeitung	AM	TNMG160408-AM	0.8	9.525	4.76	3.81
		TNMG160412-AM	1.2	9.525	4.76	3.81
	NM	TNMG160408-NM	0.8	9.525	4.76	3.81
		TNMG160412-NM	1.2	9.525	4.76	3.81
	TQ	TNMG160404-TQ	0.4	9.525	4.76	3.81
		TNMG160408-TQ	0.8	9.525	4.76	3.81
Mittlere Bearbeitung	TA	TNMG160404-TA	0.4	9.525	4.76	3.81
		TNMG160408-TA	0.8	9.525	4.76	3.81
		TNMG160412-TA	1.2	9.525	4.76	3.81

● Lagerstandard
▲ Wird eingestellt

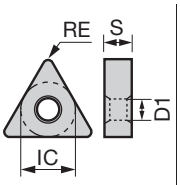
Halter / Außendrehen → C027 -
J-Serie Werkzeughalter → G045 -
Halter / Innendrehen → D046 -
Kassetten → K193 -

● : Kontinuierlicher Schnitt
◐ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

TN

Dreieckig, 60° mit Loch

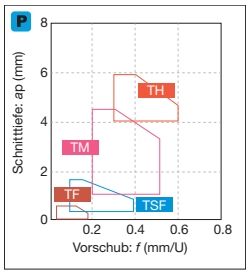
		T9205	T9215	T9225	T9235	T9105	T9115	T9125	T9135	AH630	T515	T5105	T5115	T5125	AH110	AH120	GT9530	GT720	NS9530	NS520	TH10
P	Stahl	●	◐	✣	✣	●	◐	✣	✣	◐	✣				●	◐					●
M	Rostfreier Stahl		◐							◐					●	◐					●
K	Eisenguss	◐	◐			◐	◐				◐	●	◐	✣	●	◐	◐	◐	◐	◐	●
N	Nichteisen-metalle																				●
S	Hitzebest. Legierungen														●	◐					
H	Gehärteter Stahl																				

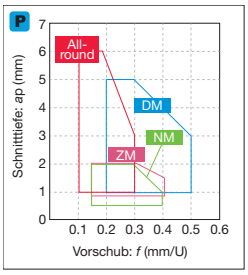


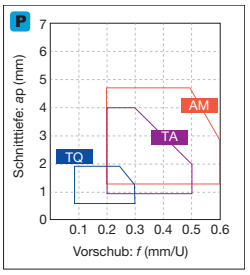
Anwendung	Spanformstufe	Katalog Nr.	RE	IC	S	D1
Schlichten bis mittlere Bearbeitung	ZM	TNMG160404-ZM	0.4	9.525	4.76	3.81
		TNMG160408-ZM	0.8	9.525	4.76	3.81
		TNMG160412-ZM	1.2	9.525	4.76	3.81
		TNMG220412-ZM	1.2	12.7	4.76	5.16
Mittlere Bearbeitung	DM	TNMG160408-DM	0.8	9.525	4.76	3.81
		TNMG160412-DM	1.2	9.525	4.76	3.81
	All-round	TNMG110304	0.4	6.35	3.18	2.26
		TNMG110308	0.8	6.35	3.18	2.26
		TNMG160304	0.4	9.525	3.18	3.81
		TNMG160308	0.8	9.525	3.18	3.81
		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
		TNMG160416	1.6	9.525	4.76	3.81
		TNMG160420	2	9.525	4.76	3.81
		TNMG220408	0.8	12.7	4.76	5.16
		TNMG220412	1.2	12.7	4.76	5.16
		TNMG220416	1.6	12.7	4.76	5.16
		TNMG270608	0.8	15.875	6.35	6.35
		TNMG270612	1.2	15.875	6.35	6.35
		TNMG270616	1.6	15.875	6.35	6.35
Schlichten bis mittlere Bearbeitung	27	TNMG160404-27	0.4	9.525	4.76	3.81
		TNMG160408-27	0.8	9.525	4.76	3.81
		TNMG160412-27	1.2	9.525	4.76	3.81
		TNMG220404-27	0.4	12.7	4.76	5.16
		TNMG220408-27	0.8	12.7	4.76	5.16
		TNMG220412-27	1.2	12.7	4.76	5.16

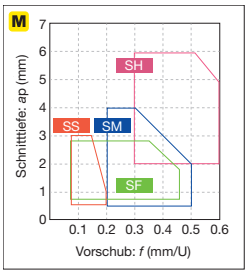
● Lagerstandard
▲ Wird eingestellt

Spankontrollbereich









Halter / Außendrehen → C027 -
Halter / Innendrehen → D046 -
J-Serie Werkzeughalter → G045 -
Kassetten → K193 -

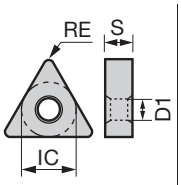
Wendeschneidplatten NEGATIV

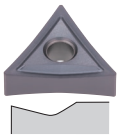
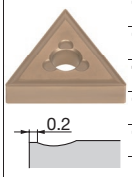
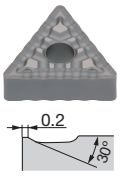
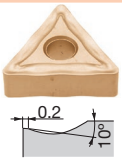
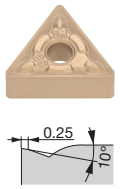
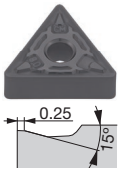
● : Kontinuierlicher Schnitt
ɔ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

TN

Dreieckig, 60° mit Loch

P	Stahl	●	●ɔ	●✣	✣	●ɔ	●✣	✣	ɔ	✣	ɔ✣	✣							●ɔ	ɔ	●ɔ	●ɔ		●ɔ		●
M	Rostfreier Stahl		●ɔ						●	ɔ	ɔ	✣	●	ɔ					●ɔ	ɔ	●ɔ					●
K	Eisenguss	●ɔ	●ɔ			●ɔ									●ɔ	●	ɔ	✣	●ɔ	ɔ	●ɔ	●ɔ		●ɔ		●
N	Nichteisen-metalle																									●
S	Hitzebest. Legierungen												●	ɔ					●ɔ	●						
H	Gehärteter Stahl																									



Anwendung	Spanform-stufe	Katalog Nr.	Beschichtet																			Cermet besch.		Cermet		Unbe-schich.	Größe (mm)			
			T9205	T9215	T9225	T9235	T9115	T9125	T9135	T6120	T6130	AH630	AH645	AH8005	AH8015	T515	T5105	T5115	T5125	AH120	AH725	GH330	GT720		NS9530		TH10	RE	IC	S	D1
Mittlere Bearbeitung	**28**	**TNMG160404-28**												●	●					●								0.4	9.525	4.76	3.81
		TNMG160408-28												●	●					●								0.8	9.525	4.76	3.81
		TNMG220404-28																		●								0.4	12.7	4.76	5.16
		TNMG220408-28																		●								0.8	12.7	4.76	5.16
	33	**TNMG160404-33**																								●		0.4	9.525	4.76	3.81
		TNMG160408-33																								●		0.8	9.525	4.76	3.81
		TNMG160416-33			●			▲																				1.6	9.525	4.76	3.81
		TNMG220404-33			●			▲															●					0.4	12.7	4.76	5.16
		TNMG220412-33				●			▲																			1.2	12.7	4.76	5.16
		TNMG220416-33			●			▲																				1.6	12.7	4.76	5.16
	37	**TNMG160404-37**		●			▲															●			●			0.4	9.525	4.76	3.81
		TNMG160408-37		●			▲															●			●			0.8	9.525	4.76	3.81
	38	**TNMG160404-38**																				●						0.4	9.525	4.76	3.81
		TNMG160408-38																				●						0.8	9.525	4.76	3.81
	SM	**TNMG110404E-SM**								●	●	●																0.4	6.35	4.76	2.26
		TNMG110408E-SM								●	●	●																0.8	6.35	4.76	2.26
		**TNMG160404-SM**								●	●	●	●								●							0.4	9.525	4.76	3.81
		TNMG160408-SM								●	●	●	●								●							0.8	9.525	4.76	3.81
		TNMG160412-SM								●	●	●	●															1.2	9.525	4.76	3.81
		TNMG220408-SM								●	●	●	●															0.8	12.7	4.76	5.16
		TNMG220412-SM								●	●	●	●															1.2	12.7	4.76	5.16
	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
		TNMG220408-CM															●	●	●									0.8	12.7	4.76	5.16
		TNMG220412-CM															●	●	●									1.2	12.7	4.76	5.16

● Lagerstandard
▲ Wird eingestellt

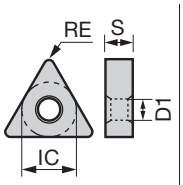
Halter / Außendrehen → C027 -
J-Serie Werkzeughalter → G045 -
Halter / Innendrehen → D046 -
Kassetten → K193 -

● : Kontinuierlicher Schnitt
ɔ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

TN

Dreieckig, 60° mit Loch

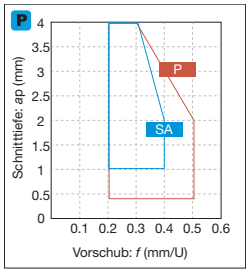
P	Stahl	ɔ ✣ ɔ✣ ✣ ●ɔ ● ɔ ● ●ɔ ●ɔ ●ɔ ●ɔ ● ●
M	Rostfreier Stahl	● ɔ ɔ ✣ ●ɔ ● ɔ ● ●ɔ ●ɔ ●ɔ ● ●
K	Eisenguss	●ɔ ● ●ɔ ●ɔ ● ●ɔ ● ɔ✣
N	Nichteisen-metalle	● ɔ✣
S	Hitzebest. Legierungen	●ɔ ● ɔ ɔ ● ɔ✣
H	Gehärteter Stahl	

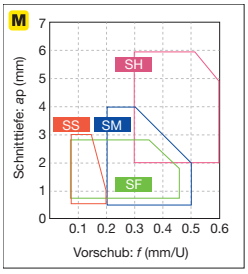


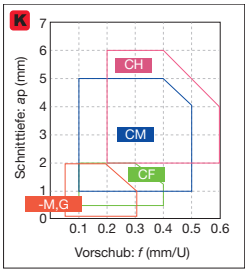
Anwendung	Spanform-stufe	Katalog Nr.	Beschichtet T6120	T6130	AH630	AH645	AH120	AH8005	AH8015	AH905	GH110	GH330	SH725	Cermet NS9530	Unbeschichtet TH10	KS20	Größe (mm) RE	IC	S	D1
Mittlere Bearbeitung	P	TNGG160402R-P									●	●		●	●		0.2	9.525	4.76	3.81
		TNGG160402L-P									●	●		●	●		0.2	9.525	4.76	3.81
		TNGG160404R-P									●	●		●	●		0.4	9.525	4.76	3.81
		TNGG160404L-P									●	●		●	●		0.4	9.525	4.76	3.81
		TNGG160408R-P									●	●		●	●		0.8	9.525	4.76	3.81
		TNGG160408L-P									●	●		●	●		0.8	9.525	4.76	3.81
Mittlere Bearbeitung (scharfkantig)	P	TNGG160402FR-P											●				0.2	9.525	4.76	3.81
		TNGG160402FL-P											●				0.2	9.525	4.76	3.81
		TNGG160404FR-P											●				0.4	9.525	4.76	3.81
		TNGG160404FL-P											●				0.4	9.525	4.76	3.81
		TNGG160408FR-P											●				0.8	9.525	4.76	3.81
		TNGG160408FL-P											●				0.8	9.525	4.76	3.81
Schlichten bis mittl. Bearbeitung	HRM	TNMG160404-HRM						●	●								0.4	9.525	4.76	3.81
		TNMG160408-HRM						●	●								0.8	9.525	4.76	3.81
		TNMG160412-HRM						●	●								1.2	9.525	4.76	3.81
Mittlere Bearbeitung	HMM	TNMG160404-HMM								●							0.4	9.525	4.76	3.81
		TNMG160408-HMM								●							0.8	9.525	4.76	3.81
		TNMG160412-HMM								●							1.2	9.525	4.76	3.81
	SA	TNMG160404-SA	●	●	●	●	●										0.4	9.525	4.76	3.81
		TNMG160408-SA	●	●	●	●	●									●	0.8	9.525	4.76	3.81
		TNMG160412-SA	●	●	●	●	●									●	1.2	9.525	4.76	3.81
		TNMG220408-SA	●	●	●	●	●									●	0.8	12.7	4.76	5.16
		TNMG220412-SA	●	●	●	●											1.2	12.7	4.76	5.16

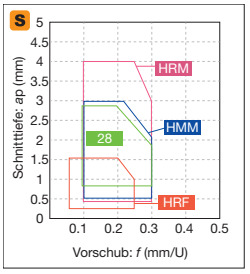
● Lagerstandard

Spankontrollbereich









*-M,G: Ohne Spanformstufe

Halter / Außendrehen → C027 -
J-Serie Werkzeughalter → G045 -
Halter / Innendrehen → D046 -
Kassetten → K193 -

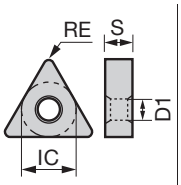
Wendeschneidplatten NEGATIV

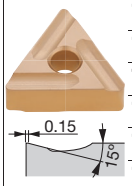
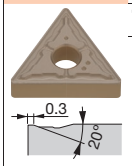
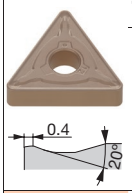
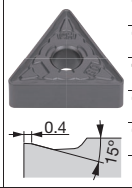
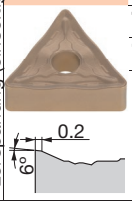
● : Kontinuierlicher Schnitt
ɔ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

TN

Dreieckig, 60° mit Loch

P	Stahl	● ●ɔ ɔ✣ ✣ ●ɔ ɔ✣ ✣ ✣ ɔ✣ ✣ ●ɔ ɔ ●ɔ ●ɔ ●ɔ
M	Rostfreier Stahl	●ɔ ɔ ɔ✣ ✣ ✣ ✣ ●ɔ ɔ ɔ ●ɔ ɔ ●ɔ ●ɔ
K	Eisenguss	●ɔ ●ɔ ●ɔ ●ɔ ●ɔ ● ɔ ✣ ●ɔ ɔ ●ɔ ●ɔ ●ɔ
N	Nichteisen-metalle	
S	Hitzebest. Legierungen	●ɔ ●
H	Gehärteter Stahl	



Anwendung	Spanform-stufe	Katalog Nr.	Beschichtet T9205	T9215	T9225	T9235	T9115	T9125	T9135	T6130	AH630	AH645	T515	T5105	T5115	T5125	AH120	AH725	GH330	Cermet NS9530	Größe (mm) RE	IC	S	D1
Mittlere Bearbeitung	S	TNMG160404R-S		●	●	●	▲	▲	▲	●	●	●						●	●	●	0.4	9.525	4.76	3.81
		TNMG160404L-S			●	●		▲	▲	●	●	●							●	●	0.4	9.525	4.76	3.81
		TNMG160408R-S			●	●		▲	▲	●	●	●						●	●	●	0.8	9.525	4.76	3.81
		TNMG160408L-S			●	●		▲	▲	●	●	●							●	●	0.8	9.525	4.76	3.81
		TNMG220404R-S			●	●		▲	▲	●	●	●							●	●	0.4	12.7	4.76	5.16
		TNMG220404L-S			●	●		▲	▲	●	●	●							●	●	0.4	12.7	4.76	5.16
		TNMG220408R-S			●	●		▲	▲	●	●	●							●	●	0.8	12.7	4.76	5.16
		TNMG220408L-S			●	●		▲	▲	●	●	●							●	●	0.8	12.7	4.76	5.16
	TH	TNMG220408-TH		●	●	●	▲	▲	▲								●				0.8	12.7	4.76	5.16
		TNMG220412-TH		●	●	●	▲	▲	▲												1.2	12.7	4.76	5.16
	THS	TNMG220408-THS		●	●	●	▲	▲	▲												0.8	12.7	4.76	5.16
		TNMG220412-THS		●	●	●	▲	▲	▲												1.2	12.7	4.76	5.16
	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
		TNMG220408-CH												●	●	●					0.8	12.7	4.76	5.16
		TNMG220412-CH												●	●	●					1.2	12.7	4.76	5.16
		TNMG220416-CH												●	●	●					1.6	12.7	4.76	5.16
Mittl. Bearb. bis Schwer-zerspanung (einseitig)	57	TNMM160408-57			●				▲												0.8	9.525	4.76	3.81
		TNMM220408-57			●				▲												0.8	12.7	4.76	5.16
		TNMM220412-57			●				▲												1.2	12.7	4.76	5.16

● Lagerstandard
▲ Wird eingestellt

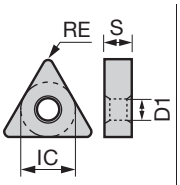
Halter / Außendrehen	→ C027 -	Halter / Innendrehen	→ D046 -
J-Serie Werkzeughalter	→ G045 -	Kassetten	→ K193 -

● : Kontinuierlicher Schnitt
ⓒ : Leicht unterbrochener Schnitt
✠ : Stark unterbrochener Schnitt

TN

Dreieckig, 60° mit Loch

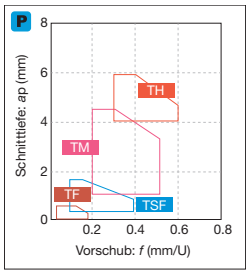
		T515	T5105	T5115	T5125	GH110	GT720	NS520	TH03	TH10	FX105	LX21	LX11
P	Stahl					●	●ⓒ	●ⓒ	●	●			
M	Rostfreier Stahl					●			●	●			
K	Eisenguss	●ⓒ	●	ⓒ	✠	●	●ⓒ	●ⓒ	●	●	●ⓒ	●	
N	Nichteisen-metalle								●	●			
S	Hitzebest. Legierungen					●							
H	Gehärteter Stahl												●

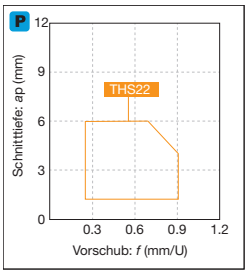


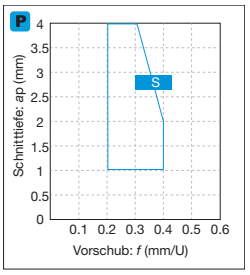
Anwendung	Spanform-stufe	Katalog Nr.	RE	IC	S	D1
Schlichten bis mittlere Bearbeitung	-	**TNMA110404E**	0.4	6.35	4.76	2.26
		TNMA110408E	0.8	6.35	4.76	2.26
		TNMA110412E	1.2	6.35	4.76	2.26
		TNMA160404	0.4	9.525	4.76	3.81
		TNMA160408	0.8	9.525	4.76	3.81
		TNMA160412	1.2	9.525	4.76	3.81
		TNMA160416	1.6	9.525	4.76	3.81
		TNMA160420	2	9.525	4.76	3.81
		TNMA220404	0.4	12.7	4.76	5.16
		TNMA220408	0.8	12.7	4.76	5.16
		TNMA220412	1.2	12.7	4.76	5.16
		TNMA220416	1.6	12.7	4.76	5.16
	-	**TNGA110304**	0.4	6.35	3.18	2.26
		TNGA110308	0.8	6.35	3.18	2.26
		TNGA160304	0.4	9.525	3.18	3.81
		TNGA160308	0.8	9.525	3.18	3.81
		TNGA160402	0.2	9.525	4.76	3.81
		TNGA160404	0.4	9.525	4.76	3.81
		TNGA160408	0.8	9.525	4.76	3.81
		TNGA160412	1.2	9.525	4.76	3.81
		TNGA160416	1.6	9.525	4.76	3.81
		TNGA220408	0.8	12.7	4.76	5.16

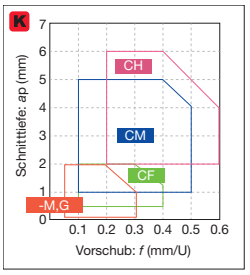
● Lagerstandard

Spankontrollbereich









*-M,G: Ohne Spanformstufe

Halter / Außendrehen	→ C027 -	Halter / Innendrehen	→ D046 -
J-Serie Werkzeughalter	→ G045 -	Kassetten	→ K193 -

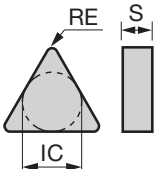
Wendeschneidplatten NEGATIV

● : Kontinuierlicher Schnitt
ⓒ : Leicht unterbrochener Schnitt
✤ : Stark unterbrochener Schnitt

TN

Dreieckig, 60° ohne Loch

		TH10	FX105	LX21	LX11
P	Stahl	●			
M	Rostfreier Stahl	●			
K	Eisenguss	●	●ⓒ	●	
N	Nichteisenmetalle	●			
S	Hitzebest. Legierungen				
H	Gehärteter Stahl				●



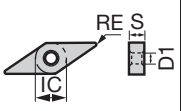
Anwendung	Spanformstufe	Katalog Nr.	Unbeschichtet TH10	Keramik FX105	Keramik LX21	Keramik LX11	RE	IC	S	D1
Schlichten bis mittlere Bearbeitung	-	TNGN110308	●			●	0.8	6.35	3.18	-
		TNGN160404			●	●	0.4	9.525	4.76	-
		TNGN160408	●		●	●	0.8	9.525	4.76	-
		TNGN160412	●	●	●	●	1.2	9.525	4.76	-
		TNGN160416		●		●	1.6	9.525	4.76	-
		TNGN160420		●			2	9.525	4.76	-
		TNGN160708				●	0.8	9.525	7.94	-
		TNGN160712				●	1.2	9.525	7.94	-

● Lagerstandard

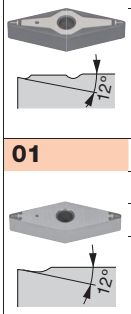
VN

Rhombisch, 35° mit Loch

		GH110	GT720	NS9530	NS520	TH10
P	Stahl	●	●ⓒ	●ⓒ	●ⓒ	●
M	Rostfreier Stahl	●				●
K	Eisenguss	●	●ⓒ	●ⓒ	●ⓒ	●
N	Nichteisenmetalle					●
S	Hitzebest. Legierungen	●				
H	Gehärteter Stahl					



Anwendung	Spanformstufe	Katalog Nr.	Beschichtet GH110	Cermet besch. GT720	Cermet NS9530	Cermet NS520	Unbeschichtet TH10	RE	IC	S	D1
Feinschlichten	TF	VNMG160404-TF			●			0.4	9.525	4.76	3.81
		VNMG160408-TF		●	●			0.8	9.525	4.76	3.81
	01	VNGG160402-01	●		●	●	●	0.2	9.525	4.76	3.81
		VNGG160404-01			●	●	●	0.4	9.525	4.76	3.81
		VNGG160408-01			●	●		0.8	9.525	4.76	3.81



● Lagerstandard

TNGN...: Halter / Außendrehen → C027 -
VNMG..., VNGG...: Halter / Außendrehen → C059 -, Halter / Innendrehen → D070 -,
TungCap → K015 -

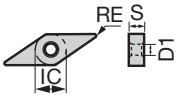
Wendeschneidplatten NEGATIV

● : Kontinuierlicher Schnitt
ɔ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

VN

Rhombisch, 35° mit Loch

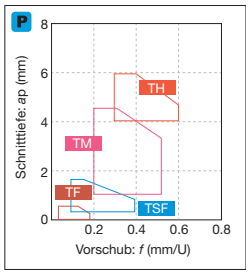
		T9205	T9215	T9225	T9235	T9105	T9115	T9125	T9135	T6120	T6130	AH630	AH120	GH330	GT9530	AT9530	NS9530	TH10
P	Stahl	●	●ɔ	●✣	✣	●	●ɔ	●✣	✣	ɔ	✣	ɔ✣	●ɔ	●ɔ	●ɔ	●ɔ	●ɔ	●
M	Rostfreier Stahl		●ɔ							●	ɔ		●ɔ	●ɔ				●
K	Eisenguss	●ɔ	●ɔ			●ɔ	●ɔ						●ɔ	●ɔ	●ɔ	●ɔ	●ɔ	●
N	Nichteisenmetalle																	●
S	Hitzebest. Legierungen												●ɔ					
H	Gehärteter Stahl																	

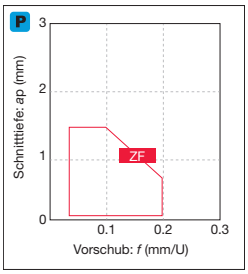


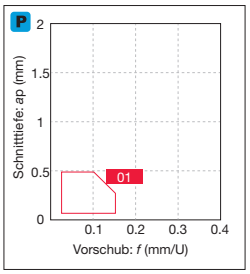
Anwendung	Spanformstufe	Katalog Nr.	RE	IC	S	D1
Schlichten	TSF	VNMG120402E-TSF	0.2	7.15	4.76	3.81
		VNMG120404E-TSF	0.4	7.15	4.76	3.81
		VNMG120408E-TSF	0.8	7.15	4.76	3.81
		VNMG160402-TSF	0.2	9.525	4.76	3.81
		VNMG160404-TSF	0.4	9.525	4.76	3.81
		VNMG160408-TSF	0.8	9.525	4.76	3.81
		VNMG160412-TSF	1.2	9.525	4.76	3.81
	ZF	VNMG160404-ZF	0.4	9.525	4.76	3.81
		VNMG160408-ZF	0.8	9.525	4.76	3.81
		VNMG160412-ZF	1.2	9.525	4.76	3.81
	11	VNMG160404-11	0.4	9.525	4.76	3.81
		VNMG160408-11	0.8	9.525	4.76	3.81
		VNMG160412-11	1.2	9.525	4.76	3.81
	SF	VNMG160404-SF	0.4	9.525	4.76	3.81
		VNMG160408-SF	0.8	9.525	4.76	3.81

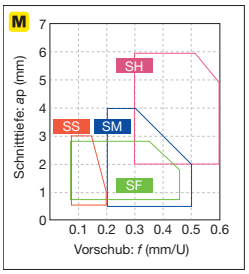
● Lagerstandard
▲ Wird eingestellt

Spankontrollbereich









Halter / Außendrehen → C054 -
TungCap → C061, K015 -
Halter / Innendrehen → D070 -

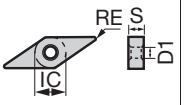
Wendeschneidplatten NEGATIV

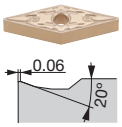
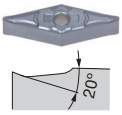
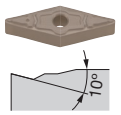
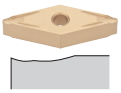
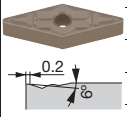
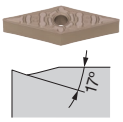
● : Kontinuierlicher Schnitt
c : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

VN

Rhombisch, 35° mit Loch

P	Stahl	●	●c	●✣	✣	●	●c	●✣	✣	c	✣	c✣	✣			●	●c			●c	●c	●c		●c	●c								
M	Rostfreier Stahl		●c							●	c	c	✣			●	●c	●	c	●c													
K	Eisenguss	●c	●c			●c	●c							●	c	●	●c			●c	●c	●c		●c	●c								
N	Nichteisen-metalle																																
S	Hitzebest. Legierungen															●	●c	●	c														
H	Gehärteter Stahl																																



Anwendung	Spanform-stufe	Katalog Nr.	Beschichtet																		Cermet besch.		Cermet		Größe (mm)			
			T9205	T9215	T9225	T9235	T9105	T9115	T9125	T9135	T6120	T6130	AH630	AH645	T5105	T5115	AH110	AH120	AH8005	AH8015	GH330	GT9530	AT9530	NS9530	NS520	RE	IC	S	D1
Schlichten	**CF**	**VNMG160404-CF**													●	●										0.4	9.525	4.76	3.81
		VNMG160408-CF													●	●										0.8	9.525	4.76	3.81
	HRF	**VNMG160404-HRF**																	●	●						0.4	9.525	4.76	3.81
		VNMG160408-HRF																	●	●						0.8	9.525	4.76	3.81
	TS	**VNMG160404-TS**		●	●	●		▲	▲	▲												●	●	●	●	0.4	9.525	4.76	3.81
		VNMG160408-TS		●	●	●		▲	▲	▲												●	●	●	●	0.8	9.525	4.76	3.81
		VNMG160412-TS		●	●	●		▲	▲	▲																1.2	9.525	4.76	3.81
	SS	**VNMG120404E-SS**									●	●	●	●												0.4	7.15	4.76	3.81
		VNMG120408E-SS									●	●	●	●												0.8	7.15	4.76	3.81
		VNMG160404-SS									●	●	●	●				●			●					0.4	9.525	4.76	3.81
		VNMG160408-SS									●	●	●	●				●			●					0.8	9.525	4.76	3.81
		VNMG160412-SS									●	●	●	●							●					1.2	9.525	4.76	3.81
Mittlere Bearbeitung	**TM**	**VNMG120404E-TM**		●	●			▲	▲																	0.4	7.15	4.76	3.81
		VNMG120408E-TM		●	●			▲	▲																	0.8	7.15	4.76	3.81
		VNMG160404-TM	●	●	●	●	▲	▲	▲	▲		●						●								0.4	9.525	4.76	3.81
		VNMG160408-TM	●	●	●	●	▲	▲	▲	▲							●	●								0.8	9.525	4.76	3.81
		VNMG160412-TM	●	●	●	●	▲	▲	▲	▲							●									1.2	9.525	4.76	3.81
Schlichten bis mittl. Bearbeitung	**TQ**	**VNMG160404-TQ**		●	●																	●	●	●		0.4	9.525	4.76	3.81
		VNMG160408-TQ		●	●																	●	●	●		0.8	9.525	4.76	3.81

● Lagerstandard
▲ Wird eingestellt

Halter / Außendrehen	→ C054 -	Halter / Innendrehen	→ D070 -
TungCap	→ C061, K015 -		

Wendeschneidplatten NEGATIV

● : Kontinuierlicher Schnitt
ɔ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

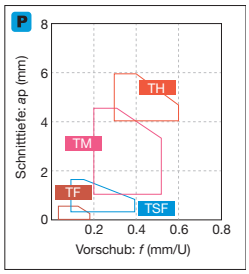
VN

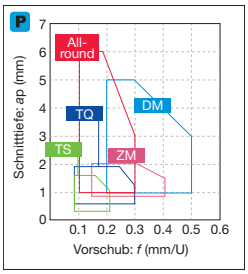
Rhombisch, 35° mit Loch

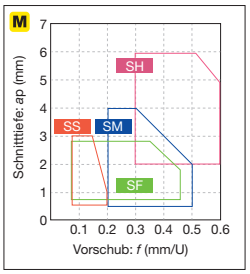
		Beschichtet															Cermet				Unbeschichtet				Größe (mm)			
Anwendung	Spanform-stufe	Katalog Nr.	T9205	T9215	T9225	T9235	T9105	T9115	T9125	T9135	T515	T5105	T5115	T5125	AH110	AH120	AH8005	AH8015	NS9530				TH10				RE	IC	S	D1
P	Stahl		●	●ɔ	●✣	✣	●	●ɔ	●✣	✣					●	●ɔ							●ɔ				●			
M	Rostfreier Stahl			●ɔ											●	●ɔ	●	ɔ					●				●			
K	Eisenguss		●ɔ	●ɔ			●ɔ	●ɔ			●ɔ	●	ɔ	✣	●	●ɔ							●ɔ				●			
N	Nichteisen-metalle																						●							
S	Hitzebest. Legierungen														●	●ɔ	●	ɔ												
H	Gehärteter Stahl																													
Schlichten bis mittl. Bearbeitung	**ZM**	**VNMG160408-ZM**		●	●	●		▲	▲	▲																	0.8	9.525	4.76	3.81
		VNMG160412-ZM		●	●	●		▲	▲	▲																	1.2	9.525	4.76	3.81
Mittlere Bearbeitung	**DM**	**VNMG160408-DM**	●	●	●	●	▲	▲	▲	▲																	0.8	9.525	4.76	3.81
		VNMG160412-DM		●	●	●		▲	▲	▲																	1.2	9.525	4.76	3.81
	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
	28	**VNMG160404-28**														●	●	●									0.4	9.525	4.76	3.81
		VNMG160408-28														●	●	●									0.8	9.525	4.76	3.81
	33	**VNMG160404-33**			●			▲							●								●				0.4	9.525	4.76	3.81
		VNMG160408-33		●	●			▲	▲														●				0.8	9.525	4.76	3.81

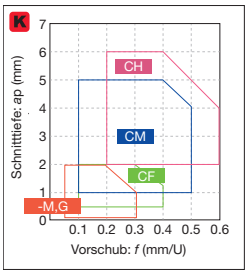
● Lagerstandard
▲ Wird eingestellt

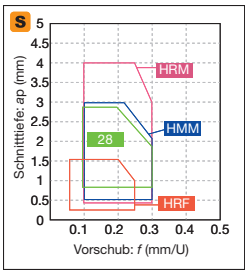
Spankontrollbereich











*-M,G: Ohne Spanformstufe

Halter / Außendrehen	→ C059 -	Halter / Innendrehen	→ D070 -
TungCap	→ C061, K015 -		

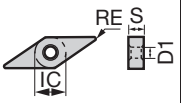
Wendeschneidplatten NEGATIV

● : Kontinuierlicher Schnitt
ɔ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

VN

Rhombisch, 35°
mit Loch

		T6120	T6130	AH630	AH645	T515	T5105	T5115	T5125	AH8005	AH8015	AH905	NS520	TH10	LX11
P	Stahl	ɔ	✣	●ɔ	✣								●ɔ	●	
M	Rostfreier Stahl	●	ɔ	ɔ	✣					●	ɔ			●	
K	Eisenguss					●ɔ	●	ɔ	✣				●ɔ	●	
N	Nichteisenmetalle													●	
S	Hitzebest. Legierungen									●	ɔ	ɔ			
H	Gehärteter Stahl														●



Anwendung	Spanformstufe	Katalog Nr.	RE	IC	S	D1
Mittlere Bearbeitung	SM	VNMG120404E-SM	0.4	7.15	4.76	3.81
		VNMG120408E-SM	0.8	7.15	4.76	3.81
		VNMG160404-SM	0.4	9.525	4.76	3.81
		VNMG160408-SM	0.8	9.525	4.76	3.81
		VNMG160412-SM	1.2	9.525	4.76	3.81
	CM	VNMG160408-CM	0.8	9.525	4.76	3.81
		VNMG160412-CM	1.2	9.525	4.76	3.81
Schlichten bis mittl. Bearbeitung	HRM	VNMG160404-HRM	0.4	9.525	4.76	3.81
		VNMG160408-HRM	0.8	9.525	4.76	3.81
		VNMG160412-HRM	1.2	9.525	4.76	3.81
Mittlere Bearbeitung	HMM	VNMG160404-HMM	0.4	9.525	4.76	3.81
		VNMG160408-HMM	0.8	9.525	4.76	3.81
		VNMG160412-HMM	1.2	9.525	4.76	3.81
Schlichten bis mittlere Bearbeitung	-	VNMA120404E	0.4	7.15	4.76	3.81
		VNMA120408E	0.8	7.15	4.76	3.81
		VNMA160402	0.2	9.525	4.76	3.81
		VNMA160404	0.4	9.525	4.76	3.81
		VNMA160408	0.8	9.525	4.76	3.81
		VNGA160404	0.4	9.525	4.76	3.81
		VNGA160408	0.8	9.525	4.76	3.81

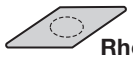
* Siehe Seiten **L032-L036** bezüglich der Anpassung des Bearbeitungsprogramms für die Konturbearbeitung mittels SW/FW.
Bei Fragen wenden Sie sich bitte an unsere Vertriebsmitarbeiter.

● Lagerstandard

Halter / Außendrehen → C054 -
TungCap → C061, K015 -
Halter / Innendrehen → D070 -

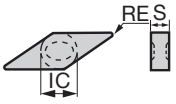
● : Kontinuierlicher Schnitt
◐ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

VN

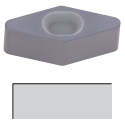


Rhombisch, 35° ohne Loch

P	Stahl	
M	Rostfreier Stahl	
K	Eisenguss	●◐
N	Nichteisenmetalle	
S	Hitzebest. Legierungen	
H	Gehärteter Stahl	



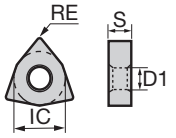
Anwendung	Spanformstufe	Katalog Nr.	Keramik FX105	RE	IC	S	D1
Schlichten bis mittl. Bearbeitung	-	VNGD160712	●	1.2	9.525	4.76	-



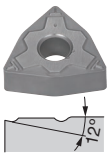
WN

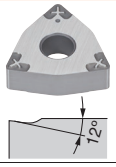
Trigonal, 80° mit Loch

P	Stahl	●◐ ●◐◐
M	Rostfreier Stahl	
K	Eisenguss	●◐ ●◐◐
N	Nichteisenmetalle	
S	Hitzebest. Legierungen	
H	Gehärteter Stahl	



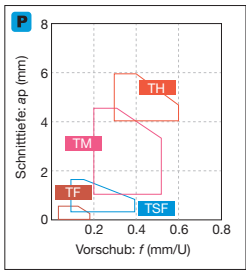
Anwendung	Spanformstufe	Katalog Nr.	Cermet besch. GT720	Cermet NS9530	Cermet NS520	RE	IC	S	D1
Feinschlichten	TF	WNMG080404-TF		●		0.4	12.7	4.76	5.16
		WNMG080408-TF		●		0.8	12.7	4.76	5.16
	01	WNGG080402-01		●	●	0.2	12.7	4.76	5.16
		WNGG080404-01	●	●	●	0.4	12.7	4.76	5.16
		WNGG080408-01	●	●		0.8	12.7	4.76	5.16

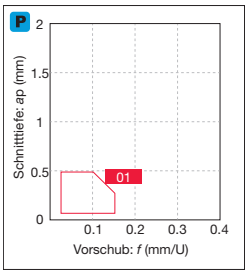


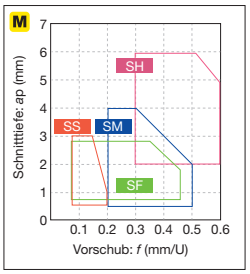


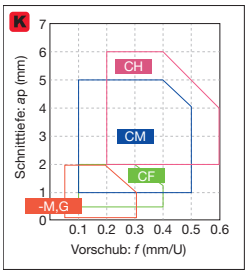
● Lagerstandard

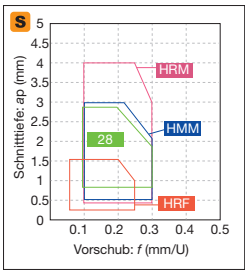
Spankontrollbereich











*-M,G: Ohne Spanformstufe

VNGD...: Halter / Außendrehen → C070
WNMG..., WNGG...: Halter / Außendrehen → C034 -, Halter / Innendrehen → D031 -,
TungCap → C035 -, K011 -

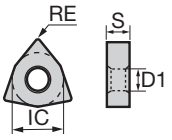
Wendeschneidplatten NEGATIV

● : Kontinuierlicher Schnitt
ɔ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

WN

Trigonal, 80° mit Loch

		T9205	T9215	T9225	T9235	T9105	T9115	T9125	T9135	AH120	GT9530	AT9530	NS9530
P	Stahl	●	●ɔ	ɔ✣	✣	●	●ɔ	ɔ✣	✣	●ɔ	●ɔ	●ɔ	●ɔ
M	Rostfreier Stahl		●ɔ							●ɔ			
K	Eisenguss	●ɔ	●ɔ			●ɔ	●ɔ			●ɔ	●ɔ	●ɔ	●ɔ
N	Nichteisenmetalle												
S	Hitzebest. Legierungen									●ɔ			
H	Gehärteter Stahl												



Anwendung	Spanformstufe	Katalog Nr.	T9205	T9215	T9225	T9235	T9105	T9115	T9125	T9135	AH120	GT9530	AT9530	NS9530	RE	IC	S	D1
			Beschichtet									Cermet besch.		Cermet	Größe (mm)			
Schlichten	TSF	WNMG060404E-TSF		●	●			▲	▲			●	●	●	0.4	9.525	4.76	3.81
		WNMG060408E-TSF		●	●			▲	▲			●	●	●	0.8	9.525	4.76	3.81
		WNMG060412E-TSF		●	●			▲	▲			●		●	1.2	9.525	4.76	3.81
		WNMG060404-TSF		●	●			▲	▲						0.4	9.525	4.76	3.81
		WNMG060408-TSF		●	●			▲	▲						0.8	9.525	4.76	3.81
		WNMG080404-TSF		●	●	●		▲	▲	▲	●	●	●	●	0.4	12.7	4.76	5.16
		WNMG080408-TSF		●	●	●		▲	▲	▲	●	●	●	●	0.8	12.7	4.76	5.16
		WNMG080412-TSF	●	●	●	●	▲	▲	▲	▲	●				1.2	12.7	4.76	5.16
Schlichten (Wiper)	FW	WNMG060404E-FW	●	●	●		▲	▲	▲			●		●	0.4	9.525	4.76	3.81
		WNMG060408E-FW	●	●	●		▲	▲	▲			●		●	0.8	9.525	4.76	3.81
		WNMG080404-FW		●	●			▲	▲			●		●	0.4	12.7	4.76	5.16
		WNMG080408-FW	●	●	●		▲	▲	▲			●		●	0.8	12.7	4.76	5.16
		*Wiper																
	AFW	WNMG060404-AFW		●	●			▲	▲					●	0.4	9.525	4.76	3.81
		WNMG060408-AFW	●	●	●	●	▲	▲	▲	▲				●	0.8	9.525	4.76	3.81
		WNMG080404-AFW		●	●			▲	▲					●	0.4	12.7	4.76	5.16
		WNMG080408-AFW	●	●	●	●	▲	▲	▲	▲				●	0.8	12.7	4.76	5.16
Schlichten	ZF	WNMG060404E-ZF		●	●			▲	▲						0.4	9.525	4.76	3.81
		WNMG060404-ZF		●	●			▲	▲						0.4	9.525	4.76	3.81
		WNMG060408-ZF		●	●			▲	▲						0.8	9.525	4.76	3.81
		WNMG080404-ZF		●	●	●		▲	▲	▲		●	●	●	0.4	12.7	4.76	5.16
		WNMG080408-ZF		●	●	●		▲	▲	▲		●	●	●	0.8	12.7	4.76	5.16
		WNMG080412-ZF		●				▲							1.2	12.7	4.76	5.16
	11	WNMG080404-11												●	0.4	12.7	4.76	5.16
		WNMG080408-11												●	0.8	12.7	4.76	5.16
Schlichten (Baustahl)	17	WNMG080404-17												●	0.4	12.7	4.76	5.16
		WNMG080408-17												●	0.8	12.7	4.76	5.16

* Siehe Seiten **L032-L036** bezüglich der Anpassung des Bearbeitungsprogramms für die Konturbearbeitung mittels SW/FW.
Bei Fragen wenden Sie sich bitte an unsere Vertriebsmitarbeiter.

● Lagerstandard
▲ Wird eingestellt

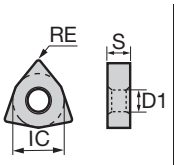
Halter / Außendrehen → C029 -
Halter / Innendrehen → D029 -
TungCap → C035 -, K011 -

● : Kontinuierlicher Schnitt
ɔ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

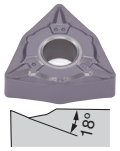
WN

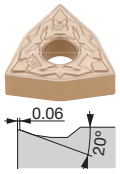
Trigonal, 80° mit Loch

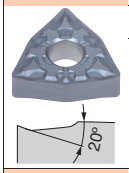
		T9205	T9215	T9225	T9235	T9115	T9125	T9135	T6120	T6130	AH630	T5105	T5115	AH8005	AH8015	GT9530	AT9530	NS9530	NS520
P	Stahl	●	●ɔ	●✣	✣	●ɔ	●✣	✣	ɔ	✣	ɔ✣					●ɔ	●ɔ		●ɔ
M	Rostfreier Stahl		●ɔ						●	ɔ	ɔ			●	ɔ				●ɔ
K	Eisenguss	●ɔ	●ɔ			●ɔ						●	ɔ			●ɔ	●ɔ	●ɔ	●ɔ
N	Nichteisenmetalle																		
S	Hitzebest. Legierungen													●	ɔ				
H	Gehärteter Stahl																		

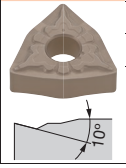


Anwendung	Spanformstufe	Katalog Nr.	RE	IC	S	D1
Schlichten	SF	WNMG060404-SF	0.4	9.525	4.76	3.81
		WNMG060408-SF	0.8	9.525	4.76	3.81
		WNMG080404-SF	0.4	12.7	4.76	5.16
		WNMG080408-SF	0.8	12.7	4.76	5.16
	CF	WNMG080404-CF	0.4	12.7	4.76	5.16
		WNMG080408-CF	0.8	12.7	4.76	5.16
		WNMG080412-CF	1.2	12.7	4.76	5.16
	HRF	WNMG080404-HRF	0.4	12.7	4.76	5.16
		WNMG080408-HRF	0.8	12.7	4.76	5.16
	TS	WNMG080404-TS	0.4	12.7	4.76	5.16
		WNMG080408-TS	0.8	12.7	4.76	5.16
		WNMG080412-TS	1.2	12.7	4.76	5.16



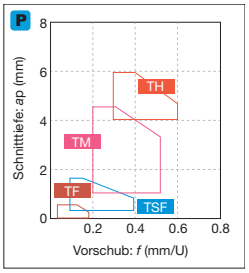


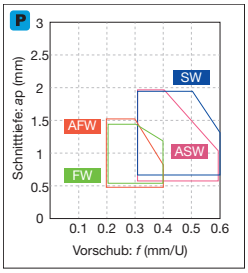


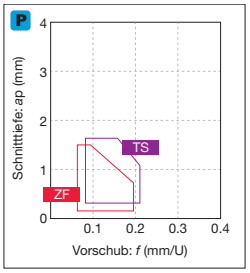


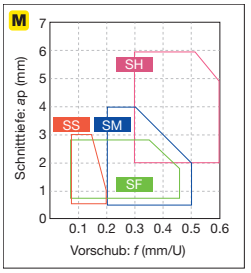
● Lagerstandard
▲ Wird eingestellt

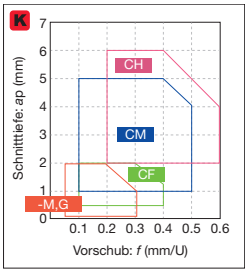
Spankontrollbereich



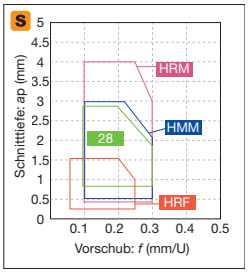








*-M,G: Ohne Spanformstufe



Halter / Außendrehen → C029 -
TungCap → C035 -, K011 -
Halter / Innendrehen → D029 -

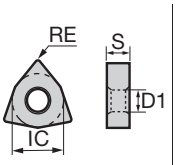
Wendeschneidplatten NEGATIV

● : Kontinuierlicher Schnitt
ɔ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

WN

Trigonal, 80° mit Loch

		T9205	T9215	T9225	T9235	T9105	T9115	T9125	T9135	T6120	T6130	AH630	AH645	T515	T5115	GH330	NS9530
P	Stahl	●	●ɔ	●✣	✣	●	●ɔ	●✣	✣	ɔ	✣	ɔ✣	✣			●ɔ	●ɔ
M	Rostfreier Stahl		●ɔ							●	ɔ	ɔ	✣			●ɔ	
K	Eisenguss	●ɔ	●ɔ			●ɔ	●ɔ							●ɔ	ɔ	●ɔ	●ɔ
N	Nichteisenmetalle																
S	Hitzebest. Legierungen																
H	Gehärteter Stahl																



Anwendung	Spanformstufe	Katalog Nr.	RE	IC	S	D1
Schlichten bis mittlere Bearbeitung (Wiper)	SW	WNMG060408E-SW	0.8	9.525	4.76	3.81
		WNMG060412E-SW	1.2	9.525	4.76	3.81
		WNMG080408-SW	0.8	12.7	4.76	5.16
		WNMG080412-SW	1.2	12.7	4.76	5.16
		*Wiper				
	ASW	WNMG060408-ASW	0.8	9.525	4.76	3.81
		WNMG060412-ASW	1.2	9.525	4.76	3.81
		WNMG080408-ASW	0.8	12.7	4.76	5.16
		WNMG080412-ASW	1.2	12.7	4.76	5.16
Hoher Vorschub, geringe Schnitttiefe	AS	WNMG080404-AS	0.4	12.7	4.76	5.16
		WNMG080408-AS	0.8	12.7	4.76	5.16
		WNMG080412-AS	1.2	12.7	4.76	5.16
Ausdrehen (doppelseitig)	CB	WNMG060404-CB	0.4	9.525	4.76	3.81
		WNMG060408-CB	0.8	9.525	4.76	3.81
Schlichten	NS	WNMG080404-NS	0.4	12.7	4.76	5.16
		WNMG080408-NS	0.8	12.7	4.76	5.16
	SS	WNMG060404E-SS	0.4	9.525	4.76	3.81
		WNMG060408E-SS	0.8	9.525	4.76	3.81
		WNMG060412E-SS	1.2	9.525	4.76	3.81
		WNMG080404-SS	0.4	12.7	4.76	5.16
		WNMG080408-SS	0.8	12.7	4.76	5.16
		WNMG080412-SS	1.2	12.7	4.76	5.16

* Siehe Seiten **L032-L036** bezüglich der Anpassung des Bearbeitungsprogramms für die Konturbearbeitung mittels SW/FW.
Bei Fragen wenden Sie sich bitte an unsere Vertriebsmitarbeiter.

● Lagerstandard
▲ Wird eingestellt

Halter / Außendrehen → C029 -
TungCap → C035 -, K011 -
Halter / Innendrehen → D029 -

● : Kontinuierlicher Schnitt
ɔ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

WN

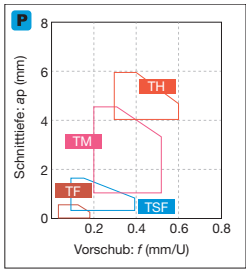
Trigonal, 80° mit Loch

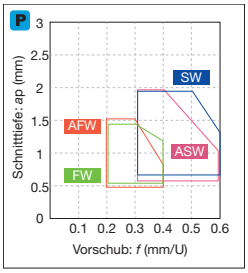
		T9205	T9215	T9225	T9235	T9105	T9115	T9125	T9135	AH120	AH725	GT9530	AT9530	NS9530
P	Stahl	●	●ɔ	●✣	✣	●	●ɔ	●✣	✣	●ɔ	ɔ	●ɔ	●ɔ	●ɔ
M	Rostfreier Stahl		●ɔ							●ɔ	ɔ			
K	Eisenguss	●ɔ	●ɔ			●ɔ	●ɔ			●ɔ	ɔ	●ɔ	●ɔ	●ɔ
N	Nichteisenmetalle													
S	Hitzebest. Legierungen									●ɔ	●			
H	Gehärteter Stahl													

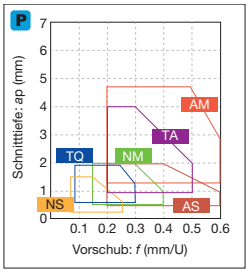
Anwendung	Spanformstufe	Katalog Nr.	RE	IC	S	D1
Mittlere Bearbeitung	TM	**WNMG060404E-TM**	0.4	9.525	4.76	3.81
		WNMG060408E-TM	0.8	9.525	4.76	3.81
		WNMG060412E-TM	1.2	9.525	4.76	3.81
		WNMG060404-TM	0.4	9.525	4.76	3.81
		WNMG060408-TM	0.8	9.525	4.76	3.81
		WNMG080404-TM	0.4	12.7	4.76	5.16
		WNMG080408-TM	0.8	12.7	4.76	5.16
		WNMG080412-TM	1.2	12.7	4.76	5.16
		WNMG080416-TM	1.6	12.7	4.76	5.16
Schlichten bis mittlere Bearbeitung	AM	**WNMG080408-AM**	0.8	12.7	4.76	5.16
		WNMG080412-AM	1.2	12.7	4.76	5.16
		WNMG080416-AM	1.6	12.7	4.76	5.16
	TQ	**WNMG080404-TQ**	0.4	12.7	4.76	5.16
		WNMG080408-TQ	0.8	12.7	4.76	5.16
Mittlere Bearbeitung	TA	**WNMG080408-TA**	0.8	12.7	4.76	5.16
		WNMG080412-TA	1.2	12.7	4.76	5.16
Schlichten bis mittlere Bearbeitung	NM	**WNMG060412E-NM**	1.2	9.525	4.76	3.81
		WNMG080408-NM	0.8	12.7	4.76	5.16
		WNMG080412-NM	1.2	12.7	4.76	5.16

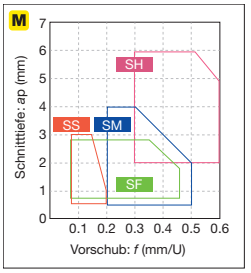
● Lagerstandard
▲ Wird eingestellt

Spankontrollbereich









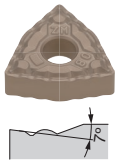
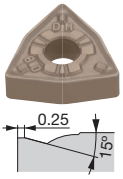
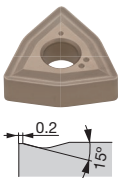
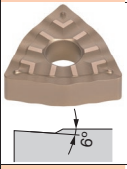
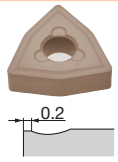
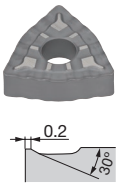
Halter / Außendrehen → C029 -
Halter / Innendrehen → D029 -
TungCap → C035 -, K011 -

Wendeschneidplatten NEGATIV

● : Kontinuierlicher Schnitt
ɔ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

WN

Trigonal, 80° mit Loch

		Beschichtet															Cermet besch.		Cermet		Unbeschichtet	Größe (mm)			
Anwendung	Spanformstufe	Katalog Nr.	T9205	T9215	T9225	T9235	T9105	T9115	T9125	T9135	T515	T5105	T5115	T5125	AH110	AH120	GH330	GT720	GT9530	NS9530	NS520	TH10	RE	IC	S	D1
P Stahl			●	●ɔ	●✣	✣	●	●ɔ	●✣	✣					●	●ɔ	●ɔ		●ɔ	●ɔ	●ɔ		●			
M Rostfreier Stahl				●ɔ											●	●ɔ	●ɔ						●			
K Eisenguss			●ɔ	●ɔ			●ɔ	●ɔ			●ɔ	●	ɔ	✣	●	●ɔ	●ɔ		●ɔ	●ɔ	●ɔ		●			
N Nichteisenmetalle																							●			
S Hitzebest. Legierungen															●	●ɔ										
H Gehärteter Stahl																										
Schlichten bis mittlere Bearbeitung	**ZM**	**WNMG060408E-ZM**		●	●			▲	▲														0.8	9.525	4.76	3.81
		WNMG060408-ZM		●	●	●		▲	▲	▲													0.8	9.525	4.76	3.81
		WNMG060412-ZM		●	●	●		▲	▲	▲													1.2	9.525	4.76	3.81
		WNMG080408-ZM		●	●	●		▲	▲	▲									●	●			0.8	12.7	4.76	5.16
		WNMG080412-ZM		●	●	●		▲	▲	▲													1.2	12.7	4.76	5.16
		WNMG080416-ZM		●	●			▲	▲														1.6	12.7	4.76	5.16
Mittlere Bearbeitung	**DM**	**WNMG080408-DM**	●	●	●	●	▲	▲	▲	▲													0.8	12.7	4.76	5.16
		WNMG080412-DM	●	●	●	●	▲	▲	▲	▲													1.2	12.7	4.76	5.16
	All-round	**WNMG060404**		●	●			▲	▲			●	●	●									0.4	9.525	4.76	3.81
		WNMG060408		●	●			▲	▲			●	●	●									0.8	9.525	4.76	3.81
		WNMG080404	●	●	●	●	▲	▲	▲	▲	●	●	●	●	●	●				●		●	0.4	12.7	4.76	5.16
		WNMG080408	●	●	●	●	▲	▲	▲	▲	●	●	●	●	●	●				●	●	●	0.8	12.7	4.76	5.16
		WNMG080412	●	●	●	●	▲	▲	▲	▲	●	●	●	●	●	●						●	1.2	12.7	4.76	5.16
		WNMG080416	●	●	●	●	▲	▲	▲	▲	●	●	●	●									1.6	12.7	4.76	5.16
Schlichten bis mittl. Bearbeitung	**27**	**WNMG080408-27**			●				▲														0.8	12.7	4.76	5.16
																										
Mittlere Bearbeitung	**33**	**WNMG080404-33**																●					0.4	12.7	4.76	5.16
		WNMG080408-33					▲															●	0.8	12.7	4.76	5.16
	37	**WNMG080404-37**																		●			0.4	12.7	4.76	5.16
		WNMG080408-37		●				▲									●			●			0.8	12.7	4.76	5.16

● Lagerstandard
▲ Wird eingestellt

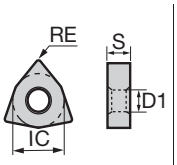
Halter / Außendrehen	→ C029 -	Halter / Innendrehen	→ D029 -
TungCap	→ C035 -, K011 -		

● : Kontinuierlicher Schnitt
ɔ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

WN

Trigonal, 80° mit Loch

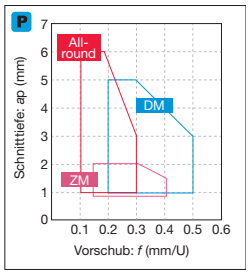
P	Stahl	ɔ	✣	●ɔ	✣					●ɔ	ɔ																						
M	Rostfreier Stahl	●	ɔ	ɔ	✣					●ɔ	ɔ	●	ɔ																				
K	Eisenguss					●ɔ	●	ɔ	✣	●ɔ	ɔ								●✣														
N	Nichteisen-metalle																		●✣														
S	Hitzebest. Legierungen									●ɔ	●	●	ɔ	ɔ					●✣														
H	Gehärteter Stahl																																

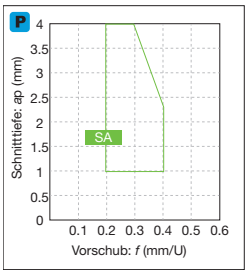


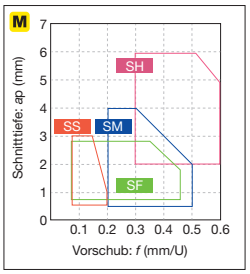
Anwendung	Spanform-stufe	Katalog Nr.	Beschichtet													Unbeschichtet											Größe (mm)			
			T6120	T6130	AH630	AH645	T515	T5105	T5115	T5125	AH120	AH725	AH8005	AH8015	AH905	KS20											RE	IC	S	D1
Mittlere Bearbeitung	**SM**	**WNMG060404E-SM**	●	●	●																						0.4	9.525	4.76	3.81
		WNMG060408E-SM	●	●	●																						0.8	9.525	4.76	3.81
		WNMG060412E-SM	●	●	●																						1.2	9.525	4.76	3.81
		WNMG060408-SM										●															0.8	9.525	4.76	3.81
		WNMG080404-SM	●	●	●	●																					0.4	12.7	4.76	5.16
		WNMG080408-SM	●	●	●	●						●															0.8	12.7	4.76	5.16
		WNMG080412-SM	●	●	●	●						●															1.2	12.7	4.76	5.16
	CM	**WNMG080404-CM**							●																		0.4	12.7	4.76	5.16
		WNMG080408-CM					●	●	●	●																	0.8	12.7	4.76	5.16
		WNMG080412-CM					●	●	●	●																	1.2	12.7	4.76	5.16
Schlichten bis mittl. Bearbeitung	**HRM**	**WNMG080404-HRM**											●	●													0.4	12.7	4.76	5.16
		WNMG080408-HRM											●	●													0.8	12.7	4.76	5.16
		WNMG080412-HRM											●	●													1.2	12.7	4.76	5.16
Mittlere Bearbeitung	**HMM**	**WNMG080404-HMM**													●												0.4	12.7	4.76	5.16
		WNMG080408-HMM													●												0.8	12.7	4.76	5.16
		WNMG080412-HMM													●												1.2	12.7	4.76	5.16
	SA	**WNMG080408-SA**	●	●	●	●					●	●				●											0.8	12.7	4.76	5.16
		WNMG080412-SA	●	●	●	●					●																1.2	12.7	4.76	5.16

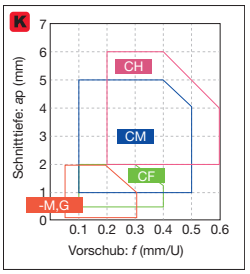
● Lagerstandard

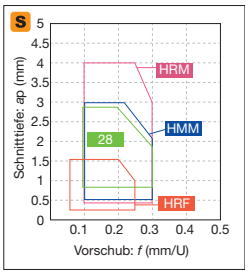
Spankontrollbereich











*-M,G: Ohne Spanformstufe

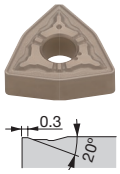
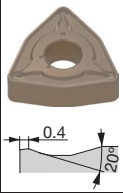
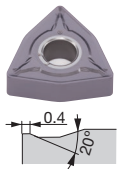
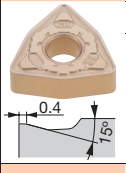
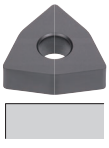
Halter / Außendrehen → C029 - Halter / Innendrehen → D029 -
TungCap → C035 -, K011 -

Wendeschneidplatten NEGATIV

● : Kontinuierlicher Schnitt
ⓒ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

WN

Trigonal, 80° mit Loch

		Beschichtet															Cermet		Unbeschichtet		Keramik		Größe (mm)			
Anwendung	Spanformstufe	Katalog Nr.	T9205	T9215	T9225	T9235	T9105	T9115	T9125	T9135	T6130	AH630	AH645	T515	T5105	T5115	T5125	AH120	NS520		TH10		LX11		RE	IC	S	D1
Mittlere Bearbeitung bis Schwerzerspanung	TH	WNMG080408-TH	●	●	●	●	▲	▲	▲	▲	●							●							0.8	12.7	4.76	5.16
		WNMG080412-TH	●	●	●	●	▲	▲	▲	▲								●							1.2	12.7	4.76	5.16
		WNMG080416-TH	●	●	●		▲	▲	▲																1.6	12.7	4.76	5.16
		WNMG100612-TH		●	●			▲	▲																1.2	15.875	6.35	6.35
		WNMG100616-TH		●	●			▲	▲																1.6	15.875	6.35	6.35
	THS	WNMG080408-THS	●	●	●	●	▲	▲	▲	▲															0.8	12.7	4.76	5.16
		WNMG080412-THS	●	●	●	●	▲	▲	▲	▲															1.2	12.7	4.76	5.16
		WNMG080416-THS		●	●			▲	▲																1.6	12.7	4.76	5.16
		WNMG100612-THS		●	●	●		▲	▲	▲															1.2	15.875	6.35	6.35
		WNMG100616-THS		●	●	●		▲	▲	▲															1.6	15.875	6.35	6.35
	SH	WNMG080408-SH									●	●	●												0.8	12.7	4.76	5.16
		WNMG080412-SH									●	●	●												1.2	12.7	4.76	5.16
	CH	WNMG080408-CH													●	●	●								0.8	12.7	4.76	5.16
		WNMG080412-CH													●	●	●								1.2	12.7	4.76	5.16
Schlichten bis mittlere Bearbeitung	-	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
		WNMA080404													●	●	●				●				0.4	12.7	4.76	5.16
		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
		WNGA080404																							0.4	12.7	4.76	5.16
		WNGA080408																					●		0.8	12.7	4.76	5.16
		WNGA080412																					●		1.2	12.7	4.76	5.16
																							●					

● Lagerstandard
▲ Wird eingestellt

Halter / Außendrehen	→ C029 -	Halter / Innendrehen	→ D029 -
TungCap	→ C035 -, K011 -		

Wendeschneidplatten NEGATIV

● : Kontinuierlicher Schnitt
ɔ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

YN

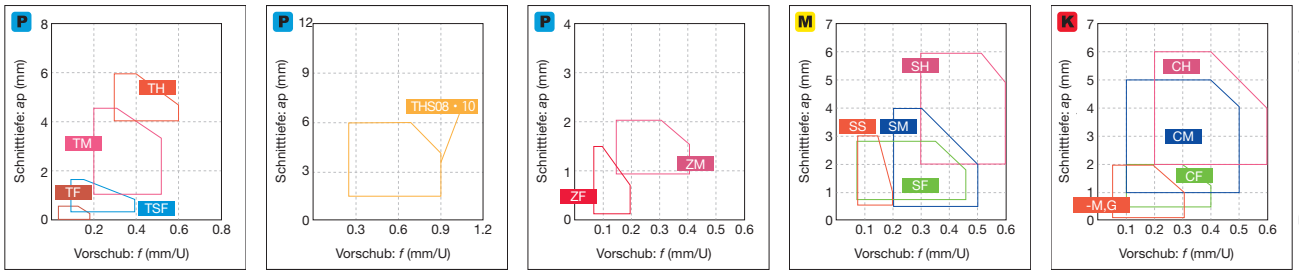
Rhombisch, 25° mit Loch

		Beschichtet				Cermet besch.	Cermet								Größe (mm)			
		T9125	T9225	T9235	T9135	GT9530	NS9530								RE	IC	S	D1
P	Stahl	ɔ✣	ɔ✣	✣	✣	●ɔ			●ɔ									
M	Rostfreier Stahl																	
K	Eisenguss					●ɔ			●ɔ									
N	Nichteisen-metalle																	
S	Hitzebest. Legierungen																	
H	Gehärteter Stahl																	

Anwendung	Spanform-stufe	Katalog Nr.	T9125	T9225	T9235	T9135	GT9530	NS9530	RE	IC	S	D1
Schlichten	ZF	YNMG160404-ZF	●	●	●	▲	●	●	0.4	9.525	4.76	3.81
		YNMG160408-ZF	●	●	●	▲	●	●	0.8	9.525	4.76	3.81
Schlichten bis mittl. Bearbeitung	ZM	YNMG160404-ZM	●	●	●	▲	●	●	0.4	9.525	4.76	3.81
		YNMG160408-ZM	●	●	●	▲	●	●	0.8	9.525	4.76	3.81

● Lagerstandard
▲ Wird eingestellt

Spankontrollbereich



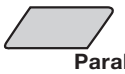
*-M,G: Ohne Spanformstufe

YNMG...: Halter / Außendrehen → C059 -, Halter / Innendrehen → D073 -

Wendeschneidplatten NEGATIV

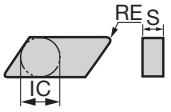
● : Kontinuierlicher Schnitt
ɔ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

KN

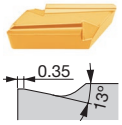


Parallelogram, 55° ohne Loch

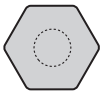
P	Stahl	●ɔ
M	Rostfreier Stahl	●ɔ
K	Eisenguss	●ɔ
N	Nichteisen-metalle	
S	Hitzebest. Legierungen	
H	Gehärteter Stahl	



Anwendung	Spanform-stufe	Katalog Nr.	Beschichtet GH330	Größe (mm) RE	IC	S	D1
Schlichten	S1	KNMX160405R-S1	●	0.5	9.525	4.76	-
		KNMX160405L-S1	●	0.5	9.525	4.76	-

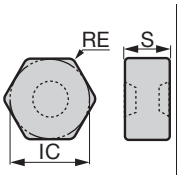


HN



Sechseckig, 120° ohne Loch

P	Stahl	
M	Rostfreier Stahl	
K	Eisenguss	●ɔ
N	Nichteisen-metalle	
S	Hitzebest. Legierungen	
H	Gehärteter Stahl	



Anwendung	Spanform-stufe	Katalog Nr.	Keramik FX105	Größe (mm) RE	IC	S	D1
Schlichten bis mittlere Bearbeitung	-	HNGD050712	●	1.2	12.7	7.94	-
		HNGD050716	●	1.6	12.7	7.94	-

● Lagerstandard

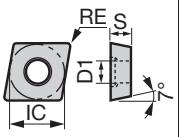
HNGD...: Halter / Außendrehen → C105

● : Kontinuierlicher Schnitt
ⓒ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

CC

Rhombisch, 80°
mit Loch
Positiv 7°

		T9215	T9225	T9115	T9125	T6130	AH725	AH8005	AH8015	GH730	SH725	J740	GT9530	NS9530
P	Stahl	●ⓒ	ⓒ✣	●ⓒ	ⓒ✣	✣	ⓒ			ⓒ	●ⓒ	●ⓒ	●ⓒ	●ⓒ
M	Rostfreier Stahl	●ⓒ				ⓒ	ⓒ	●	ⓒ	ⓒ	●ⓒ	●ⓒ		
K	Eisenguss	●ⓒ		●ⓒ			ⓒ			ⓒ			●ⓒ	●ⓒ
N	Nichteisen-metalle													
S	Hitzebest. Legierungen						●	●	ⓒ					
H	Gehärteter Stahl													

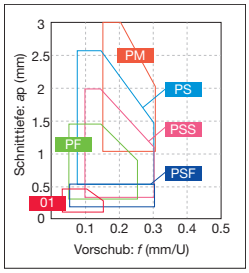


Anwendung	Spanformstufe	Katalog Nr.	RE	IC	S	D1
Feinschlichten	01	CCGT060202-01	0.2	6.35	2.38	2.8
		CCGT09T302-01	0.2	9.525	3.97	4.4
Feinschlichten (scharfkantig)	01	CCGT060202F-01	<0.2	6.35	2.38	2.8
		CCGT060204F-01	<0.4	6.35	2.38	2.8
		CCGT09T302F-01	<0.2	9.525	3.97	4.4
		CCGT09T304F-01	<0.4	9.525	3.97	4.4
Schlichten	PSF	CCMT060202-PSF	0.2	6.35	2.38	2.8
		CCMT060204-PSF	0.4	6.35	2.38	2.8
		CCMT09T302-PSF	0.2	9.525	3.97	4.4
		CCMT09T304-PSF	0.4	9.525	3.97	4.4
		CCMT09T308-PSF	0.8	9.525	3.97	4.4
	PF	CCMT060202-PF	0.2	6.35	2.38	2.8
		CCMT060204-PF	0.4	6.35	2.38	2.8
		CCMT060208-PF	0.8	6.35	2.38	2.8
		CCMT09T302-PF	0.2	9.525	3.97	4.4
		CCMT09T304-PF	0.4	9.525	3.97	4.4
		CCMT09T308-PF	0.8	9.525	3.97	4.4

*Eckenradius (RE) mit einem Kleiner-als-Zeichen (<) bedeutet eine Minustoleranz.

● Lagerstandard
▲ Wird eingestellt

Spankontrollbereich



Halter / Außendrehen	→ C024 -	Halter / Innendrehen	→ D014
J-Serie Werkzeughalter	→ G019 -	PINZBOHR®	→ K180 -

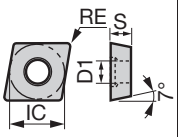
Wendeschneidplatten POSITIV

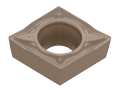
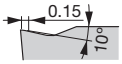
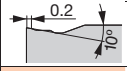
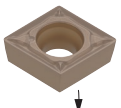
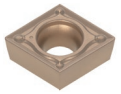
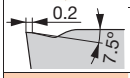
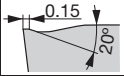
● : Kontinuierlicher Schnitt
ɔ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

CC

Rhombisch, 80°
mit Loch
Positiv 7°

P	Stahl	●ɔ	ɔ✣	●ɔ	ɔ✣	ɔ	✣	ɔ✣	✣	●ɔ	ɔ			ɔ			●ɔ	●ɔ			●ɔ										
M	Rostfreier Stahl	●ɔ				●	ɔ	ɔ	✣	●ɔ	ɔ	●	ɔ	ɔ																	
K	Eisenguss	●ɔ		●ɔ						●ɔ	ɔ			ɔ			●ɔ	●ɔ			●ɔ										
N	Nichteisen-metalle																														
S	Hitzebest. Legierungen									●ɔ	●	●	ɔ																		
H	Gehärteter Stahl																														



Anwendung	Spanform-stufe	Katalog Nr.	Beschichtet													Cermet besch.		Cermet		Größe (mm)			
			T9215	T9225	T9115	T9125	T6120	T6130	AH630	AH645	AH120	AH725	AH8005	AH8015	GH730	GT9530	AT9530	NS9530		RE	IC	S	D1
Schlichten bis leichte Bearbeitung	**PSS**	**CCMT060204-PSS**	●	●	▲	▲	●	●	●	●		●	●	●		●		●		0.4	6.35	2.38	2.8
		CCMT06020**8-PSS**	●	●	▲	▲	●	●	●	●		●	●	●		●		●		0.8	6.35	2.38	2.8
		CCMT09T304-PSS	●	●	▲	▲	●	●	●	●		●	●	●		●		●		0.4	9.525	3.97	4.4
		CCMT09T3**08-PSS**	●	●	▲	▲	●	●	●	●		●	●	●		●		●		0.8	9.525	3.97	4.4
		CCMT120404-PSS	●	●	▲	▲	●	●	●	●		●								0.4	12.7	4.76	5.5
		CCMT12040**8-PSS**	●	●	▲	▲	●	●	●	●		●								0.8	12.7	4.76	5.5
		CCMT12041**2-PSS**	●	●	▲	▲	●	●	●	●		●								1.2	12.7	4.76	5.5
Mittlere Bearbeitung (Wiper)	**SW**	**CCMT060204-SW**	●	●	▲	▲														0.4	6.35	2.38	2.8
		CCMT06020**8-SW**	●	●	▲	▲														0.8	6.35	2.38	2.8
		CCMT09T304-SW	●	●	▲	▲														0.4	9.525	3.97	4.4
		CCMT09T3**08-SW**	●	●	▲	▲														0.8	9.525	3.97	4.4
		*Wiper																					
Schlichten bis mittlere Bearbeitung	**PS**	**CCMT060202-PS**	●	●	▲	▲	●	●	●	●	●	●	●	●	●	●	●	●		0.2	6.35	2.38	2.8
		CCMT06020**4-PS**	●	●	▲	▲	●	●	●	●	●	●	●	●	●	●	●	●		0.4	6.35	2.38	2.8
		CCMT06020**8-PS**	●	●	▲	▲	●	●	●	●	●	●	●	●	●	●	●	●		0.8	6.35	2.38	2.8
		CCMT09T302-PS	●	●	▲	▲	●	●	●	●	●	●	●	●	●	●	●	●		0.2	9.525	3.97	4.4
		CCMT09T3**04-PS**	●	●	▲	▲	●	●	●	●	●	●	●	●	●	●	●	●		0.4	9.525	3.97	4.4
		CCMT09T3**08-PS**	●	●	▲	▲	●	●	●	●	●	●	●	●	●	●	●	●		0.8	9.525	3.97	4.4
		CCMT120404-PS	●	●	▲	▲	●	●	●	●		●	●	●						0.4	12.7	4.76	5.5
		CCMT12040**8-PS**	●	●	▲	▲	●	●	●	●		●	●	●						0.8	12.7	4.76	5.5
		CCMT12041**2-PS**	●	●	▲	▲	●	●	●	●		●								1.2	12.7	4.76	5.5
	TSF	**CCMT060204-TSF**	●	●																0.4	6.35	2.38	2.8
		CCMT06020**8-TSF**	●	●																0.8	6.35	2.38	2.8
		CCMT09T304-TSF	●	●																0.4	9.525	3.97	4.4
		CCMT09T3**08-TSF**	●	●																0.8	9.525	3.97	4.4
																							
	TM	**CCMT060204-TM**	●	●																0.4	6.35	2.38	2.8
		CCMT06020**8-TM**	●	●																0.8	6.35	2.38	2.8
		CCMT09T304-TM	●	●																0.4	9.525	3.97	4.4
		CCMT09T3**08-TM**	●	●																0.8	9.525	3.97	4.4
																							

* Siehe Seiten **L032-L036** bezüglich der Anpassung des Bearbeitungsprogramms für die Konturbearbeitung mittels SW/FW.
Bei Fragen wenden Sie sich bitte an unsere Vertriebsmitarbeiter.

● Lagerstandard
▲ Wird eingestellt

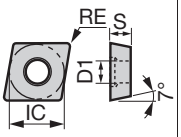
Halter / Außendrehen → C024 -
J-Serie Werkzeughalter → G019 -
Halter / Innendrehen → D014
PINZBOHR® → K180 -

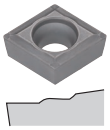
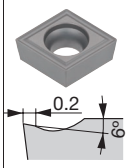
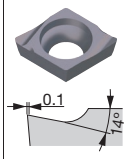
● : Kontinuierlicher Schnitt
◐ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

CC

Rhombisch, 80°
mit Loch
Positiv 7°

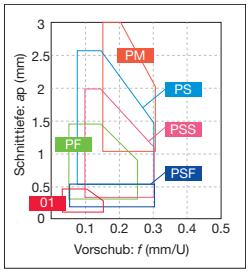
P	Stahl	●◐	◐✣	●◐	◐✣	✣	●◐	●◐					●◐					●																
M	Rostfreier Stahl	●◐				◐	●◐	●◐										●																
K	Eisenguss	●◐		●◐			●◐						●◐					●																
N	Nichteisen-metalle																	●																
S	Hitzebest. Legierungen						●◐	●◐																										
H	Gehärteter Stahl																																	

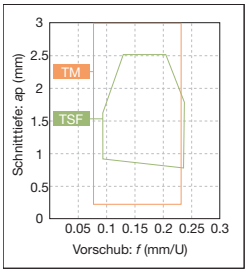


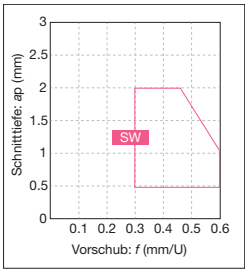
Anwendung	Spanform-stufe	Katalog Nr.	Beschichtet								Cermet		Unbeschichtet				Größe (mm)			
			T9215	T9225	T9115	T9125	T6130	AH120	SH730		NS9530		TH10				RE	IC	S	D1
Schlichten bis mittl. Bearbeitung	23	CCMT060202-23									●						0.2	6.35	2.38	2.8
		CCMT060204-23		●		▲					●						0.4	6.35	2.38	2.8
		CCMT060208-23		●		▲											0.8	6.35	2.38	2.8
		CCMT09T304-23		●		▲					●						0.4	9.525	3.97	4.4
		CCMT09T308-23		●		▲					●						0.8	9.525	3.97	4.4
Mittlere Bearbeitung	24	CCMT060202-24		●		▲					●						0.2	6.35	2.38	2.8
		CCMT060204-24	●	●	▲	▲		●			●						0.4	6.35	2.38	2.8
		CCMT060208-24	●	●	▲	▲	●				●						0.8	6.35	2.38	2.8
		CCMT09T302-24		●		▲					●						0.2	9.525	3.97	4.4
		CCMT09T304-24	●	●	▲	▲					●						0.4	9.525	3.97	4.4
		CCMT09T308-24	●	●	▲	▲	●				●						0.8	9.525	3.97	4.4
		CCMT120408-24	●	●	▲	▲		●			●						0.8	12.7	4.76	5.5
Schlichten	W08	CCGT03X100R-W08							●				●				0.03	3.57	1.39	1.9
		CCGT03X100L-W08							●				●				0.03	3.57	1.39	1.9
		CCGT03X101R-W08							●				●				0.1	3.57	1.39	1.9
		CCGT03X101L-W08							●				●				0.1	3.57	1.39	1.9
		CCGT03X102R-W08							●				●				0.2	3.57	1.39	1.9
		CCGT03X102L-W08							●				●				0.2	3.57	1.39	1.9
		CCGT03X104R-W08							●				●				0.4	3.57	1.39	1.9
		CCGT03X104L-W08							●				●				0.4	3.57	1.39	1.9
		CCGT04T100R-W08							●				●				0.03	4.37	1.79	2.2
		CCGT04T100L-W08							●				●				0.03	4.37	1.79	2.2
		CCGT04T101R-W08							●				●				0.1	4.37	1.79	2.2
		CCGT04T101L-W08							●				●				0.1	4.37	1.79	2.2
		CCGT04T102R-W08							●				●				0.2	4.37	1.79	2.2
		CCGT04T102L-W08							●				●				0.2	4.37	1.79	2.2
		CCGT04T104R-W08							●				●				0.4	4.37	1.79	2.2
		CCGT04T104L-W08							●				●				0.4	4.37	1.79	2.2

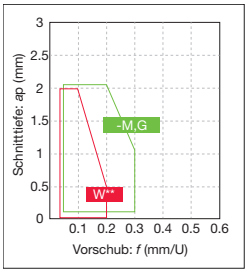
● Lagerstandard
▲ Wird eingestellt

Spankontrollbereich









*-M,G: Ohne Spanformstufe

Halter / Außendrehen	→ C024 -	Halter / Innendrehen	→ D014
J-Serie Werkzeughalter	→ G019 -	PINZBOHR®	→ K180 -

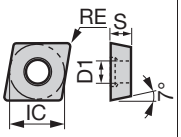
Wendeschneidplatten POSITIV

● : Kontinuierlicher Schnitt
c : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

CC

Rhombisch, 80°
mit Loch
Positiv 7°

		T9215	T9225	T9115	T9125	T6120	T6130	AH630	AH645	T515	T5115	AH120	AH725	GH110	GH330	GH730	SH725	GT9530	NS9530	TH10	UX30
P	Stahl	●c	c✣	●c	c✣	c	✣	c✣	✣			●c	c	●	●c	c	●c	●c	●c	●	c
M	Rostfreier Stahl	●c				●	c	c	✣			●c	c	●	●c	c	●c			●	c
K	Eisenguss	●c		●c						●c	c	●c	c	●	●c	c		●c	●c	●	
N	Nichteisen-metalle																			●	
S	Hitzebest. Legierungen											●c	●	●							
H	Gehärteter Stahl																				



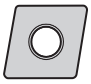
Anwendung	Spanform-stufe	Katalog Nr.	RE	IC	S	D1
Schlichten (scharfkantig)	W08	CCGT03X100FL-W08	0.03	3.57	1.39	1.9
		CCGT03X100FR-W08	0.03	3.57	1.39	1.9
		CCGT03X101FL-W08	0.1	3.57	1.39	1.9
		CCGT03X101FR-W08	0.1	3.57	1.39	1.9
		CCGT03X102FL-W08	0.2	3.57	1.39	1.9
		CCGT03X102FR-W08	0.2	3.57	1.39	1.9
		CCGT03X104FL-W08	0.4	3.57	1.39	1.9
		CCGT03X104FR-W08	0.4	3.57	1.39	1.9
		CCGT04T100FL-W08	0.03	4.37	1.79	2.2
		CCGT04T100FR-W08	0.03	4.37	1.79	2.2
		CCGT04T101FL-W08	0.1	4.37	1.79	2.2
		CCGT04T101FR-W08	0.1	4.37	1.79	2.2
		CCGT04T102FL-W08	0.2	4.37	1.79	2.2
		CCGT04T102FR-W08	0.2	4.37	1.79	2.2
		CCGT04T104FL-W08	0.4	4.37	1.79	2.2
		CCGT04T104FR-W08	0.4	4.37	1.79	2.2
Schlichten	W15	CCGT060200R-W15	0.03	6.35	2.38	2.8
		CCGT060200L-W15	0.03	6.35	2.38	2.8
		CCGT060202R-W15	0.2	6.35	2.38	2.8
		CCGT060202L-W15	0.2	6.35	2.38	2.8
		CCGT060204R-W15	0.4	6.35	2.38	2.8
		CCGT060204L-W15	0.4	6.35	2.38	2.8
	W20	CCGT09T302R-W20	0.2	9.525	3.97	4.4
		CCGT09T302L-W20	0.2	9.525	3.97	4.4
		CCGT09T304R-W20	0.4	9.525	3.97	4.4
		CCGT09T304L-W20	0.4	9.525	3.97	4.4
		CCGT09T308R-W20	0.8	9.525	3.97	4.4
		CCGT09T308L-W20	0.8	9.525	3.97	4.4
Mittlere Bearbeitung	PM	CCMT060204-PM	0.4	6.35	2.38	2.8
		CCMT060208-PM	0.8	6.35	2.38	2.8
		CCMT09T304-PM	0.4	9.525	3.97	4.4
		CCMT09T308-PM	0.8	9.525	3.97	4.4
		CCMT09T312-PM	1.2	9.525	3.97	4.4
		CCMT120408-PM	0.8	12.7	4.76	5.5
		CCMT120412-PM	1.2	12.7	4.76	5.5
Schlichten bis mittlere Bearbeitung	CM	CCMT060204-CM	0.4	6.35	2.38	2.8
		CCMT060208-CM	0.8	6.35	2.38	2.8
		CCMT09T304-CM	0.4	9.525	3.97	4.4
		CCMT09T308-CM	0.8	9.525	3.97	4.4
		CCMT09T312-CM	1.2	9.525	3.97	4.4
		CCMT120404-CM	0.4	12.7	4.76	5.5
		CCMT120408-CM	0.8	12.7	4.76	5.5

● Lagerstandard
▲ Wird eingestellt

Halter / Außendrehen → C024 -
J-Serie Werkzeughalter → G019 -
Halter / Innendrehen → D016 -
PINZBOHR® → K180 -

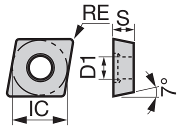
● : Kontinuierlicher Schnitt
◐ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

CC

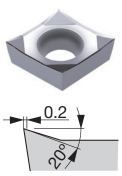
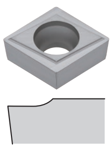
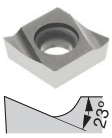
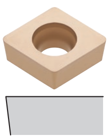
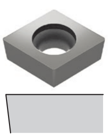


Rhombisch, 80° mit Loch Positiv 7°

		T5115	GH110	NS9530	TH10	KS05F
P	Stahl		●	●◐	●	
M	Rostfreier Stahl		●		●	
K	Eisenguss	◐	●	●◐	●	●
N	Nichteisenmetalle				●	●
S	Hitzebest. Legierungen		●			●
H	Gehärteter Stahl					

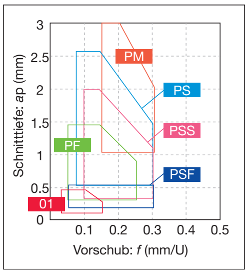


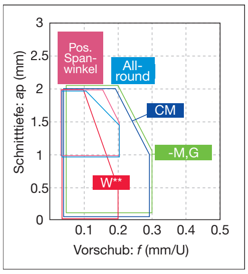
Anwendung: Schlichten bis mittlere Bearbeitung

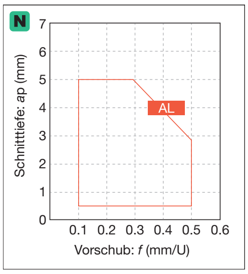
Spanformstufe	Katalog Nr.	T5115 (Beschichtet)	GH110 (Beschichtet)	NS9530 (Cermet)	TH10 (Unbeschichtet)	KS05F (Unbeschichtet)	RE	IC	S	D1
AL	CCGT060202-AL					●	0.2	6.35	2.38	2.8
	CCGT060204-AL					●	0.4	6.35	2.38	2.8
	CCGT09T302-AL					●	0.2	9.525	3.97	4.4
	CCGT09T304-AL					●	0.4	9.525	3.97	4.4
	CCGT09T308-AL					●	0.8	9.525	3.97	4.4
	CCGT120402-AL					●	0.2	12.7	4.76	5.5
	CCGT120404-AL					●	0.4	12.7	4.76	5.5
	CCGT120408-AL					●	0.8	12.7	4.76	5.5
All-round	CCGT060202			●			0.2	6.35	2.38	2.8
	CCGT060204			●			0.4	6.35	2.38	2.8
	CCGT09T302			●			0.2	9.525	3.97	4.4
	CCGT09T304			●			0.4	9.525	3.97	4.4
	CCGT09T308			●			0.8	9.525	3.97	4.4
Pos. Spanwinkel	CCGT060200R				●		0.03	6.35	2.38	2.8
	CCGT060202R				●		0.2	6.35	2.38	2.8
	CCGT060202L				●		0.2	6.35	2.38	2.8
	CCGT060204L				●		0.4	6.35	2.38	2.8
	CCGT09T302R				●		0.2	9.525	3.97	4.4
	CCGT09T302L				●		0.2	9.525	3.97	4.4
	CCGT09T304R				●		0.4	9.525	3.97	4.4
	CCGT09T304L				●		0.4	9.525	3.97	4.4
-	CCMW060204	●					0.4	6.35	2.38	2.8
	CCMW060208	●					0.8	6.35	2.38	2.8
	CCMW09T304	●					0.4	9.525	3.97	4.4
	CCMW09T308	●					0.8	9.525	3.97	4.4
-	CCGW060202				●		0.2	6.35	2.38	2.8
	CCGW060204				●		0.4	6.35	2.38	2.8
	CCGW09T304		●		●		0.4	9.525	3.97	4.4

● Lagerstandard

Spankontrollbereich







*-M,G: Ohne Spanformstufe

Halter / Außendrehen → C024 -
J-Serie Werkzeughalter → G019 -
Halter / Innendrehen → D016 -
PINZBOHR® → K180 -

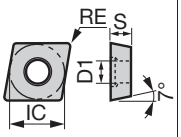
Wendeschneidplatten POSITIV

● : Kontinuierlicher Schnitt
ɔ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

CC

Rhombisch, 80°
mit Loch
Positiv 7°

P	Stahl	ɔ ●ɔ ●ɔ
M	Rostfreier Stahl	ɔ ●ɔ ●ɔ
K	Eisenguss	ɔ
N	Nichteisen-metalle	
S	Hitzebest. Legierungen	● ●ɔ
H	Gehärteter Stahl	



Anwendung	Spanform-stufe	Katalog Nr.	Beschichtet AH725	SH725	SH730	Größe (mm) RE	IC	S	D1
Innendrehen auf Langdrehautomaten	JS	CCGT03X101-JS			●	<0.1	3.57	1.39	1.9
		CCGT03X102-JS			●	<0.2	3.57	1.39	1.9
		CCGT03X104-JS			●	<0.4	3.57	1.39	1.9
		CCGT04T101-JS			●	<0.1	4.37	1.79	2.2
		CCGT04T102-JS			●	<0.2	4.37	1.79	2.2
		CCGT04T104-JS			●	<0.4	4.37	1.79	2.2
Innendrehen auf Langdreh-automaten (scharfkantig)	JS	CCGT03X101F-JS		●		<0.1	3.57	1.39	1.9
		CCGT03X102F-JS		●		<0.2	3.57	1.39	1.9
		CCGT03X104F-JS		●		<0.4	3.57	1.39	1.9
		CCGT04T101F-JS		●		<0.1	4.37	1.79	2.2
		CCGT04T102F-JS		●		<0.2	4.37	1.79	2.2
		CCGT04T104F-JS		●		<0.4	4.37	1.79	2.2
Außendrehen auf Langdrehautomaten	JS	CCGT060201N-JS	●			0.1	6.35	2.38	2.8
		CCGT060202N-JS	●			0.2	6.35	2.38	2.8
		CCGT060204N-JS	●			0.4	6.35	2.38	2.8
		CCGT09T301N-JS	●			0.1	9.525	3.97	4.4
		CCGT09T302N-JS	●			0.2	9.525	3.97	4.4
		CCGT09T304N-JS	●			0.4	9.525	3.97	4.4
Außendrehen auf Langdreh-automaten (scharfkantig)	JS	CCGT060200FN-JS		●	●	0.03	6.35	2.38	2.8
		CCGT060201FN-JS		●	●	<0.1	6.35	2.38	2.8
		CCGT060202FN-JS		●	●	<0.2	6.35	2.38	2.8
		CCGT060204FN-JS		●	●	<0.4	6.35	2.38	2.8
		CCGT09T300FN-JS		●	●	0.03	9.525	3.97	4.4
		CCGT09T301FN-JS		●	●	<0.1	9.525	3.97	4.4
		CCGT09T302FN-JS		●	●	<0.2	9.525	3.97	4.4
		CCGT09T304FN-JS		●	●	<0.4	9.525	3.97	4.4

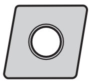
*Eckenradius (RE) mit einem Kleiner-als-Zeichen (<) bedeutet eine Minustoleranz.

● Lagerstandard

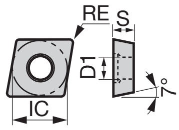
Halter / Außendrehen	→ C024 -	Halter / Innendrehen	→ D016 -
J-Serie Werkzeughalter	→ G019 -	PINZBOHR®	→ K180 -

● : Kontinuierlicher Schnitt
◐ : Leicht unterbrochener Schnitt
✤ : Stark unterbrochener Schnitt

CC

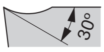


Rhombisch, 80°
mit Loch
Positiv 7°



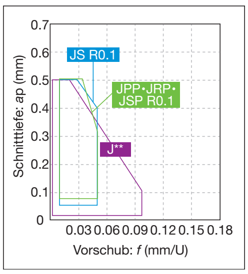
	Material	SH725	J740	NS9530	TH10
P	Stahl	●◐	●◐	●◐	●
M	Rostfreier Stahl	●◐	●◐		●
K	Eisenguss			●◐	●
N	Nichteisen-metalle				●
S	Hitzebest. Legierungen				
H	Gehärteter Stahl				

Anwendung	Spanform-stufe	Katalog Nr.	Beschichtet SH725	Beschichtet J740	Cermet NS9530	Unbeschichtet TH10	RE	IC	S	D1
Außendrehen auf Langdrehautomaten (scharfkantig)	J10	CCGT060200FR-J10	●	●		●	0.03	6.35	2.38	2.8
		CCGT060200FL-J10	●	●		●	0.03	6.35	2.38	2.8
		CCGT060201FR-J10	●	●	●	●	0.1	6.35	2.38	2.8
		CCGT060201FL-J10	●	●		●	0.1	6.35	2.38	2.8
		CCGT060202FR-J10	●	●	●	●	0.2	6.35	2.38	2.8
		CCGT060202FL-J10	●	●	●	●	0.2	6.35	2.38	2.8
		CCGT09T300FR-J10	●	●		●	0.03	9.525	3.97	4.4
		CCGT09T300FL-J10	●	●		●	0.03	9.525	3.97	4.4
		CCGT09T301FR-J10	●	●		●	0.1	9.525	3.97	4.4
		CCGT09T301FL-J10	●	●		●	0.1	9.525	3.97	4.4
		CCGT09T302FR-J10	●	●		●	0.2	9.525	3.97	4.4
		CCGT09T302FL-J10	●	●		●	0.2	9.525	3.97	4.4
		CCGT09T304FR-J10	●				0.4	9.525	3.97	4.4



● Lagerstandard

Spankontrollbereich



*Spankontrolle mit typ. R0.1

Halter / Außendrehen → C024 -
J-Serie Werkzeughalter → G019 -
Halter / Innendrehen → D016 -
PINZBOHR® → K180 -

A Schneidstoffe
B Wende-schneidplatten
C Halter / Außendrehen
D Halter / Innendrehen
E Gewinde-werkzeuge
F Stech-werkzeuge
G Miniatur-bearbeitung
H Fräser
I Schaftfräser
J Bohrer
K Werkzeug-aufnahmen
L Benutzer-handbuch
M Index

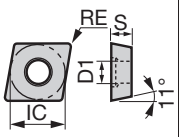
Wendeschneidplatten POSITIV

● : Kontinuierlicher Schnitt
ɔ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

CP

Rhombisch, 80°
mit Loch
Positiv 11°

P	Stahl	●	●ɔ	●✣	✣	●ɔ	●✣	ɔ	✣	ɔ✣	✣	●ɔ	ɔ			ɔ	●ɔ	●ɔ			●ɔ										
M	Rostfreier Stahl		●ɔ					●	ɔ	ɔ	✣	●ɔ	ɔ	●	ɔ	ɔ															
K	Eisenguss	●ɔ	●ɔ			●ɔ						●ɔ	ɔ			ɔ	●ɔ	●ɔ			●ɔ										
N	Nichteisen-metalle																														
S	Hitzebest. Legierungen											●ɔ	●	●	ɔ																
H	Gehärteter Stahl																														



Anwendung	Spanform-stufe	Katalog Nr.	Beschichtet															Cermet besch.		Cermet				Größe (mm)			
			T9205	T9215	T9225	T9235	T9115	T9125	T6120	T6130	AH630	AH645	AH120	AH725	AH8005	AH8015	GH730	GT9530	AT9530	NS9530				RE	IC	S	D1
Schlichten	**PSF**	**CPMT060202-PSF**												●										0.2	6.35	2.38	2.8
		CPMT06020**4-PSF**		●	●		▲	▲						●										0.4	6.35	2.38	2.8
		CPMT080202-PSF												●										0.2	7.94	2.38	3.4
		CPMT0802**04-PSF**		●	●		▲	▲						●										0.4	7.94	2.38	3.4
		CPMT090302-PSF												●				●		●				0.2	9.525	3.18	4.4
		CPMT0903**04-PSF**		●	●		▲	▲						●				●		●				0.4	9.525	3.18	4.4
		CPMT09T302-PSF												●										0.2	9.525	3.97	4.4
		CPMT09T3**04-PSF**		●	●		▲	▲						●										0.4	9.525	3.97	4.4
	PF	**CPMT090302-PF**																●		●				0.2	9.525	3.18	4.4
		CPMT0903**04-PF**																●		●				0.4	9.525	3.18	4.4
Schlichten bis leichte Bearbeitung	**PSS**	**CPMT060204-PSS**		●	●		▲	▲						●				●		●				0.4	6.35	2.38	2.8
		CPMT080204-PSS		●	●		▲	▲	●	●	●	●		●				●		●				0.4	7.94	2.38	3.4
		CPMT0802**08-PSS**		●	●		▲	▲	●	●	●	●		●				●		●				0.8	7.94	2.38	3.4
		CPMT090304-PSS		●	●		▲	▲	●	●	●	●		●				●		●				0.4	9.525	3.18	4.4
		CPMT0903**08-PSS**		●	●		▲	▲	●	●	●	●		●				●		●				0.8	9.525	3.18	4.4
		CPMT09T304-PSS		●	●		▲	▲						●										0.4	9.525	3.97	4.4
		CPMT09T3**08-PSS**		●	●		▲	▲						●										0.8	9.525	3.97	4.4
Schlichten bis mittlere Bearbeitung	**PS**	**CPMT060202-PS**		●	●		▲	▲						●	●	●	●			●				0.2	6.35	2.38	2.8
		CPMT06020**4-PS**		●	●		▲	▲					●	●	●	●	●	●	●	●				0.4	6.35	2.38	2.8
		CPMT080202-PS		●	●		▲	▲	●	●	●	●		●				●	●	●				0.2	7.94	2.38	3.4
		CPMT0802**04-PS**		●	●		▲	▲	●	●	●	●		●				●	●	●				0.4	7.94	2.38	3.4
		CPMT0802**08-PS**		●	●		▲	▲	●	●	●	●		●				●	●	●				0.8	7.94	2.38	3.4
		CPMT090304-PS		●	●		▲	▲	●	●	●	●		●				●	●	●				0.4	9.525	3.18	4.4
		CPMT0903**08-PS**		●	●		▲	▲	●	●	●	●		●				●	●	●				0.8	9.525	3.18	4.4
		CPMT09T302-PS		●	●		▲	▲						●	●	●								0.2	9.525	3.97	4.4
		CPMT09T3**04-PS**		●	●		▲	▲						●	●	●				●				0.4	9.525	3.97	4.4
		CPMT09T3**08-PS**		●	●		▲	▲					●	●	●	●								0.8	9.525	3.97	4.4
	TSF	**CPMT09T304-TSF**		●	●																			0.4	9.525	3.97	4.4
		CPMT09T3**08-TSF**		●	●																			0.8	9.525	3.97	4.4
	TM	**CPMT09T304-TM**		●	●																			0.4	9.525	3.97	4.4
		CPMT09T3**08-TM**		●	●																			0.8	9.525	3.97	4.4

● Lagerstandard
▲ Wird eingestellt

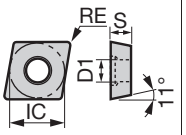
Halter / Innendrehen → D019 -

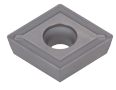
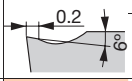
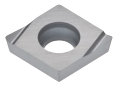
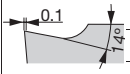
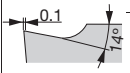
● : Kontinuierlicher Schnitt
◐ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

CP

Rhombisch, 80° mit Loch Positiv 11°

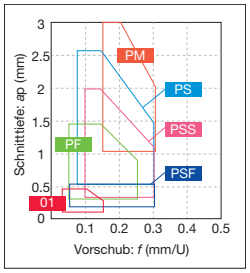
P	Stahl	●◐ ◐✣ ●◐ ◐✣ ●◐ ●
M	Rostfreier Stahl	●◐ ●
K	Eisenguss	●◐ ●◐ ●◐ ●
N	Nichteisen-metalle	●
S	Hitzebest. Legierungen	
H	Gehärteter Stahl	

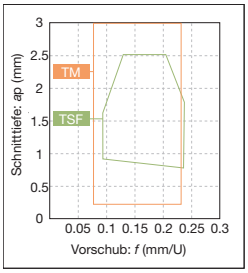


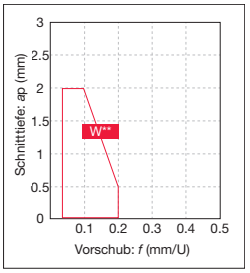
Anwendung	Spanform-stufe	Katalog Nr.	Beschichtet T9215	Beschichtet T9225	Beschichtet T9115	Beschichtet T9125	Cermet NS9530	Unbeschichtet TH10	Größe (mm) RE	IC	S	D1
Mittlere Bearbeitung	24	**CPMT080204-24**	●		▲	▲			0.4	7.94	2.38	3.4
		**CPMT120408-24**		●			●		0.8	12.7	4.76	5.5
		CPMT160508-24		●		▲	●		0.8	15.875	5.56	5.5
		CPMT160512-24		●			●		1.2	15.875	5.56	5.5
												
Schlichten	W15	**CPGT050202L-W15**					●		0.2	5.56	2.35	2.5
		**CPGT050204L-W15**					●		0.4	5.56	2.35	2.5
		CPGT080202R-W15						●	0.2	7.94	2.38	3.4
		CPGT080202L-W15					●	●	0.2	7.94	2.38	3.4
		CPGT080204R-W15						●	0.4	7.94	2.38	3.4
		**CPGT080204L-W15**					●	●	0.4	7.94	2.38	3.4
	W20	**CPGT090302R-W20**					●	●	0.2	9.525	3.18	4.4
		CPGT090302L-W20					●	●	0.2	9.525	3.18	4.4
		CPGT090304R-W20					●	●	0.4	9.525	3.18	4.4
		CPGT090304L-W20					●	●	0.4	9.525	3.18	4.4
												

● Lagerstandard
▲ Wird eingestellt

Spankontrollbereich







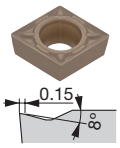
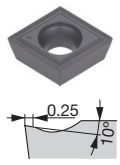
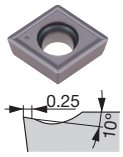
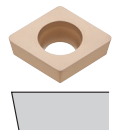
Halter / Innendrehen → D019 -
Bohrstangen → K209 -
Kassetten → K194 -

Wendeschneidplatten POSITIV

● : Kontinuierlicher Schnitt
ɔ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

CP

Rhombisch, 80°
mit Loch
Positiv 11°

		T9225	T9105	T9125	T6120	T6130	AH630	AH645	T515	T5115	AH725	AH8005	AH8015	AH905	NS9530	RE	IC	S	D1
		Beschichtet													Cermet	Größe (mm)			
Anwendung	Spanformstufe	Katalog Nr.																	
Mittlere Bearbeitung	PM	CPMT060204-PM				●	●	●	●			●					0.4	6.35	2.38	2.8
		CPMT060208-PM	●		▲	●	●	●	●			●					0.8	6.35	2.38	2.8
		CPMT090304-PM	●		▲	●	●	●	●			●				●	0.4	9.525	3.18	4.4
		CPMT090308-PM	●		▲	●	●	●	●			●				●	0.8	9.525	3.18	4.4
Schlichten bis mittlere Bearbeitung	CM	CPMT060204-CM									●						0.4	6.35	2.38	2.8
		CPMT060208-CM									●						0.8	6.35	2.38	2.8
		CPMT080204-CM									●						0.4	7.94	2.38	3.4
		CPMT080208-CM									●						0.8	7.94	2.38	3.4
		CPMT090304-CM								●	●						0.4	9.525	3.18	4.4
		CPMT090308-CM								●	●						0.8	9.525	3.18	4.4
		CPMT09T304-CM								●	●						0.4	9.525	3.97	4.4
		CPMT09T308-CM								●	●						0.8	9.525	3.97	4.4
		CPMT09T312-CM									●						1.2	9.525	3.97	4.4
		CPMT120408-CM									●						0.8	12.7	4.76	5.5
		CPMT120412-CM									●						1.2	12.7	4.76	5.5
Mittlere Bearbeitung	All-round	CPMT120408										●	●	●			0.8	12.7	4.76	5.5
																				
	-	CPMW080204									●						0.4	7.94	2.38	3.4
		CPMW080208									●						0.8	7.94	2.38	3.4
		CPMW090304		▲							●						0.4	9.525	3.18	4.4
		CPMW090308									●						0.8	9.525	3.18	4.4

● Lagerstandard
▲ Wird eingestellt

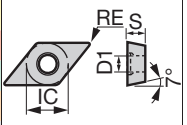
Halter / Innendrehen → D019 - Borhrstangen → K209 -

● : Kontinuierlicher Schnitt
c : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

DC

Rhombisch, 55° mit Loch Positiv 7°

P	Stahl	●c	c✣	●c	c✣	c				c	●c	●c			●c	●c			●c												
M	Rostfreier Stahl	●c				c	●	c		c	●c	●c																			
K	Eisenguss	●c		●c		c				c					●c	●c			●c												
N	Nichteisen-metalle																														
S	Hitzebest. Legierungen					●	●	c	c																						
H	Gehärteter Stahl																														

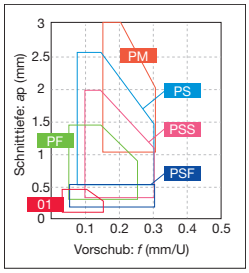


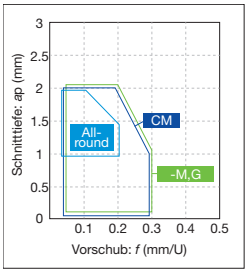
Anwendung	Spanform-stufe	Katalog Nr.	Beschichtet											Cermet besch.		Cermet				Größe (mm)			
			T9215	T9225	T9115	T9125	AH725	AH8005	AH8015	AH905	GH730	SH725	J740	GT9530	J9530	NS9530				RE	IC	S	D1
Feinschlichten	01	DCGT070202-01											●		●					0.2	6.35	2.38	2.8
		DCGT11T302-01											●							0.2	9.525	3.97	4.4
Feinschlichten (scharfkantig)	01	DCGT070202F-01										●								<0.2	6.35	2.38	2.8
		DCGT070204F-01										●								<0.4	6.35	2.38	2.8
		DCGT11T302F-01										●								<0.2	9.525	3.97	4.4
		DCGT11T304F-01										●								<0.4	9.525	3.97	4.4
Schlichten	PSF	DCMT070202-PSF					●							●		●				0.2	6.35	2.38	2.8
		DCMT070204-PSF	●	●	▲	▲	●							●		●				0.4	6.35	2.38	2.8
		DCMT11T302-PSF					●							●		●				0.2	9.525	3.97	4.4
		DCMT11T304-PSF	●	●	▲	▲	●	●	●	●				●		●				0.4	9.525	3.97	4.4
		DCMT11T308-PSF	●	●	▲	▲	●	●	●	●										0.8	9.525	3.97	4.4
	PF	DCMT070202-PF									●			●		●				0.2	6.35	2.38	2.8
		DCMT070204-PF									●			●		●				0.4	6.35	2.38	2.8
		DCMT070208-PF												●		●				0.8	6.35	2.38	2.8
		DCMT11T302-PF									●			●		●				0.2	9.525	3.97	4.4
		DCMT11T304-PF									●			●		●				0.4	9.525	3.97	4.4
		DCMT11T308-PF												●						0.8	9.525	3.97	4.4

*Eckenradius (RE) mit einem Kleiner-als-Zeichen (<) bedeutet eine Minustoleranz.

● Lagerstandard
▲ Wird eingestellt

Spankontrollbereich





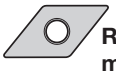
*-M,G: Ohne Spanformstufe

Halter / Außendrehen	→ C048 -	Halter / Innendrehen	→ D048 -
J-Serie Werkzeughalter	→ G026 -	PINZBOHR®	→ K184 -

Wendeschneidplatten POSITIV

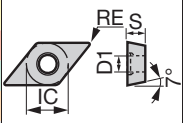
● : Kontinuierlicher Schnitt
ɔ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

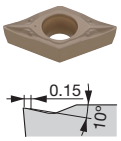
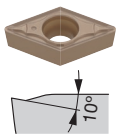
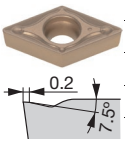
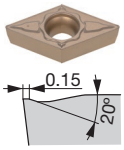
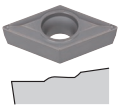
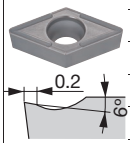
DC



Rhombisch, 55° mit Loch Positiv 7°

P	Stahl	●ɔ	ɔ✣	●ɔ	ɔ✣	ɔ	✣	ɔ✣	✣	●ɔ	ɔ				ɔ			●ɔ	●ɔ			●ɔ									
M	Rostfreier Stahl	●ɔ				●	ɔ	ɔ	✣	●ɔ	ɔ	●	ɔ		ɔ																
K	Eisenguss	●ɔ		●ɔ						●ɔ	ɔ				ɔ			●ɔ	●ɔ			●ɔ									
N	Nichteisen-metalle																														
S	Hitzebest. Legierungen									●ɔ	●	●	ɔ	ɔ																
H	Gehärteter Stahl																														



Anwendung	Spanform-stufe	Katalog Nr.	Beschichtet														Cermet besch.		Cermet	Größe (mm)			
			T9215	T9225	T9115	T9125	T6120	T6130	AH630	AH645	AH120	AH725	AH8005	AH8015	AH905	GH730	GT9530	AT9530	NS9530	RE	IC	S	D1
Schlichten bis leichte Bearbeitung	**PSS**	**DCMT070204-PSS**	●	●	▲	▲	●	●	●	●		●					●		●	0.4	6.35	2.38	2.8
		DCMT070208-PSS	●	●	▲	▲	●	●	●	●		●					●		●	0.8	6.35	2.38	2.8
		DCMT11T304-PSS	●	●	▲	▲	●	●	●	●		●	●	●	●		●		●	0.4	9.525	3.97	4.4
		DCMT11T308-PSS	●	●	▲	▲	●	●	●	●		●	●	●	●		●		●	0.8	9.525	3.97	4.4
		DCMT11T312-PSS	●	●	▲	▲	●	●	●	●		●	●	●	●					1.2	9.525	3.97	4.4
Schlichten bis mittlere Bearbeitung	**PS**	**DCMT070202-PS**	●	●	▲	▲	●	●	●	●	●	●	●	●		●	●	●	●	0.2	6.35	2.38	2.8
		DCMT070204-PS	●	●	▲	▲	●	●	●	●	●	●	●	●		●	●	●	●	0.4	6.35	2.38	2.8
		DCMT070208-PS	●	●	▲	▲						●	●	●		●	●	●	●	0.8	6.35	2.38	2.8
		DCMT11T302-PS	●	●	▲	▲	●	●	●	●	●	●	●	●		●	●	●	●	0.2	9.525	3.97	4.4
		DCMT11T304-PS	●	●	▲	▲	●	●	●	●	●	●	●	●	●	●	●	●	●	0.4	9.525	3.97	4.4
		DCMT11T308-PS	●	●	▲	▲	●	●	●	●	●	●	●	●	●	●	●	●	●	0.8	9.525	3.97	4.4
		DCMT11T312-PS	●	●	▲	▲	●	●	●	●		●	●	●	●					1.2	9.525	3.97	4.4
	TSF	**DCMT070202-TSF**	●	●																0.2	6.35	2.38	2.8
		DCMT070204-TSF	●	●																0.4	6.35	2.38	2.8
		DCMT070208-TSF	●	●																0.8	6.35	2.38	2.8
		DCMT11T304-TSF	●	●																0.4	9.525	3.97	4.4
		DCMT11T308-TSF	●	●																0.8	9.525	3.97	4.4
	TM	**DCMT070202-TM**	●	●																0.2	6.35	2.38	2.8
		DCMT070204-TM	●	●																0.4	6.35	2.38	2.8
		DCMT070208-TM	●	●																0.8	6.35	2.38	2.8
		DCMT11T304-TM	●	●																0.4	9.525	3.97	4.4
		DCMT11T308-TM	●	●																0.8	9.525	3.97	4.4
	23	**DCMT070204-23**																	●	0.4	6.35	2.38	2.8
		DCMT11T304-23																	●	0.4	9.525	3.97	4.4
		DCMT11T308-23																	●	0.8	9.525	3.97	4.4
Mittlere Bearbeitung	**24**	**DCMT070202-24**		●															●	0.2	6.35	2.38	2.8
		DCMT070204-24	●	●	▲	▲													●	0.4	6.35	2.38	2.8
		DCMT070208-24		●		▲													●	0.8	6.35	2.38	2.8
		DCMT11T302-24		●		▲													●	0.2	9.525	3.97	4.4
		DCMT11T304-24	●	●	▲	▲													●	0.4	9.525	3.97	4.4
		DCMT11T308-24	●	●	▲	▲		●											●	0.8	9.525	3.97	4.4

● Lagerstandard
▲ Wird eingestellt

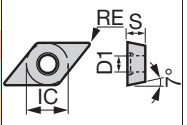
Halter / Außendrehen	→ C048 -	Halter / Innendrehen	→ D048 -
J-Serie Werkzeughalter	→ G026 -	PINZBOHR®	→ K184 -

● : Kontinuierlicher Schnitt
ɔ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

DC

Rhombisch, 55° mit Loch Positiv 7°

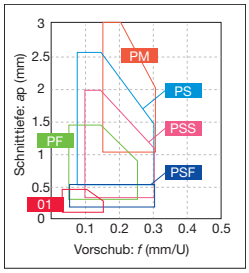
P	Stahl	●ɔ ɔ✣ ●ɔ ɔ✣ ɔ ✣ ɔ✣ ✣ ●ɔ ɔ ●ɔ ɔ ●ɔ ɔ
M	Rostfreier Stahl	●ɔ ● ɔ ɔ ✣ ●ɔ ɔ ●ɔ ɔ ●ɔ ɔ
K	Eisenguss	●ɔ ●ɔ ●ɔ ●ɔ ɔ ●ɔ ɔ ●ɔ ɔ ●ɔ ɔ ●ɔ ɔ
N	Nichteisen-metalle	●
S	Hitzebest. Legierungen	●ɔ ●
H	Gehärteter Stahl	

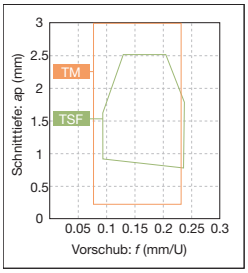


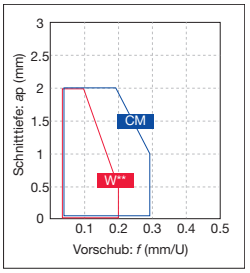
Anwendung	Spanform-stufe	Katalog Nr.	Beschichtet T9215	T9225	T9115	T9125	T6120	T6130	AH630	AH645	T515	T5115	AH120	AH725	GH330	GH730	Cermet besch. GT9530	Cermet NS9530	Unbeschichtet TH10	RE	IC	S	D1
Schlichten	W10	DCGT070200R-W10																	●	0.03	6.35	2.38	2.8
		DCGT070200L-W10																	●	0.03	6.35	2.38	2.8
		DCGT070202R-W10																●	●	0.2	6.35	2.38	2.8
		DCGT070202L-W10															●	●		0.2	6.35	2.38	2.8
		DCGT070204R-W10													●			●	●	0.4	6.35	2.38	2.8
		DCGT070204L-W10													●		●	●	●	0.4	6.35	2.38	2.8
	W15	DCGT11T302R-W15																●	●	0.2	9.525	3.97	4.4
		DCGT11T302L-W15															●	●		0.2	9.525	3.97	4.4
		DCGT11T304R-W15																●		0.4	9.525	3.97	4.4
		DCGT11T304L-W15													●		●	●	●	0.4	9.525	3.97	4.4
		DCGT11T308R-W15																●	●	0.8	9.525	3.97	4.4
		DCGT11T308L-W15																●	●	0.8	9.525	3.97	4.4
Mittlere Bearbeitung	PM	DCMT070204-PM	●	●	▲	▲	●	●	●	●			●	●		●	●	●		0.4	6.35	2.38	2.8
		DCMT070208-PM	●	●	▲	▲	●	●	●	●			●	●		●	●	●		0.8	6.35	2.38	2.8
		DCMT11T304-PM	●	●	▲	▲	●	●	●	●			●	●		●	●	●		0.4	9.525	3.97	4.4
		DCMT11T308-PM	●	●	▲	▲	●	●	●	●			●	●		●	●	●		0.8	9.525	3.97	4.4
		DCMT11T312-PM		●		▲	●	●	●	●				●						1.2	9.525	3.97	4.4
Schlichten bis mittl. Bearbeitung	CM	DCMT070204-CM										●								0.4	6.35	2.38	2.8
		DCMT070208-CM										●								0.8	6.35	2.38	2.8
		DCMT11T304-CM									●	●								0.4	9.525	3.97	4.4
		DCMT11T308-CM									●	●								0.8	9.525	3.97	4.4
		DCMT11T312-CM										●								1.2	9.525	3.97	4.4

● Lagerstandard
▲ Wird eingestellt

Spankontrollbereich







Halter / Außendrehen	→ C048 -	Halter / Innendrehen	→ D048 -
J-Serie Werkzeughalter	→ G026 -	PINZBOHR®	→ K184 -

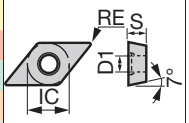
Wendeschneidplatten POSITIV

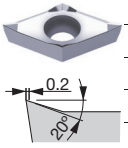
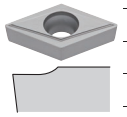
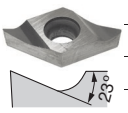
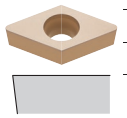
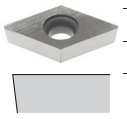
● : Kontinuierlicher Schnitt
ɔ : Leicht unterbrochener Schnitt
✠ : Stark unterbrochener Schnitt

DC

Rhombisch, 55° mit Loch Positiv 7°

		Beschichtet			Cermet	Unbeschichtet		Größe (mm)			
		T9105	T5115	GH110	NS9530	TH10	KS05F	RE	IC	S	D1
P	Stahl	●		●	●ɔ	●					
M	Rostfreier Stahl			●		●					
K	Eisenguss	●ɔ	ɔ	●	●ɔ	●	●				
N	Nichteisenmetalle					●	●				
S	Hitzebest. Legierungen			●			●				
H	Gehärteter Stahl										



Anwendung	Spanformstufe	Katalog Nr.	T9105	T5115	GH110	NS9530	TH10	KS05F	RE	IC	S	D1
Schlichten bis mittlere Bearbeitung	AL	DCGT070202-AL						●	0.2	6.35	2.38	2.8
		DCGT070204-AL						●	0.4	6.35	2.38	2.8
		DCGT11T302-AL						●	0.2	9.525	3.97	4.4
		DCGT11T304-AL						●	0.4	9.525	3.97	4.4
		DCGT11T308-AL						●	0.8	9.525	3.97	4.4
	All-round	DCGT070202				●			0.2	6.35	2.38	2.8
		DCGT070204				●			0.4	6.35	2.38	2.8
		DCGT11T302				●			0.2	9.525	3.97	4.4
		DCGT11T304				●			0.4	9.525	3.97	4.4
		DCGT11T308				●			0.8	9.525	3.97	4.4
	Pos. Spanwinkel	DCGT070202R					●		0.2	6.35	2.38	2.8
		DCGT070202L					●		0.2	6.35	2.38	2.8
		DCGT070204R					●		0.4	6.35	2.38	2.8
		DCGT070204L					●		0.4	6.35	2.38	2.8
		DCGT11T302R					●		0.2	9.525	3.97	4.4
		DCGT11T302L					●		0.2	9.525	3.97	4.4
		DCGT11T304R					●		0.4	9.525	3.97	4.4
		DCGT11T304L					●		0.4	9.525	3.97	4.4
Mittlere Bearbeitung	-	DCMW070204	▲	●					0.4	6.35	2.38	2.8
		DCMW070208		●					0.8	6.35	2.38	2.8
		DCMW11T304	▲	●					0.4	9.525	3.97	4.4
		DCMW11T308		●					0.8	9.525	3.97	4.4
	-	DCGW070202					●		0.2	6.35	2.38	2.8
		DCGW070204			●		●		0.4	6.35	2.38	2.8
		DCGW11T304					●		0.4	9.525	3.97	4.4
		DCGW11T308					●		0.8	9.525	3.97	4.4

● Lagerstandard
▲ Wird eingestellt

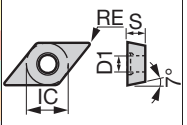
Halter / Außendrehen → C048 -
J-Serie Werkzeughalter → G026 -
Halter / Innendrehen → D048 -
PINZBOHR® → K184 -

● : Kontinuierlicher Schnitt
c : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

DC

Rhombisch, 55°
mit Loch
Positiv 7°

P	Stahl	c	●c	●c
M	Rostfreier Stahl	c	●c	●c
K	Eisenguss	c		
N	Nichteisen-metalle			
S	Hitzebest. Legierungen	●		●c
H	Gehärteter Stahl			

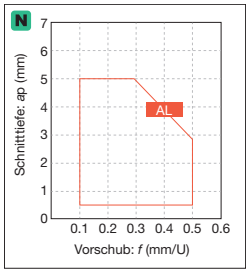


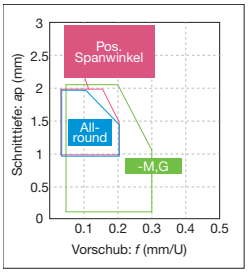
Anwendung	Spanform-stufe	Katalog Nr.	Beschichtet AH725	SH725	SH730	RE	IC	S	D1
Außendrehen auf Langdrehautomaten (scharfkantig)	JS	**DCGT070200FN-JS**		●	●	0.03	6.35	2.38	2.8
		DCGT07020**1FN-JS**		●	●	<0.1	6.35	2.38	2.8
		DCGT07020**2FN-JS**		●	●	<0.2	6.35	2.38	2.8
		DCGT11T300FN-JS		●	●	0.03	9.525	3.97	4.4
		DCGT11T3**01FN-JS**		●	●	<0.1	9.525	3.97	4.4
		DCGT11T3**02FN-JS**		●	●	<0.2	9.525	3.97	4.4
		DCGT11T3**04FN-JS**		●	●	<0.4	9.525	3.97	4.4
Außendrehen auf Langdrehautomaten	JS	**DCGT070201N-JS**	●			0.1	6.35	2.38	2.8
		DCGT07020**2N-JS**	●			0.2	6.35	2.38	2.8
		DCGT11T301N-JS	●			0.1	9.525	3.97	4.4
		DCGT11T3**02N-JS**	●			0.2	9.525	3.97	4.4
		DCGT11T3**04N-JS**	●			0.4	9.525	3.97	4.4
Außendrehen auf Langdrehautomaten (scharfkantig)	JPP	**DCET0702008MFR-JPP**		●	●	<0.08	6.35	2.38	2.8
		DCET070200**8MFL-JPP**		●	●	<0.08	6.35	2.38	2.8
		DCET07020**1MFR-JPP**		●	●	<0.1	6.35	2.38	2.8
		DCET07020**1MFL-JPP**		●	●	<0.1	6.35	2.38	2.8
		DCET07020**18MFR-JPP**		●	●	<0.18	6.35	2.38	2.8
		DCET07020**18MFL-JPP**		●	●	<0.18	6.35	2.38	2.8
		DCET07020**2MFR-JPP**		●	●	<0.2	6.35	2.38	2.8
		DCET07020**2MFL-JPP**		●	●	<0.2	6.35	2.38	2.8
		DCET11T3008MFR-JPP		●	●	<0.08	9.525	3.97	4.4
		DCET11T3**008MFL-JPP**		●	●	<0.08	9.525	3.97	4.4
		DCET11T3**01MFR-JPP**		●	●	<0.1	9.525	3.97	4.4
		DCET11T3**01MFL-JPP**		●	●	<0.1	9.525	3.97	4.4
		DCET11T3**018MFR-JPP**		●	●	<0.18	9.525	3.97	4.4
		DCET11T3**018MFL-JPP**		●	●	<0.18	9.525	3.97	4.4
		DCET11T3**02MFR-JPP**		●	●	<0.2	9.525	3.97	4.4
		DCET11T3**02MFL-JPP**		●	●	<0.2	9.525	3.97	4.4

*Eckenradius (RE) mit einem Kleiner-als-Zeichen (<) bedeutet eine Minustoleranz.

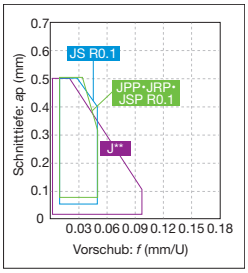
● Lagerstandard

Spankontrollbereich





*-M,G: Ohne Spanformstufe



*Spankontrolle mit typ. R0.1

Halter / Außendrehen	→ C049 -	Halter / Innendrehen	→ D048 -
J-Serie Werkzeughalter	→ G026 -	PINZBOHR®	→ K184 -

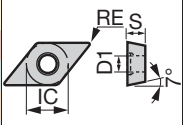
Wendeschneidplatten POSITIV

● : Kontinuierlicher Schnitt
◐ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

DC

Rhombisch, 55° mit Loch Positiv 7°

		SH725	SH730	J740	J9530	NS9530	TH10
P	Stahl	◐	◐	◐	◐	◐	●
M	Rostfreier Stahl	◐	◐	◐			●
K	Eisenguss				◐	◐	●
N	Nichteisen-metalle						●
S	Hitzebest. Legierungen		◐				
H	Gehärteter Stahl						



Anwendung	Spanform-stufe	Katalog Nr.	Beschichtet SH725	Beschichtet SH730	Beschichtet J740	Cermet besch. J9530	Cermet NS9530	Unbeschichtet TH10	Größe (mm) RE	IC	S	D1
Außendrehen auf Langdrehautomaten (scharfkantig)	JRP	DCET0702008MFR-JRP	●	●					<0.08	6.35	2.38	2.8
		DCET0702008MFL-JRP	●	●					<0.08	6.35	2.38	2.8
		DCET070201MFR-JRP	●	●					<0.1	6.35	2.38	2.8
		DCET070201MFL-JRP	●	●					<0.1	6.35	2.38	2.8
		DCET0702018MFR-JRP	●	●					<0.18	6.35	2.38	2.8
		DCET0702018MFL-JRP	●	●					<0.18	6.35	2.38	2.8
		DCET070202MFR-JRP	●	●					<0.2	6.35	2.38	2.8
		DCET070202MFL-JRP	●	●					<0.2	6.35	2.38	2.8
		DCET11T3008MFR-JRP	●	●					<0.08	9.525	3.97	4.4
		DCET11T3008MFL-JRP	●	●					<0.08	9.525	3.97	4.4
		DCET11T301MFR-JRP	●	●					<0.1	9.525	3.97	4.4
		DCET11T301MFL-JRP	●	●					<0.1	9.525	3.97	4.4
		DCET11T3018MFR-JRP	●	●					<0.18	9.525	3.97	4.4
		DCET11T3018MFL-JRP	●	●					<0.18	9.525	3.97	4.4
		DCET11T302MFR-JRP	●	●					<0.2	9.525	3.97	4.4
		DCET11T302MFL-JRP	●	●					<0.2	9.525	3.97	4.4
	JSP	DCET0702008MFN-JSP	●	●					<0.08	6.35	2.38	2.8
		DCET070201MFN-JSP	●	●					<0.1	6.35	2.38	2.8
		DCET0702018MFN-JSP	●	●					<0.18	6.35	2.38	2.8
		DCET070202MFN-JSP	●	●					<0.2	6.35	2.38	2.8
		DCET11T3008MFN-JSP	●	●					<0.08	9.525	3.97	4.4
		DCET11T301MFN-JSP	●	●					<0.1	9.525	3.97	4.4
		DCET11T3018MFN-JSP	●	●					<0.18	9.525	3.97	4.4
		DCET11T302MFN-JSP	●	●					<0.2	9.525	3.97	4.4
	J10	DCGT070200FR-J10	●		●			●	0.03	6.35	2.38	2.8
		DCGT070200FL-J10	●		●			●	0.03	6.35	2.38	2.8
		DCGT070201FR-J10	●		●		●	●	0.1	6.35	2.38	2.8
		DCGT070201FL-J10	●		●		●	●	0.1	6.35	2.38	2.8
		DCGT070202FR-J10	●		●		●	●	0.2	6.35	2.38	2.8
		DCGT070202FL-J10	●		●		●	●	0.2	6.35	2.38	2.8
		DCGT070204FR-J10	●						0.4	6.35	2.38	2.8
		DCGT070204FL-J10	●						0.4	6.35	2.38	2.8
		DCGT11T300FR-J10	●		●			●	0.03	9.525	3.97	4.4
		DCGT11T300FL-J10	●		●			●	0.03	9.525	3.97	4.4
		DCGT11T301FR-J10	●		●		●	●	0.1	9.525	3.97	4.4
		DCGT11T301FL-J10	●		●		●	●	0.1	9.525	3.97	4.4
		DCGT11T302FR-J10	●		●		●	●	0.2	9.525	3.97	4.4
		DCGT11T302FL-J10	●		●		●	●	0.2	9.525	3.97	4.4
Außendrehen auf Langdrehautomaten (geschliffen)	J10	DCGT070202R-J10				●			0.2	6.35	2.38	2.8
		DCGT11T302R-J10				●			0.2	9.525	3.97	4.4

*Eckenradius (RE) mit einem Kleiner-als-Zeichen (<) bedeutet eine Minustoleranz.

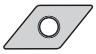
● Lagerstandard

Halter / Außendrehen → C049 -
J-Serie Werkzeughalter → G026 -
Halter / Innendrehen → D048 -
PINZBOHR® → K184 -

Wendeschneidplatten POSITIV

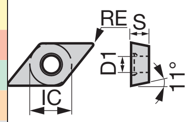
● : Kontinuierlicher Schnitt
◖ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

DP

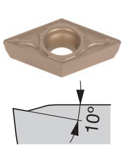


Rhombisch, 55°
mit Loch
Positiv 11°

		T9225	T9125	AH8015	NS9530
P	Stahl	◖✣	◖✣		●◖
M	Rostfreier Stahl			◖	
K	Eisenguss				●◖
N	Nichteisen-metalle				
S	Hitzebest. Legierungen			◖	
H	Gehärteter Stahl				



Anwendung	Spanform-stufe	Katalog Nr.	Beschichtet T9225	Beschichtet T9125	Beschichtet AH8015	Cermet NS9530	Größe (mm) RE	IC	S	D1
Schlichten bis mittl. Bearbeitung	PS	DPMT070202-PS	●	▲	●	●	0.2	6.35	2.38	2.8
		DPMT070204-PS	●	▲	●	●	0.4	6.35	2.38	2.8
		DPMT070208-PS	●	▲	●	●	0.8	6.35	2.38	2.8

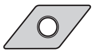


● Lagerstandard
▲ Wird eingestellt

Wendeschneidplatten POSITIV / DOPPELSEITIG

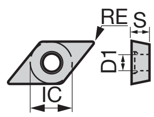
● : Kontinuierlicher Schnitt
◖ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

DX

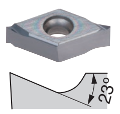


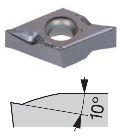
Rhombisch, 55°
mit Loch

		SH725
P	Stahl	●◖
M	Rostfreier Stahl	●◖
K	Eisenguss	
N	Nichteisen-metalle	
S	Hitzebest. Legierungen	
H	Gehärteter Stahl	



Anwendung	Spanform-stufe	Katalog Nr.	Beschichtet SH725	Größe (mm) RE	IC	S	D1
Schlichten (scharfkantig)	JRP	DXGU070301MFRE-JRP	●	<0.1	6.35	3.18	2.7
		DXGU070301MFLE-JRP	●	<0.1	6.35	3.18	2.7
		DXGU070302MFRE-JRP	●	<0.2	6.35	3.18	2.7
		DXGU070302MFLE-JRP	●	<0.2	6.35	3.18	2.7
Schlichten bis mittl. Bearb. (scharfkantig)	JS	DXGU070301MFR-JS	●	<0.1	6.35	3.18	2.7
		DXGU070301MFL-JS	●	<0.1	6.35	3.18	2.7
		DXGU070302MFR-JS	●	<0.2	6.35	3.18	2.7
		DXGU070302MFL-JS	●	<0.2	6.35	3.18	2.7
		DXGU070304MFR-JS	●	<0.4	6.35	3.18	2.7
		DXGU070304MFL-JS	●	<0.4	6.35	3.18	2.7

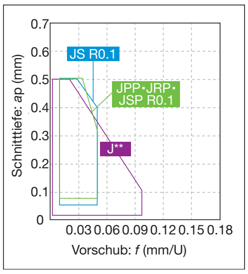




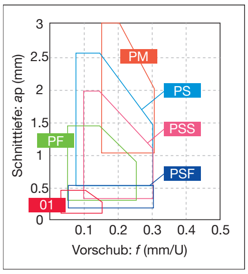
*Eckenradius (RE) mit einem Kleiner-als-Zeichen (<) bedeutet eine Minustoleranz.

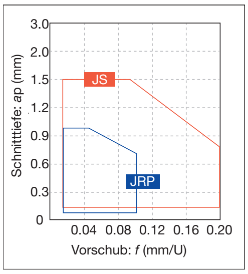
● Lagerstandard

Spankontrollbereich



*Spankontrolle mit typ. R0.1





DPMT...: Halter / Innendrehen → D051 -
DXGU...: Halter / Außendrehen → C039 -, Halter / Innendrehen → D035 -

A Schneidstoffe
B Wende-schneidplatten
C Halter / Außendrehen
D Halter / Innendrehen
E Gewinde-werkzeuge
F Stech-werkzeuge
G Miniatur-bearbeitung
H Fräser
I Schaftfräser
J Bohrer
K Werkzeug-aufnahmen
L Benutzer-handbuch
M Index

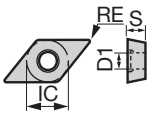
Wendeschneidplatten **POSITIV / DOPPELSEITIG**

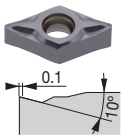
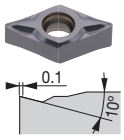
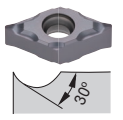
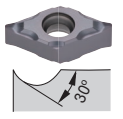
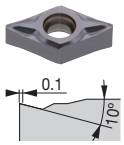
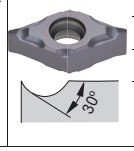
● : Kontinuierlicher Schnitt
ɔ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

DX

Rhombisch, 55° mit Loch

		AH725	AH8015	SH725	GT9530	NS9530	KS05F
P	Stahl	ɔ		●ɔ	●ɔ	●ɔ	
M	Rostfreier Stahl	ɔ	ɔ	●ɔ			
K	Eisenguss	ɔ			●ɔ	●ɔ	●
N	Nichteisen-metalle						●
S	Hitzebest. Legierungen	●	ɔ				●
H	Gehärteter Stahl						



Anwendung	Spanform-stufe	Katalog Nr.	Beschichtet AH725	Beschichtet AH8015	Beschichtet SH725	Cermet besch. GT9530	Cermet NS9530	Unbeschichtet KS05F	RE	IC	S	D1
Schlichten bis mittl. Bearb. (scharfkantig)	JTS	DXGU070301MFR-JTS			●				<0.1	6.35	3.18	2.7
		DXGU070301MFL-JTS			●				<0.1	6.35	3.18	2.7
		DXGU070302MFR-JTS			●				<0.2	6.35	3.18	2.7
		DXGU070302MFL-JTS			●				<0.2	6.35	3.18	2.7
Schlichten bis mittl. Bearbeitung	JTS	DXGU070301MR-JTS	●						<0.1	6.35	3.18	2.7
		DXGU070301ML-JTS	●						<0.1	6.35	3.18	2.7
		DXGU070302MR-JTS	●						<0.2	6.35	3.18	2.7
		DXGU070302ML-JTS	●						<0.2	6.35	3.18	2.7
Schlichten (Niedrige Schnittkräfte, scharfkantig)	JSS	DXGU070301MFR-JSS			●				<0.1	6.35	3.18	2.7
		DXGU070301MFL-JSS			●				<0.1	6.35	3.18	2.7
		DXGU070302MFR-JSS			●				<0.2	6.35	3.18	2.7
		DXGU070302MFL-JSS			●				<0.2	6.35	3.18	2.7
Schlichten (Niedrige Schnittkräfte)	JSS	DXGU070301MR-JSS	●						<0.1	6.35	3.18	2.7
		DXGU070301ML-JSS	●						<0.1	6.35	3.18	2.7
		DXGU070302MR-JSS	●						<0.2	6.35	3.18	2.7
		DXGU070302ML-JSS	●						<0.2	6.35	3.18	2.7
Schlichten bis mittlere Bearbeitung	TS	DXGU070302R-TS	●	●		●	●	●	0.2	6.35	3.18	2.7
		DXGU070302L-TS	●	●		●	●	●	0.2	6.35	3.18	2.7
		DXGU070304R-TS	●	●		●	●	●	0.4	6.35	3.18	2.7
		DXGU070304L-TS	●	●		●	●	●	0.4	6.35	3.18	2.7
		DXGU070308R-TS	●	●		●	●	●	0.8	6.35	3.18	2.7
		DXGU070308L-TS	●	●		●	●	●	0.8	6.35	3.18	2.7
Schlichten (Niedrige Schnittkräfte)	SS	DXGU070302R-SS	●	●		●	●	●	0.2	6.35	3.18	2.7
		DXGU070302L-SS	●	●		●	●	●	0.2	6.35	3.18	2.7
		DXGU070304R-SS	●	●		●	●	●	0.4	6.35	3.18	2.7
		DXGU070304L-SS	●	●		●	●	●	0.4	6.35	3.18	2.7

*Eckenradius (RE) mit einem Kleiner-als-Zeichen (<) bedeutet eine Minustoleranz.

● Lagerstandard

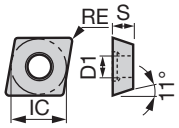
Halter / Außendrehen → C039 - Halter / Innendrehen → D035 -

● : Kontinuierlicher Schnitt
ⓒ : Leicht unterbrochener Schnitt
✠ : Stark unterbrochener Schnitt

EP

Rhombisch, 75°
mit Loch
Positiv 11°

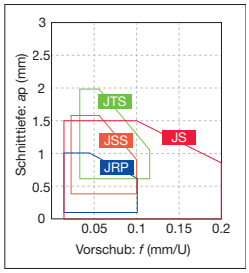
P	Stahl	● ⓒ ⓒ ⓒ ⓒ ● ⓒ
M	Rostfreier Stahl	● ⓒ ⓒ ⓒ ⓒ ● ⓒ
K	Eisenguss	● ⓒ ⓒ ⓒ ●
N	Nichteisen-metalle	●
S	Hitzebest. Legierungen	● ⓒ ⓒ
H	Gehärteter Stahl	

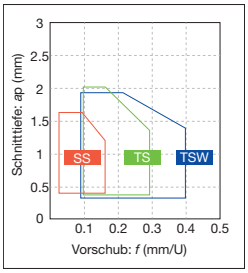


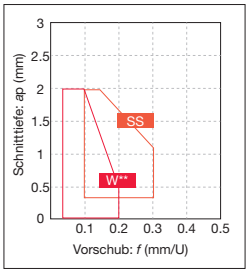
Anwendung	Spanform-stufe	Katalog Nr.	Beschichtet GH110	Beschichtet SH725	Beschichtet SH730	Cermet besch. GT9530	Cermet NS9530	Unbeschichtet TH10	Unbeschichtet UX30	RE	IC	S	D1
Schlichten	W08	**EPGT03X100R-W08**			●			●		0.03	3.57	1.39	1.9
		EPGT03X100L-W08			●			●		0.03	3.57	1.39	1.9
		EPGT03X101R-W08			●			●		0.1	3.57	1.39	1.9
		EPGT03X101L-W08			●			●		0.1	3.57	1.39	1.9
		EPGT03X102R-W08			●			●		0.2	3.57	1.39	1.9
		EPGT03X102L-W08			●			●		0.2	3.57	1.39	1.9
		EPGT03X104R-W08			●			●		0.4	3.57	1.39	1.9
		EPGT03X104L-W08			●			●		0.4	3.57	1.39	1.9
		EPGT040100R-W08			●			●		0.03	3.97	1.59	2.3
		EPGT040100L-W08	●		●		●	●		0.03	3.97	1.59	2.3
		EPGT040101R-W08			●			●		0.1	3.97	1.59	2.3
		EPGT040101L-W08			●			●		0.1	3.97	1.59	2.3
		EPGT040102R-W08	●		●		●	●		0.2	3.97	1.59	2.3
		EPGT040102L-W08	●		●	●	●	●	●	0.2	3.97	1.59	2.3
		EPGT040104R-W08	●		●		●	●		0.4	3.97	1.59	2.3
		EPGT040104L-W08	●		●	●	●	●	●	0.4	3.97	1.59	2.3
Schlichten (scharfkantig)	W08	**EPGT03X100FL-W08**		●						0.03	3.57	1.39	1.9
		EPGT03X100FR-W08		●						0.03	3.57	1.39	1.9
		EPGT03X101FL-W08		●						0.1	3.57	1.39	1.9
		EPGT03X101FR-W08		●						0.1	3.57	1.39	1.9
		EPGT03X102FL-W08		●						0.2	3.57	1.39	1.9
		EPGT03X102FR-W08		●						0.2	3.57	1.39	1.9
		EPGT03X104FL-W08		●						0.4	3.57	1.39	1.9
		EPGT03X104FR-W08		●						0.4	3.57	1.39	1.9
		EPGT040100FL-W08		●						0.03	3.97	1.59	2.3
		EPGT040100FR-W08		●						0.03	3.97	1.59	2.3
		EPGT040101FL-W08		●						0.1	3.97	1.59	2.3
		EPGT040101FR-W08		●						0.1	3.97	1.59	2.3
		EPGT040102FL-W08		●						0.2	3.97	1.59	2.3
		EPGT040102FR-W08		●						0.2	3.97	1.59	2.3
		EPGT040104FL-W08		●						0.4	3.97	1.59	2.3
		EPGT040104FR-W08		●						0.4	3.97	1.59	2.3

● Lagerstandard

Spankontrollbereich







Halter / Innendrehen → D033 -
Bohrstangen → K211 -
Top-Borer Tools → K213

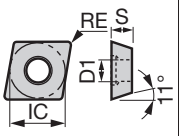
Wendeschneidplatten POSITIV

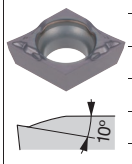
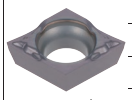
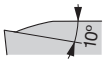
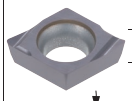
● : Kontinuierlicher Schnitt
◐ : Leicht unterbrochener Schnitt
✽ : Stark unterbrochener Schnitt

EP

Rhombisch, 75°
mit Loch
Positiv 11°

		SH725	SH730	J740
P	Stahl	◐	◐	◐
M	Rostfreier Stahl	◐	◐	◐
K	Eisenguss			
N	Nichteisenmetalle			
S	Hitzebest. Legierungen		◐	
H	Gehärteter Stahl			



Anwendung	Spanformstufe	Katalog Nr.	Beschichtet SH725	SH730	J740	Größe (mm) RE	IC	S	D1
Innendrehen auf Langdrehautomaten	JS	EPGT03X101-JS		●		<0.1	3.57	1.39	1.9
		EPGT03X102-JS		●		<0.2	3.57	1.39	1.9
		EPGT03X104-JS		●		<0.4	3.57	1.39	1.9
		EPGT040101-JS		●		<0.1	3.97	1.59	2.3
		EPGT040102-JS		●		<0.2	3.97	1.59	2.3
		EPGT040104-JS		●		<0.4	3.97	1.59	2.3
Innendrehen auf Langdrehautomaten (scharfkantig)	JS	EPGT03X101F-JS	●			<0.1	3.57	1.39	1.9
		EPGT03X102F-JS	●			<0.2	3.57	1.39	1.9
		EPGT03X104F-JS	●			<0.4	3.57	1.39	1.9
		EPGT040101F-JS	●			<0.1	3.97	1.59	2.3
		EPGT040102F-JS	●			<0.2	3.97	1.59	2.3
		EPGT040104F-JS	●			<0.4	3.97	1.59	2.3
Schlichten	J08	EPGT040100L-J08		●	●	0.03	3.97	1.59	2.3
		EPGT040102L-J08		●	●	0.2	3.97	1.59	2.3
		EPGT040104L-J08		●	●	0.4	3.97	1.59	2.3
Schlichten (scharfkantig)	J08	EPGT040100FL-J08	●			0.03	3.97	1.59	2.3
		EPGT040102FL-J08	●			0.2	3.97	1.59	2.3
		EPGT040104FL-J08	●			0.4	3.97	1.59	2.3

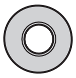
*Eckenradius (RE) mit einem Kleiner-als-Zeichen (<) bedeutet eine Minustoleranz.

● Lagerstandard

Halter / Innendrehen → D033 - Bohrstangen → K211 -
Top-Borer Tools → K213

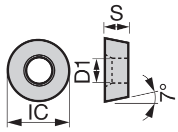
● : Kontinuierlicher Schnitt
◖ : Leicht unterbrochener Schnitt
✠ : Stark unterbrochener Schnitt

RC

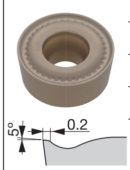


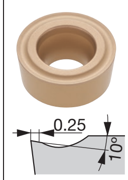
Rund, mit Loch Positiv 7°

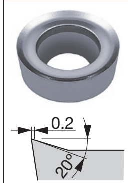
Werkstoff	T9215	T9225	T9115	T9125	T5115	AH120	AH8005	AH8015	AH905	KS05F
P Stahl	●◖	◖✠	●◖	◖✠		●◖				
M Rostfreier Stahl	●◖					●◖	●	◖		
K Eisenguss	●◖		●◖		◖	●◖				●
N Nichteisenmetalle										●
S Hitzebest. Legierungen						●◖	●	◖	◖	●
H Gehärteter Stahl										

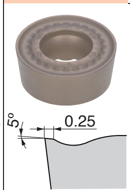


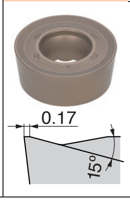
Anwendung	Spanformstufe	Katalog Nr.	Beschichtet: T9215	T9225	T9115	T9125	T5115	AH120	AH8005	AH8015	AH905	Unbeschichtet: KS05F	Größe (mm): RE	IC	S	D1
Schlichten bis mittlere Bearbeitung	RS	RCMT10T3M0-RS	●	●	▲	▲			●	●	●		-	10	3.97	4.4
		RCMT1204M0-RS	●	●	▲	▲			●	●	●		-	12	4.76	4.4
		RCMT1606M0-RS	●	●	▲	▲		●					-	16	6.35	5.5
		RCMT2006M0-RS		●		▲							-	20	6.35	6.5
		RCMT2507M0-RS		●		▲							-	25	7.94	7.6
	CM	RCMT0502M0-CM					●						-	5	2.38	2.5
		RCMT0602M0-CM					●						-	6	2.38	2.8
		RCMT0803M0-CM					●						-	8	3.18	3.4
	AL	RCGT0602M0-AL										●	-	6	2.38	2.8
		RCGT0803M0-AL										●	-	8	3.18	3.4
		RCGT1003M0-AL										●	-	10	3.18	4
Schlichten (Niedrige Schnittkräfte)	6RS	RCMT1204M0-6RS	●	●	▲	▲							-	12	4.76	5.16
Mittlere Bearbeitung	6RM	RCMT1204M0-6RM	●	●	▲	▲							-	12	4.76	5.16

RS:


CM:


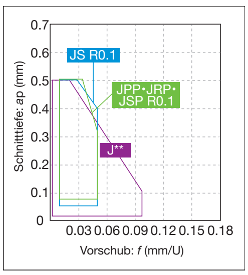
AL:


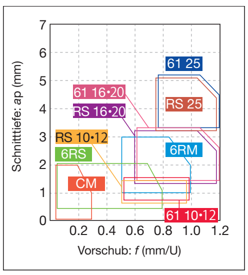
6RS:


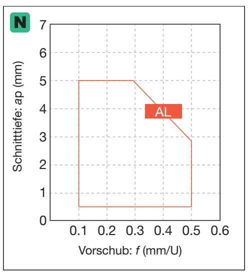
6RM:


● Lagerstandard
▲ Wird eingestellt

Spankontrollbereich







*Spankontrolle mit typ. R0.1

Halter / Außendrehen → C074 -, C083

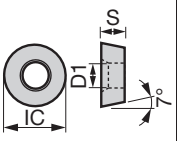
Wendeschneidplatten POSITIV

● : Kontinuierlicher Schnitt
◐ : Leicht unterbrochener Schnitt
✠ : Stark unterbrochener Schnitt

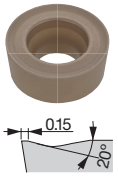
RC

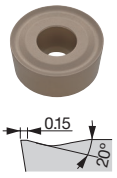
Rund, mit Loch Positiv 7°

		T9215	T9225	T9115	T9125	AH8005	AH8015	AH905	NS9530	TH10
P	Stahl	●◐	◐✠	●◐	◐✠				●◐	●
M	Rostfreier Stahl	●◐				●	◐			●
K	Eisenguss	●◐		●◐					●◐	●
N	Nichteisen-metalle									●
S	Hitzebest. Legierungen					●	◐	◐		
H	Gehärteter Stahl									



Anwendung	Spanform-stufe	Katalog Nr.	Beschichtet T9215	T9225	T9115	T9125	AH8005	AH8015	AH905	Cermet NS9530	Unbeschichtet TH10	Größe (mm) RE	IC	S	D1
Schwerzerspanung	61	RCMT0502M0-61	●	●	▲	▲				●	●	-	5	2.38	2.5
		RCMT0602M0-61	●	●	▲	▲				●	●	-	6	2.38	2.8
		RCMT0803M0-61	●	●	▲	▲				●	●	-	8	3.18	3.4
	61	RCMM1003M0-61	●	●	▲	▲	●	●	●	●	●	-	10	3.18	3.6
		RCMM1204M0-61	●	●	▲	▲	●	●	●	●	●	-	12	4.76	4.2
		RCMM1606M0-61	●	●	▲	▲					●	-	16	6.35	5.2
		RCMM2006M0-61		●		▲					●	-	20	6.35	6.5
		RCMM2507M0-61		●		▲						-	25	7.94	7.2



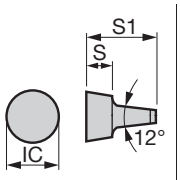


D1 (mm)	Katalog Nr.	0502M0	0602M0	0803M0	1003M0	1204M0	1606M0	2006M0	2507M0
	RC*T	2.5	2.8	3.4	4.4	4.4	5.5	6.5	7.6
	RCMM	-	-	-	3.6	4.2	5.2	6.5	7.2

RT

Spezielle runde WSP

		TH10	KS20
P	Stahl	●	
M	Rostfreier Stahl	●	
K	Eisenguss	●	◐✠
N	Nichteisen-metalle	●	◐✠
S	Hitzebest. Legierungen		◐✠
H	Gehärteter Stahl		



Anwendung	Spanform-stufe	Katalog Nr.	Unbeschichtet TH10	KS20	Größe (mm) RE	IC	S	S1
Mittlere Bearbeitung	-	RT05	●		-	5	2.5	6.5
		RT06	●	●	-	6	3	7.7
		RT08	●		-	8	4.2	10.3

● Lagerstandard
▲ Wird eingestellt

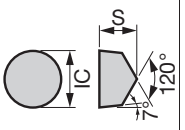
RC...: Halter / Außendrehen → C074 -

● : Kontinuierlicher Schnitt
◐ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

RC

Rund, ohne Loch
Positiv 7°

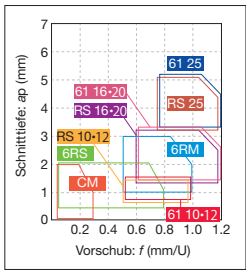
P	Stahl	
M	Rostfreier Stahl	
K	Eisenguss	
N	Nichteisen-metalle	
S	Hitzebest. Legierungen	
H	Gehärteter Stahl	●



Anwendung	Spanform-stufe	Katalog Nr.	Keramik LX11	RE	IC	S	D1
Mittlere Bearbeitung	-	RCGX090800	●	-	9.525	8	-
		RCGX120800	●	-	12.7	8	-

● Lagerstandard

Spankontrollbereich



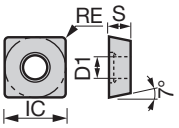
MEMO

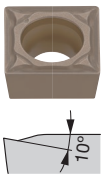
● : Kontinuierlicher Schnitt
c : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

SC

Quadratisch, 90° mit Loch Positiv 7°

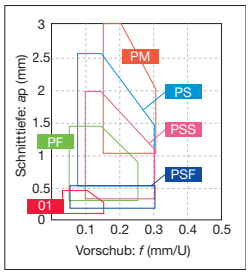
		T9215	T9225	T9115	T9125	T6120	T6130	AH630	AH645	T515	T5115	AH120	AH725	GT9530	AT9530	NS9530
P	Stahl	●c	c✣	●c	c✣	c	✣	c✣	✣			●c	c	●c	●c	●c
M	Rostfreier Stahl	●c				●	c	c	✣			●c	c			
K	Eisenguss	●c		●c						●c	c	●c	c	●c	●c	●c
N	Nichteisenmetalle															
S	Hitzebest. Legierungen											●c	●			
H	Gehärteter Stahl															

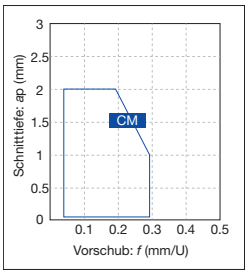


Anwendung	Spanformstufe	Katalog Nr.	Beschichtet												Cermet besch.		Cermet		Größe (mm)			
			T9215	T9225	T9115	T9125	T6120	T6130	AH630	AH645	T515	T5115	AH120	AH725	GT9530	AT9530	NS9530		RE	IC	S	D1
Schlichten bis mittlere Bearbeitung	**PS**	**SCMT09T304-PS**	●	●	▲	▲	●	●	●	●				●	●	●	●		0.4	9.525	3.97	4.4
		SCMT09T308-PS	●	●	▲	▲	●	●	●	●				●	●	●	●		0.8	9.525	3.97	4.4
		SCMT120404-PS	●	●	▲	▲	●	●	●	●				●			●		0.4	12.7	4.76	5.5
		SCMT120408-PS	●	●	▲	▲	●	●	●	●				●			●		0.8	12.7	4.76	5.5
	23	**SCMT09T302-23**															●		0.2	9.525	3.97	4.4
		SCMT09T308-23		●		▲							●						0.8	9.525	3.97	4.4
		SCMT120408-23		●		▲							●	●					0.8	12.7	4.76	5.5
Mittlere Bearbeitung	**24**	**SCMT070204-24**		●		▲											●		0.4	7.94	2.38	3.4
		SCMT09T302-24		●													●		0.2	9.525	3.97	4.4
		SCMT09T304-24		●		▲											●		0.4	9.525	3.97	4.4
		SCMT09T308-24	●	●	▲	▲											●		0.8	9.525	3.97	4.4
		SCMT120404-24		●		▲											●		0.4	12.7	4.76	5.5
		SCMT120408-24		●		▲											●		0.8	12.7	4.76	5.5
	PM	**SCMT09T304-PM**	●	●	▲	▲	●	●	●	●				●			●		0.4	9.525	3.97	4.4
		SCMT09T308-PM	●	●	▲	▲	●	●	●	●				●			●		0.8	9.525	3.97	4.4
		SCMT120408-PM	●	●	▲	▲	●	●	●	●				●			●		0.8	12.7	4.76	5.5
		SCMT120412-PM		●		▲	●	●	●	●				●			●		1.2	12.7	4.76	5.5
Schlichten bis mittlere Bearbeitung	**CM**	**SCMT09T304-CM**									●	●							0.4	9.525	3.97	4.4
		SCMT09T308-CM									●	●							0.8	9.525	3.97	4.4
		SCMT09T312-CM										●							1.2	9.525	3.97	4.4
		SCMT120404-CM									●	●							0.4	12.7	4.76	5.5
		SCMT120408-CM									●	●							0.8	12.7	4.76	5.5

● Lagerstandard
▲ Wird eingestellt

Spankontrollbereich





Halter / Außendrehen → C104 -

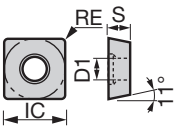
Wendeschneidplatten POSITIV

● : Kontinuierlicher Schnitt
c : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

SP

Quadratisch, 90°
mit Loch
Positiv 11°

		T9215	T9225	T9115	T9125	T6120	T6130	AH630	AH645	AH120	AH725	GT9530	AT9530	NS9530	TH10
P	Stahl	●c	c✣	●c	c✣	c	✣	c✣	✣	●c	c	●c	●c	●c	●
M	Rostfreier Stahl	●c				●	c	c	✣	●c	c				●
K	Eisenguss	●c		●c						●c	c	●c	●c	●c	●
N	Nichteisenmetalle														●
S	Hitzebest. Legierungen									●c	●				
H	Gehärteter Stahl														



Anwendung	Spanformstufe	Katalog Nr.	RE	IC	S	D1
Schlichten bis mittlere Bearbeitung	PS	SPMT090304-PS	0.4	9.525	3.18	4.4
		SPMT090308-PS	0.8	9.525	3.18	4.4
		SPMT120404-PS	0.4	12.7	4.76	5.5
		SPMT120408-PS	0.8	12.7	4.76	5.5
	23	SPMT090304-23	0.4	9.525	3.18	4.4
		SPMT090308-23	0.8	9.525	3.18	4.4
Mittlere Bearbeitung	24	SPMT090304-24	0.4	9.525	3.18	4.4
		SPMT090308-24	0.8	9.525	3.18	4.4
		SPMT120404-24	0.4	12.7	4.76	5.5
		SPMT120408-24	0.8	12.7	4.76	5.5
Schlichten	W15	SPGT090302L-W15	0.2	9.525	3.18	4.4
		SPGT090304L-W15	0.4	9.525	3.18	4.4
		SPGT090308R-W15	0.8	9.525	3.18	4.4
		SPGT090308L-W15	0.8	9.525	3.18	4.4
	W20	SPGT120404L-W20	0.4	12.7	4.76	5.5

● Lagerstandard
▲ Wird eingestellt

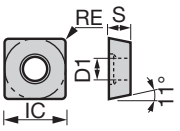
Halter / Innendrehen → D038 - Kassetten → K197 -

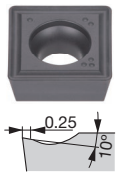
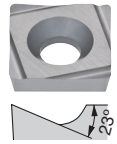
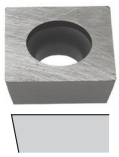
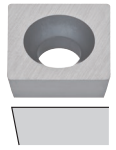
● : Kontinuierlicher Schnitt
c : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

SP

Quadratisch, 90°
mit Loch
Positiv 11°

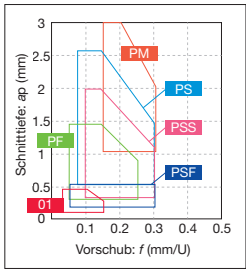
P	Stahl	●c
M	Rostfreier Stahl	●
K	Eisenguss	●c c
N	Nichteisen-metalle	●
S	Hitzebest. Legierungen	
H	Gehärteter Stahl	

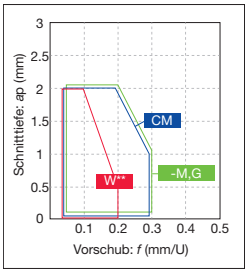


Anwendung	Spanform-stufe	Katalog Nr.	Beschichtet T515	Beschichtet T5115	Cermet NS9530	Unbeschichtet TH10	Größe (mm) RE	IC	S	D1
Schlichten bis mittlere Bearbeitung	CM	SPMT090304-CM		●			0.4	9.525	3.18	4.4
		SPMT090308-CM		●			0.8	9.525	3.18	4.4
		SPMT120404-CM	●	●			0.4	12.7	4.76	5.5
		SPMT120408-CM	●	●			0.8	12.7	4.76	5.5
	-	SPGM090304L			●		0.4	9.525	3.18	4.4
	(Tungaloy Standard-Loch)	SPGM120304L			●		0.4	12.7	3.18	5
		SPGM120308L			●		0.8	12.7	3.18	5
	-	SPMW090304		●			0.4	9.525	3.18	4.4
		SPMW090308		●			0.8	9.525	3.18	4.4
		SPMW120404		●			0.4	12.7	4.76	5.5
		SPMW120408		●			0.8	12.7	4.76	5.5
	-	SPGW090302				●	0.2	9.525	3.18	4.4
		SPGW090304				●	0.4	9.525	3.18	4.4
		SPGW120404				●	0.4	12.7	4.76	5.5
	-	SPGA090304			●		0.4	9.525	3.18	4.4
	(Tungaloy Standard-Loch)									
										

● Lagerstandard

Spankontrollbereich





*-M,G: Ohne Spanformstufe

Halter / Innendrehen → D038 - Kassetten → K197 -

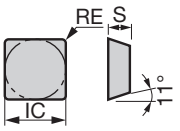
Wendeschneidplatten POSITIV

● : Kontinuierlicher Schnitt
ᑕ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

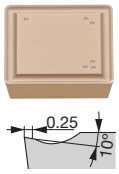
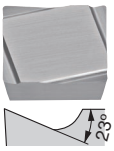
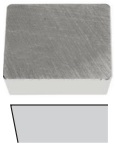
SP

Quadratisch, 90°
ohne Loch
Positiv 11°

		T9225	T9125	T5115	NS9530	TH10	UX30	LX11	WG300
P	Stahl	ᑕ✣	ᑕ✣		●ᑕ	●	●		
M	Rostfreier Stahl					●	●		
K	Eisenguss			ᑕ	●ᑕ	●			
N	Nichteisenmetalle					●			
S	Hitzebest. Legierungen								●ᑕ
H	Gehärteter Stahl							●	



Schlichten bis mittlere Bearbeitung

Anwendung	Spanformstufe	Katalog Nr.	Beschichtet T9225	Beschichtet T9125	Beschichtet T5115	Cermet NS9530	Unbeschichtet TH10	Unbeschichtet UX30	Keramik LX11	Keramik WG300	Größe (mm) RE	IC	S	D1
Schlichten bis mittlere Bearbeitung	**23**	**SPMR090304-23**				●					0.4	9.525	3.18	-
		SPMR090308-23	●	▲		●					0.8	9.525	3.18	-
		SPMR120304-23	●	▲		●					0.4	12.7	3.18	-
		SPMR120308-23	●	▲		●					0.8	12.7	3.18	-
	CM	**SPMR090304-CM**			●						0.4	9.525	3.18	-
		SPMR090308-CM			●						0.8	9.525	3.18	-
		SPMR120304-CM			●						0.4	12.7	3.18	-
		SPMR120308-CM			●						0.8	12.7	3.18	-
		SPMR120312-CM			●						1.2	12.7	3.18	-
	-	**SPGR090304L**				●					0.4	9.525	3.18	-
														
	-	**SPGN090304**					●		●		0.4	9.525	3.18	-
		SPGN090308					●		●		0.8	9.525	3.18	-
		**SPGN120304**					●		●		0.4	12.7	3.18	-
		SPGN120308					●		●		0.8	12.7	3.18	-
		SPGN120312				●			●		1.2	12.7	3.18	-
		SPGN120408					●				0.8	12.7	4.76	-
	-	**SPMN090304**			●						0.4	9.525	3.18	-
		SPMN090308			●						0.8	9.525	3.18	-
		SPMN120304			●						0.4	12.7	3.18	-
		SPMN120308			●	●	●	●			0.8	12.7	3.18	-
		SPMN120312			●		●				1.2	12.7	3.18	-
		SPMN120408			●		●				0.8	12.7	4.76	-
		SPMN120412			●						1.2	12.7	4.76	-

● Lagerstandard
▲ Wird eingestellt

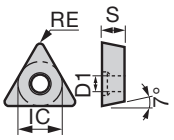
Halter / Innendrehen → D038 - Kassetten → K197 -

● : Kontinuierlicher Schnitt
c : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

TC

Dreieckig, 60°
mit Loch
Positiv 7°

P	Stahl	●c	c✣	●c	c✣	c	●c	●c			●c					●c	●c			●									
M	Rostfreier Stahl	●c				c	●c	●c												●									
K	Eisenguss	●c		●c		c					●c					●c	●c			●									
N	Nichteisen-metalle																			●									
S	Hitzebest. Legierungen					●																							
H	Gehärteter Stahl																												

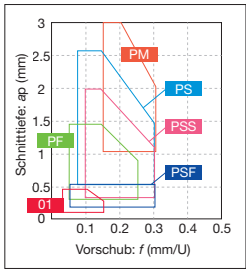


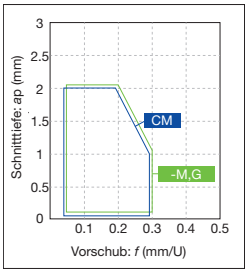
Anwendung	Spanform-stufe	Katalog Nr.	Beschichtet							Cermet besch.	Cermet		Unbe-schichtet				Größe (mm)			
			T9215	T9225	T9115	T9125	AH725	SH725	J740	GT9530	NS9530	NS520	TH10				RE	IC	S	D1
Feinschlichten	01	TCGT090204-01										●	●				0.4	5.56	2.38	2.5
		TCGT110202-01							●								0.2	6.35	2.38	2.8
		TCGT1102**04**-01								●	●	●	●				0.4	6.35	2.38	2.8
		TCGT1102**08**-01									●						0.8	6.35	2.38	2.8
		TCGT16T304-01											●				0.4	9.525	3.97	4.4
		TCGT16T3**08**-01										●	●				0.8	9.525	3.97	4.4
Feinschlichten (scharfkantig)	01	TCGT110202F-01						●									<0.2	6.35	2.38	2.8
		TCGT1102**04**F-01						●									<0.4	6.35	2.38	2.8
Schlichten	PSF	TCMT090202-PSF					●										0.2	5.56	2.38	2.5
		TCMT0902**04**-PSF	●	●	▲	▲	●										0.4	5.56	2.38	2.5
		TCMT110202-PSF					●										0.2	6.35	2.38	2.8
		TCMT1102**04**-PSF	●	●	▲	▲	●										0.4	6.35	2.38	2.8
		TCMT110302-PSF					●										0.2	6.35	3.18	2.8
		TCMT1103**04**-PSF	●	●	▲	▲	●										0.4	6.35	3.18	2.8
		TCMT16T304-PSF	●	●	▲	▲	●										0.4	9.525	3.97	4.4
Schlichten bis leichte Bearbeitung	PSS	TCMT090204-PSS	●	●	▲	▲	●										0.4	5.56	2.38	2.5
		TCMT0902**08**-PSS	●	●	▲	▲	●										0.8	5.56	2.38	2.5
		TCMT110204-PSS	●	●	▲	▲	●										0.4	6.35	2.38	2.8
		TCMT1102**08**-PSS	●	●	▲	▲	●										0.8	6.35	2.38	2.8
		TCMT110304-PSS	●	●	▲	▲	●										0.4	6.35	3.18	2.8
		TCMT1103**08**-PSS	●	●	▲	▲	●										0.8	6.35	3.18	2.8
		TCMT16T304-PSS	●	●	▲	▲	●										0.4	9.525	3.97	4.4
		TCMT16T3**08**-PSS	●	●	▲	▲	●										0.8	9.525	3.97	4.4
		TCMT16T3**12**-PSS	●	●	▲	▲	●										1.2	9.525	3.97	4.4

*Eckenradius (RE) mit einem Kleiner-als-Zeichen (<) bedeutet eine Minustoleranz.

● Lagerstandard
▲ Wird eingestellt

Spankontrollbereich





*-M,G: Ohne Spanformstufe

Halter / Außendrehen	→ C076 -	Halter / Innendrehen	→ D042
J-Serie Werkzeughalter	→ G039 -	PINZBOHR®	→ K180 -

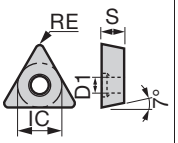
Wendeschneidplatten POSITIV

● : Kontinuierlicher Schnitt
ɔ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

TC

Dreieckig, 60°
mit Loch
Positiv 7°

		T9215	T9225	T9115	T9125	T6120	T6130	AH630	AH645	AH725	GH730	GT9530	AT9530	NS9530	TH10
P	Stahl	●ɔ	ɔ✣	●ɔ	ɔ✣	ɔ	✣	ɔ✣	✣	ɔ	ɔ	●ɔ	●ɔ	●ɔ	●
M	Rostfreier Stahl	●ɔ				●	ɔ	ɔ	✣	ɔ	ɔ				●
K	Eisenguss	●ɔ		●ɔ						ɔ	ɔ	●ɔ	●ɔ	●ɔ	●
N	Nichteisen-metalle														●
S	Hitzebest. Legierungen									●					
H	Gehärteter Stahl														



Anwendung	Spanform-stufe	Katalog Nr.	RE	IC	S	D1
Schlichten bis mittlere Bearbeitung	PS	TCMT090204-PS	0.4	5.56	2.38	2.5
		TCMT09020**8**-PS	0.8	5.56	2.38	2.5
		TCMT110202-PS	0.2	6.35	2.38	2.8
		TCMT11020**4**-PS	0.4	6.35	2.38	2.8
		TCMT11020**8**-PS	0.8	6.35	2.38	2.8
		TCMT110302-PS	0.2	6.35	3.18	2.8
		TCMT11030**4**-PS	0.4	6.35	3.18	2.8
		TCMT11030**8**-PS	0.8	6.35	3.18	2.8
		TCMT16T302-PS	0.2	9.525	3.97	4.4
		TCMT16T3**04**-PS	0.4	9.525	3.97	4.4
		TCMT16T3**08**-PS	0.8	9.525	3.97	4.4
	TSF	TCMT110204-TSF	0.4	6.35	2.38	2.8
		TCMT11020**8**-TSF	0.8	6.35	2.38	2.8
		TCMT16T304-TSF	0.4	9.525	3.97	4.4
		TCMT16T3**08**-TSF	0.8	9.525	3.97	4.4
	TM	TCMT110204-TM	0.4	6.35	2.38	2.8
		TCMT11020**8**-TM	0.8	6.35	2.38	2.8
		TCMT16T304-TM	0.4	9.525	3.97	4.4
		TCMT16T3**08**-TM	0.8	9.525	3.97	4.4
	23	TCMT090204-23	0.4	5.56	2.38	2.5
		TCMT110204-23	0.4	6.35	2.38	2.8
		TCMT16T304-23	0.4	9.525	3.97	4.4
		TCMT16T3**08**-23	0.8	9.525	3.97	4.4
Mittlere Bearbeitung	24	TCMT090202-24	0.2	5.56	2.38	2.5
		TCMT09020**4**-24	0.4	5.56	2.38	2.5
		TCMT110202-24	0.2	6.35	2.38	2.8
		TCMT11020**4**-24	0.4	6.35	2.38	2.8
		TCMT11020**8**-24	0.8	6.35	2.38	2.8
		TCMT16T304-24	0.4	9.525	3.97	4.4
		TCMT16T3**08**-24	0.8	9.525	3.97	4.4
Schlichten	W15	TCGT16T302L-W15	0.2	9.525	3.97	4.4
		TCGT16T3**04**L-W15	0.4	9.525	3.97	4.4
		TCGT16T3**08**L-W15	0.8	9.525	3.97	4.4

● Lagerstandard
▲ Wird eingestellt

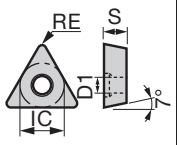
Halter / Außendrehen → C076 -
J-Serie Werkzeughalter → G039 -
Halter / Innendrehen → D042
PINZBOHR® → K180 -

● : Kontinuierlicher Schnitt
ɕ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

TC

Dreieckig, 60°
mit Loch
Positiv 7°

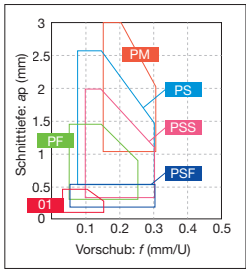
P	Stahl	●ɕ	ɕ✣	●ɕ	ɕ✣	ɕ	✣	ɕ✣	✣		●ɕ	ɕ				●ɕ															
M	Rostfreier Stahl	●ɕ				●	ɕ	ɕ	✣			ɕ																			
K	Eisenguss	●ɕ		●ɕ						●ɕ	●ɕ	ɕ				●ɕ				●											
N	Nichteisen-metalle																			●											
S	Hitzebest. Legierungen											●								●											
H	Gehärteter Stahl																														

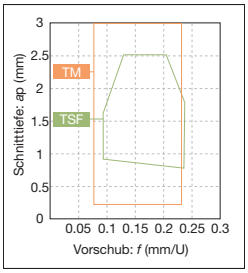


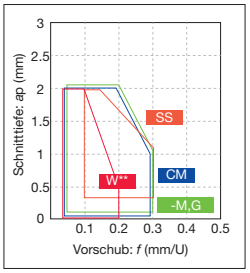
Anwendung	Spanform-stufe	Katalog Nr.	Beschichtet											Cermet	Unbe-schichtet			Größe (mm)			
			T9215	T9225	T9115	T9125	T6120	T6130	AH630	AH645	T515	T5115	AH725	NS9530	KS05F			RE	IC	S	D1
Mittlere Bearbeitung	PM	TCMT110202-PM					●	●	●	●			●					0.2	6.35	2.38	2.8
		TCMT11020**4**-PM	●	●	▲	▲	●	●	●	●			●	●				0.4	6.35	2.38	2.8
		TCMT11020**8**-PM	●	●	▲	▲	●	●	●	●			●	●				0.8	6.35	2.38	2.8
		TCMT110302-PM					●	●	●	●								0.2	6.35	3.18	2.8
		TCMT11030**4**-PM	●	●			●	●	●	●								0.4	6.35	3.18	2.8
		TCMT11030**8**-PM					●	●	●	●								0.8	6.35	3.18	2.8
		TCMT16T304-PM			▲	▲	●	●	●	●			●	●				0.4	9.525	3.97	4.4
		TCMT16T3**08**-PM	●	●	▲	▲	●	●	●	●			●	●				0.8	9.525	3.97	4.4
		TCMT16T3**12**-PM	●	●	▲	▲	●	●	●	●			●					1.2	9.525	3.97	4.4
Schlichten bis mittlere Bearbeitung	CM	TCMT090204-CM										●						0.4	5.56	2.38	2.5
		TCMT0902**08**-CM										●						0.8	5.56	2.38	2.5
		TCMT110204-CM										●						0.4	6.35	2.38	2.8
		TCMT11020**8**-CM										●						0.8	6.35	2.38	2.8
		TCMT110304-CM										●						0.4	6.35	3.18	2.8
		TCMT11030**8**-CM										●						0.8	6.35	3.18	2.8
		TCMT16T304-CM									●	●						0.4	9.525	3.97	4.4
		TCMT16T3**08**-CM									●	●						0.8	9.525	3.97	4.4
		TCMT16T3**12**-CM									●	●						1.2	9.525	3.97	4.4
	SS	TCGT110202-SS												●				0.2	6.35	2.38	2.8
		TCGT11020**4**-SS												●				0.4	6.35	2.38	2.8
		TCGT11020**8**-SS												●				0.8	6.35	2.38	2.8
		TCGT16T304-SS												●				0.4	9.525	3.97	4.4
	AL	TCGT110202-AL													●			0.2	6.35	2.38	2.8
		TCGT11020**4**-AL													●			0.4	6.35	2.38	2.8
		TCGT16T302-AL													●			0.2	9.525	3.97	4.4
		TCGT16T3**04**-AL													●			0.4	9.525	3.97	4.4
		TCGT16T3**08**-AL													●			0.8	9.525	3.97	4.4

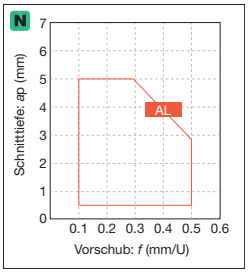
● Lagerstandard
▲ Wird eingestellt

Spankontrollbereich









*-M,G: Ohne Spanformstufe

Halter / Außendrehen	→ C076 -	Halter / Innendrehen	→ D042
J-Serie Werkzeughalter	→ G039 -	PINZBOHR®	→ K180 -

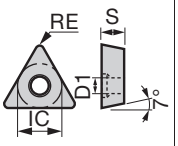
Wendeschneidplatten POSITIV

● : Kontinuierlicher Schnitt
◐ : Leicht unterbrochener Schnitt
✠ : Stark unterbrochener Schnitt

TC

Dreieckig, 60° mit Loch Positiv 7°

		AH725	SH725	SH730	J740	NS9530	TH10
P	Stahl	◐	●◐	●◐	●◐	●◐	●
M	Rostfreier Stahl	◐	●◐	●◐	●◐		●
K	Eisenguss	◐				●◐	●
N	Nichteisen-metalle						●
S	Hitzebest. Legierungen	●		●◐			
H	Gehärteter Stahl						



Anwendung	Spanform-stufe	Katalog Nr.	Beschichtet AH725	SH725	SH730	J740	Cermet NS9530	Unbeschichtet TH10	Größe (mm) RE	IC	S	D1
Schlichten	-	TCGT080102R					●	●	0.2	4.76	1.59	2.7
Außendrehen auf Langdreh-automaten (scharfkantig)	JS	TCGT110200FN-JS		●	●				0.03	6.35	2.38	2.8
		TCGT110201FN-JS		●	●				<0.1	6.35	2.38	2.8
		TCGT110202FN-JS		●	●				<0.2	6.35	2.38	2.8
		TCGT110204FN-JS		●	●				<0.4	6.35	2.38	2.8
Außendrehen auf Langdreh-automaten (geschliffen)	JS	TCGT110201N-JS	●						0.1	6.35	2.38	2.8
		TCGT110202N-JS	●						0.2	6.35	2.38	2.8
		TCGT110204N-JS	●						0.4	6.35	2.38	2.8
Außendrehen auf Langdreh-automaten (scharfkantig)	J08	TCGT080200FR-J08		●		●		●	0.03	4.76	2.38	2.3
		TCGT080200FL-J08		●		●		●	0.03	4.76	2.38	2.3
		TCGT080201FR-J08		●		●		●	0.1	4.76	2.38	2.3
		TCGT080201FL-J08		●		●		●	0.1	4.76	2.38	2.3
		TCGT080202FR-J08		●		●		●	0.2	4.76	2.38	2.3
		TCGT080202FL-J08		●		●		●	0.2	4.76	2.38	2.3
		TCGT080204FR-J08		●					0.4	4.76	2.38	2.3

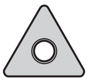
*Eckenradius (RE) mit einem Kleiner-als-Zeichen (<) bedeutet eine Minustoleranz.

● Lagerstandard

J-Serie Werkzeughalter → G039

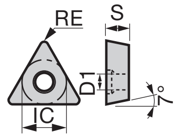
● : Kontinuierlicher Schnitt
◐ : Leicht unterbrochener Schnitt
✠ : Stark unterbrochener Schnitt

TC

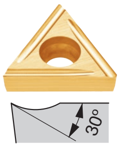


Dreieckig, 60°
mit Loch
Positiv 7°

		Beschichtet		Cermet besch.	Cermet	Unbeschichtet
P	Stahl	●◐	●◐	●◐	●◐	●
M	Rostfreier Stahl	●◐	●◐			●
K	Eisenguss			●◐	●◐	●
N	Nichteisenmetalle					●
S	Hitzebest. Legierungen					
H	Gehärteter Stahl					
		SH725	J740	J9530	NS9530	TH10

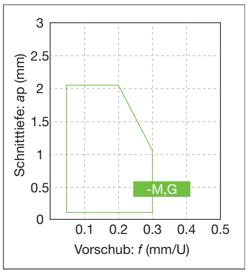


Anwendung	Spanformstufe	Katalog Nr.	SH725	J740	J9530	NS9530	TH10	RE	IC	S	D1
Außendrehen auf Langdrehautomaten (scharfkantig)	J10	TCGT110200FR-J10	●	●			●	0.03	6.35	2.38	2.8
		TCGT110200FL-J10	●	●			●	0.03	6.35	2.38	2.8
		TCGT110201FR-J10	●	●			●	0.1	6.35	2.38	2.8
		TCGT110201FL-J10	●	●			●	0.1	6.35	2.38	2.8
		TCGT110202FR-J10	●	●		●	●	0.2	6.35	2.38	2.8
		TCGT110202FL-J10	●	●		●	●	0.2	6.35	2.38	2.8
		TCGT110204FR-J10	●					0.4	6.35	2.38	2.8
		TCGT110300FR-J10	●	●			●	0.03	6.35	3.18	2.8
		TCGT110300FL-J10	●	●			●	0.03	6.35	3.18	2.8
		TCGT110301FR-J10	●	●			●	0.1	6.35	3.18	2.8
		TCGT110301FL-J10	●	●			●	0.1	6.35	3.18	2.8
		TCGT110302FR-J10	●	●		●	●	0.2	6.35	3.18	2.8
		TCGT110302FL-J10	●	●		●	●	0.2	6.35	3.18	2.8
Außendrehen auf Langdrehautomaten (geschliffen)	J10	TCGT110302R-J10			●			0.2	6.35	3.18	2.8
		TCGT110302L-J10			●			0.2	6.35	3.18	2.8

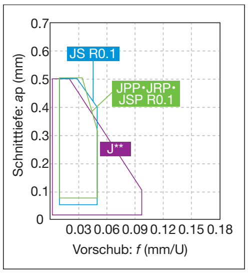


● Lagerstandard

Spankontrollbereich



*-M,G: Ohne Spanformstufe



*Spankontrolle mit R0.1

Halter / Innendrehen → D042 J-Serie Werkzeughalter → G039

A Schneidstoffe
B Wendeschneidplatten
C Halter / Außendrehen
D Halter / Innendrehen
E Gewindewerkzeuge
F Stechwerkzeuge
G Miniaturbearbeitung
H Fräser
I Schaftfräser
J Bohrer
K Werkzeugaufnahmen
L Benutzerhandbuch
M Index

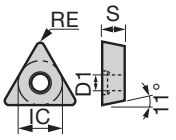
Wendeschneidplatten POSITIV

● : Kontinuierlicher Schnitt
ɔ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

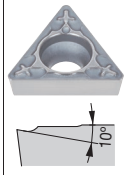
TP

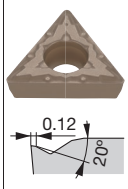
Dreieckig, 60°
mit Loch
Positiv 11°

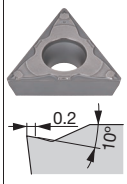
		T9215	T9225	T9115	T9125	AH725	GH730	GT9530	GT720	NS9530	NS520	TH10
P	Stahl	●ɔ	ɔ✣	●ɔ	ɔ✣	ɔ	ɔ	●ɔ	●ɔ	●ɔ	●ɔ	●
M	Rostfreier Stahl	●ɔ				ɔ	ɔ					●
K	Eisenguss	●ɔ		●ɔ		ɔ	ɔ	●ɔ	●ɔ	●ɔ	●ɔ	●
N	Nichteisenmetalle											●
S	Hitzebest. Legierungen					●						
H	Gehärteter Stahl											



Anwendung	Spanformstufe	Katalog Nr.	RE	IC	S	D1
Feinschlichten	01	TPGT090202-01	0.2	5.56	2.38	2.5
		TPGT090204-01	0.4	5.56	2.38	2.5
		TPGT110202-01	0.2	6.35	2.38	2.8
		TPGT110204-01	0.4	6.35	2.38	2.8
		TPGT110208-01	0.8	6.35	2.38	2.8
		TPGT130302-01	0.2	7.94	3.18	3.4
		TPGT130304-01	0.4	7.94	3.18	3.4
		TPGT130308-01	0.8	7.94	3.18	3.4
		TPGT16T304-01	0.4	9.525	3.97	4.4
		TPGT16T308-01	0.8	9.525	3.97	4.4
Schlichten	PSF	TPMT090202-PSF	0.2	5.56	2.38	2.5
		TPMT090204-PSF	0.4	5.56	2.38	2.5
		TPMT110202-PSF	0.2	6.35	2.38	2.8
		TPMT110204-PSF	0.4	6.35	2.38	2.8
		TPMT110302-PSF	0.2	6.35	3.18	3.4
		TPMT110304-PSF	0.4	6.35	3.18	3.4
		TPMT130304-PSF	0.4	7.94	3.18	3.4
		TPMT16T304-PSF	0.4	9.525	3.97	4.4
	PF	TPMT110204-PF	0.4	6.35	2.38	2.8
		TPMT110208-PF	0.8	6.35	2.38	2.8
		TPMT110302-PF	0.2	6.35	3.18	3.4
		TPMT110304-PF	0.4	6.35	3.18	3.4
		TPMT130304-PF	0.4	7.94	3.18	3.4
		TPMT130308-PF	0.8	7.94	3.18	3.4
		TPMT16T304-PF	0.4	9.525	3.97	4.4







● Lagerstandard
▲ Wird eingestellt

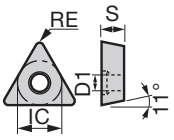
Montagelochspezifikation → B147
Halter / Innendrehen → D043 -
Bohrstangen → K209 -
Kassetten → K193 -
Top-Borer Tools → K213

● : Kontinuierlicher Schnitt
c : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

TP

Dreieckig, 60°
mit Loch
Positiv 11°

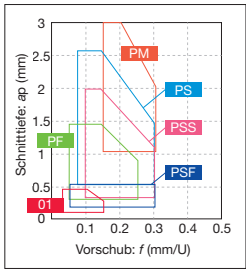
P	Stahl	●c	c✣	●c	c✣	c	✣	c✣	✣	●c	c	c			●c	●c			●c												
M	Rostfreier Stahl	●c				●	c	c	✣	●c	c	c																			
K	Eisenguss	●c		●c						●c	c	c			●c	●c			●c												
N	Nichteisen-metalle																														
S	Hitzebest. Legierungen									●c	●																				
H	Gehärteter Stahl																														

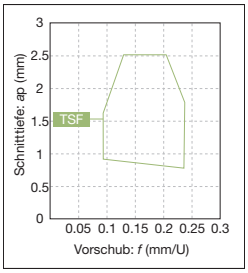


Anwendung	Spanform-stufe	Katalog Nr.	Beschichtet											Cermet besch.		Cermet				Größe (mm)			
			T9215	T9225	T9115	T9125	T6120	T6130	AH630	AH645	AH120	AH725	GH730	GT9530	AT9530	NS9530				RE	IC	S	D1
Schlichten bis leichte Bearbeitung	**PSS**	**TPMT090204-PSS**	●	●	▲	▲	●	●	●	●		●		●		●				0.4	5.56	2.38	2.5
		TPMT090208-PSS	●	●	▲	▲	●	●	●	●		●		●		●				0.8	5.56	2.38	2.5
		TPMT110204-PSS	●	●	▲	▲	●	●	●	●		●		●		●				0.4	6.35	2.38	2.8
		TPMT110208-PSS	●	●	▲	▲	●	●	●	●		●		●		●				0.8	6.35	2.38	2.8
		TPMT110304-PSS	●	●	▲	▲	●	●	●	●		●								0.4	6.35	3.18	3.4
		TPMT110308-PSS	●	●	▲	▲	●	●	●	●		●								0.8	6.35	3.18	3.4
		TPMT130304-PSS	●	●	▲	▲	●	●	●	●		●								0.4	7.94	3.18	3.4
		TPMT130308-PSS	●	●	▲	▲	●	●	●	●		●		●		●				0.8	7.94	3.18	3.4
		TPMT16T304-PSS	●	●	▲	▲	●	●	●	●		●		●		●				0.4	9.525	3.97	4.4
		TPMT16T308-PSS	●	●	▲	▲	●	●	●	●		●		●		●				0.8	9.525	3.97	4.4
Schlichten bis mittlere Bearbeitung	**PS**	**TPMT090202-PS**	●	●	▲	▲	●	●	●	●		●	●	●	●	●				0.2	5.56	2.38	2.5
		TPMT090204-PS	●	●	▲	▲	●	●	●	●		●	●	●	●	●				0.4	5.56	2.38	2.5
		TPMT090208-PS	●	●	▲	▲	●	●	●	●		●	●	●	●	●				0.8	5.56	2.38	2.5
		TPMT110202-PS	●	●	▲	▲	●	●	●	●		●	●	●	●	●				0.2	6.35	2.38	2.8
		TPMT110204-PS	●	●	▲	▲	●	●	●	●	●	●	●	●	●	●				0.4	6.35	2.38	2.8
		TPMT110208-PS	●	●	▲	▲	●	●	●	●	●	●	●	●	●	●				0.8	6.35	2.38	2.8
		TPMT110304-PS	●	●	▲	▲	●	●	●	●		●	●	●	●	●				0.4	6.35	3.18	3.4
		TPMT110308-PS	●	●	▲	▲	●	●	●	●		●	●	●	●	●				0.8	6.35	3.18	3.4
		TPMT130302-PS	●	●	▲	▲						●		●	●	●				0.2	7.94	3.18	3.4
		TPMT130304-PS	●	●	▲	▲	●	●	●	●		●		●	●	●				0.4	7.94	3.18	3.4
		TPMT130308-PS	●	●	▲	▲	●	●	●	●		●		●	●	●				0.8	7.94	3.18	3.4
		TPMT16T304-PS	●	●	▲	▲	●	●	●	●		●		●	●	●				0.4	9.525	3.97	4.4
		TPMT16T308-PS	●	●	▲	▲	●	●	●	●		●		●	●	●				0.8	9.525	3.97	4.4
	TSF	**TPMT110204-TSF**	●	●																0.4	6.35	2.38	2.8
		TPMT110208-TSF	●	●																0.8	6.35	2.38	2.8
		TPMT110304-TSF	●	●																0.4	6.35	3.18	2.8
		TPMT110308-TSF	●	●																0.8	6.35	3.18	2.8
		TPMT16T304-TSF	●	●																0.4	9.525	3.97	4.4
		TPMT16T308-TSF	●	●																0.8	9.525	3.97	4.4

● Lagerstandard
▲ Wird eingestellt

Spankontrollbereich





Montagelochspezifikation	→ B147		
Halter / Innendrehen	→ D043 -	Kassetten	→ K193 -
Bohrstangen	→ K209 -	Top-Borer Tools	→ K213

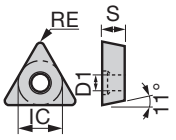
Wendeschneidplatten POSITIV

● : Kontinuierlicher Schnitt
ɔ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

TP

Dreieckig, 60°
mit Loch
Positiv 11°

		T9215	T9225	T9125	GH110	SH725	SH730	GT9530	NS9530	TH10	UX30
P	Stahl	ɔ✣	●ɔ	ɔ✣	●	●ɔ	●ɔ	●ɔ	●ɔ	●	ɔ
M	Rostfreier Stahl		●ɔ		●	●ɔ	●ɔ			●	ɔ
K	Eisenguss		●ɔ		●			●ɔ	●ɔ	●	
N	Nichteisenmetalle									●	
S	Hitzebest. Legierungen				●		●ɔ				
H	Gehärteter Stahl										



Anwendung	Spanformstufe	Katalog Nr.	T9215	T9225	T9125	GH110	SH725	SH730	GT9530	NS9530	TH10	UX30	RE	IC	S	D1
			Beschichtet						Cermet besch.	Cermet	Unbeschichtet		Größe (mm)			
Schlichten bis mittlere Bearbeitung	TM	TPMT110204-TM	●	●									0.4	6.35	2.38	2.8
		TPMT110208-TM	●	●									0.8	6.35	2.38	2.8
		TPMT110304-TM	●	●									0.4	6.35	3.18	3.4
		TPMT110308-TM	●	●									0.8	6.35	3.18	3.4
		TPMT16T304-TM	●	●									0.4	9.525	3.97	4.4
		TPMT16T308-TM	●	●									0.8	9.525	3.97	4.4
	23	TPMT090202-23								●			0.2	5.56	2.38	2.5
		TPMT090204-23		●	▲					●			0.4	5.56	2.38	2.5
		TPMT110204-23		●	▲					●			0.4	6.35	2.38	2.8
		TPMT130304-23		●	▲					●			0.4	7.94	3.18	3.4
		TPMT130308-23		●	▲					●			0.8	7.94	3.18	3.4
		TPMT16T304-23								●			0.4	9.525	3.97	4.4
		TPMT16T308-23		●	▲					●			0.8	9.525	3.97	4.4
Mittlere Bearbeitung	24	TPMT090204-24		●	▲					●			0.4	5.56	2.38	2.5
		TPMT110204-24		●	▲					●			0.4	6.35	2.38	2.8
		TPMT110208-24								●			0.8	6.35	2.38	2.8
		TPMT130304-24		●	▲					●			0.4	7.94	3.18	3.4
		TPMT130308-24		●	▲					●			0.8	7.94	3.18	3.4
		TPMT16T304-24		●	▲					●			0.4	9.525	3.97	4.4
		TPMT16T308-24		●	▲					●			0.8	9.525	3.97	4.4
Schlichten	W08	TPGT070100R-W08						●				●	0.03	4.37	1.59	2.58
		TPGT070100L-W08						●				●	0.03	4.37	1.59	2.58
		TPGT070101R-W08						●				●	0.1	4.37	1.59	2.58
		TPGT070101L-W08						●				●	0.1	4.37	1.59	2.58
		TPGT070102R-W08						●				●	0.2	4.37	1.59	2.58
		TPGT070102L-W08						●				●	0.2	4.37	1.59	2.58
		TPGT070104R-W08						●				●	0.4	4.37	1.59	2.58
		TPGT070104L-W08						●				●	0.4	4.37	1.59	2.58
		TPGT080200L-W08							●	●			0.03	4.76	2.38	2.3
		TPGT080202L-W08				●			●	●		● ●	0.2	4.76	2.38	2.3
		TPGT080204L-W08				●			●	●		● ●	0.4	4.76	2.38	2.3
Schlichten (scharfkantig)	W08	TPGT070100FL-W08					●						0.03	4.37	1.59	2.58
		TPGT070100FR-W08					●						0.03	4.37	1.59	2.58
		TPGT070101FL-W08					●						0.1	4.37	1.59	2.58
		TPGT070101FR-W08					●						0.1	4.37	1.59	2.58
		TPGT070102FL-W08					●						0.2	4.37	1.59	2.58
		TPGT070102FR-W08					●						0.2	4.37	1.59	2.58
		TPGT070104FL-W08					●						0.4	4.37	1.59	2.58
		TPGT070104FR-W08					●						0.4	4.37	1.59	2.58

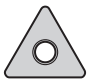
● Lagerstandard
▲ Wird eingestellt

Montagelochspezifikation → B147
Halter / Innendrehen → D043 -
Top-Borer Tools → K213
Kassetten → K193 -

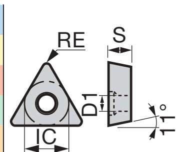
Wendeschneidplatten POSITIV

● : Kontinuierlicher Schnitt
◐ : Leicht unterbrochener Schnitt
✠ : Stark unterbrochener Schnitt

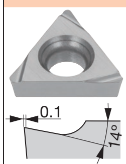
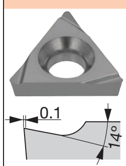
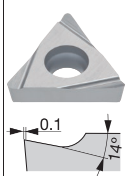
TP



Dreieckig, 60° mit Loch Positiv 11°



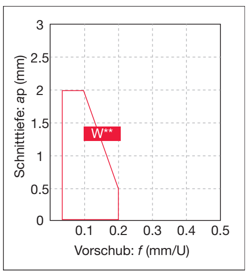
		GH110	GH330	GT9530	NS9530	TH10	UX30
P	Stahl	●	●◐	●◐	●◐	●	◐
M	Rostfreier Stahl	●	●◐			●	◐
K	Eisenguss	●	●◐	●◐	●◐	●	
N	Nichteisen-metalle					●	
S	Hitzebest. Legierungen	●					
H	Gehärteter Stahl						

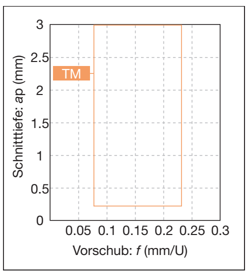
Anwendung	Spanform-stufe	Katalog Nr.	GH110 (Beschichtet)	GH330 (Beschichtet)	GT9530 (Cermet besch.)	NS9530 (Cermet)	TH10 (Unbeschichtet)	UX30 (Unbeschichtet)	RE	IC	S	D1
Schlichten	W10 	TPGH080202L-W10			●	●			0.2	4.76	2.38	2.3
		TPGH080204L-W10			●	●			0.4	4.76	2.38	2.3
		TPGH090204L-W10			●	●			0.4	5.56	2.38	3
	W13 	TPGH110204L-W13			●	●			0.4	6.35	2.38	3.4
		TPGH110302L-W13			●	●			0.2	6.35	3.18	3.4
		TPGH110304L-W13			●	●			0.4	6.35	3.18	3.4
	W15 	TPGT090202R-W15				●			0.2	5.56	2.38	2.5
		TPGT090202L-W15			●	●	●		0.2	5.56	2.38	2.5
		TPGT090204R-W15				●			0.4	5.56	2.38	2.5
		TPGT090204L-W15	●	●	●	●	●	●	0.4	5.56	2.38	2.5
		TPGT110202R-W15				●			0.2	6.35	2.38	2.8
		TPGT110202L-W15			●	●	●		0.2	6.35	2.38	2.8
		TPGT110204L-W15	●	●	●	●	●	●	0.4	6.35	2.38	2.8
		TPGT110208R-W15				●			0.8	6.35	2.38	2.8
		TPGT110208L-W15						●	0.8	6.35	2.38	2.8
		TPGT110302L-W15				●			0.2	6.35	3.18	3.4
		TPGT110304R-W15				●			0.4	6.35	3.18	3.4
		TPGT110304L-W15				●			0.4	6.35	3.18	3.4
		TPGT110308L-W15				●			0.8	6.35	3.18	3.4
		TPGT130302R-W15				●			0.2	7.94	3.18	3.4
		TPGT130302L-W15			●	●	●		0.2	7.94	3.18	3.4
		TPGT130304R-W15	●			●			0.4	7.94	3.18	3.4
		TPGT130304L-W15	●	●	●	●	●	●	0.4	7.94	3.18	3.4
		TPGT130308L-W15				●	●		0.8	7.94	3.18	3.4
		TPGT16T302R-W15				●			0.2	9.525	3.97	4.4
		TPGT16T302L-W15			●	●	●		0.2	9.525	3.97	4.4
		TPGT16T304R-W15				●	●		0.4	9.525	3.97	4.4
		TPGT16T304L-W15	●	●	●	●	●	●	0.4	9.525	3.97	4.4
		TPGT16T308L-W15				●	●	●	0.8	9.525	3.97	4.4

Größe (mm)

● Lagerstandard

Spankontrollbereich





Montagelochspezifikation → B147
Halter / Innendrehen → D043 -
Kassetten → K193 -
Top-Borer Tools → K213

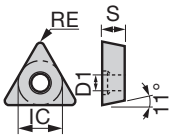
Wendeschneidplatten POSITIV

● : Kontinuierlicher Schnitt
ɔ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

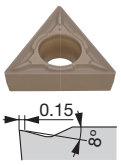
TP

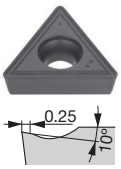
Dreieckig, 60°
mit Loch
Positiv 11°

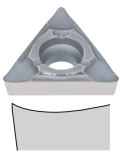
		T9215	T9225	T9115	T9125	T6120	T6130	AH630	AH645	T515	T5115	AH120	AH725	GH330	GH730	GT9530	NS9530
P	Stahl	●ɔ	ɔ✣	●ɔ	ɔ✣	ɔ	✣	ɔ✣	✣			●ɔ	ɔ	●ɔ	ɔ	●ɔ	●ɔ
M	Rostfreier Stahl	●ɔ				●	ɔ	ɔ	✣			●ɔ	ɔ	●ɔ	ɔ		
K	Eisenguss	●ɔ		●ɔ						●ɔ	ɔ	●ɔ	ɔ	●ɔ	ɔ	●ɔ	●ɔ
N	Nichteisenmetalle																
S	Hitzebest. Legierungen											●ɔ	●				
H	Gehärteter Stahl																

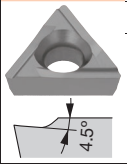


Anwendung	Spanformstufe	Katalog Nr.	RE	IC	S	D1
Mittlere Bearbeitung	PM	TPMT090204-PM	0.4	5.56	2.38	2.5
		TPMT090208-PM	0.8	5.56	2.38	2.5
		TPMT110204-PM	0.4	6.35	2.38	2.8
		TPMT110208-PM	0.8	6.35	2.38	2.8
		TPMT110304-PM	0.4	6.35	3.18	3.4
		TPMT110308-PM	0.8	6.35	3.18	3.4
		TPMT130304-PM	0.4	7.94	3.18	3.4
		TPMT130308-PM	0.8	7.94	3.18	3.4
		TPMT16T304-PM	0.4	9.525	3.97	4.4
		TPMT16T308-PM	0.8	9.525	3.97	4.4
		TPMT16T312-PM	1.2	9.525	3.97	4.4
Schlichten bis mittlere Bearbeitung	CM	TPMT090204-CM	0.4	5.56	2.38	2.5
		TPMT090208-CM	0.8	5.56	2.38	2.5
		TPMT110204-CM	0.4	6.35	2.38	2.8
		TPMT110208-CM	0.8	6.35	2.38	2.8
		TPMT110304-CM	0.4	6.35	3.18	3.4
		TPMT110308-CM	0.8	6.35	3.18	3.4
		TPMT130304-CM	0.4	7.94	3.18	3.4
		TPMT130308-CM	0.8	7.94	3.18	3.4
		TPMT16T304-CM	0.4	9.525	3.97	4.4
		TPMT16T308-CM	0.8	9.525	3.97	4.4
		TPMT16T312-CM	1.2	9.525	3.97	4.4
	SS	TPGT110202-SS	0.2	6.35	2.38	2.8
		TPGT110204-SS	0.4	6.35	2.38	2.8
		TPGT130302-SS	0.2	7.94	3.18	3.4
		TPGT130304-SS	0.4	7.94	3.18	3.4
		TPGT16T304-SS	0.4	9.525	3.97	4.4
	H11	TPGH110302L-H11	0.2	6.35	3.18	3.4
		TPGH110304L-H11	0.4	6.35	3.18	3.4









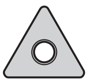
● Lagerstandard
▲ Wird eingestellt

Montagelochspezifikation	→ B147		
Halter / Innendrehen	→ D043 -	Kassetten	→ K193 -
Bohrstangen	→ K209 -	Top-Borer Tools	→ K213

Wendeschneidplatten POSITIV

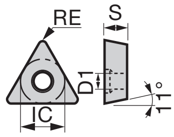
● : Kontinuierlicher Schnitt
◐ : Leicht unterbrochener Schnitt
✠ : Stark unterbrochener Schnitt

TP

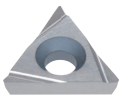


Dreieckig, 60°
mit Loch
Positiv 11°

		T5115	NS9530	TH10	UX30
P	Stahl		●◐	●	◐
M	Rostfreier Stahl			●	◐
K	Eisenguss	◐	●◐	●	
N	Nichteisen-metalle			●	
S	Hitzebest. Legierungen				
H	Gehärteter Stahl				

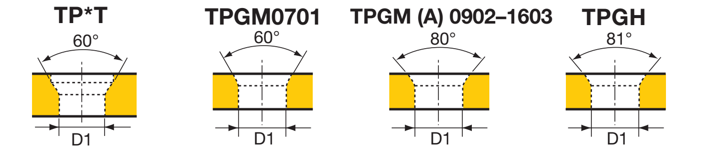


Anwendung	Spanform-stufe	Katalog Nr.	Beschichtet T5115	Cermet NS9530	Unbeschichtet TH10	Unbeschichtet UX30	RE	IC	S	D1
Schlichten bis mittlere Bearbeitung	-	TPGM070102R		●			0.2	4.37	1.59	2.7
		TPGM070102L		●	●		0.2	4.37	1.59	2.7
		TPGM070104R		●			0.4	4.37	1.59	2.7
		TPGM070104L		●	●		0.4	4.37	1.59	2.7
		TPGM090202R		●			0.2	5.56	2.38	3.2
		TPGM090202L		●			0.2	5.56	2.38	3.2
		TPGM090204L		●			0.4	5.56	2.38	3.2
	(Tungaloy Standard-Loch) Nicht ISO-konform	TPGM110202R		●			0.2	6.35	2.38	3
		TPGM110202L		●		●	0.2	6.35	2.38	3
		TPGM110204R		●			0.4	6.35	2.38	3
		TPGM110204L		●		●	0.4	6.35	2.38	3
		TPGM110302R		●			0.2	6.35	3.18	3
	TPGM...R/L	TPGM110302L		●			0.2	6.35	3.18	3
		TPGM110302L-2			●		0.2	6.35	3.18	3
		TPGM110304R		●			0.4	6.35	3.18	3
		TPGM110304L		●		●	0.4	6.35	3.18	3
		TPGM110304L-2			●		0.4	6.35	3.18	3
		TPGM160302L		●			0.2	9.525	3.18	4
		TPGM160304R		●			0.4	9.525	3.18	4
		TPGM160304L		●		●	0.4	9.525	3.18	4
		TPGM160304L-2			●		0.4	9.525	3.18	4
	-	TPMW110204	●				0.4	6.35	2.38	2.8
		TPMW110208	●				0.8	6.35	2.38	2.8
		TPMW130304	●				0.4	7.94	3.18	3.4
		TPMW130308	●				0.8	7.94	3.18	3.4
		TPMW16T304	●				0.4	9.525	3.97	4.4
		TPMW16T308	●				0.8	9.525	3.97	4.4



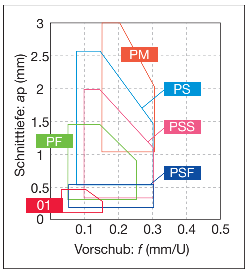
● Lagerstandard

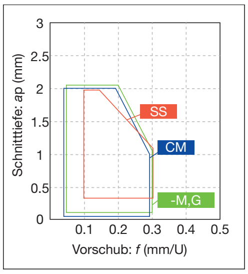
Montageloch-spezifikation



D1 (mm)	0701**	0802**	0902**	1102**	1103**	1303**	1603**	16T3**
TP*T(W)	-	2.3	2.5	2.8	3.4	3.4	-	4.4
TPGM(A)	2.7	-	3.2	3.0	3.0	-	4.0	-
TPGH	-	2.3	3.0	3.4	3.4	-	4.5	-

Spankontrollbereich





*-M,G: Ohne Spanformstufe

Halter / Innendrehen → D043 -
Bohrstangen → K209 -
Kassetten → K193 -

A Schneidstoffe
B Wende-schneidplatten
C Halter / Außendrehen
D Halter / Innendrehen
E Gewinde-werkzeuge
F Stech-werkzeuge
G Miniatur-bearbeitung
H Fräser
I Schaftfräser
J Bohrer
K Werkzeug-aufnahmen
L Benutzer-handbuch
M Index

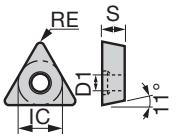
Wendeschneidplatten POSITIV

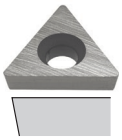
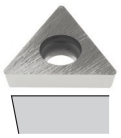
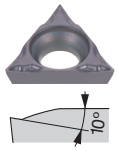
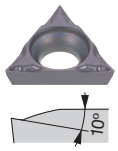
● : Kontinuierlicher Schnitt
ᑕ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

TP

Dreieckig, 60°
mit Loch
Positiv 11°

		GH110	SH725	SH730	NS9530	TH10
P	Stahl	●	●ᑕ	●ᑕ	●ᑕ	●
M	Rostfreier Stahl	●	●ᑕ	●ᑕ		●
K	Eisenguss	●			●ᑕ	●
N	Nichteisen-metalle					●
S	Hitzebest. Legierungen	●		●ᑕ		
H	Gehärteter Stahl					



Anwendung	Spanform-stufe	Katalog Nr.	GH110	SH725	SH730	NS9530	TH10	RE	IC	S	D1
Schlichten bis mittlere Bearbeitung	-	**TPGA090204**					●	0.4	5.56	2.38	3.2
	(Ehemals Tungaloy Standard-Loch) Nicht ISO-konform	**TPGA110202**				●	●	0.2	6.35	2.38	3
		TPGA1102**04**					●	0.4	6.35	2.38	3
		**TPGA110302**				●	●	0.2	6.35	3.18	3
		TPGA1103**04**					●	0.4	6.35	3.18	3
		TPGA160304				●	●	0.4	9.525	3.18	4
		TPGA1603**08**					●	0.8	9.525	3.18	4
	-	**TPGW090202**					●	0.2	5.56	2.38	2.5
		TPGW0902**04**					●	0.4	5.56	2.38	2.5
		TPGW110202					●	0.2	6.35	2.38	2.8
		TPGW1102**04**	●				●	0.4	6.35	2.38	2.8
		TPGW110304					●	0.4	6.35	3.18	3.4
		TPGW130304					●	0.4	7.94	3.18	3.4
		TPGW16T304	●				●	0.4	9.525	3.97	4.4
		TPGW16T3**08**					●	0.8	9.525	3.97	4.4
Innendrehen auf Langdrehautomaten	**JS**	**TPGT070101-JS**			●			<0.1	4.37	1.59	2.58
		TPGT07010**2-JS**			●			<0.2	4.37	1.59	2.58
		TPGT07010**4-JS**			●			<0.4	4.37	1.59	2.58
Innendrehen auf Langdreh-automaten (scharfkantig)	**JS**	**TPGT070101F-JS**		●				<0.1	4.37	1.59	2.58
		TPGT07010**2F-JS**		●				<0.2	4.37	1.59	2.58
		TPGT07010**4F-JS**		●				<0.4	4.37	1.59	2.58

*Eckenradius (RE) mit einem Kleiner-als-Zeichen (<) bedeutet eine Minustoleranz.

● Lagerstandard

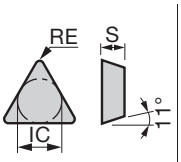
Halter / Innendrehen → D043 -
Bohrstangen → K209 -
Kassetten → K193 -

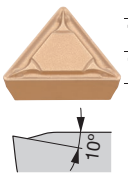
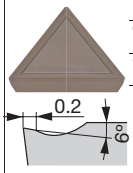
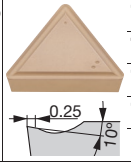
● : Kontinuierlicher Schnitt
c : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

TP

Dreieckig, 60°
ohne Loch
Positiv 11°

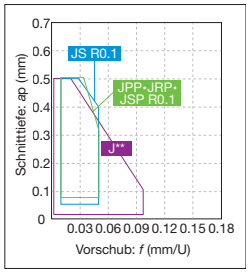
P	Stahl	●c ●c✣ ●c ●c✣ c ●c ●c
M	Rostfreier Stahl	●c c ●c
K	Eisenguss	●c ●c c c ●c ●c
N	Nichteisen-metalle	●
S	Hitzebest. Legierungen	●
H	Gehärteter Stahl	



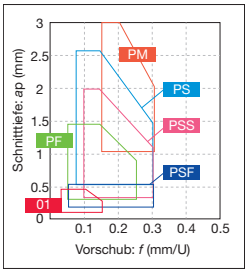
Anwendung	Spanform-stufe	Katalog Nr.	Beschichtet T9215	T9225	T9115	T9125	T5115	AH725	Cermet NS9530	Unbeschichtet TH10	Größe (mm) RE	IC	S	D1
Schlichten bis mittlere Bearbeitung	PS	TPMR110304-PS		●		▲					0.4	6.35	3.18	-
		TPMR110308-PS		●		▲					0.8	6.35	3.18	-
		TPMR160304-PS		●		▲					0.4	9.525	3.18	-
		TPMR160308-PS		●		▲					0.8	9.525	3.18	-
	23	TPMR110304-23	●	●	▲	▲			●		0.4	6.35	3.18	-
		TPMR110308-23		●		▲			●	●	0.8	6.35	3.18	-
		TPMR160304-23	●	●	▲	▲			●	●	0.4	9.525	3.18	-
		TPMR160308-23		●		▲			●		0.8	9.525	3.18	-
Mittlere Bearbeitung	24	TPMR110304-24		●		▲			●		0.4	6.35	3.18	-
		TPMR110308-24		●		▲			●		0.8	6.35	3.18	-
		TPMR160304-24	●	●	▲	▲		●	●		0.4	9.525	3.18	-
		TPMR160308-24	●	●	▲	▲			●		0.8	9.525	3.18	-
Schlichten bis mittl. Bearbeitung	CM	TPMR110304-CM					●				0.4	6.35	3.18	-
		TPMR110308-CM					●				0.8	6.35	3.18	-
		TPMR160304-CM					●				0.4	9.525	3.18	-
		TPMR160308-CM					●				0.8	9.525	3.18	-
		TPMR160312-CM					●				1.2	9.525	3.18	-

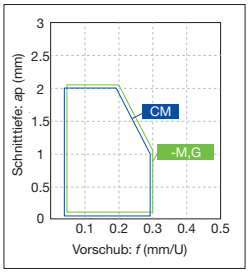
● Lagerstandard
▲ Wird eingestellt

Spankontrollbereich



*Spankontrolle mit R0.1





*-M,G: Ohne Spanformstufe

Halter / Innendrehen → D044 - Kassetten → K193 -

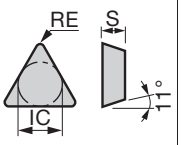
Wendeschneidplatten POSITIV

● : Kontinuierlicher Schnitt
ᑕ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

TP

Dreieckig, 60°
ohne Loch
Positiv 11°

		T5115	GH110	AH120	NS9530	TH10	UX30	LX21	LX11
P	Stahl		●	●ᑕ	●ᑕ	●	ᑕ		
M	Rostfreier Stahl		●	●ᑕ		●	ᑕ		
K	Eisenguss	ᑕ	●	●ᑕ	●ᑕ	●		●	
N	Nichteisenmetalle					●			
S	Hitzebest. Legierungen		●	●ᑕ					
H	Gehärteter Stahl								●



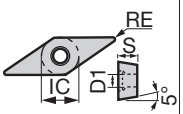
Anwendung	Spanformstufe	Katalog Nr.	T5115	GH110	AH120	NS9530	TH10	UX30	LX21	LX11	RE	IC	S	D1
Schlichten bis mittlere Bearbeitung	-	**TPGR110302L**				●					0.2	6.35	3.18	-
		TPGR1103**04L**				●					0.4	6.35	3.18	-
		TPGR160304R				●					0.4	9.525	3.18	-
		TPGR1603**04L**				●					0.4	9.525	3.18	-
		TPGR1603**08L**				●					0.8	9.525	3.18	-
	-	**TPMN110304**	●				●				0.4	6.35	3.18	-
		TPMN1103**08**	●								0.8	6.35	3.18	-
		TPMN160304	●		●		●	●			0.4	9.525	3.18	-
		TPMN1603**08**	●		●		●	●			0.8	9.525	3.18	-
		TPMN1603**12**	●								1.2	9.525	3.18	-
		TPMN220408						●			0.8	12.7	4.76	-
		TPMN2204**12**						●			1.2	12.7	4.76	-
	-	**TPGN110302**					●				0.2	6.35	3.18	-
		TPGN1103**04**		●			●		●	●	0.4	6.35	3.18	-
		TPGN1103**08**					●			●	0.8	6.35	3.18	-
		TPGN160302					●				0.2	9.525	3.18	-
		TPGN1603**04**		●		●	●			●	0.4	9.525	3.18	-
		TPGN1603**08**		●		●	●			●	0.8	9.525	3.18	-
		TPGN1603**12**								●	1.2	9.525	3.18	-
		TPGN220404					●				0.4	12.7	4.76	-

● Lagerstandard

VB

Rhombisch, 35°
mit Loch
Positiv 5°

		T9215	T9225	T9115	T9125	AH725	GT9530	NS9530
P	Stahl	●ᑕ	ᑕ✣	●ᑕ	ᑕ✣	ᑕ	●ᑕ	●ᑕ
M	Rostfreier Stahl	●ᑕ				ᑕ		
K	Eisenguss	●ᑕ		●ᑕ		ᑕ	●ᑕ	●ᑕ
N	Nichteisenmetalle							
S	Hitzebest. Legierungen					●		
H	Gehärteter Stahl							



Anwendung	Spanformstufe	Katalog Nr.	T9215	T9225	T9115	T9125	AH725	GT9530	NS9530	RE	IC	S	D1
Schlichten	PSF	**VBMT110302-PSF**					●	●	●	0.2	6.35	3.18	2.8
		VBMT1103**04-PSF**	●	●	▲	▲	●	●	●	0.4	6.35	3.18	2.8
		VBMT160402-PSF					●	●	●	0.2	9.525	4.76	4.4
		VBMT1604**04-PSF**	●	●	▲	▲	●	●	●	0.4	9.525	4.76	4.4

● Lagerstandard
▲ Wird eingestellt

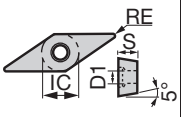
VBMT...: Halter / Außendrehen → C062
Halter / Innendrehen → D044 -
Kassetten → K193 -

● : Kontinuierlicher Schnitt
ɔ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

VB

Rhombisch, 35°
mit Loch
Positiv 5°

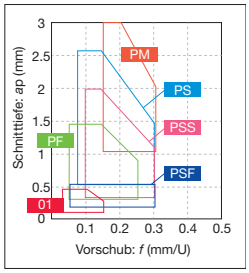
P	Stahl	●ɔ	ɔ✣	●ɔ	ɔ✣	ɔ	✣	ɔ✣	✣			●ɔ	ɔ				●ɔ	●ɔ			●ɔ								
M	Rostfreier Stahl	●ɔ				●	ɔ	ɔ	✣			●ɔ	ɔ	●	ɔ														
K	Eisenguss	●ɔ		●ɔ						●ɔ	ɔ	●ɔ	ɔ				●ɔ	●ɔ			●ɔ								
N	Nichteisen-metalle																												
S	Hitzebest. Legierungen											●ɔ	●	●	ɔ														
H	Gehärteter Stahl																												

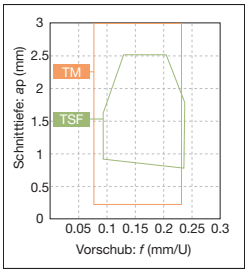


Anwendung	Spanform-stufe	Katalog Nr.	Beschichtet													Cermet besch.		Cermet			Größe (mm)			
			T9215	T9225	T9115	T9125	T6120	T6130	AH630	AH645	T515	T5115	AH120	AH725	AH8005	AH8015	GT9530	AT9530		NS9530			RE	IC	S	D1
Schlichten	**PF**	**VBMT110302-PF**															●			●			0.2	6.35	3.18	2.8
		VBMT110304-PF															●			●			0.4	6.35	3.18	2.8
		VBMT110308-PF															●			●			0.8	6.35	3.18	2.8
		VBMT160404-PF															●			●			0.4	9.525	4.76	4.4
		VBMT160408-PF		●		▲											●			●			0.8	9.525	4.76	4.4
Schlichten bis leichte Bearbeitung	**PSS**	**VBMT110304-PSS**	●	●	▲	▲	●	●	●	●				●			●			●			0.4	6.35	3.18	2.8
		VBMT110308-PSS	●	●	▲	▲	●	●	●	●				●			●			●			0.8	6.35	3.18	2.8
		VBMT160404-PSS	●	●	▲	▲	●	●	●	●				●			●			●			0.4	9.525	4.76	4.4
		VBMT160408-PSS	●	●	▲	▲	●	●	●	●				●			●			●			0.8	9.525	4.76	4.4
		VBMT160412-PSS	●	●	▲	▲								●									1.2	9.525	4.76	4.4
Schlichten bis mittlere Bearbeitung	**PS**	**VBMT110302-PS**	●	●	▲	▲	●	●	●	●				●	●	●	●	●		●			0.2	6.35	3.18	2.8
		VBMT110304-PS	●	●	▲	▲	●	●	●	●			●	●	●	●	●	●		●			0.4	6.35	3.18	2.8
		VBMT110308-PS	●	●	▲	▲	●	●	●	●			●	●	●	●	●	●		●			0.8	6.35	3.18	2.8
		VBMT160402-PS	●	●	▲	▲	●	●	●	●				●	●	●	●	●		●			0.2	9.525	4.76	4.4
		VBMT160404-PS	●	●	▲	▲	●	●	●	●			●	●	●	●	●	●		●			0.4	9.525	4.76	4.4
		VBMT160408-PS	●	●	▲	▲	●	●	●	●			●	●	●	●	●	●		●			0.8	9.525	4.76	4.4
	TSF	**VBMT110302-TSF**	●	●																			0.2	6.35	3.18	2.8
		VBMT110304-TSF	●	●																			0.4	6.35	3.18	2.8
		VBMT110308-TSF	●	●																			0.8	6.35	3.18	2.8
		VBMT160404-TSF	●	●																			0.4	9.525	4.76	4.4
		VBMT160408-TSF	●	●																			0.8	9.525	4.76	4.4
	TM	**VBMT110302-TM**	●	●																			0.2	6.35	3.18	2.8
		VBMT110304-TM	●	●																			0.4	6.35	3.18	2.8
		VBMT110308-TM	●	●																			0.8	6.35	3.18	2.8
		VBMT160404-TM	●	●																			0.4	9.525	4.76	4.4
		VBMT160408-TM	●	●																			0.8	9.525	4.76	4.4

● Lagerstandard
▲ Wird eingestellt

Spankontrollbereich



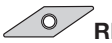


Halter / Außendrehen → C062
J-Serie Werkzeughalter → G033 -
Halter / Innendrehen → D036 -

Wendeschneidplatten POSITIV

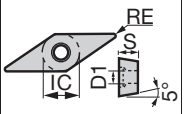
● : Kontinuierlicher Schnitt
ᑕ : Leicht unterbrochener Schnitt
✠ : Stark unterbrochener Schnitt

VB



Rhombisch, 35°
mit Loch
Positiv 5°

		T9215	T9225	T9115	T9125	T515	T5115	AH725	SH725	SH730	J740	J9530	NS9530	TH10
P	Stahl	●ᑕ	ᑕ✠	●ᑕ	ᑕ✠			ᑕ	●ᑕ	●ᑕ	●ᑕ			
M	Rostfreier Stahl	●ᑕ						ᑕ	●ᑕ	●ᑕ	●ᑕ			
K	Eisenguss	●ᑕ		●ᑕ		●ᑕ	ᑕ	ᑕ				●ᑕ	●ᑕ	
N	Nichteisenmetalle													
S	Hitzebest. Legierungen							●		●ᑕ				
H	Gehärteter Stahl													



Anwendung	Spanformstufe	Katalog Nr.	Beschichtet										Cermet besch.	Cermet	Unbeschichtet	Größe (mm)			
			T9215	T9225	T9115	T9125	T515	T5115	AH725	SH725	SH730	J740	J9530	NS9530	TH10	RE	IC	S	D1
Mittlere Bearbeitung	24	VBMT160404-24	●	●	▲	▲								●		0.4	9.525	4.76	4.4
		VBMT160408-24	●	●	▲	▲								●		0.8	9.525	4.76	4.4
Schlichten bis mittl. Bearbeitung	CM	VBMT110304-CM						●								0.4	6.35	3.18	2.8
		VBMT110308-CM						●								0.8	6.35	3.18	2.8
		VBMT160404-CM					●	●								0.4	9.525	4.76	4.4
		VBMT160408-CM					●	●								0.8	9.525	4.76	4.4
		VBMT160412-CM					●	●								1.2	9.525	4.76	4.4
Außendrehen auf Langdrehautomaten (scharfkantig)	JS	VBGT110300FN-JS								●	●					0.03	6.35	3.18	2.8
		VBGT110301FN-JS								●	●					<0.1	6.35	3.18	2.8
		VBGT110302FN-JS								●	●					<0.2	6.35	3.18	2.8
		VBGT110304FN-JS								●	●					<0.4	6.35	3.18	2.8
Außendrehen auf Langdrehautomaten	JS	VBGT110301N-JS							●							0.1	6.35	3.18	2.8
		VBGT110302N-JS							●							0.2	6.35	3.18	2.8
		VBGT110304N-JS							●							0.4	6.35	3.18	2.8
Außendrehen auf Langdrehautomaten (scharfkantig)	J10	VBGT110300FR-J10								●		●			●	0.03	6.35	3.18	2.8
		VBGT110300FL-J10								●		●			●	0.03	6.35	3.18	2.8
		VBGT110301FR-J10								●		●		●	●	0.1	6.35	3.18	2.8
		VBGT110301FL-J10								●		●		●	●	0.1	6.35	3.18	2.8
		VBGT110302FR-J10								●		●		●	●	0.2	6.35	3.18	2.8
		VBGT110302FL-J10								●		●		●	●	0.2	6.35	3.18	2.8
		VBGT110304FR-J10								●		●		●	●	0.4	6.35	3.18	2.8
		VBGT110304FL-J10								●		●		●	●	0.4	6.35	3.18	2.8
Außendrehen auf Langdrehautomaten (geschliffen)	J10	VBGT110302R-J10											●			0.2	6.35	3.18	2.8
		VBGT110302L-J10											●			0.2	6.35	3.18	2.8
		VBGT110304R-J10											●			0.4	6.35	3.18	2.8
		VBGT110304L-J10											●			0.4	6.35	3.18	2.8

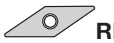
*Eckenradius (RE) mit einem Kleiner-als-Zeichen (<) bedeutet eine Minustoleranz.

● Lagerstandard
▲ Wird eingestellt

Halter / Außendrehen → C062
J-Serie Werkzeughalter → G033 -
Halter / Innendrehen → D036 -

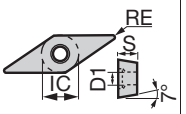
● : Kontinuierlicher Schnitt
ⓒ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

VC



Rhombisch, 35°
mit Loch
Positiv 7°

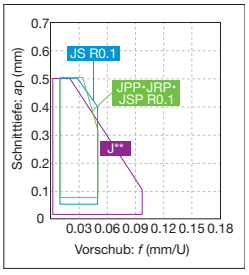
P	Stahl	●ⓒ ⓒ✣ ●ⓒ ⓒ✣ ⓒ ✣ ⓒ✣ ✣ ●ⓒ ⓒ ●ⓒ ●ⓒ ●ⓒ
M	Rostfreier Stahl	●ⓒ ● ⓒ ⓒ ✣ ●ⓒ ⓒ ● ⓒ
K	Eisenguss	●ⓒ ●ⓒ ●ⓒ ⓒ ●ⓒ ●ⓒ ●ⓒ
N	Nichteisen-metalle	
S	Hitzebest. Legierungen	●ⓒ ● ● ⓒ ⓒ
H	Gehärteter Stahl	



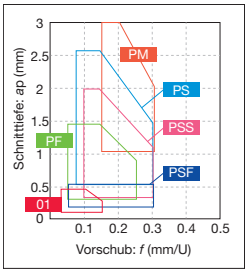
Anwendung	Spanform-stufe	Katalog Nr.	Beschichtet T9215	T9225	T9115	T9125	T6120	T6130	AH630	AH645	AH120	AH725	AH8005	AH8015	AH905	Cermet besch. GT9530	AT9530	Cermet NS9530	RE	IC	S	D1
Schlichten	PSF	VCMT080202-PSF										●				●		●	0.2	4.76	2.38	2.3
		VCMT080204-PSF	●	●	▲	▲						●				●		●	0.4	4.76	2.38	2.3
		VCMT110302-PSF										●							0.2	6.35	3.18	2.8
		VCMT110304-PSF	●	●	▲	▲						●							0.4	6.35	3.18	2.8
		VCMT160404-PSF	●	●	▲	▲						●	●	●	●	●		●	0.4	9.525	4.76	4.4
		VCMT160408-PSF	●	●	▲	▲						●	●	●	●	●		●	0.8	9.525	4.76	4.4
	PF	VCMT080202-PF														●		●	0.2	4.76	2.38	2.3
		VCMT080204-PF														●		●	0.4	4.76	2.38	2.3
		VCMT160404-PF														●		●	0.4	9.525	4.76	4.4
		VCMT160408-PF														●		●	0.8	9.525	4.76	4.4
Schlichten bis leichte Bearbeitung	PSS	VCMT110304-PSS	●	●	▲	▲	●	●	●	●		●				●		●	0.4	6.35	3.18	2.8
		VCMT110308-PSS	●	●	▲	▲	●	●	●	●		●				●		●	0.8	6.35	3.18	2.8
		VCMT160404-PSS	●	●	▲	▲	●	●	●	●		●	●	●	●	●		●	0.4	9.525	4.76	4.4
		VCMT160408-PSS	●	●	▲	▲	●	●	●	●		●	●	●	●	●		●	0.8	9.525	4.76	4.4
Schlichten bis mittlere Bearbeitung	PS	VCMT110302-PS	●	●	▲	▲	●	●	●	●		●	●	●		●	●	●	0.2	6.35	3.18	2.8
		VCMT110304-PS	●	●	▲	▲	●	●	●	●		●	●	●		●	●	●	0.4	6.35	3.18	2.8
		VCMT110308-PS	●	●	▲	▲	●	●	●	●		●	●	●		●	●	●	0.8	6.35	3.18	2.8
		VCMT160404-PS	●	●	▲	▲	●	●	●	●	●	●	●	●	●	●	●	●	0.4	9.525	4.76	4.4
		VCMT160408-PS	●	●	▲	▲	●	●	●	●	●	●	●	●	●	●	●	●	0.8	9.525	4.76	4.4
	TSF	VCMT160404-TSF	●	●															0.4	9.525	4.76	4.4
		VCMT160408-TSF	●	●															0.8	9.525	4.76	4.4
	TM	VCMT160404-TM	●	●															0.4	9.525	4.76	4.4
		VCMT160408-TM	●	●															0.8	9.525	4.76	4.4

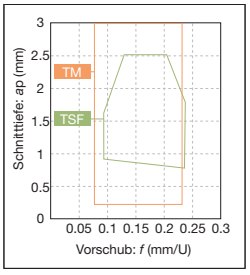
● Lagerstandard
▲ Wird eingestellt

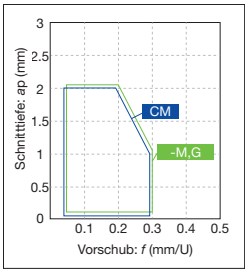
Spankontrollbereich



*Spankontrolle mit R0.1







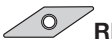
*-M,G: Ohne Spanformstufe

Halter / Außendrehen → C063 -
TungCap → K016 -
Halter / Innendrehen → D037 -

Wendeschneidplatten POSITIV

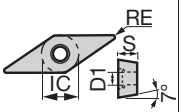
● : Kontinuierlicher Schnitt
ɔ : Leicht unterbrochener Schnitt
✠ : Stark unterbrochener Schnitt

VC



Rhombisch, 35°
mit Loch
Positiv 7°

		T9215	T9225	T9115	T9125	T515	T5115	AH8005	AH8015	AH905	NS9530	KS05F
P	Stahl	●ɔ	ɔ✠	●ɔ	ɔ✠						●ɔ	
M	Rostfreier Stahl	●ɔ						●	ɔ			
K	Eisenguss	●ɔ		●ɔ		●ɔ	ɔ				●ɔ	●
N	Nichteisen-metalle											●
S	Hitzebest. Legierungen							●	ɔ	ɔ		●
H	Gehärteter Stahl											



Anwendung	Spanform-stufe	Katalog Nr.	RE	IC	S	D1
Schlichten bis mittlere Bearbeitung	24	VCMT160404-24	0.4	9.525	4.76	4.4
		VCMT160408-24	0.8	9.525	4.76	4.4
	CM	VCMT080204-CM	0.4	4.76	2.38	2.3
		VCMT160404-CM	0.4	9.525	4.76	4.4
		VCMT160408-CM	0.8	9.525	4.76	4.4
		VCMT160412-CM	1.2	9.525	4.76	4.4
Mittlere Bearbeitung	All-round	VCMT160404	0.4	9.525	4.76	4.4
		VCMT160408	0.8	9.525	4.76	4.4
		VCMT160412	1.2	9.525	4.76	4.4
Schlichten bis mittl. Bearbeitung	AL	VCGT160404-AL	0.4	9.525	4.76	4.4
		VCGT160408-AL	0.8	9.525	4.76	4.4
		VCGT160412-AL	1.2	9.525	4.76	4.4
		VCGT220520-AL	2	12.7	5.56	5.5
		VCGT220530-AL	3	12.7	5.56	5.5

● Lagerstandard
▲ Wird eingestellt

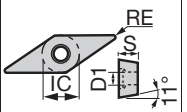
VC*T...: Halter / Außendrehen → C063 - Halter / Innendrehen → D037 -

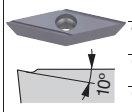
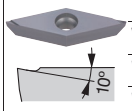
● : Kontinuierlicher Schnitt
◐ : Leicht unterbrochener Schnitt
✠ : Stark unterbrochener Schnitt

VP

Rhombisch, 35°
mit Loch
Positiv 11°

P	Stahl	◐ ◐
M	Rostfreier Stahl	◐ ◐
K	Eisenguss	
N	Nichteisen-metalle	
S	Hitzebest. Legierungen	◐
H	Gehärteter Stahl	

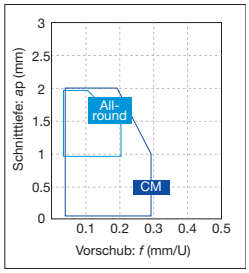


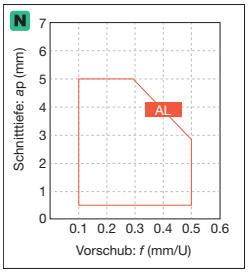
Anwendung	Spanform-stufe	Katalog Nr.	Beschichtet SH725	Beschichtet SH730	Größe (mm) RE	IC	S	D1
Außendrehen auf Langdrehautomaten (scharfkantig)	JPP	VPET0802008MFR-JPP	●	●	<0.08	4.76	2.38	2.3
		VPET0802008MFL-JPP	●	●	<0.08	4.76	2.38	2.3
		VPET080201MFR-JPP	●	●	<0.1	4.76	2.38	2.3
		VPET080201MFL-JPP	●	●	<0.1	4.76	2.38	2.3
		VPET0802018MFR-JPP	●	●	<0.18	4.76	2.38	2.3
		VPET0802018MFL-JPP	●	●	<0.18	4.76	2.38	2.3
		VPET080202MFR-JPP	●	●	<0.2	4.76	2.38	2.3
		VPET080202MFL-JPP	●	●	<0.2	4.76	2.38	2.3
		VPET1103008MFR-JPP	●	●	<0.08	6.35	3.18	2.8
		VPET1103008MFL-JPP	●	●	<0.08	6.35	3.18	2.8
		VPET110301MFR-JPP	●	●	<0.1	6.35	3.18	2.8
		VPET110301MFL-JPP	●	●	<0.1	6.35	3.18	2.8
		VPET1103018MFR-JPP	●	●	<0.18	6.35	3.18	2.8
		VPET1103018MFL-JPP	●	●	<0.18	6.35	3.18	2.8
		VPET110302MFR-JPP	●	●	<0.2	6.35	3.18	2.8
		VPET110302MFL-JPP	●	●	<0.2	6.35	3.18	2.8
	JRP	VPET0802008MFR-JRP	●	●	<0.08	4.76	2.38	2.3
		VPET0802008MFL-JRP	●	●	<0.08	4.76	2.38	2.3
		VPET080201MFR-JRP	●	●	<0.1	4.76	2.38	2.3
		VPET080201MFL-JRP	●	●	<0.1	4.76	2.38	2.3
		VPET0802018MFR-JRP	●	●	<0.18	4.76	2.38	2.3
		VPET0802018MFL-JRP	●	●	<0.18	4.76	2.38	2.3
		VPET080202MFR-JRP	●	●	<0.2	4.76	2.38	2.3
		VPET080202MFL-JRP	●	●	<0.2	4.76	2.38	2.3
		VPET1103008MFR-JRP	●	●	<0.08	6.35	3.18	2.8
		VPET1103008MFL-JRP	●	●	<0.08	6.35	3.18	2.8
		VPET110301MFR-JRP	●	●	<0.1	6.35	3.18	2.8
		VPET110301MFL-JRP	●	●	<0.1	6.35	3.18	2.8
		VPET1103018MFR-JRP	●	●	<0.18	6.35	3.18	2.8
		VPET1103018MFL-JRP	●	●	<0.18	6.35	3.18	2.8
		VPET110302MFR-JRP	●	●	<0.2	6.35	3.18	2.8
		VPET110302MFL-JRP	●	●	<0.2	6.35	3.18	2.8

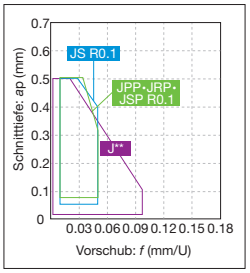
*Eckenradius (RE) mit einem Kleiner-als-Zeichen (<) bedeutet eine Minustoleranz.

● Lagerstandard

Spankontrollbereich







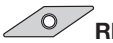
*Spankontrolle mit R0.1

VPET...: J-Serie Werkzeughalter → G022 -

Wendeschneidplatten POSITIV

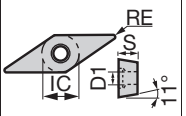
● : Kontinuierlicher Schnitt
ᑕ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

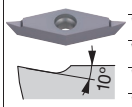
VP



Rhombisch, 35°
mit Loch
Positiv 11°

P	Stahl	●ᑕ ●ᑕ
M	Rostfreier Stahl	●ᑕ ●ᑕ
K	Eisenguss	
N	Nichteisenmetalle	
S	Hitzebest. Legierungen	●ᑕ
H	Gehärteter Stahl	



Anwendung	Spanformstufe	Katalog Nr.	Beschichtet SH725	Beschichtet SH730	RE	IC	S	D1
Außendrehen auf Langdrehautomaten (scharfkantig)	JSP	VPET0802008MFN-JSP	●	●	<0.08	4.76	2.38	2.3
		VPET080201MFN-JSP	●	●	<0.1	4.76	2.38	2.3
		VPET080218MFN-JSP	●	●	<0.18	4.76	2.38	2.3
		VPET080202MFN-JSP	●	●	<0.2	4.76	2.38	2.3
		VPET1103008MFN-JSP	●	●	<0.08	6.35	3.18	2.8
		VPET110301MFN-JSP	●	●	<0.1	6.35	3.18	2.8
		VPET110318MFN-JSP	●	●	<0.18	6.35	3.18	2.8
		VPET110302MFN-JSP	●	●	<0.2	6.35	3.18	2.8

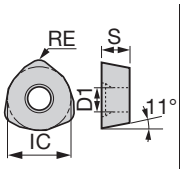
*Eckenradius (RE) mit einem Kleiner-als-Zeichen (<) bedeutet eine Minustoleranz.

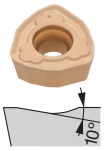
● Lagerstandard

WP

Trigonal, 80°
mit Loch
Positiv 11°

P	Stahl	●ᑕ ᑕ✣ ●ᑕ ᑕ✣ ●ᑕ
M	Rostfreier Stahl	●ᑕ ●ᑕ
K	Eisenguss	●ᑕ ●ᑕ ●ᑕ
N	Nichteisenmetalle	
S	Hitzebest. Legierungen	●ᑕ
H	Gehärteter Stahl	



Anwendung	Spanformstufe	Katalog Nr.	Beschichtet T9215	T9225	T9115	T9125	AH120	RE	IC	S	D1
Schwerzerspanung	ML	WPMT090725ZPR-ML	●	●	▲	▲	●	2.5	15	7	5.5
		WPMT090725ZPL-ML	●	●	▲	▲	●	2.5	15	7	5.5

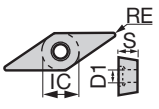
● Lagerstandard
▲ Wird eingestellt

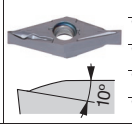
Wendeschneidplatten POSITIV / DOPPELSEITIG

VX

Rhombisch, 35°
mit Loch

P	Stahl	●ᑕ
M	Rostfreier Stahl	●ᑕ
K	Eisenguss	
N	Nichteisenmetalle	
S	Hitzebest. Legierungen	
H	Gehärteter Stahl	



Anwendung	Spanformstufe	Katalog Nr.	Beschichtet SH725	RE	IC	S	D1
Schlichten (scharfkantig)	JRP	VXGU09T201MFRE-JRP	●	<0.1	5.56	2.47	2.5
		VXGU09T201MFLE-JRP	●	<0.1	5.56	2.47	2.5
		VXGU09T202MFRE-JRP	●	<0.2	5.56	2.47	2.5
		VXGU09T202MFLE-JRP	●	<0.2	5.56	2.47	2.5
Schlichten bis mittl. Bearb. (scharfkantig)	JS	VXGU09T201MFR-JS	●	<0.1	5.56	2.47	2.5
		VXGU09T201MFL-JS	●	<0.1	5.56	2.47	2.5
		VXGU09T202MFR-JS	●	<0.2	5.56	2.47	2.5
		VXGU09T202MFL-JS	●	<0.2	5.56	2.47	2.5
		VXGU09T204MFR-JS	●	<0.4	5.56	2.47	2.5
		VXGU09T204MFL-JS	●	<0.4	5.56	2.47	2.5

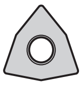
*Eckenradius (RE) mit einem Kleiner-als-Zeichen (<) bedeutet eine Minustoleranz.

● Lagerstandard

WPMT...: Halter / Außendrehen → C098
VPET... : J-Serie Werkzeughalter → G022 -
VXGU...: Halter / Außendrehen → C056 -

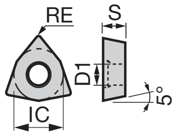
● : Kontinuierlicher Schnitt
◐ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

WB



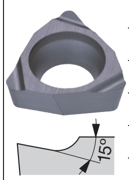
Trigonal, 80°
mit Loch
Positiv 5°

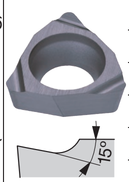
	Werkstoff	Beschichtet			Cermet	Unbeschichtet	
		GH110	SH725	SH730	NS9530	TH10	UX30
P	Stahl		●◐	●◐	●◐	●	◐
M	Rostfreier Stahl		●◐	●◐		●	◐
K	Eisenguss				●◐	●	
N	Nichteisen-metalle					●	
S	Hitzebest. Legierungen			●◐			
H	Gehärteter Stahl						



Anwendung	Spanform-stufe	Katalog Nr.	GH110	SH725	SH730	NS9530	TH10	UX30	RE	IC	S	D1
Schlichten	W08	WBGT030100R-W08			●				0.03	3.97	1.59	2.3
		WBGT030100L-W08			●	●	●	●	0.03	3.97	1.59	2.3
		WBGT030101R-W08			●				0.1	3.97	1.59	2.3
		WBGT030101L-W08			●		●		0.1	3.97	1.59	2.3
		WBGT030102R-W08			●				0.2	3.97	1.59	2.3
		WBGT030102L-W08	●		●	●	●	●	0.2	3.97	1.59	2.3
		WBGT030104R-W08			●				0.4	3.97	1.59	2.3
		WBGT030104L-W08	●		●	●	●	●	0.4	3.97	1.59	2.3
Schlichten (scharfkantig)	W08	WBGT030100FL-W08		●					0.03	3.97	1.59	2.3
		WBGT030100FR-W08		●					0.03	3.97	1.59	2.3
		WBGT030101FL-W08		●					0.1	3.97	1.59	2.3
		WBGT030101FR-W08		●					0.1	3.97	1.59	2.3
		WBGT030102FL-W08		●					0.2	3.97	1.59	2.3
		WBGT030102FR-W08		●					0.2	3.97	1.59	2.3
		WBGT030104FL-W08		●					0.4	3.97	1.59	2.3
		WBGT030104FR-W08		●					0.4	3.97	1.59	2.3

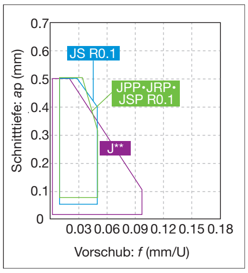
Größe (mm)

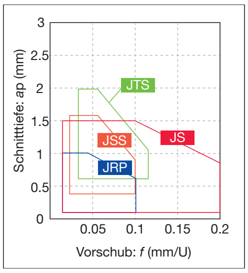


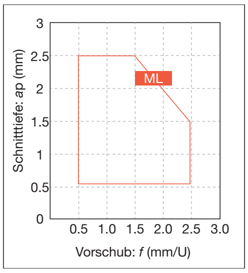


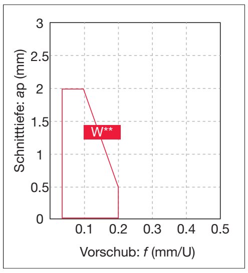
● Lagerstandard

Spankontrollbereich









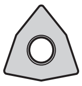
*Spankontrolle mit R0.1

Halter / Innendrehen → D075 Top-Borer Tools → K213

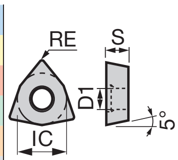
● : Kontinuierlicher Schnitt
◐ : Leicht unterbrochener Schnitt
✠ : Stark unterbrochener Schnitt

Wendeschneidplatten POSITIV

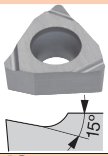
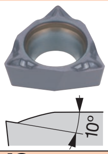
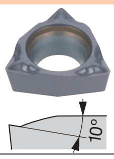
WB



Trigonal, 80° mit Loch Positiv 5°



Werkstoff	GH110	SH725	SH730	NS9530
P Stahl	●	●◐	●◐	●◐
M Rostfreier Stahl	●	●◐	●◐	
K Eisenguss	●			●◐
N Nichteisenmetalle				
S Hitzebest. Legierungen	●		●◐	
H Gehärteter Stahl				

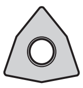
Anwendung	Spanformstufe	Katalog Nr.	GH110 (Beschichtet)	SH725 (Beschichtet)	SH730 (Beschichtet)	NS9530 (Cermet)	RE	IC	S	D1
Schlichten (scharfkantig)	W11  15°	WBGT060102L-W11	●			●	0.2	3.97	1.59	2.3
		WBGT060104L-W11				●	0.4	3.97	1.59	2.3
		WBGT080202L-W11				●	0.2	4.76	2.38	2.3
		WBGT080204L-W11				●	0.4	4.76	2.38	2.3
Innendrehen auf Langdrehautomaten	JS  10°	WBGT030101R-JS			●		<0.1	3.97	1.59	2.3
		WBGT030101L-JS			●		<0.1	3.97	1.59	2.3
		WBGT030102R-JS			●		<0.2	3.97	1.59	2.3
		WBGT030102L-JS			●		<0.2	3.97	1.59	2.3
		WBGT030104R-JS			●		<0.4	3.97	1.59	2.3
		WBGT030104L-JS			●		<0.4	3.97	1.59	2.3
Innendrehen auf Langdrehautomaten (scharfkantig)	JS  10°	WBGT030101FL-JS		●			<0.1	3.97	1.59	2.3
		WBGT030101FR-JS		●			<0.1	3.97	1.59	2.3
		WBGT030102FL-JS		●			<0.2	3.97	1.59	2.3
		WBGT030102FR-JS		●			<0.2	3.97	1.59	2.3
		WBGT030104FL-JS		●			<0.4	3.97	1.59	2.3
		WBGT030104FR-JS		●			<0.4	3.97	1.59	2.3

Größe (mm)

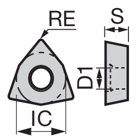
*Eckenradius (RE) mit einem Kleiner-als-Zeichen (<) bedeutet eine Minustoleranz.

Wendeschneidplatten POSITIV / DOPPELSEITIG

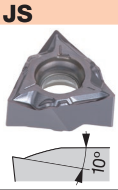
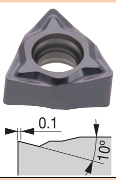
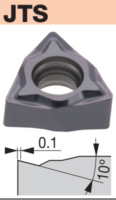
WX



Trigonal, 80° mit Loch



Werkstoff	AH725	SH725
P Stahl	◐	●◐
M Rostfreier Stahl	◐	●◐
K Eisenguss	◐	
N Nichteisenmetalle		
S Hitzebest. Legierungen	●	
H Gehärteter Stahl		

Anwendung	Spanformstufe	Katalog Nr.	AH725 (Beschichtet)	SH725 (Beschichtet)	RE	IC	S	D1
Schlichten bis mittlere Bearbeitung (scharfkantig)	JS  10°	WXGU040301MFR-JS		●	<0.1	6.35	3.18	2.7
		WXGU040301MFL-JS		●	<0.1	6.35	3.18	2.7
		WXGU040302MFR-JS		●	<0.2	6.35	3.18	2.7
		WXGU040302MFL-JS		●	<0.2	6.35	3.18	2.7
		WXGU040304MFR-JS		●	<0.4	6.35	3.18	2.7
		WXGU040304MFL-JS		●	<0.4	6.35	3.18	2.7
	JTS  0.1 10°	WXGU040301MFR-JTS		●	<0.1	6.35	3.18	2.7
		WXGU040301MFL-JTS		●	<0.1	6.35	3.18	2.7
		WXGU040302MFR-JTS		●	<0.2	6.35	3.18	2.7
		WXGU040302MFL-JTS		●	<0.2	6.35	3.18	2.7
Schlichten bis mittl. Bearbeitung	JTS  0.1 10°	WXGU040301MR-JTS	●		<0.1	6.35	3.18	2.7
		WXGU040301ML-JTS	●		<0.1	6.35	3.18	2.7
		WXGU040302MR-JTS	●		<0.2	6.35	3.18	2.7
		WXGU040302ML-JTS	●		<0.2	6.35	3.18	2.7

Größe (mm)

*Eckenradius (RE) mit einem Kleiner-als-Zeichen (<) bedeutet eine Minustoleranz.

● Lagerstandard

WBGT...: Halter / Innendrehen → D075
WXGU...: Halter / Außendrehen → C031 -, Halter / Innendrehen → D028

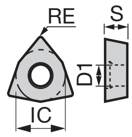
Wendeschneidplatten POSITIV / DOPPELSEITIG

● : Kontinuierlicher Schnitt
◐ : Leicht unterbrochener Schnitt
✠ : Stark unterbrochener Schnitt

WX

Trigonal, 80° mit Loch

	Werkstoff	AH725	AH8015	SH725	GT9530	NS9530	KS05F
P	Stahl	◐	●◐	●◐	●◐	●◐	
M	Rostfreier Stahl	◐	●◐	●◐			
K	Eisenguss	◐			●◐	●◐	●
N	Nichteisenmetalle						●
S	Hitzebest. Legierungen	●					●
H	Gehärteter Stahl						



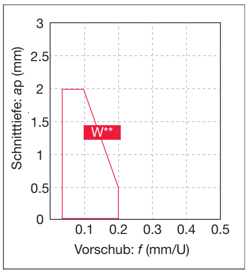
Anwendung	Spanformstufe	Katalog Nr.	AH725 (Beschichtet)	AH8015 (Beschichtet)	SH725 (Beschichtet)	GT9530 (Cermet besch.)	NS9530 (Cermet)	KS05F (Unbeschichtet)	RE	IC	S	D1
Schlichten (Niedrige Schnittkräfte, scharfkantig)	JSS	WXGU040301MFR-JSS			●				<0.1	6.35	3.18	2.7
		WXGU040301MFL-JSS			●				<0.1	6.35	3.18	2.7
		WXGU040302MFR-JSS			●				<0.2	6.35	3.18	2.7
		WXGU040302MFL-JSS			●				<0.2	6.35	3.18	2.7
Schlichten (Niedrige Schnittkräfte)	JSS	WXGU040301MR-JSS	●						<0.1	6.35	3.18	2.7
		WXGU040301ML-JSS	●						<0.1	6.35	3.18	2.7
		WXGU040302MR-JSS	●						<0.2	6.35	3.18	2.7
		WXGU040302ML-JSS	●						<0.2	6.35	3.18	2.7
Schlichten bis mittlere Bearbeitung	TS	WXGU040302R-TS	●	●		●	●	●	0.2	6.35	3.18	2.7
		WXGU040302L-TS	●	●		●	●	●	0.2	6.35	3.18	2.7
		WXGU040304R-TS	●	●		●	●	●	0.4	6.35	3.18	2.7
		WXGU040304L-TS	●	●		●	●	●	0.4	6.35	3.18	2.7
		WXGU040308R-TS	●	●		●	●	●	0.8	6.35	3.18	2.7
		WXGU040308L-TS	●	●		●	●	●	0.8	6.35	3.18	2.7
Schlichten (Wiper)	TSW	WXGU040304R-TSW	●	●		●	●		0.4	6.35	3.18	2.7
		WXGU040304L-TSW	●	●		●	●		0.4	6.35	3.18	2.7
		WXGU040308R-TSW	●	●		●	●		0.8	6.35	3.18	2.7
		WXGU040308L-TSW	●	●		●	●		0.8	6.35	3.18	2.7
Schlichten (Niedrige Schnittkräfte)	SS	WXGU040302R-SS	●	●		●	●	●	0.2	6.35	3.18	2.7
		WXGU040302L-SS	●	●		●	●	●	0.2	6.35	3.18	2.7
		WXGU040304R-SS	●	●		●	●	●	0.4	6.35	3.18	2.7
		WXGU040304L-SS	●	●		●	●	●	0.4	6.35	3.18	2.7

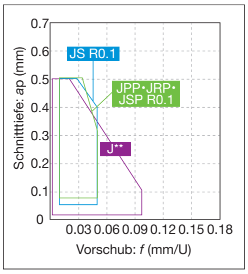
Größe (mm)

*Eckenradius (RE) mit einem Kleiner-als-Zeichen (<) bedeutet eine Minustoleranz.

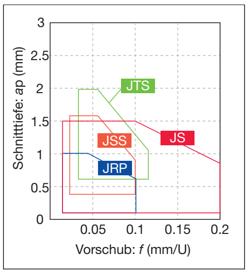
● Lagerstandard

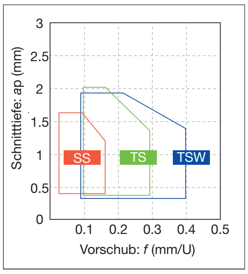
Spankontrollbereich





*Spankontrolle mit R0.1



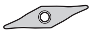


Halter / Außendrehen → C031 -   Halter / Innendrehen → D028

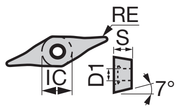
Wendeschneidplatten POSITIV

● : Kontinuierlicher Schnitt
◐ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

YW



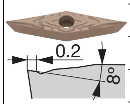
Rhombisch, 25°
mit Loch
Positiv 7°

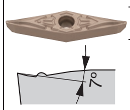


Werkstoff		T9225	T9125	GT9530
P	Stahl	◐✣	◐✣	●◐
M	Rostfreier Stahl			
K	Eisenguss			●◐
N	Nichteisenmetalle			
S	Hitzebest. Legierungen			
H	Gehärteter Stahl			

Anwendung	Spanformstufe	Katalog Nr.	T9225 (Beschichtet)	T9125 (Beschichtet)	GT9530 (Cermet besch.)	RE	IC	S	D1
Schlichten bis mittlere Bearbeitung	ZF	YWMT11T202-ZF	●	▲	●	0.2	4.679	2.78	2.3
		YWMT11T204-ZF	●	▲	●	0.4	4.679	2.78	2.3
		YWMT16T302-ZF	●	▲	●	0.2	7.018	3.97	2.86
		YWMT16T304-ZF	●	▲	●	0.4	7.018	3.97	2.86
		YWMT16T308-ZF	●	▲	●	0.8	7.018	3.97	2.86
	ZM	YWMT11T204-ZM	●	▲	●	0.4	4.679	2.78	2.3
		YWMT16T304-ZM	●	▲	●	0.4	7.018	3.97	2.86
		YWMT16T308-ZM	●	▲	●	0.8	7.018	3.97	2.86

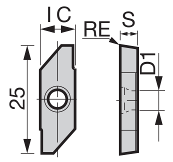
Größe (mm)





JXF

Vorwärts-
drehen



Werkstoff		J740	TH10
P	Stahl	●◐	●
M	Rostfreier Stahl	●◐	●
K	Eisenguss		●
N	Nichteisenmetalle		●
S	Hitzebest. Legierungen		
H	Gehärteter Stahl		

Anwendung	Spanformstufe	Katalog Nr.	J740 (Beschichtet)	TH10 (Unbeschichtet)	RE	IC	S	D1
Vorwärtsdrehen	-	JXFR8000F	●	●	0.03	8	3.97	4.4
		JXFR8010F	●	●	0.1	8	3.97	4.4

Größe (mm)

● Lagerstandard
▲ Wird eingestellt

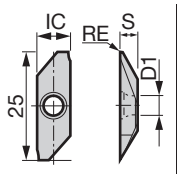
Halter / Außendrehen → C064, C128 Halter / Innendrehen → D076

● : Kontinuierlicher Schnitt
◐ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

JXR

Rückwärts-drehen

P	Stahl	●◐
M	Rostfreier Stahl	●◐
K	Eisenguss	●
N	Nichteisen-metalle	●
S	Hitzebest. Legierungen	
H	Gehärteter Stahl	

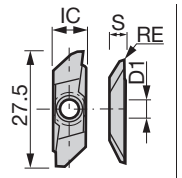


Anwendung	Spanform-stufe	Katalog Nr.	Beschichtet J740	Unbeschichtet TH10	Größe (mm) RE	IC	S	D1
Rückwärtsdrehen	-	JXRR8000F	●	●	0.03	8	3.97	4.4
		JXRR8010F	●	●	0.1	8	3.97	4.4

JXB

Rückwärts-drehen

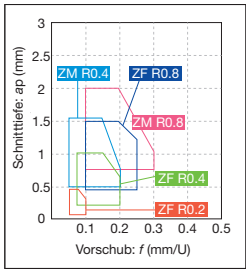
P	Stahl	●◐
M	Rostfreier Stahl	●◐
K	Eisenguss	●
N	Nichteisen-metalle	●
S	Hitzebest. Legierungen	
H	Gehärteter Stahl	



Anwendung	Spanform-stufe	Katalog Nr.	Beschichtet J740	Unbeschichtet TH10	Größe (mm) RE	IC	S	D1
Rückwärtsdrehen	-	JXBR8000F	●	●	0.03	8	3.97	4.4
		JXBL8000F	●	●	0.03	8	3.97	4.4
		JXBR8005F	●	●	0.05	8	3.97	4.4
		JXBL8005F	●	●	0.05	8	3.97	4.4
		JXBR8005	●		0.05	8	3.97	4.4
		JXBL8005	●		0.05	8	3.97	4.4
		JXBR8010F	●	●	0.10	8	3.97	4.4
		JXBL8010F	●	●	0.10	8	3.97	4.4
		JXBR8010	●		0.10	8	3.97	4.4
		JXBL8010	●		0.10	8	3.97	4.4
		JXBR8015F	●	●	0.15	8	3.97	4.4
		JXBL8015F	●	●	0.15	8	3.97	4.4
		JXBR8015	●		0.15	8	3.97	4.4
		JXBL8015	●		0.15	8	3.97	4.4

● Lagerstandard

Spankontrollbereich



JXF..., JXR..., JXB...: J-Serie Werkzeughalter → G043 -

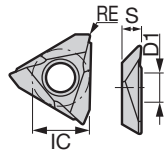
Wendeschneidplatten POSITIV

● : Kontinuierlicher Schnitt
◐ : Leicht unterbrochener Schnitt
✠ : Stark unterbrochener Schnitt

JTB*

Rückwärts-drehen

		SH725	J740	J9530	NS9530	TH10
P	Stahl	●◐	●◐	●◐	●◐	●
M	Rostfreier Stahl	●◐	●◐			●
K	Eisenguss			●◐	●◐	●
N	Nichteisen-metalle					●
S	Hitzebest. Legierungen					
H	Gehärteter Stahl					

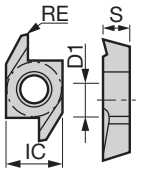


Anwendung	Spanform-stufe	Katalog Nr.	Beschichtet SH725	Beschichtet J740	Cermet besch. J9530	Cermet NS9530	Unbeschichtet TH10	Größe (mm) RE	IC	S	D1
Rückwärtsdrehen	-	JTBR3000F	●	●			●	0.03	9.5	3.18	4.4
		JTBL3000F	●	●			●	0.03	9.5	3.18	4.4
		JTBR3005F	●	●			●	0.05	9.5	3.18	4.4
		JTBL3005F	●	●			●	0.05	9.5	3.18	4.4
		JTBR3005		●	●			0.05	9.5	3.18	4.4
		JTBL3005		●				0.05	9.5	3.18	4.4
		JTBR3010F	●	●		●	●	0.10	9.5	3.18	4.4
		JTBL3010F	●	●		●	●	0.10	9.5	3.18	4.4
		JTBR3010		●	●			0.10	9.5	3.18	4.4
		JTBL3010		●				0.10	9.5	3.18	4.4
		JTBR3015F	●	●				0.15	9.5	3.18	4.4
		JTBL3015F	●					0.15	9.5	3.18	4.4

J10E*

Rückwärts-drehen

		SH725	J740	J9530	NS9530	TH10
P	Stahl	●◐	●◐	●◐	●◐	●
M	Rostfreier Stahl	●◐	●◐			●
K	Eisenguss			●◐	●◐	●
N	Nichteisen-metalle					●
S	Hitzebest. Legierungen					
H	Gehärteter Stahl					



Anwendung	Spanform-stufe	Katalog Nr.	Beschichtet SH725	Beschichtet J740	Cermet besch. J9530	Cermet NS9530	Unbeschichtet TH10	Größe (mm) RE	IC	S	D1
Rückwärtsdrehen	-	J10ER005BF	●	●		●	●	0.05	6.35	3.18	3.0
		J10EL005BF	●	●			●	0.05	6.35	3.18	3.0
		J10ER005B		●	●			0.05	6.35	3.18	3.0
		J10EL005B		●				0.05	6.35	3.18	3.0
		J10ER010BF	●	●		●	●	0.10	6.35	3.18	3.0
		J10EL010BF	●	●			●	0.10	6.35	3.18	3.0
		J10ER010B		●	●			0.10	6.35	3.18	3.0
		J10EL010B		●				0.10	6.35	3.18	3.0
		J10EL015BF	●					0.15	6.35	3.18	3.0
		J10ER015BF	●					0.15	6.35	3.18	3.0

● Lagerstandard

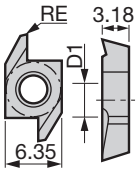
JTB...: J-Serie Werkzeughalter → G048 J10E...: J-Serie Werkzeughalter → G050

● : Kontinuierlicher Schnitt
◐ : Leicht unterbrochener Schnitt
✠ : Stark unterbrochener Schnitt

10E*

Rückwärts-drehen

P	Stahl	●
M	Rostfreier Stahl	●
K	Eisenguss	●
N	Nichteisen-metalle	●
S	Hitzebest. Legierungen	
H	Gehärteter Stahl	



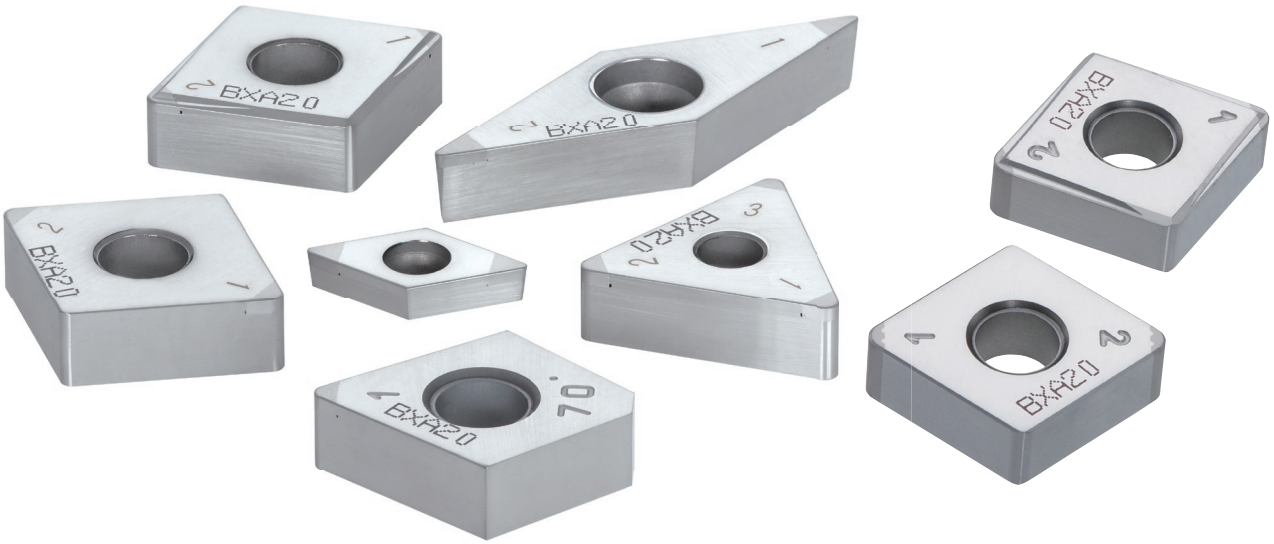
Anwendung	Spanform-stufe	Katalog Nr.	Unbeschichtet TH10	Größe (mm) RE	IC	S	D1
Rückwärtsdrehen	-	**10ER100B**	●	0.03	6.35	3.18	3.0
		10EL100B	●	0.03	6.35	3.18	3.0
		10ER150B	●	0.03	6.35	3.18	3.0
		10EL150B	●	0.03	6.35	3.18	3.0
		10ER300	●	-	6.35	3.18	3.0
		10EL300	●	-	6.35	3.18	3.0

● Lagerstandard

MEMO

BXA20

- Beschichteter CBN-Schneidstoff für gehärteten Stahl



Besonders zuverlässig

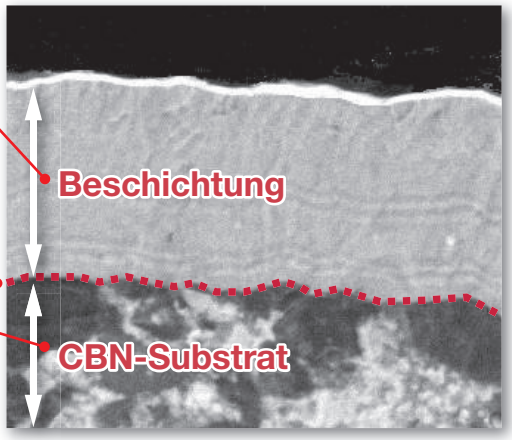
bei der Drehbearbeitung von gehärtetem Stahl

- Für Anwendungen mit niedriger bis mittlerer Schnittgeschwindigkeit
- Geeignet für ein breites Anwendungssprektrum von kontinuierlichem bis stark unterbrochenem Schnitt

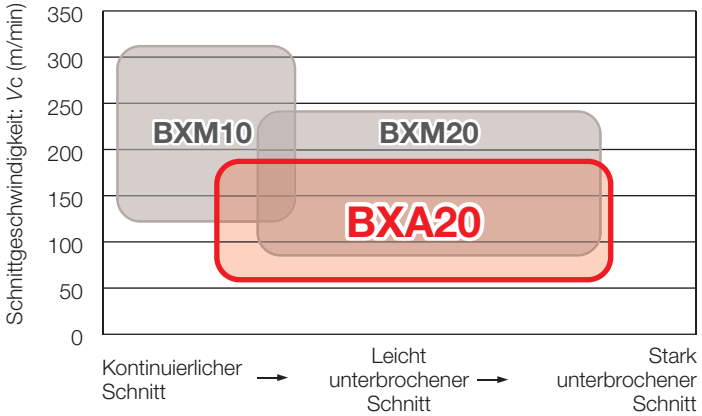
Mehrfachbeschichtung – doppelt so dick wie bei herkömmlichen Schneidstoffen
- Exzellente Verschleißfestigkeit

Verbesserte Adhäsionskraft
- Verhindert das Absplittern der Beschichtung – für eine ausgezeichnete Oberflächengüte

Neuentwickeltes CBN-Substrat mit einzigartigem Binder
- Optimaler CBN-Gehalt für eine hohe Verschleißfestigkeit und Robustheit



ANWENDUNGSBEREICH



BXM10
Geeignet für kontinuierlichen bis leicht unterbrochenen Schnitt bei hohen Schnittgeschwindigkeiten

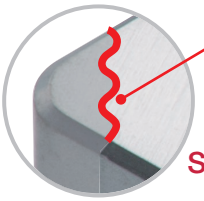
BXM20
Geeignet für ein breites Anwendungsspektrum bei mittleren bis hohen Schnittgeschwindigkeiten

BXA20
Ausgezeichnete Stabilität bei niedrigen bis mittleren Schnittgeschwindigkeiten

Hohe Effizienz
bei der Bearbeitung von gehärtetem Stahl

Neue Hartlöttechnologie für eine verbesserte Bearbeitungseffizienz „WavyJoint“

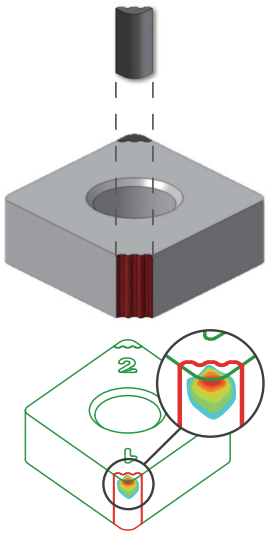
- Maximale Schnitttiefe 0,8 mm
  → Senkt die Anzahl der Schnitte und steigert die Produktivität



Die „gewellte“ Kontaktfläche verstärkt die Hartlötverbindung

Starke Verbindung

WavyJoint BXA20 **Vs.** Standard



Größe der CBN-Spitze:

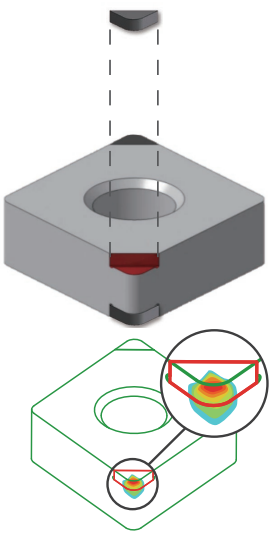
CBN-Spitzen mit **200%** mehr Masse als konventionelle CBN-Spitzen verbessern die Wärmeverteilung und senken die Temperatur an der Lötstelle.

Hartlötbereich:

Vergrößerung der Lötfläche um **160%** für verbesserte Adhäsionskräfte und Haftung

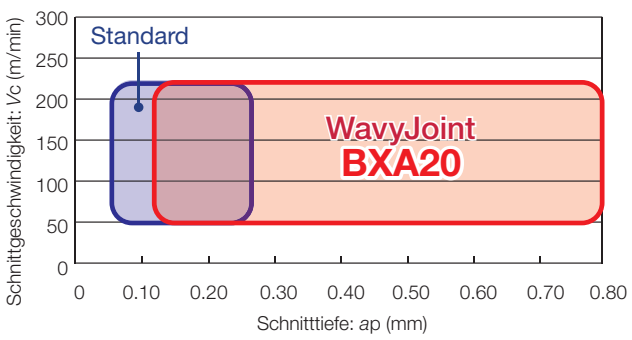
Während der Bearbeitung konzentriert sich die Temperatur in der CBN-Spitze und an der Hartlötverbindung. Durch das neue WavyJoint Prinzip treten hier weniger Termperatureinwirkungen auf.

Werkstoff	: SCM420 / 20CrMo4 (60HRC)
Schnittgeschwindigkeit	: *Vc* = 150 m/min
Vorschub	: *fz* = 0.20 mm/U
Schnitttiefe	: *ap* = 0.75 mm
Kühlmittel	: Trocken



ANWENDUNGS-GEBIET

Drehbearbeitung gehärteter Werkstoffe



H

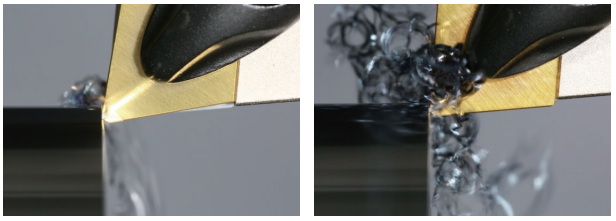
WavyJoint BXA20
Ausgezeichnete Leistung bei kontinuierlichem bis stark unterbrochenem Schnitt und geringen bis mittleren Geschwindigkeiten.

T-CBN SERIES – CBN-Typ: GNGA

Hohe Effizienz beim Schlichten von gehärtetem Stahl, Eisenguss und gesinterten Metallen

Spankontrolle beim Plandrehen

Kontinuierlicher Schnitt

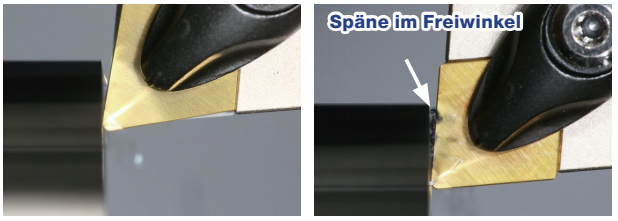


Typ: GNGA
Eckenradius: 70°

Typ: CNGA
Eckenradius: 80°

Da Wendeschneidplatten des Typs GNGA ausreichend Platz für den Spanfluss bieten, treten keine Spanansammlungen auf. Dies verbessert die Oberflächengüte und verhindert einen plötzlichen Bruch der Schneidkante. Vorhandene Standard-Werkzeughalter für CNGA1204 können weiterhin verwendet werden.

Unterbrochener Schnitt



Typ: GNGA
Eckenradius: 70°

Typ: CNGA
Eckenradius: 80°

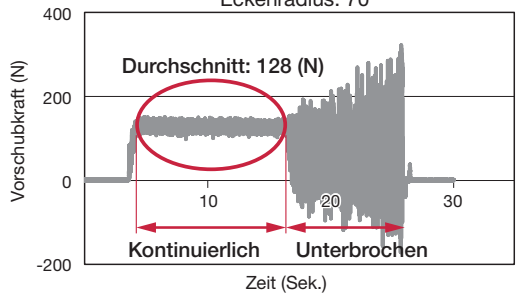
H

Halter	: ACLNL2525M12-A
Wendeschneidplatte	: 2QP-GNGA120408 BXM20 2QP-CNGA120408 BXM20
Werkstoff	: SCM420 / 18CrMo4 (60HRC)
Schnittgeschwindigkeit	: *Vc* = 150 m/min
Vorschub	: *f* = 0.10 mm/U
Schnitttiefe	: *ap* = 0.125 mm
Bearbeitung	: Plandrehen
Kühlmittel	: Trocken

SCHNITTLEISTUNG

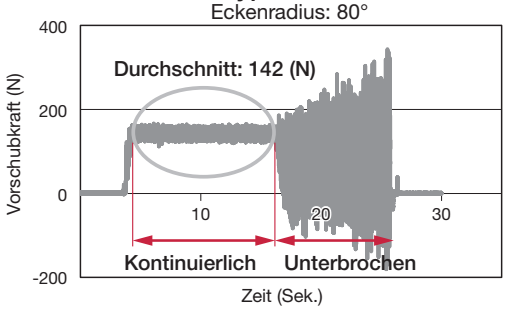
Schnittkraft (Vorschubkraft)

Typ: GNGA
Eckenradius: 70°



Wendeschneidplatten des Typs GNGA verfügen über einen großen Freiwinkel und verringert die Schnittkräfte im Vergleich zu herkömmlichen Wendeschneidplatten des Typs CNGA.

Typ: CNGA
Eckenradius: 80°



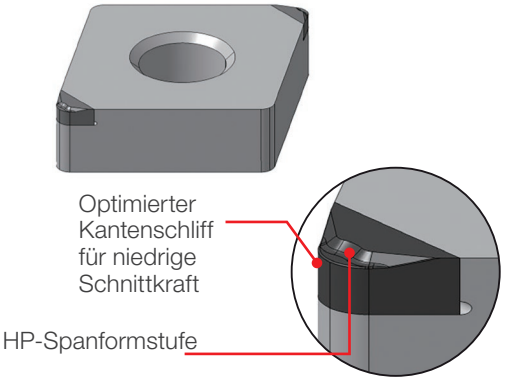
H

Außendrehen	: ACLNL2525M12-A
Wendeschneidplatte	: 2QP-GNGA120408 BXM20 2QP-CNGA120408 BXM20
Werkstoff	: SCM420 / 18CrMo4 (59HRC)
Schnittgeschwindigkeit	: *Vc* = 150 m/min
Vorschub	: *f* = 0.15 mm/U
Schnitttiefe	: *ap* = 0.125 mm
Bearbeitung	: Plandrehen
Kühlmittel	: Trocken

HARDBREAKER HP

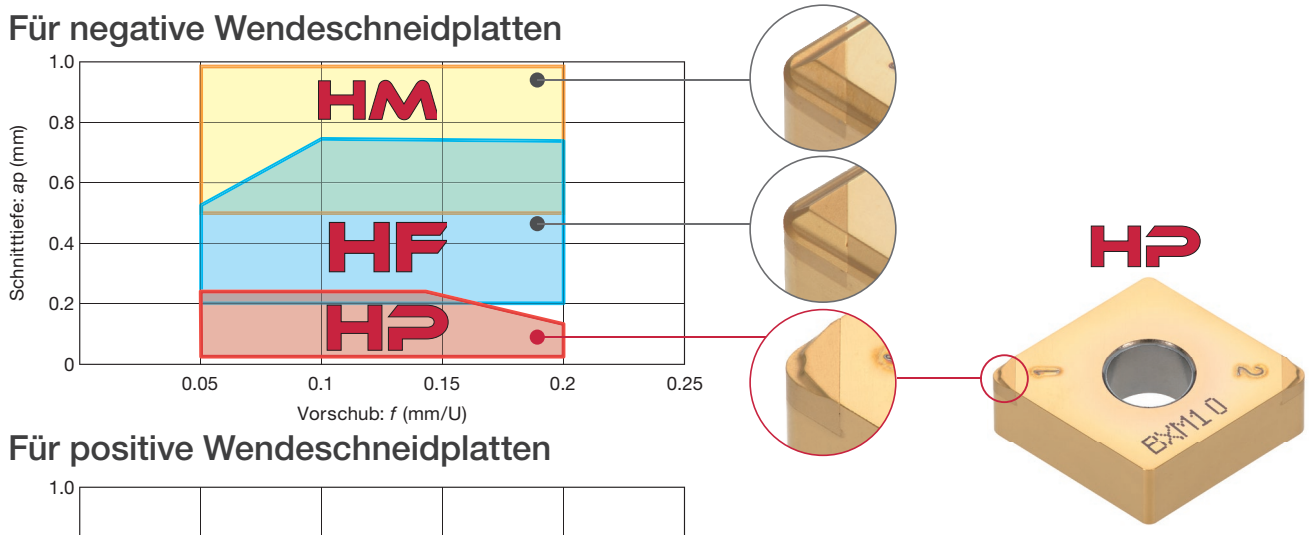
Neue HP-Spanformstufe für das Schlichten von gehärtetem Stahl

1. Durch die Spanformstufe reduziert sich die Schnittkraft signifikant. Die Standzeit des Werkzeuges wird verlängert.
2. Durch die reduzierten Schnittkräfte und die geschliffenen Schneiden können kleine Toleranzgrenzen ohne Abweichungen hergestellt werden.
3. Die HP-Spanformstufe mit integrierten Wipern bietet eine herausragende Oberflächengüte und eine gute Spankontrolle.

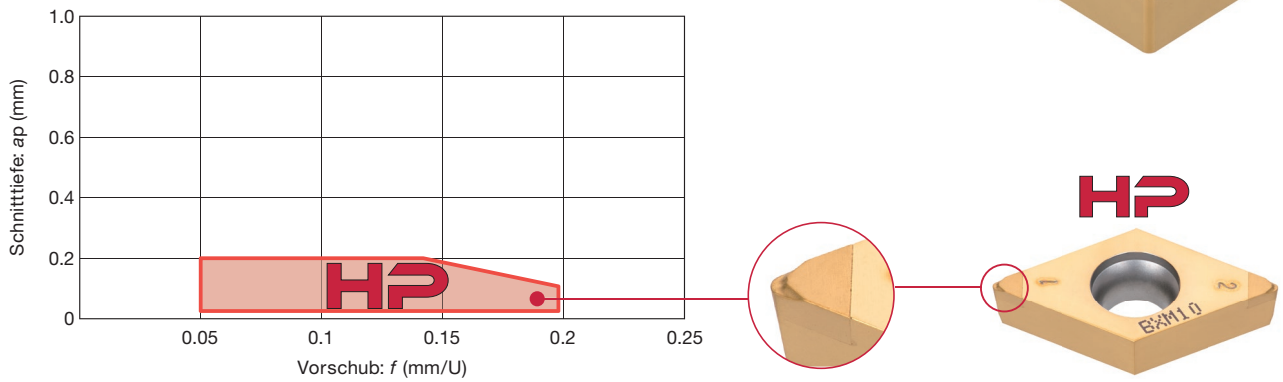


ANWENDUNGSBEREICH

Für negative Wendeschneidplatten



Für positive Wendeschneidplatten



Nomenklatur für CBN Wendeschneidplatten

Mehrschneidenausführung

2 QP - CNGA120404 -L

① Anzahl Schneiden

② Typ

QP	CBN Wende-schneidplatten
QS	WavyJoint

③ ISO-Standard-bezeichnung

④ Spezialeigenschaften & Spanformstufe

Ohne	Standard	W	Mit Wiper
F	Scharfe Schneidkante	W□	Mit Wiper
-L	Reduzierter Verschleiß	-HF	mit Spanformstufe
-LF	Reduzierter Freiflächenverschleiß	-HM	mit Spanformstufe
-LC	Reduzierter Kolkverschleiß	-HP	mit Spanformstufe
-H	Erhöhte Bruchfestigkeit		

Mehrschneidenausführung (VE = 10 Stück)

T 2 QP - CNGA120408

① „T“ = 10 Stück pro Packung.

Für die allgemeine Drehbearbeitung

TNGA160402 - QBN

① ISO-Standard-bezeichnung

② CBN Wendeschneid-platten

CBN-Stechplatten (PCBN aufgelötet)

XG R 63 10 S - QBN

① Für Stechwerkzeuge Typ: GX

② Schneid-richtung

L	Links
R	Rechts

③ Stechbreite (mm)

10	1.0
15	1.5

④ Eckenradius: RE (mm)

S	0.2

⑤ CBN Wendeschneid-platten

Für TUNGCUT

S G N 200 - 020

① Anzahl Schneiden

S	1 Schneide

② Anwendung

G	Stechwerkzeuge

③ Einsatz

N	Ohne Spanbrecher

④ Stechbreite (mm)

200	2.0

⑤ Eckenradius: RE (mm)

020	0.2

Nomenklatur für PKD Wendeschneidplatten

Wendeschneidplatten für die Drehbearbeitung

TPGW110204 - DIA

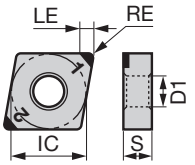
① ISO-Standard-bezeichnung

② PKD Wendeschneid-platten

CBN Wendeschneidplatten NEGATIV

● : Kontinuierlicher Schnitt
ᑕ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

		BXM10	BXM20	BXA20	BX310	BX330	BX360	BX380	BX470	BX480	BX930
P	Stahl										
M	Rostfreier Stahl										
K	Eisenguss								●ᑕ	✣	●ᑕ
N	Nichteisenmetalle										
S	Hitzebest. Legierungen										
H	Gehärteter Stahl	●	●ᑕ	●ᑕ	●	●ᑕ	●ᑕ	✣			
	Sintermetalle								●ᑕ	ᑕ✣	



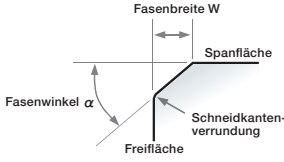
Katalog Nr.		BXM10	BXM20	BXA20	BX310	BX330	BX360	BX380	BX470	BX480	BX930	Größe (mm) Anzahl Schneiden	LE	RE	IC	S	D1	Mikrogeometrie Standard	Scharfe Schneidkante	L	LF	LC	H	Wiper	Spanformstufe
2QP-CNGA	**2QP-CNGA120404**	●	●	●	●	●	●	●	●	●	●	2	2.3	0.4	12.7	4.76	5.16	○							
	2QP-CNGA120408	●	●	●	●	●	●	●	●	●	●	2	2.2	0.8	12.7	4.76	5.16	○							
	2QP-CNGA120412		●	●	●	●	●	●	●	●	●	2	2.4	1.2	12.7	4.76	5.16	○							
	2QP-CNGA120416			●								2	3.3	1.6	12.7	4.76	5.16	○							
	2QP-CNGA120420			●								2	3.2	2.0	12.7	4.76	5.16	○							
	2QP-CNGA120424			●								2	3.1	2.4	12.7	4.76	5.16	○							
T2QP-CNGA	**T2QP-CNGA120404**						●					2	2.3	0.4	12.7	4.76	5.16	○							
	T2QP-CNGA120408						●					2	2.2	0.8	12.7	4.76	5.16	○							
2QP-CNGAF**	**2QP-CNGA120404F**								●			2	2.3	0.4	12.7	4.76	5.16		○						
	2QP-CNGA120408F								●			2	2.2	0.8	12.7	4.76	5.16		○						
2QP-CNGA-L**	**2QP-CNGA120404-L**	●	●	●		●						2	2.3	0.4	12.7	4.76	5.16			○					
	2QP-CNGA120408-L	●	●	●		●						2	2.2	0.8	12.7	4.76	5.16			○					
	2QP-CNGA120412-L	●	●	●		●						2	2.4	1.2	12.7	4.76	5.16			○					
2QP-CNGA-LF**	**2QP-CNGA120404-LF**			●								2	2.3	0.4	12.7	4.76	5.16				○				
	2QP-CNGA120408-LF			●								2	2.2	0.8	12.7	4.76	5.16				○				
	2QP-CNGA120412-LF			●								2	2.4	1.2	12.7	4.76	5.16				○				
2QP-CNGA-LC**	**2QP-CNGA120404-LC**			●								2	2.3	0.4	12.7	4.76	5.16					○			
	2QP-CNGA120408-LC			●								2	2.2	0.8	12.7	4.76	5.16					○			
	2QP-CNGA120412-LC			●								2	2.4	1.2	12.7	4.76	5.16					○			
2QP-CNGA-H**	**2QP-CNGA120404-H**		●	●			●	●				2	2.3	0.4	12.7	4.76	5.16						○		
	2QP-CNGA120408-H		●	●			●	●				2	2.2	0.8	12.7	4.76	5.16						○		
	2QP-CNGA120412-H		●	●			●	●				2	2.4	1.2	12.7	4.76	5.16						○		
2QP-CNGAWL**	**2QP-CNGA120404WL**	●	●	●								2	2.3	0.4	12.7	4.76	5.16							○	
	2QP-CNGA120408WL	●	●	●								2	2.2	0.8	12.7	4.76	5.16							○	
	2QP-CNGA120412WL	●	●	●								2	2.4	1.2	12.7	4.76	5.16							○	
2QP-CNMAW**	**2QP-CNMA120404W**					●						2	2.3	0.4	12.7	4.76	5.16							○	
	2QP-CNMA120408W					●						2	2.2	0.8	12.7	4.76	5.16							○	
	2QP-CNMA120412W					●						2	2.4	1.2	12.7	4.76	5.16							○	

*Siehe Seite **B199** bezüglich Details zu empfohlenen Werkzeughaltern für Wiper-Wendeschneidplatten mit Bezeichnungen, die auf W, WL oder WJ enden.

● Lagerstandard

Mikrogeometrie

	BXM10 BX310 BX330 BX480	BXA20	BXM20	BX360 BX380	BX470	BX910 BX930 BXC50	BXC90
Standard	S01325	S01325	S01325	S01325	T01315	S01325	T02020
Scharfe Schneidkante	-	-	-	-	F	-	-
-L	S01315	S01315	S01315	-	-	-	-
-LF	-	S00515	-	-	-	-	-
-LC	-	S00535	-	-	-	-	-
-H	-	S01835	S01835	S01335	-	-	-
Wiper	S01315	S01315	S01315	-	-	-	-



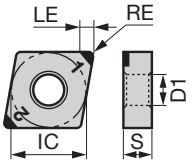
S	0	1	3	2	5
Form	Fasenbreite (W) (mm)			Fasenwinkel α	

T ··· Gefast
S ··· Gefast + verrundet
E ··· Verrundet
F ··· Scharfkantig

CBN Wendeschneidplatten NEGATIV

● : Kontinuierlicher Schnitt
ᑕ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

		BXM10	BXM20	BXA20	BXC50	BX360	BXC90
P	Stahl						
M	Rostfreier Stahl						
K	Eisenguss					●ᑕ	
N	Nichteisenmetalle						
S	Hitzebest. Legierungen						
H	Gehärteter Stahl	●	●ᑕ	●ᑕ	✣	●ᑕ	
	Sintermetalle						



	Katalog Nr.	Anzahl Schneiden	Größe (mm) LE	RE	IC	S	D1	Mikrogeometrie Standard	Scharfe Schneidkante	L	LF	LC	H	Wiper	Spanformstufe
2QP-CNGM-H***	**2QP-CNGM120408-HF**	2	2.2	0.8	12.7	4.76	5.16								○
	2QP-CNGM120412-HF	2	2.4	1.2	12.7	4.76	5.16								○
	2QP-CNGM120408-HM	2	2.2	0.8	12.7	4.76	5.16								○
	2QP-CNGM120412-HM	2	2.4	1.2	12.7	4.76	5.16								○
	2QP-CNGM120404-HP	2	2.3	0.4	12.7	4.76	5.16								○
	2QP-CNGM120408-HP	2	2.2	0.8	12.7	4.76	5.16								○
	2QP-CNGM120412-HP	2	2.4	1.2	12.7	4.76	5.16								○
2QP-CNGMWL-HP**	**2QP-CNGM120408WL-HP**	2	2.2	0.8	12.7	4.76	5.16							○	○
4QP-CNGA	**4QP-CNGA120404**	4	2.3	0.4	12.7	4.76	5.16	○							
	4QP-CNGA120408	4	2.2	0.8	12.7	4.76	5.16	○							
	4QP-CNGA120412	4	2.4	1.2	12.7	4.76	5.16	○							
4QP-CNMAW**	**4QP-CNMA120404W**	4	2.3	0.4	12.7	4.76	5.16							○	
	4QP-CNMA120408W	4	2.2	0.8	12.7	4.76	5.16							○	
	4QP-CNMA120412W	4	2.4	1.2	12.7	4.76	5.16							○	
4QS-CNGA	**4QS-CNGA120408**	4	2.2	0.8	12.7	4.76	5.16	○							
	4QS-CNGA120412	4	2.4	1.2	12.7	4.76	5.16	○							
4QS-CNGA-H**	**4QS-CNGA120408-H**	4	1.5	0.8	12.7	4.76	5.16						○		
	4QS-CNGA120412-H	4	1.7	1.2	12.7	4.76	5.16						○		
4QS-CNGG-HM**	**4QS-CNGG120408-HM**	4	1.5	0.8	12.7	4.76	5.16								○
	4QS-CNGG120412-HM	4	1.7	1.2	12.7	4.76	5.16								○
CNGA-QBN**	**CNGA120402-QBN**	1	4.1	0.2	12.7	4.76	5.16	○							
	CNGA120404-QBN	1	4.0	0.4	12.7	4.76	5.16	○							
	CNGA120408-QBN	1	3.9	0.8	12.7	4.76	5.16	○							
	CNGA120412-QBN	1	3.9	1.2	12.7	4.76	5.16	○							
S-CNGN	**S-CNGN090308**	4	-	0.8	9.525	3.18	-	○							
	S-CNGN090312	4	-	1.2	9.525	3.18	-	○							
	S-CNGN120408	4	-	0.8	12.7	4.76	-	○							
	S-CNGN120412	4	-	1.2	12.7	4.76	-	○							

*Siehe Seite **B199** bezüglich Details zu empfohlenen Werkzeughaltern für Wiper-Wendeschneidplatten mit Bezeichnungen, die auf W, WL und WJ enden.

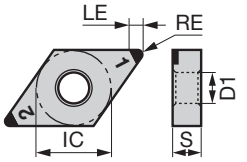
● Lagerstandard

Halter / Außendrehen	→ C018 -	Halter / Innendrehen	→ D023 -
J-Serie Werkzeughalter	→ G044	TungCap	→ K008 -
PINZBOHR®	→ K180 -	Kassetten	→ K199 -

CBN Wendeschneidplatten NEGATIV

● : Kontinuierlicher Schnitt
◐ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

		BXM10	BXM20	BXA20	BX310	BX330	BX360	BX380	BX470	BX480	BX930
P	Stahl								◐	✣	◐
M	Rostfreier Stahl										
K	Eisenguss								◐	✣	◐
N	Nichteisenmetalle										
S	Hitzebest. Legierungen										
H	Gehärteter Stahl	●	◐	◐	●	◐	◐	✣			
	Sintermetalle								◐	◐✣	



	Katalog Nr.	Anzahl Schneiden	Größe (mm) LE	RE	IC	S	D1	Mikrogeometrie Standard	Scharfe Schneidkante	L	LF	LC	H	Wiper	Spanformstufe
2QP-DNGA	**2QP-DNGA110404**	2	2.5	0.4	9.525	4.76	3.81	○							
	2QP-DNGA110408	2	2.1	0.8	9.525	4.76	3.81	○							
	2QP-DNGA110412	2	2.0	1.2	9.525	4.76	3.81	○							
	2QP-DNGA150404	2	2.5	0.4	12.7	4.76	5.16	○							
	2QP-DNGA150408	2	2.1	0.8	12.7	4.76	5.16	○							
	2QP-DNGA150412	2	2.0	1.2	12.7	4.76	5.16	○							
	2QP-DNGA150416	2	3.4	1.6	12.7	4.76	5.16	○							
	2QP-DNGA150420	2	3.0	2.0	12.7	4.76	5.16	○							
	2QP-DNGA150424	2	2.6	2.4	12.7	4.76	5.16	○							
	2QP-DNGA150604	2	2.5	0.4	12.7	6.35	5.16	○							
	2QP-DNGA150608	2	2.1	0.8	12.7	6.35	5.16	○							
	2QP-DNGA150612	2	2.0	1.2	12.7	6.35	5.16	○							
2QP-DNGA-L**	**2QP-DNGA150404-L**	2	2.5	0.4	12.7	4.76	5.16			○					
	2QP-DNGA150408-L	2	2.1	0.8	12.7	4.76	5.16			○					
	2QP-DNGA150412-L	2	2.0	1.2	12.7	4.76	5.16			○					
	2QP-DNGA150604-L	2	2.5	0.4	12.7	6.35	5.16			○					
	2QP-DNGA150608-L	2	2.1	0.8	12.7	6.35	5.16			○					
	2QP-DNGA150612-L	2	2.0	1.2	12.7	6.35	5.16			○					
2QP-DNGA-LF**	**2QP-DNGA150404-LF**	2	2.5	0.4	12.7	4.76	5.16				○				
	2QP-DNGA150408-LF	2	2.1	0.8	12.7	4.76	5.16				○				
	2QP-DNGA150412-LF	2	2.0	1.2	12.7	4.76	5.16				○				
	2QP-DNGA150604-LF	2	2.5	0.4	12.7	6.35	5.16				○				
	2QP-DNGA150608-LF	2	2.1	0.8	12.7	6.35	5.16				○				
	2QP-DNGA150612-LF	2	2.0	1.2	12.7	6.35	5.16				○				
2QP-DNGA-LC**	**2QP-DNGA150404-LC**	2	2.5	0.4	12.7	4.76	5.16					○			
	2QP-DNGA150408-LC	2	2.1	0.8	12.7	4.76	5.16					○			
	2QP-DNGA150412-LC	2	2.0	1.2	12.7	4.76	5.16					○			
	2QP-DNGA150604-LC	2	2.5	0.4	12.7	6.35	5.16					○			
	2QP-DNGA150608-LC	2	2.1	0.8	12.7	6.35	5.16					○			
	2QP-DNGA150612-LC	2	2.0	1.2	12.7	6.35	5.16					○			
2QP-DNGA-H**	**2QP-DNGA150404-H**	2	2.5	0.4	12.7	4.76	5.16						○		
	2QP-DNGA150408-H	2	2.1	0.8	12.7	4.76	5.16						○		
	2QP-DNGA150412-H	2	2.0	1.2	12.7	4.76	5.16						○		
	2QP-DNGA150604-H	2	2.5	0.4	12.7	6.35	5.16						○		
	2QP-DNGA150608-H	2	2.1	0.8	12.7	6.35	5.16						○		
	2QP-DNGA150612-H	2	2.0	1.2	12.7	6.35	5.16						○		
2QP-DNGAWJ**	**2QP-DNGA150404WJ**	2	2.5	0.4	12.7	4.76	5.16							○	
	2QP-DNGA150408WJ	2	2.1	0.8	12.7	4.76	5.16							○	

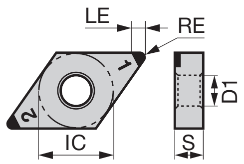
● Lagerstandard

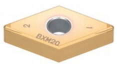
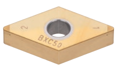
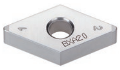
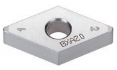
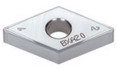
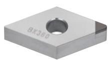
*Siehe Seite **B199** bezüglich Details zu empfohlenen Werkzeughaltern für Wiper-Wendeschneidplatten mit Bezeichnungen, die auf W, WL und WJ enden.

Halter / Außendrehen → C042 -
J-Serie Werkzeughalter → G046 -
Halter /Innendrehen → D052 -

● : Kontinuierlicher Schnitt
◐ : Leicht unterbrochener Schnitt
✠ : Stark unterbrochener Schnitt

		BXM10	BXM20	BXA20	BXC50	BX360
P	Stahl					
M	Rostfreier Stahl					
K	Eisenguss					
N	Nichteisenmetalle					
S	Hitzebest. Legierungen					
H	Gehärteter Stahl	●	●◐	●◐	✠	●◐
	Sintermetalle					



	Katalog Nr.	BXM10	BXM20	BXA20	BXC50	BX360	Anzahl Schneiden	LE	RE	IC	S	D1	Standard	Scharfe Schneidkante	L	LF	LC	H	Wiper	Spanformstufe
2QP-DNGM-H***	2QP-DNGM150408-HF		●				2	2.1	0.8	12.7	4.76	5.16								○
	2QP-DNGM150412-HF		●				2	2.0	1.2	12.7	4.76	5.16								○
	2QP-DNGM150408-HM		●				2	2.1	0.8	12.7	4.76	5.16								○
	2QP-DNGM150412-HM		●				2	2.0	1.2	12.7	4.76	5.16								○
	2QP-DNGM150404-HP	●		●			2	2.5	0.4	12.7	4.76	5.16								○
	2QP-DNGM150408-HP	●		●			2	2.1	0.8	12.7	4.76	5.16								○
	2QP-DNGM150608-HP	●		●			2	2.1	0.8	12.7	6.35	5.16								○
4QP-DNGA	4QP-DNGA150404				●		4	2.5	0.4	12.7	4.76	5.16	○							
	4QP-DNGA150408				●		4	2.1	0.8	12.7	4.76	5.16	○							
	4QP-DNGA150412				●		4	2.0	1.2	12.7	4.76	5.16	○							
4QS-DNGA	4QS-DNGA150408			●			4	2.1	0.8	12.7	4.76	5.16	○							
	4QS-DNGA150412			●			4	2.0	1.2	12.7	4.76	5.16	○							
4QS-DNGA-H**	4QS-DNGA150408-H			●			4	1.6	0.8	12.7	4.76	5.16						○		
	4QS-DNGA150412-H			●			4	1.6	1.2	12.7	4.76	5.16						○		
4QS-DNGG-HM**	4QS-DNGG150408-HM			●			4	1.6	0.8	12.7	4.76	5.16								○
																				
DNGA-QBN**	DNGA150402-QBN					●	1	4.3	0.2	12.7	4.76	5.16	○							
	DNGA150404-QBN					●	1	4.1	0.4	12.7	4.76	5.16	○							
	DNGA150408-QBN					●	1	3.8	0.8	12.7	4.76	5.16	○							
	DNGA150412-QBN					●	1	3.4	1.2	12.7	4.76	5.16	○							

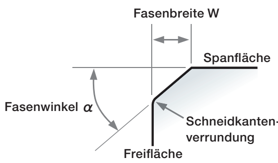
Größe (mm): Anzahl Schneiden, LE, RE, IC, S, D1 — Mikrogeometrie: Standard, Scharfe Schneidkante, L, LF, LC, H

*Siehe Seite **B195** bezüglich Details zu empfohlenen Werkzeughaltern für Wiper-Wendeschneidplatten mit Bezeichnungen, die auf W, WL und WJ enden.

● Lagerstandard

Mikrogeometrie

	BXM10 BX310 BX330 BX480	BXA20	BXM20	BX360 BX380	BX470	BX910 BX930 BXC50	BXC90
Standard	S01325	S01325	S01325	S01325	T01315	S01325	T02020
Scharfe Schneidkante	-	-	-	-	F	-	-
-L	S01315	S01315	S01315	-	-	-	-
-LF	-	S00515	-	-	-	-	-
-LC	-	S00535	-	-	-	-	-
-H	-	S01835	S01835	S01335	-	-	-
Wiper	S01315	S01315	S01315	-	-	-	-



S 0 1 3 2 5

Form — Fasenbreite (W) (mm) — Fasenwinkel α

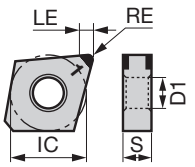
T … Gefast
S … Gefast + verrundet
E … Verrundet
F … Scharfkantig

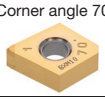
Halter / Innendrehen → D052 -

CBN Wendeschneidplatten NEGATIV

● : Kontinuierlicher Schnitt
ᑕ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

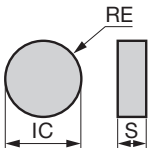
		BXM10	BXM20	BXA20	BX360	BX470	BX930
P	Stahl						
M	Rostfreier Stahl						
K	Eisenguss					●ᑕ	●ᑕ
N	Nichteisenmetalle						
S	Hitzebest. Legierungen						
H	Gehärteter Stahl	●	●ᑕ	●ᑕ	●ᑕ		
	Sintermetalle					●ᑕ	



Katalog Nr.		Größe (mm)						Mikrogeometrie							
		Anzahl Schneiden	LE	RE	IC	S	D1	Standard	Scharfe Schneidkante	L	LF	LC	H	Wiper	Spanformstufe
2QP-GNGA	*2QP-GNGA120404	2	2.3	0.4	12.7	4.76	5.16	○							
(Corner angle 70°)	*2QP-GNGA120408	2	2.2	0.8	12.7	4.76	5.16	○							
	*2QP-GNGA120412	2	2.4	1.2	12.7	4.76	5.16	○							
2QP-GNGA-L**	*2QP-GNGA120404-L	2	2.3	0.4	12.7	4.76	5.16			○					
	*2QP-GNGA120408-L	2	2.2	0.8	12.7	4.76	5.16			○					
	*2QP-GNGA120412-L	2	2.4	1.2	12.7	4.76	5.16			○					
2QP-GNGA-LF**	*2QP-GNGA120404-LF	2	2.3	0.4	12.7	4.76	5.16				○				
	*2QP-GNGA120408-LF	2	2.2	0.8	12.7	4.76	5.16				○				
	*2QP-GNGA120412-LF	2	2.4	1.2	12.7	4.76	5.16				○				
2QP-GNGA-LC**	*2QP-GNGA120404-LC	2	2.3	0.4	12.7	4.76	5.16					○			
	*2QP-GNGA120408-LC	2	2.2	0.8	12.7	4.76	5.16					○			
	*2QP-GNGA120412-LC	2	2.4	1.2	12.7	4.76	5.16					○			
2QP-GNGA-H**	*2QP-GNGA120404-H	2	2.3	0.4	12.7	4.76	5.16						○		
	*2QP-GNGA120408-H	2	2.2	0.8	12.7	4.76	5.16						○		
	*2QP-GNGA120412-H	2	2.4	1.2	12.7	4.76	5.16						○		
2QP-GNGG-HP**	*2QP-GNGG120404-HP	2	2.1	0.4	12.7	4.76	5.16								○
(Corner angle 70°)	*2QP-GNGG120408-HP	2	2.1	0.8	12.7	4.76	5.16								○
	*2QP-GNGG120412-HP	2	2.2	1.2	12.7	4.76	5.16								○

* Tungaloy-Standard

		BXC90
P	Stahl	
M	Rostfreier Stahl	
K	Eisenguss	●ᑕ
N	Nichteisenmetalle	
S	Hitzebest. Legierungen	
H	Gehärteter Stahl	

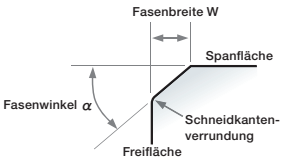


Katalog Nr.		Größe (mm)						Mikrogeometrie							
		Anzahl Schneiden	LE	RE	IC	S	D1	Standard	Scharfe Schneidkante	L	LF	LC	H	Wiper	Spanformstufe
S-RNGN	S-RNGN090300	-	-	-	9.525	3.18	-	○							
	S-RNGN120400	-	-	-	12.7	4.76	-	○							

● Lagerstandard

Mikrogeometrie

	BXM10 BX310 BX330 BX480	BXA20	BXM20	BX360 BX380	BX470	BX910 BX930 BXC50	BXC90
Standard	S01325	S01325	S01325	S01325	T01315	S01325	T02020
Scharfe Schneidkante	-	-	-	-	F	-	-
-L	S01315	S01315	S01315	-	-	-	-
-LF	-	S00515	-	-	-	-	-
-LC	-	S00535	-	-	-	-	-
-H	-	S01835	S01835	S01335	-	-	-
Wiper	S01315	S01315	S01315	-	-	-	-



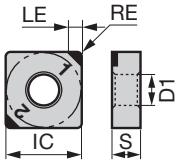
S	0	1	3	2	5
Form	Fasenbreite (W) (mm)			Fasenwinkel α	

T ··· Gefast
S ··· Gefast + verrundet
E ··· Verrundet
F ··· Scharfkantig

CBN Wendeschneidplatten NEGATIV

● : Kontinuierlicher Schnitt
ᑕ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

		BXM20	BXA20	BXC50	BX310	BX330	BX360	BX380	BX480	BX910	BX930	BXC90
P	Stahl	●ᑕ	●ᑕ	✣	●	●ᑕ	●ᑕ	✣				
M	Rostfreier Stahl											
K	Eisenguss								✣	●	●ᑕ	●ᑕ
N	Nichteisenmetalle											
S	Hitzebest. Legierungen											
H	Gehärteter Stahl	●ᑕ	●ᑕ	✣	●	●ᑕ	●ᑕ	✣				
	Sintermetalle								ᑕ✣			



	Katalog Nr.	Anzahl Schneiden	Größe (mm) LE	RE	IC	S	D1	Mikrogeometrie Standard	Scharfe Schneidkante	L	LF	LC	H	Wiper	Spanformstufe
2QP-SNGA	**2QP-SNGA120404**	2	2.4	0.4	12.7	4.76	5.16	○							
	2QP-SNGA120408	2	2.4	0.8	12.7	4.76	5.16	○							
	2QP-SNGA120412	2	2.4	1.2	12.7	4.76	5.16	○							
2QP-SNGA-L**	**2QP-SNGA120404-L**	2	2.4	0.4	12.7	4.76	5.16			○					
	2QP-SNGA120408-L	2	2.4	0.8	12.7	4.76	5.16			○					
	2QP-SNGA120412-L	2	2.4	1.2	12.7	4.76	5.16			○					
2QP-SNGA-LF**	**2QP-SNGA120408-LF**	2	2.4	0.8	12.7	4.76	5.16				○				
	2QP-SNGA120412-LF	2	2.4	1.2	12.7	4.76	5.16				○				
2QP-SNGA-H**	**2QP-SNGA120404-H**	2	2.4	0.4	12.7	4.76	5.16						○		
	2QP-SNGA120408-H	2	2.4	0.8	12.7	4.76	5.16						○		
	2QP-SNGA120412-H	2	2.4	1.2	12.7	4.76	5.16						○		
4QP-SNGA	**4QP-SNGA120404**	4	2.4	0.4	12.7	4.76	5.16	○							
	4QP-SNGA120408	4	2.4	0.8	12.7	4.76	5.16	○							
	4QP-SNGA120412	4	2.4	1.2	12.7	4.76	5.16	○							
SNGA-QBN**	**SNGA120402-QBN**	1	4.1	0.2	12.7	4.76	5.16	○							
	SNGA120404-QBN	1	4.1	0.4	12.7	4.76	5.16	○							
	SNGA120408-QBN	1	4.1	0.8	12.7	4.76	5.16	○							
	SNGA120412-QBN	1	4.1	1.2	12.7	4.76	5.16	○							
2QP-SNGN	**2QP-SNGN090308**	2	2.4	0.8	9.525	3.18	-	○							
	2QP-SNGN090312	2	2.4	1.2	9.525	3.18	-	○							
S-SNGN	**S-SNGN090308**	8	-	0.8	9.525	3.18	-	○							
	S-SNGN090312	8	-	1.2	9.525	3.18	-	○							
	S-SNGN120308	8	-	0.8	12.7	3.18	-	○							
	S-SNGN120312	8	-	1.2	12.7	3.18	-	○							
	S-SNGN120408	8	-	0.8	12.7	4.76	-	○							
	S-SNGN120412	8	-	1.2	12.7	4.76	-	○							

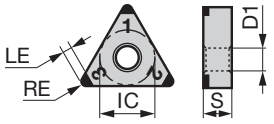
● Lagerstandard

Halter / Außendrehen → C093 -
Halter / Innendrehen → D040 -
Kassetten → K197 -

CBN Wendeschneidplatten NEGATIV

● : Kontinuierlicher Schnitt
ᑕ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

		BXM10	BXM20	BXA20	BX310	BX330	BX360	BX380	BX470	BX480	BX930
P	Stahl								●ᑕ	✣	●ᑕ
M	Rostfreier Stahl										
K	Eisenguss										
N	Nichteisenmetalle										
S	Hitzebest. Legierungen										
H	Gehärteter Stahl	●	●ᑕ	●ᑕ	●	●ᑕ	●ᑕ	✣			
	Sintermetalle								●ᑕ	●ᑕ✣	



Katalog Nr.		BXM10	BXM20	BXA20	BX310	BX330	BX360	BX380	BX470	BX480	BX930	Größe (mm) Anzahl Schneiden	LE	RE	IC	S	D1	Mikrogeometrie Standard	Scharfe Schneidkante	L	LF	LC	H	Wiper	Spanformstufe
3QP-TNGA	**3QP-TNGA160404**	●	●	●	●	●	●	●	●	●	●	3	2.2	0.4	9.525	4.76	3.81	○							
	3QP-TNGA160408	●	●	●	●	●	●	●	●	●	●	3	1.9	0.8	9.525	4.76	3.81	○							
	3QP-TNGA160412	●	●	●	●	●	●	●	●	●	●	3	2.4	1.2	9.525	4.76	3.81	○							
	3QP-TNGA160416			●								3	3.3	1.6	9.525	4.76	3.81	○							
	3QP-TNGA160420			●								3	3.0	2.0	9.525	4.76	3.81	○							
	3QP-TNGA160424			●								3	2.7	2.4	9.525	4.76	3.81	○							
T3QP-TNGA	**T3QP-TNGA160404**						●					3	2.2	0.4	9.525	4.76	3.81	○							
	T3QP-TNGA160408						●					3	1.9	0.8	9.525	4.76	3.81	○							
3QP-TNGAF**	**3QP-TNGA160404F**								●			3	2.2	0.4	9.525	4.76	3.81		○						
	3QP-TNGA160408F								●			3	1.9	0.8	9.525	4.76	3.81		○						
3QP-TNGA-L**	**3QP-TNGA160404-L**	●	●	●		●						3	2.2	0.4	9.525	4.76	3.81			○					
	3QP-TNGA160408-L	●	●	●		●						3	1.9	0.8	9.525	4.76	3.81			○					
	3QP-TNGA160412-L	●	●	●		●						3	2.4	1.2	9.525	4.76	3.81			○					
3QP-TNGA-LF**	**3QP-TNGA160404-LF**			●								3	2.2	0.4	9.525	4.76	3.81				○				
	3QP-TNGA160408-LF			●								3	1.9	0.8	9.525	4.76	3.81				○				
	3QP-TNGA160412-LF			●								3	2.4	1.2	9.525	4.76	3.81				○				
3QP-TNGA-LC**	**3QP-TNGA160404-LC**			●								3	2.2	0.4	9.525	4.76	3.81					○			
	3QP-TNGA160408-LC			●								3	1.9	0.8	9.525	4.76	3.81					○			
	3QP-TNGA160412-LC			●								3	2.4	1.2	9.525	4.76	3.81					○			
3QP-TNGA-H**	**3QP-TNGA160404-H**		●	●	●		●	●				3	2.2	0.4	9.525	4.76	3.81						○		
	3QP-TNGA160408-H		●	●			●	●				3	1.9	0.8	9.525	4.76	3.81						○		
	3QP-TNGA160412-H		●	●			●	●				3	2.4	1.2	9.525	4.76	3.81						○		
3QP-TNGAWG**	**3QP-TNGA160404WG**		●	●								3	2.2	0.4	9.525	4.76	3.81							○	
	3QP-TNGA160408WG	●	●	●								3	1.9	0.8	9.525	4.76	3.81							○	
3QP-TNGM-H***	**3QP-TNGM160408-HF**		●									3	1.9	0.8	9.525	4.76	3.81								○
	3QP-TNGM160412-HF		●									3	2.4	1.2	9.525	4.76	3.81								○
	3QP-TNGM160408-HM		●									3	1.9	0.8	9.525	4.76	3.81								○
	3QP-TNGM160412-HM		●									3	2.2	1.2	9.525	4.76	3.81								○
	3QP-TNGM160404-HP	●		●								3	2.2	0.4	9.525	4.76	3.81								○
	3QP-TNGM160408-HP	●		●								3	1.9	0.8	9.525	4.76	3.81								○

*Bezeichnung beginnend mit „T“ = 10 Stück pro Packung.
Siehe Seite **B199** bezüglich Details zu empfohlenen Werkzeughaltern für Wiper-Wendeschneidplatten mit Bezeichnungen, die auf WG enden.

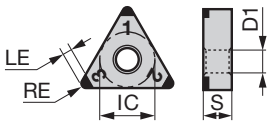
● Lagerstandard

Halter / Außendrehen → C115 -
J-Serie Werkzeughalter → G047 -
Kassetten → K193 -
Halter / Innendrehen → D046 -
TungCap → K014 -

CBN Wendeschneidplatten NEGATIV

● : Kontinuierlicher Schnitt
ᑕ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

		BXA20	BXC50	BX360	BXC90
P	Stahl				
M	Rostfreier Stahl				
K	Eisenguss				●ᑕ
N	Nichteisenmetalle				
S	Hitzebest. Legierungen				
H	Gehärteter Stahl	●ᑕ	✣	●ᑕ	
	Sintermetalle				

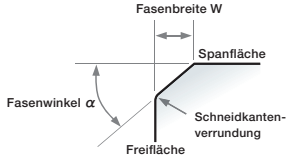


	Katalog Nr.	Anzahl Schneiden	LE	RE	IC	S	D1	Standard	Scharfe Schneidkante	L	LF	LC	H	Wiper	Spanformstufe
			Größe (mm)					Mikrogeometrie							
6QP-TNGA	**6QP-TNGA160404**	6	2.2	0.4	9.525	4.76	3.81	○							
	6QP-TNGA160408	6	1.9	0.8	9.525	4.76	3.81	○							
	6QP-TNGA160412	6	2.4	1.2	9.525	4.76	3.81	○							
6QS-TNGA	**6QS-TNGA160408**	6	1.9	0.8	9.525	4.76	3.81	○							
	6QS-TNGA160412	6	2.4	1.2	9.525	4.76	3.81	○							
6QS-TNGA-H**	**6QS-TNGA160408-H**	6	1.6	0.8	9.525	4.76	3.81						○		
	6QS-TNGA160412-H	6	1.8	1.2	9.525	4.76	3.81						○		
6QS-TNGG-HM**	**6QS-TNGG160408-HM**	6	1.6	0.8	9.525	4.76	3.81								○
	6QS-TNGG160412-HM	6	1.8	1.2	9.525	4.76	3.81								○
TNGA-QBN**	**TNGA160402-QBN**	1	4.4	0.2	9.525	4.76	3.81	○							
	TNGA160404-QBN	1	4.2	0.4	9.525	4.76	3.81	○							
	TNGA160408-QBN	1	4.0	0.8	9.525	4.76	3.81	○							
	TNGA160412-QBN	1	3.7	1.2	9.525	4.76	3.81	○							
S-TNGN	**S-TNGN110308**	6	-	0.8	6.35	3.18	-	○							
	S-TNGN110312	6	-	1.2	6.35	3.18	-	○							
	S-TNGN160408	6	-	0.8	9.525	4.76	-	○							
	S-TNGN160412	6	-	1.2	9.525	4.76	-	○							

● Lagerstandard

Mikrogeometrie

	BXM10 BX310 BX330 BX480	BXA20	BXM20	BX360 BX380	BX470	BX910 BX930 BXC50	BXC90
Standard	S01325	S01325	S01325	S01325	T01315	S01325	T02020
Scharfe Schneidkante	-	-	-	-	F	-	-
-L	S01315	S01315	S01315	-	-	-	-
-LF	-	S00515	-	-	-	-	-
-LC	-	S00535	-	-	-	-	-
-H	-	S01835	S01835	S01335	-	-	-
Wiper	S01315	S01315	S01315	-	-	-	-



S	0	1	3	2	5
Form	Fasenbreite (W) (mm)			Fasenwinkel α	

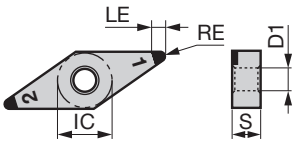
T ··· Gefast
S ··· Gefast + verrundet
E ··· Verrundet
F ··· Scharfkantig

Halter / Außendrehen → C115 -
J-Serie Werkzeughalter → G047 -
Kassetten → K193 -
Halter / Innendrehen → D046 -
TungCap → K014 -

CBN Wendeschneidplatten NEGATIV

● : Kontinuierlicher Schnitt
ᑕ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

		BXM10	BXM20	BXA20	BXC50	BX310	BX330	BX360	BX380	BX470	BX480	BX930
P	Stahl											
M	Rostfreier Stahl											
K	Eisenguss									●ᑕ	✣	●ᑕ
N	Nichteisenmetalle											
S	Hitzebest. Legierungen											
H	Gehärteter Stahl	●	●ᑕ	●ᑕ	✣	●	●ᑕ	●ᑕ	✣			
	Sintermetalle									●ᑕ	●✣	



Katalog Nr.		BXM10	BXM20	BXA20	BXC50	BX310	BX330	BX360	BX380	BX470	BX480	BX930	Größe (mm) Anzahl Schneiden	LE	RE	IC	S	D1	Mikrogeometrie Standard	Scharfe Schneidkante	L	LF	LC	H	Wiper	Spanformstufe
2QP-VNGA	2QP-VNGA160404	●	●	●		●	●	●	●	●	●	●	2	3.1	0.4	9.525	4.76	3.81	○							
	2QP-VNGA160408	●	●	●		●	●	●	●	●	●	●	2	2.2	0.8	9.525	4.76	3.81	○							
	2QP-VNGA160412			●									2	3.0	1.2	9.525	4.76	3.81	○							
2QP-VNGA-L**	2QP-VNGA160404-L	●	●	●			●						2	3.1	0.4	9.525	4.76	3.81			○					
	2QP-VNGA160408-L	●	●	●			●						2	2.2	0.8	9.525	4.76	3.81			○					
	2QP-VNGA160412-L			●									2	3.0	1.2	9.525	4.76	3.81			○					
2QP-VNGA-LF**	2QP-VNGA160404-LF			●									2	3.1	0.4	9.525	4.76	3.81				○				
	2QP-VNGA160408-LF			●									2	2.2	0.8	9.525	4.76	3.81				○				
	2QP-VNGA160412-LF			●									2	3.0	1.2	9.525	4.76	3.81				○				
2QP-VNGA-LC**	2QP-VNGA160404-LC			●									2	3.1	0.4	9.525	4.76	3.81					○			
	2QP-VNGA160408-LC			●									2	2.2	0.8	9.525	4.76	3.81					○			
	2QP-VNGA160412-LC			●									2	3.0	1.2	9.525	4.76	3.81					○			
2QP-VNGA-H**	2QP-VNGA160404-H		●	●				●	●				2	3.1	0.4	9.525	4.76	3.81						○		
	2QP-VNGA160408-H		●	●				●	●				2	2.2	0.8	9.525	4.76	3.81						○		
	2QP-VNGA160412-H			●									2	3.0	1.2	9.525	4.76	3.81						○		
2QP-VNGM-H***	2QP-VNGM160408-HF		●										2	2.2	0.8	9.525	4.76	3.81								○
	2QP-VNGM160408-HM		●										2	2.4	0.8	9.525	4.76	3.81								○
	2QP-VNGM160408-HP	●		●									2	2.2	0.8	9.525	4.76	3.81								○
4QP-VNGA	4QP-VNGA160404				●								4	3.1	0.4	9.525	4.76	3.81	○							
	4QP-VNGA160408				●								4	2.2	0.8	9.525	4.76	3.81	○							
4QS-VNGA	4QS-VNGA160408			●									4	1.7	0.8	9.525	4.76	3.81	○							
4QS-VNGA-H**	4QS-VNGA160408-H			●									4	1.7	0.8	9.525	4.76	3.81						○		
4QS-VNGG-HM**	4QS-VNGG160408-HM			●									4	1.7	0.8	9.525	4.76	3.81								○

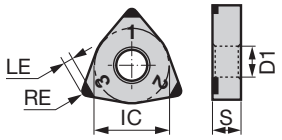
● Lagerstandard

Halter / Außendrehen → C059 -
TungCap → K015 -
Halter / Innendrehen → D070 -

CBN Wendeschneidplatten NEGATIV

● : Kontinuierlicher Schnitt
ᑕ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

		BXM10	BXM20	BXA20	BXC50	BX310	BX330	BX360	BX380	BX480	BX930			Größe (mm)						Mikrogeometrie								
	Katalog Nr.													Anzahl Schneiden	LE	RE	IC	S	D1	Standard	Scharfe Schneidkante	L	LF	CL	H	Wiper	Spanformstufe
3QP-WNGA	**3QP-WNGA080404**			●										3	2.3	0.4	12.7	4.76	5.16	○							
	3QP-WNGA080408	●	●	●		●	●	●	●	●	●			3	2.2	0.8	12.7	4.76	5.16	○							
	3QP-WNGA080412			●										3	2.4	1.2	12.7	4.76	5.16	○							
3QP-WNGA-L**	**3QP-WNGA080408-L**			●										3	2.2	0.8	12.7	4.76	5.16			○					
3QP-WNGA-LF**	**3QP-WNGA080408-LF**			●										3	2.2	0.8	12.7	4.76	5.16				○				
3QP-WNGA-H**	**3QP-WNGA080408-H**			●										3	2.2	0.8	12.7	4.76	5.16						○		
3QP-WNGAWL**	**3QP-WNGA080408WL**	●	●	●										3	2.2	0.8	12.7	4.76	5.16	○						○	
6QP-WNGA	**6QP-WNGA080404**				●									6	2.3	0.4	12.7	4.76	5.16	○							
	6QP-WNGA080408				●									6	2.2	0.8	12.7	4.76	5.16	○							
6QS-WNGA	**6QS-WNGA080408**			●										6	1.5	0.8	12.7	4.76	5.16	○							
6QS-WNGA-H**	**6QS-WNGA080408-H**			●										6	1.5	0.8	12.7	4.76	5.16						○		

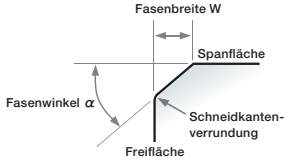


*Siehe Seite **B199** bezüglich Details zu empfohlenen Werkzeughaltern für Wiper-Wendeschneidplatten mit Bezeichnungen, die auf WL enden.

● Lagerstandard

Mikrogeometrie

	BXM10 BX310 BX330 BX480	BXA20	BXM20	BX360 BX380	BX470	BX910 BX930 BXC50	BXC90
Standard	S01325	S01325	S01325	S01325	T01315	S01325	T02020
Scharfe Schneidkante	-	-	-	-	F	-	-
-L	S01315	S01315	S01315	-	-	-	-
-LF	-	S00515	-	-	-	-	-
-LC	-	S00535	-	-	-	-	-
-H	-	S01835	S01835	S01335	-	-	-
Wiper	S01315	S01315	S01315	-	-	-	-



S	0	1	3	2	5
Form	Fasenbreite (W) (mm)			Fasenwinkel α	

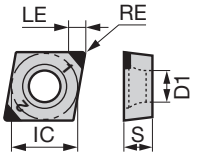
T ··· Gefast
S ··· Gefast + verrundet
E ··· Verrundet
F ··· Scharfkantig

Halter / Außendrehen → C034 -
TungCap → C035 -, K011 -
Halter / Innendrehen → D031 -

CBN Wendeschneidplatten POSITIV

● : Kontinuierlicher Schnitt
ⓒ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

		BXM10	BXM20	BXA20	BX310	BX330	BX360	BX470	BX480	BX930
P	Stahl							●ⓒ	✣	●ⓒ
M	Rostfreier Stahl							●ⓒ		
K	Eisenguss	●	●ⓒ	●ⓒ	●	●ⓒ	●ⓒ			
N	Nichteisenmetalle							●ⓒ	✣	
S	Hitzebest. Legierungen							●ⓒ	✣	
H	Gehärteter Stahl									
	Sintermetalle									



	Katalog Nr.	Anzahl Schneiden	LE	RE	IC	S	D1	Schliff: Standard	Schliff: Scharfe Schneidkante	Schliff: L	Schliff: LF	Schliff: LC	Schliff: H	Wiper	Spanformstufe
		Größe (mm)						Schliff							
2QP-CCGW	2QP-CCGW060202	2	2.3	0.2	6.35	2.38	2.8	○							
	2QP-CCGW060204	2	2.3	0.4	6.35	2.38	2.8	○							
	2QP-CCGW060208	2	2.2	0.8	6.35	2.38	2.8	○							
	2QP-CCGW09T304	2	2.3	0.4	9.525	3.97	4.4	○							
	2QP-CCGW09T308	2	2.2	0.8	9.525	3.97	4.4	○							
2QP-CCGW**-L	2QP-CCGW060204-L	2	2.3	0.4	6.35	2.38	2.8			○					
	2QP-CCGW060208-L	2	2.2	0.8	6.35	2.38	2.8			○					
	2QP-CCGW09T304-L	2	2.3	0.4	9.525	3.97	4.4			○					
	2QP-CCGW09T308-L	2	2.2	0.8	9.525	3.97	4.4			○					
2QP-CCGW**-LF	2QP-CCGW060204-LF	2	2.3	0.4	6.35	2.38	2.8				○				
	2QP-CCGW060208-LF	2	2.2	0.8	6.35	2.38	2.8				○				
	2QP-CCGW09T304-LF	2	2.3	0.4	9.525	3.97	4.4				○				
	2QP-CCGW09T308-LF	2	2.2	0.8	9.525	3.97	4.4				○				
2QP-CCGW**-LC	2QP-CCGW060204-LC	2	2.3	0.4	6.35	2.38	2.8					○			
	2QP-CCGW060208-LC	2	2.2	0.8	6.35	2.38	2.8					○			
	2QP-CCGW09T304-LC	2	2.3	0.4	9.525	3.97	4.4					○			
	2QP-CCGW09T308-LC	2	2.2	0.8	9.525	3.97	4.4					○			
2QP-CCGW**-H	2QP-CCGW09T304-H	2	2.3	0.4	9.525	3.97	4.4						○		
	2QP-CCGW09T308-H	2	2.2	0.8	9.525	3.97	4.4						○		
2QP-CCGW**WL	2QP-CCGW09T304WL	2	2.3	0.4	9.525	3.97	4.4	○						○	
	2QP-CCGW09T308WL	2	2.2	0.8	9.525	3.97	4.4	○						○	
2QP-CCGT**-HP	2QP-CCGT060204-HP	2	2.3	0.4	6.35	2.38	2.8								○
	2QP-CCGT09T304-HP	2	2.3	0.4	9.525	3.97	4.4								○
	2QP-CCGT09T308-HP	2	2.2	0.8	9.525	3.97	4.4								○
2QP-CCGT**WL-HP	2QP-CCGT09T304WL-HP	2	2.3	0.4	9.525	3.97	4.4							○	○
	2QP-CCGT09T308WL-HP	2	2.2	0.8	9.525	3.97	4.4							○	○

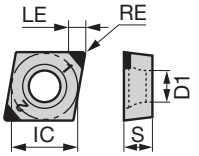
● Lagerstandard

Halter / Außendrehen → C024 -
J-Serie Werkzeughalter → G019 -
Halter / Innendrehen → D014 -
PINZBOHR® → K180 -

CBN Wendeschneidplatten POSITIV

● : Kontinuierlicher Schnitt
ᑕ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

		BXM10	BXM20	BXA20	BX310	BX330	BX360	BX470	BX480	BX930
P	Stahl				●	●ᑕ	●ᑕ			
M	Rostfreier Stahl				●	●ᑕ	●ᑕ			
K	Eisenguss							●ᑕ	✣	●ᑕ
N	Nichteisenmetalle									
S	Hitzebest. Legierungen									
H	Gehärteter Stahl	●	●ᑕ	●ᑕ	●	●ᑕ	●ᑕ			
	Sintermetalle							●ᑕ	✣	



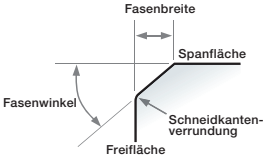
	Katalog Nr.	Größe (mm) Anzahl Schneiden	LE	RE	IC	S	D1	Schliff Standard	Scharfkantig	L	LF	LC	H	Wiper	Spanformstufe
2QP-CCMW	**2QP-CCMW060202**	2	2.3	0.2	6.35	2.38	2.8	○							
	2QP-CCMW060204	2	2.3	0.4	6.35	2.38	2.8	○							
	2QP-CCMW09T304	2	2.3	0.4	9.525	3.97	4.4	○							
	2QP-CCMW09T308	2	2.2	0.8	9.525	3.97	4.4	○							
Q-CCMW	**Q-CCMW060204**	1	2.5	0.4	6.35	2.38	2.8	○							
	Q-CCMW09T304	1	2.5	0.4	9.525	3.97	4.4	○							
1QP-CCGW	**1QP-CCGW03X102**	1	1.4	0.2	3.57	1.39	1.9	○							
	1QP-CCGW03X104	1	1.3	0.4	3.57	1.39	1.9	○							
	1QP-CCGW04T102	1	1.9	0.2	4.37	1.79	2.3	○							
	1QP-CCGW04T104	1	1.8	0.4	4.37	1.79	2.3	○							
2QP-CPGW	**2QP-CPGW080204**	2	2.3	0.4	7.94	2.38	3.4	○							
	2QP-CPGW080208	2	2.2	0.8	7.94	2.38	3.4	○							
	2QP-CPGW090304	2	2.3	0.4	9.525	3.18	4.4	○							
	2QP-CPGW090308	2	2.2	0.8	9.525	3.18	4.4	○							
CPGA-QBN**	**CPGA090204-QBN**	1	4.0	0.4	9.525	2.38	4.0	○							
	CPGA090208-QBN	1	3.8	0.8	9.525	2.38	4.0	○							

Q-CCMW: 2 Stück pro Packung

● Lagerstandard

Standardmikrogeometrie

	BXM10 BX310 BX330 BX480	BXA20	BXM20	BX360 BX380	BX470	BX910 BX930 BXC50	BXC90
Standard	S01325	S01325	S01325	S01325	T01315	S01325	T02020
Scharfkantig	-	-	-	-	F	-	-
-L	S01315	S01315	S01315	-	-	-	-
-LF	-	S00515	-	-	-	-	-
-LC	-	S00535	-	-	-	-	-
-H	-	S01835	S01835	S01335	-	-	-
Wiper	S01315	S01315	S01315	-	-	-	-



S	0	1	3	2	5
Form	Fasenbreite (W) (mm)			Fasenwinkel α	

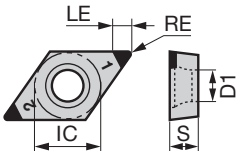
T … Gefast
S … Gefast + verrundet
E … Verrundet
F … Scharfkantig

Halter / Außendrehen → C024 -
Halter / Innendrehen → D014 -
J-Serie Werkzeughalter → G019 -
PINZBOHR® → K180 -

CBN Wendeschneidplatten POSITIV

● : Kontinuierlicher Schnitt
ɔ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

		BXM10	BXM20	BXA20	BX310	BX330	BX360	BX470	BX480	BX930
P	Stahl									
M	Rostfreier Stahl									
K	Eisenguss							●ɔ	✣	●ɔ
N	Nichteisenmetalle									
S	Hitzebest. Legierungen									
H	Gehärteter Stahl	●	●ɔ	●ɔ	●	●ɔ	●ɔ			
	Sintermetalle							●ɔ	ɔ✣	



	Katalog Nr.	Größe (mm) Anzahl Schneiden	LE	RE	IC	S	D1	Schliff Standard	Scharfkantig	L	LF	LC	H	Wiper	Spanformstufe
2QP-DCGW	**2QP-DCGW070202**	2	2.7	0.2	6.35	2.38	2.8	○							
	2QP-DCGW070204	2	2.5	0.4	6.35	2.38	2.8	○							
	2QP-DCGW070208	2	2.5	0.8	6.35	2.38	2.8	○							
	2QP-DCGW11T302	2	2.7	0.2	9.525	3.97	4.4	○							
	2QP-DCGW11T304	2	2.5	0.4	9.525	3.97	4.4	○							
	2QP-DCGW11T308	2	2.1	0.8	9.525	3.97	4.4	○							
2QP-DCGW-L**	**2QP-DCGW070204-L**	2	2.5	0.4	6.35	2.38	2.8			○					
	2QP-DCGW070208-L	2	2.5	0.8	6.35	2.38	2.8			○					
	2QP-DCGW11T304-L	2	2.5	0.4	9.525	3.97	4.4			○					
	2QP-DCGW11T308-L	2	2.1	0.8	9.525	3.97	4.4			○					
2QP-DCGW-LF**	**2QP-DCGW070204-LF**	2	2.5	0.4	6.35	2.38	2.8				○				
	2QP-DCGW070208-LF	2	2.5	0.8	6.35	2.38	2.8				○				
	2QP-DCGW11T304-LF	2	2.5	0.4	9.525	3.97	4.4				○				
	2QP-DCGW11T308-LF	2	2.1	0.8	9.525	3.97	4.4				○				
2QP-DCGW-LC**	**2QP-DCGW070204-LC**	2	2.5	0.4	6.35	2.38	2.8					○			
	2QP-DCGW070208-LC	2	2.5	0.8	6.35	2.38	2.8					○			
	2QP-DCGW11T304-LC	2	2.5	0.4	9.525	3.97	4.4					○			
	2QP-DCGW11T308-LC	2	2.1	0.8	9.525	3.97	4.4					○			
2QP-DCGW-H**	**2QP-DCGW11T304-H**	2	2.5	0.4	9.525	3.97	4.4						○		
	2QP-DCGW11T308-H	2	2.1	0.8	9.525	3.97	4.4						○		
2QP-DCGT-HP**	**2QP-DCGT070204-HP**	2	2.5	0.4	6.35	2.38	2.8								○
	2QP-DCGT11T304-HP	2	2.5	0.4	9.525	3.97	4.4								○
	2QP-DCGT11T308-HP	2	2.1	0.8	9.525	3.97	4.4								○

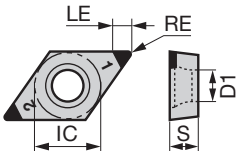
● Lagerstandard

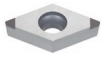
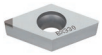
Halter / Außendrehen → C048 -
J-Serie Werkzeughalter → G026 -
Halter / Innendrehen → D048 -
PINZBOHR® → K184 -

CBN Wendeschneidplatten POSITIV

● : Kontinuierlicher Schnitt
ᑕ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

		BXM10	BXM20	BXA20	BX310	BX330	BX360	BX470	BX480	BX930
P	Stahl									
M	Rostfreier Stahl									
K	Eisenguss							●ᑕ	✣	●ᑕ
N	Nichteisenmetalle									
S	Hitzebest. Legierungen									
H	Gehärteter Stahl	●	●ᑕ	●ᑕ	●	●ᑕ	●ᑕ			
	Sintermetalle							●ᑕ	✣	



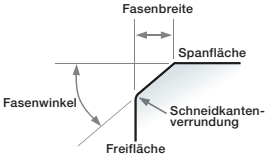
	Katalog Nr.	Anzahl Schneiden	LE	RE	IC	S	D1	Schliff: Standard	Schliff: Scharfkantig	L	LF	LC	H	Wiper	Spanformstufe
2QP-DCMW	**2QP-DCMW070202**	2	2.7	0.2	6.35	2.38	2.8	○							
	2QP-DCMW070204	2	2.5	0.4	6.35	2.38	2.8	○							
	**2QP-DCMW11T302**	2	2.7	0.2	9.525	3.97	4.4	○							
	2QP-DCMW11T304	2	2.5	0.4	9.525	3.97	4.4	○							
	2QP-DCMW11T308	2	2.1	0.8	9.525	3.97	4.4	○							
2QP-DCGWF**	**2QP-DCGW11T302F**	2	2.7	0.2	9.525	3.97	4.4		○						
	2QP-DCGW11T304F	2	2.5	0.4	9.525	3.97	4.4		○						
Q-DCMW	**Q-DCMW070204**	1	2.1	0.4	6.35	2.38	2.8	○							
	Q-DCMW11T304	1	2.1	0.4	9.525	3.97	4.4	○							
															

Q-DCMW: 2 Stück pro Packung

● Lagerstandard

Standardmikrogeometrie

	BXM10 BX310 BX330 BX480	BXA20	BXM20	BX360 BX380	BX470	BX910 BX930 BXC50	BXC90
Standard	S01325	S01325	S01325	S01325	T01315	S01325	T02020
Scharfkantig	-	-	-	-	F	-	-
-L	S01315	S01315	S01315	-	-	-	-
-LF	-	S00515	-	-	-	-	-
-LC	-	S00535	-	-	-	-	-
-H	-	S01835	S01835	S01335	-	-	-
Wiper	S01315	S01315	S01315	-	-	-	-



S	0	1	3	2	5
Form	Fasenbreite (W) (mm)			Fasenwinkel α	

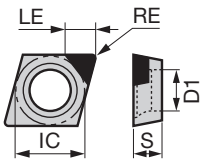
T … Gefast
S … Gefast + verrundet
E … Verrundet
F … Scharfkantig

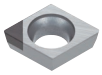
Halter / Außendrehen → C048 -
Halter / Innendrehen → D048 -
J-Serie Werkzeughalter → G026 -
PINZBOHR® → K184 -

CBN Wendeschneidplatten POSITIV

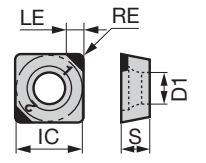
● : Kontinuierlicher Schnitt
ⓒ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

P	Stahl
M	Rostfreier Stahl
K	Eisenguss
N	Nichteisenmetalle
S	Hitzebest. Legierungen
H	Gehärteter Stahl
	Sintermetalle



	Katalog Nr.	BX310	BX470	Größe (mm) Anzahl Schneiden	LE	RE	IC	S	D1	Schliff Standard	Scharfkantig	L	LF	LC	H	Wiper	Spanformstufe
1QP-EPGW	**1QP-EPGW03X102**	●	●	1	1.4	0.2	3.57	1.39	1.9	○							
	1QP-EPGW03X104	●	●	1	1.3	0.4	3.57	1.39	1.9	○							
	1QP-EPGW040102	●	●	1	1.7	0.2	3.97	1.59	2.3	○							
	1QP-EPGW040104	●	●	1	1.6	0.4	3.97	1.59	2.3	○							

P	Stahl
M	Rostfreier Stahl
K	Eisenguss
N	Nichteisenmetalle
S	Hitzebest. Legierungen
H	Gehärteter Stahl
	Sintermetalle



	Katalog Nr.	BXM10	BXM20	BXA20	BX310	BX330	BX360	BX470	BX480	BX910	BX930	Größe (mm) Anzahl Schneiden	LE	RE	IC	S	D1	Schliff Standard	Scharfkantig	L	LF	LC	H	Wiper	Spanformstufe
2QP-SPGN	**2QP-SPGN090308**									●		2	2.4	0.8	9.525	3.18	-	○							
	2QP-SPGN090312									●		2	2.4	1.2	9.525	3.18	-	○							
2QP-SPMN	**2QP-SPMN090304**					●	●				●	2	2.4	0.4	9.525	3.18	-	○							
	2QP-SPMN090308					●	●				●	2	2.4	0.8	9.525	3.18	-	○							
Q-SPGN	**Q-SPGN090304**					●						1	2.8	0.4	9.525	3.18	-	○							
	Q-SPGN090308					●						1	2.8	0.8	9.525	3.18	-	○							
SPGN-QBN**	**SPGN090304-QBN**						●					1	4.1	0.4	9.525	3.18	-	○							
	SPGN090308-QBN						●					1	4.1	0.8	9.525	3.18	-	○							
	SPGN090312-QBN						●					1	4.1	1.2	9.525	3.18	-	○							
	SPGN120308-QBN						●					1	4.1	0.8	12.7	3.18	-	○							
	SPGN120312-QBN						●					1	4.1	1.2	12.7	3.18	-	○							
2QP-SPGW	**2QP-SPGW09T308**									●		2	2.4	0.8	9.525	3.97	4.4	○							
	2QP-SPGW09T312									●		2	2.4	1.2	9.525	3.97	4.4	○							
	2QP-SPGW120408									●		2	2.4	0.8	12.7	4.76	5.5	○							
	2QP-SPGW120412									●		2	2.4	1.2	12.7	4.76	5.5	○							
	2QP-SPGW120416									●		2	2.4	1.6	12.7	4.76	5.5	○							

Q-SPGN: 2 Stück pro Packung

● Lagerstandard

Halter / Innendrehen → D033 - PINZBOHR® → K197 -

CBN Wendeschneidplatten POSITIV

● : Kontinuierlicher Schnitt
ᑕ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

		BXM10	BXM20	BXA20	BX310	BX330	BX360	BX470	BX480	BX910	BX930
P	Stahl										
M	Rostfreier Stahl										
K	Eisenguss							●ᑕ	✣	●	●ᑕ
N	Nichteisenmetalle										
S	Hitzebest. Legierungen										
H	Gehärteter Stahl	●	●ᑕ	●ᑕ	●	●ᑕ	●ᑕ				
	Sintermetalle							●ᑕ	✣		

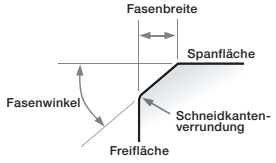
	Katalog Nr.	Anzahl Schneiden	LE	RE	IC	S	D1	Schliff: Standard	Schliff: Scharfkantig	L	LF	LC	H	Wiper	Spanformstufe
		Größe (mm)						Schliff							
3QP-TPGN	**3QP-TPGN110302**	3	2.3	0.2	6.35	3.18	-	○							
	3QP-TPGN110304	3	2.2	0.4	6.35	3.18	-	○							
	3QP-TPGN110308	3	2.2	0.8	6.35	3.18	-	○							
	3QP-TPGN110312	3	2.4	1.2	6.35	3.18	-	○							
	3QP-TPGN160304	3	2.2	0.4	9.525	4.76	-	○							
	3QP-TPGN160308	3	1.9	0.8	9.525	4.76	-	○							
3QP-TPMN	**3QP-TPMN110302**	3	2.3	0.2	6.35	3.18	-	○							
	3QP-TPMN110304	3	2.2	0.4	6.35	3.18	-	○							
	3QP-TPMN110308	3	1.9	0.8	6.35	3.18	-	○							
	3QP-TPMN160304	3	2.2	0.4	9.525	3.18	-	○							
	3QP-TPMN160308	3	1.9	0.8	9.525	3.18	-	○							
Q-TPGN	**Q-TPGN110304**	1	2.2	0.4	6.35	3.18	-	○							
	Q-TPGN110308	1	2.2	0.8	6.35	3.18	-	○							
	Q-TPGN160304	1	2.3	0.4	9.525	3.18	-	○							
	Q-TPGN160308	1	1.9	0.8	9.525	3.18	-	○							
TPGN-QBN**	**TPGN110304-QBN**	1	3.7	0.4	6.35	3.18	-	○							
	TPGN110308-QBN	1	3.5	0.8	6.35	3.18	-	○							
	TPGN160304-QBN	1	4.2	0.4	9.525	3.18	-	○							
	TPGN160308-QBN	1	4.0	0.8	9.525	3.18	-	○							
TBGN-QBN**	**TBGN060104-15-QBN**	3	-	0.4	3.97	1.59	-	○							
	TBGN060108-15-QBN	3	-	0.8	3.97	1.59	-	○							

Q-TPGN: 2 Stück pro Packung

● Lagerstandard

Standardmikrogeometrie

	BXM10 BX310 BX330 BX480	BXA20	BXM20	BX360 BX380	BX470	BX910 BX930 BXC50	BXC90
Standard	S01325	S01325	S01325	S01325	T01315	S01325	T02020
Scharfkantig	-	-	-	-	F	-	-
-L	S01315	S01315	S01315	-	-	-	-
-LF	-	S00515	-	-	-	-	-
-LC	-	S00535	-	-	-	-	-
-H	-	S01835	S01835	S01335	-	-	-
Wiper	S01315	S01315	S01315	-	-	-	-



S	0	1	3	2	5
Form	Fasenbreite (W) (mm)			Fasenwinkel α	

T … Gefast
S … Gefast + verrundet
E … Verrundet
F … Scharfkantig

Halter / Innendrehen	→ D044 -	Kassette	→ K193 -
Bohrstangen	→ K209 -	Top-Borer Tools	→ K213

CBN Wendeschneidplatten POSITIV

● : Kontinuierlicher Schnitt
ᑕ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

		BXM10	BXM20	BXA20	BX310	BX330	BX360	BX470	BX480	BX910	BX930
P	Stahl							●ᑕ	✣	●	●ᑕ
M	Rostfreier Stahl										
K	Eisenguss										
N	Nichteisenmetalle										
S	Hitzebest. Legierungen										
H	Gehärteter Stahl	●	●ᑕ	●ᑕ	●	●ᑕ	●ᑕ				
	Sintermetalle							●ᑕ	●✣		

	Katalog Nr.	Anzahl Schneiden	Größe (mm) LE	RE	IC	S	D1	Schliff Standard	Scharfkantig	L	LF	LC	H	Wiper	Spanformstufe
3QP-TPGW	3QP-TPGW080204	3	2.2	0.4	4.76	2.38	2.3	○							
	3QP-TPGW080208	3	2.2	0.8	4.76	2.38	2.3	○							
	3QP-TPGW090204	3	2.2	0.4	5.56	2.38	2.5	○							
	3QP-TPGW090208	3	2.2	0.8	5.56	2.38	2.5	○							
	3QP-TPGW110202	3	2.3	0.2	6.35	2.38	2.8	○							
	3QP-TPGW110204	3	2.2	0.4	6.35	2.38	2.8	○							
	3QP-TPGW110208	3	2.2	0.8	6.35	2.38	2.8	○							
	3QP-TPGW110302	3	2.3	0.2	6.35	3.18	3.4	○							
	3QP-TPGW110304	3	2.2	0.4	6.35	3.18	3.4	○							
	3QP-TPGW110308	3	2.2	0.8	6.35	3.18	3.4	○							
	3QP-TPGW130302	3	2.3	0.2	7.94	3.18	3.4	○							
	3QP-TPGW130304	3	2.2	0.4	7.94	3.18	3.4	○							
	3QP-TPGW130308	3	2.2	0.8	7.94	3.18	3.4	○							
	3QP-TPGW16T304	3	2.2	0.4	9.525	3.97	4.4	○							
	3QP-TPGW16T308	3	1.9	0.8	9.525	3.97	4.4	○							
	3QP-TPGW160404	3	2.2	0.4	9.525	4.76	4.4	○							
	3QP-TPGW160408	3	1.9	0.8	9.525	4.76	4.4	○							
3QP-TPGW**F	3QP-TPGW110304F	3	2.2	0.4	6.35	3.18	3.4		○						
	3QP-TPGW110308F	3	2.2	0.8	6.35	3.18	3.4		○						
3QP-TPGW**-L	3QP-TPGW110304-L	3	2.2	0.4	6.35	3.18	3.4			○					
	3QP-TPGW110308-L	3	2.2	0.8	6.35	3.18	3.4			○					
3QP-TPGW**-LF	3QP-TPGW110304-LF	3	2.2	0.4	6.35	3.18	3.4				○				
	3QP-TPGW110308-LF	3	2.2	0.8	6.35	3.18	3.4				○				
3QP-TPGW**-LC	3QP-TPGW110304-LC	3	2.2	0.4	6.35	3.18	3.4					○			
	3QP-TPGW110308-LC	3	2.2	0.8	6.35	3.18	3.4					○			
3QP-TPGW**-H	3QP-TPGW110304-H	3	2.2	0.4	6.35	3.18	3.4						○		
	3QP-TPGW110308-H	3	2.2	0.8	6.35	3.18	3.4						○		
	3QP-TPGW160404-H	3	2.2	0.4	9.525	4.76	4.4						○		
	3QP-TPGW160408-H	3	1.9	0.8	9.525	4.76	4.4						○		

● Lagerstandard

Halter / Innendrehen → D043 -
Bohrstangen → K209 -
Kassetten → K193 -

CBN Wendeschneidplatten POSITIV

● : Kontinuierlicher Schnitt
ᑕ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

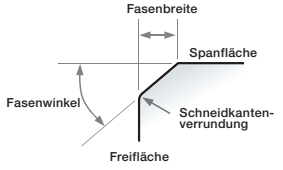
		BXM10	BXM20	BXA20	BX310	BX330	BX360	BX470	BX480	BX910	BX930
P	Stahl							●ᑕ	✣	●	●ᑕ
M	Rostfreier Stahl										
K	Eisenguss										
N	Nichteisenmetalle										
S	Hitzebest. Legierungen										
H	Gehärteter Stahl	●	●ᑕ	●ᑕ	●	●ᑕ	●ᑕ				
	Sintermetalle							●ᑕ	✣		

	Katalog Nr.	Anzahl Schneiden	LE	RE	IC	S	D1	Schliff: Standard	Schliff: Scharfkantig	L	LF	LC	H	Wiper	Spanformstufe
		Größe (mm)						Schliff							
3QP-TPGT	**3QP-TPGT110304-HP**	3	2.2	0.4	6.35	3.18	3.4								○
	3QP-TPGT110308-HP	3	1.9	0.8	6.35	3.18	3.4								○
3QP-TPMW	**3QP-TPMW080204**	3	2.2	0.4	4.76	2.38	2.3	○							
	3QP-TPMW090202	3	2.3	0.2	5.56	2.38	2.5	○							
	3QP-TPMW090204	3	2.2	0.4	5.56	2.38	2.5	○							
	3QP-TPMW110202	3	2.3	0.2	6.35	2.38	2.8	○							
	3QP-TPMW110204	3	2.2	0.4	6.35	2.38	2.8	○							
	3QP-TPMW110302	3	2.3	0.2	6.35	3.18	3.4	○							
	3QP-TPMW110304	3	2.2	0.4	6.35	3.18	3.4	○							
	3QP-TPMW110308	3	1.9	0.8	6.35	3.18	3.4	○							
	3QP-TPMW130302	3	2.4	0.2	7.94	3.18	3.4	○							
	3QP-TPMW130304	3	2.2	0.4	7.94	3.18	3.4	○							
	3QP-TPMW16T304	3	2.2	0.4	9.525	3.97	4.4	○							
	3QP-TPMW16T308	3	1.9	0.8	9.525	3.97	4.4	○							
	3QP-TPMW160404	3	2.2	0.4	9.525	4.76	4.4	○							
	3QP-TPMW160408	3	1.9	0.8	9.525	4.76	4.4	○							
3QP-TCGW	**3QP-TCGW090204**	3	2.2	0.4	5.56	2.38	2.5	○							
	3QP-TCGW090208	3	1.9	0.8	5.56	2.38	2.5	○							
	3QP-TCGW110204	3	2.2	0.4	6.35	2.38	2.8	○							
	3QP-TCGW110208	3	1.9	0.8	6.35	2.38	2.8	○							
	3QP-TCGW16T304	3	2.2	0.4	9.525	3.97	4.3	○							
	3QP-TCGW16T308	3	1.9	0.8	9.525	3.97	4.3	○							

● Lagerstandard

Standardmikrogeometrie

	BXM10 BX310 BX330 BX480	BXA20	BXM20	BX360 BX380	BX470	BX910 BX930 BXC50	BXC90
Standard	S01325	S01325	S01325	S01325	T01315	S01325	T02020
Scharfkantig	-	-	-	-	F	-	-
-L	S01315	S01315	S01315	-	-	-	-
-LF	-	S00515	-	-	-	-	-
-LC	-	S00535	-	-	-	-	-
-H	-	S01835	S01835	S01335	-	-	-
Wiper	S01315	S01315	S01315	-	-	-	-



S	0	1	3	2	5
Form	Fasenbreite (W) (mm)			Fasenwinkel α	

T … Gefast
S … Gefast + verrundet
E … Verrundet
F … Scharfkantig

Halter / Innendrehen → D043 -
Bohrstangen → K209 -
Kassetten → K193 -

CBN Wendeschneidplatten POSITIV

● : Kontinuierlicher Schnitt
◐ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

P	Stahl	
M	Rostfreier Stahl	
K	Eisenguss	
N	Nichteisenmetalle	
S	Hitzebest. Legierungen	
H	Gehärteter Stahl	◐ ◐

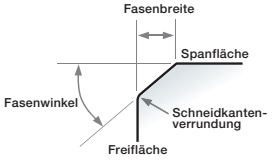
	Katalog Nr.	BX330	BX360	Größe (mm) Anzahl Schneiden	LE	RE	IC	S	D1	Schliff Standard	Scharfkantig	L	LF	LC	H	Wiper	Spanformstufe
Q-TPMW	**Q-TPMW080204**	●		1	2.2	0.4	4.76	2.38	2.3	○							
	Q-TPMW090202	●		1	2.4	0.2	5.56	2.38	2.5	○							
	Q-TPMW0902**04**	●		1	2.3	0.4	5.56	2.38	2.5	○							
	Q-TPMW110202	●		1	2.4	0.2	6.35	2.38	2.8	○							
	Q-TPMW1102**04**	●		1	2.2	0.4	6.35	2.38	2.8	○							
	Q-TPMW110304	●		1	2.3	0.4	6.35	3.18	3.4	○							
	Q-TPMW1103**08**	●		1	2.2	0.8	6.35	3.18	3.4	○							
	Q-TPMW130302	●		1	2.4	0.2	7.94	3.18	3.4	○							
	Q-TPMW1303**04**	●		1	2.3	0.4	7.94	3.18	3.4	○							
	Q-TPMW16T304	●		1	2.3	0.4	9.525	3.97	4.4	○							
	Q-TPMW160404	●		1	2.3	0.4	9.525	4.76	4.4	○							
	Q-TPMW1604**08**	●		1	1.9	0.8	9.525	4.76	4.4	○							
TPGW-QBN**	**TPGW090202-QBN**		●	1	3.3	0.2	5.56	2.38	2.5	○							
	TPGW0902**04-QBN**		●	1	3.2	0.4	5.56	2.38	2.5	○							
	TPGW110202-QBN		●	1	3.9	0.2	6.35	2.38	2.8	○							
	TPGW1102**04-QBN**		●	1	3.7	0.4	6.35	2.38	2.8	○							
	TPGW130302-QBN		●	1	3.9	0.2	7.94	3.18	3.4	○							
	TPGW1303**04-QBN**		●	1	3.7	0.4	7.94	3.18	3.4	○							
	TPGW16T302-QBN		●	1	4.4	0.2	9.525	3.97	4.4	○							
	TPGW16T3**04-QBN**		●	1	4.2	0.4	9.525	3.97	4.4	○							
	TPGW16T3**08-QBN**		●	1	4.0	0.8	9.525	3.97	4.4	○							
TPGA-QBN**	**TPGA090202-QBN**		●	1	3.1	0.2	5.56	2.38	3.2	○							
	TPGA0902**04-QBN**		●	1	2.9	0.4	5.56	2.38	3.2	○							
	TPGA110202-QBN		●	1	3.9	0.2	6.35	2.38	3.0	○							
	TPGA1102**04-QBN**		●	1	3.7	0.4	6.35	2.38	3.0	○							
	TPGA110302-QBN		●	1	3.9	0.2	6.35	3.18	3.0	○							
	TPGA1103**04-QBN**		●	1	3.7	0.4	6.35	3.18	3.0	○							
	TPGA160302-QBN		●	1	4.4	0.2	9.525	3.18	4.0	○							
	TPGA1603**04-QBN**		●	1	4.2	0.4	9.525	3.18	4.0	○							
	TPGA1603**08-QBN**		●	1	4.0	0.8	9.525	3.18	4.0	○							

Q-TPMW: 2 Stück pro Packung

● Lagerstandard

Standardmikrogeometrie

	BXM10 BX310 BX330 BX480	BXA20	BXM20	BX360 BX380	BX470	BX910 BX930 BXC50	BXC90
Standard	S01325	S01325	S01325	S01325	T01315	S01325	T02020
Scharfkantig	-	-	-	-	F	-	-
-L	S01315	S01315	S01315	-	-	-	-
-LF	-	S00515	-	-	-	-	-
-LC	-	S00535	-	-	-	-	-
-H	-	S01835	S01835	S01335	-	-	-
Wiper	S01315	S01315	S01315	-	-	-	-



S	0	1	3	2	5
Form	Fasenbreite (W) (mm)			Fasenwinkel α	

T … Gefast
S … Gefast + verrundet
E … Verrundet
F … Scharfkantig

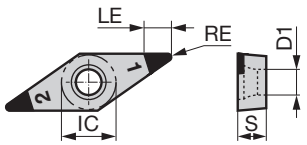
Halter / Innendrehen → D043 -
Bohrstangen → K209 -
Kassetten → K193 -

CBN Wendeschneidplatten POSITIV

● : Kontinuierlicher Schnitt
ᑕ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

		BXM10	BXM20	BXA20	BX310	BX330	BX360	BX930							Größe (mm)						Schliff							
	Katalog Nr.														Anzahl Schneiden	LE	RE	IC	S	D1	Standard	Scharfkantig	L	LF	LC	H	Wiper	Spanformstufe
2QP-VBGW	**2QP-VBGW110204**			●											2	3.1	0.4	6.35	2.38	2.8	○							
	2QP-VBGW110208			●											2	2.2	0.8	6.35	2.38	2.8	○							
	2QP-VBGW110304	●	●	●											2	3.1	0.4	6.35	3.18	2.8	○							
	2QP-VBGW110308	●	●	●											2	2.2	0.8	6.35	3.18	2.8	○							
	2QP-VBGW160404	●	●	●											2	3.1	0.4	9.525	4.76	4.4	○							
	2QP-VBGW160408	●	●	●											2	2.2	0.8	9.525	4.76	4.4	○							
	2QP-VBGW160412			●											2	3.0	1.2	9.525	4.76	4.4	○							
2QP-VBGW-L**	**2QP-VBGW110304-L**			●											2	3.1	0.4	6.35	3.18	2.8			○					
	2QP-VBGW110308-L			●											2	2.2	0.8	6.35	3.18	2.8			○					
	2QP-VBGW160404-L			●											2	3.1	0.4	9.525	4.76	4.4			○					
	2QP-VBGW160408-L			●											2	2.2	0.8	9.525	4.76	4.4			○					
2QP-VBGW-LF**	**2QP-VBGW110304-LF**			●											2	3.1	0.4	6.35	3.18	2.8				○				
	2QP-VBGW110308-LF			●											2	2.2	0.8	6.35	3.18	2.8				○				
	2QP-VBGW160404-LF			●											2	3.1	0.4	9.525	4.76	4.4				○				
	2QP-VBGW160408-LF			●											2	2.2	0.8	9.525	4.76	4.4				○				
2QP-VBGW-LC**	**2QP-VBGW110304-LC**			●											2	3.1	0.4	6.35	3.18	2.8					○			
	2QP-VBGW110308-LC			●											2	2.2	0.8	6.35	3.18	2.8					○			
	2QP-VBGW160404-LC			●											2	3.1	0.4	9.525	4.76	4.4					○			
	2QP-VBGW160408-LC			●											2	2.2	0.8	9.525	4.76	4.4					○			
2QP-VBGW-H**	**2QP-VBGW160404-H**			●											2	3.1	0.4	9.525	4.76	4.4						○		
	2QP-VBGW160408-H			●											2	2.2	0.8	9.525	4.76	4.4						○		

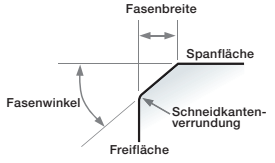
P	Stahl																											
M	Rostfreier Stahl																											
K	Eisenguss							ᑕ																				
N	Nichteisenmetalle																											
S	Hitzebest. Legierungen																											
H	Gehärteter Stahl	●	ᑕ	ᑕ	●	ᑕ	ᑕ																					
	Sintermetalle																											



● Lagerstandard

Standardmikrogeometrie

	BXM10 BX310 BX330 BX480	BXA20	BXM20	BX360 BX380	BX470	BX910 BX930 BXC50	BXC90
Standard	S01325	S01325	S01325	S01325	T01315	S01325	T02020
Scharfkantig	-	-	-	-	F	-	-
-L	S01315	S01315	S01315	-	-	-	-
-LF	-	S00515	-	-	-	-	-
-LC	-	S00535	-	-	-	-	-
-H	-	S01835	S01835	S01335	-	-	-
Wiper	S01315	S01315	S01315	-	-	-	-



S	0	1	3	2	5
Form	Fasenbreite (W) (mm)			Fasenwinkel α	

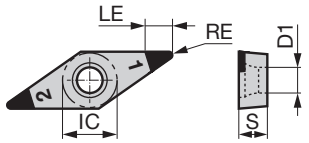
T … Gefast
S … Gefast + verrundet
E … Verrundet
F … Scharfkantig

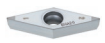
Halter / Außendrehen → C062 -
Halter / Innendrehen → D036 -
J-Serie Werkzeughalter → G033 -
TungCap → K022

CBN Wendeschneidplatten POSITIV

● : Kontinuierlicher Schnitt
ᑕ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

		BXM10	BXM20	BXA20	BX310	BX330	BX360	BX930
P	Stahl							
M	Rostfreier Stahl							
K	Eisenguss							●ᑕ
N	Nichteisenmetalle							
S	Hitzebest. Legierungen							
H	Gehärteter Stahl	●	●ᑕ	●ᑕ	●	●ᑕ	●ᑕ	
	Sintermetalle							

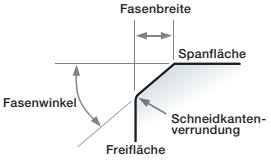


	Katalog Nr.	BXM10	BXM20	BXA20	BX310	BX330	BX360	BX930	Größe (mm) Anzahl Schneiden	LE	RE	IC	S	D1	Schliff Standard	Scharfkantig	L	LF	LC	H	Wiper	Spanformstufe
2QP-VBGT-HP**	**2QP-VBGT110304-HP**	●		●					2	3.1	0.4	6.35	3.18	2.8								○
	2QP-VBGT110308-HP	●		●					2	2.2	0.8	6.35	3.18	2.8								○
	2QP-VBGT160404-HP	●		●					2	3.1	0.4	9.525	4.76	4.4								○
	2QP-VBGT160408-HP	●		●					2	2.2	0.8	9.525	4.76	4.4								○
2QP-VBMW	**2QP-VBMW110304**				●	●	●	●	2	3.1	0.4	6.35	3.18	2.8	○							
	2QP-VBMW110308				●	●	●	●	2	2.2	0.8	6.35	3.18	2.8	○							
	2QP-VBMW160404				●	●	●		2	3.1	0.4	9.525	4.76	4.4	○							
	2QP-VBMW160408				●	●	●		2	2.2	0.8	9.525	4.76	4.4	○							
2QP-VCGW	**2QP-VCGW080204**			●					2	3.1	0.4	4.76	2.38	2.3	○							
	2QP-VCGW080208			●					2	2.2	0.8	4.76	2.38	2.3	○							
	2QP-VCGW160404	●	●	●					2	3.1	0.4	9.525	4.76	4.4	○							
	2QP-VCGW160408			●					2	2.2	0.8	9.525	4.76	4.4	○							
2QP-VCGW-H**	**2QP-VCGW160404-H**			●					2	3.1	0.4	9.525	4.76	4.4						○		
	2QP-VCGW160408-H			●					2	2.2	0.8	9.525	4.76	4.4						○		
																						
2QP-VCMW	**2QP-VCMW160404**					●	●	●	2	3.1	0.4	9.525	4.76	4.4	○							

● Lagerstandard

Standardmikrogeometrie

	BXM10 BX310 BX330 BX480	BXA20	BXM20	BX360 BX380	BX470	BX910 BX930 BXC50	BXC90
Standard	S01325	S01325	S01325	S01325	T01315	S01325	T02020
Scharfkantig	-	-	-	-	F	-	-
-L	S01315	S01315	S01315	-	-	-	-
-LF	-	S00515	-	-	-	-	-
-LC	-	S00535	-	-	-	-	-
-H	-	S01835	S01835	S01335	-	-	-
Wiper	S01315	S01315	S01315	-	-	-	-



S	0	1	3	2	5
Form	Fasenbreite (W) (mm)			Fasenwinkel α	

T ... Gefast
S ... Gefast + verrundet
E ... Verrundet
F ... Scharfkantig

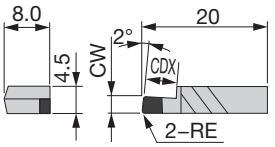
Halter / Außendrehen → C062 -
J-Serie Werkzeughalter → G033 -
Halter / Innendrehen → D036 -
TungCap → K016 -

CBN Wendeschneidplatten NEGATIV

● : Kontinuierlicher Schnitt
c : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

Für GX-RE

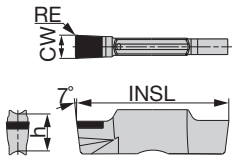
P	Stahl	
M	Rostfreier Stahl	
K	Eisenguss	
N	Nichteisenmetalle	
S	Hitzebest. Legierungen	
H	Gehärteter Stahl	●c



	Katalog Nr.	BX360	Größe (mm) CW±0.05	RE	CDX
XGR-QBN**	**XGR6310S-QBN**		-	-	-
	XGR63**15S-QBN**	●	1.5	0.2	2.3
	XGR63**20S-QBN**	●	2	0.2	3
	XGR63**25S-QBN**	●	2.5	0.2	3.8
	XGR63**30S-QBN**	●	3	0.2	4.5
	XGR63**35S-QBN**	●	3.5	0.2	5.3
	XGR63**40S-QBN**	●	4	0.2	6
	XGR63**45S-QBN**	●	4.5	0.2	6

Für TungCut

P	Stahl	
M	Rostfreier Stahl	
K	Eisenguss	
N	Nichteisenmetalle	
S	Hitzebest. Legierungen	
H	Gehärteter Stahl	●c



	Katalog Nr.	BX360	Größe (mm) Platten-größe	CW±0.025	RE	INSL	h
SGN	**SGN200-020**	●	2	2	0.2	20	5
	SGN**300-020**	●	3	3	0.2	20	5
	SGN**400-020**	●	4	4	0.2	20	5

● Lagerstandard

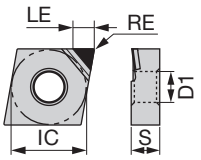
XGR...: Werkzeughalter → F082 - SGN...: Werkzeughalter → F010 -

PKD Wendeschneidplatten

● : Kontinuierlicher Schnitt
ᑕ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

Negativ mit Spanwinkel

P	Stahl
M	Rostfreier Stahl
K	Eisenguss
N	Nichteisenmetalle
S	Hitzebest. Legierungen
H	Gehärteter Stahl



Katalog Nr.	DX110	DX120	Größe (mm) Anzahl Schneiden	LE	RE	IC	S	D1	Mikrogeometrie Scharfe Schneidkante	Spanwinkel
CNMN-DIA**										
CNMM120402-DIA		●	1	3.5	0.2	12.7	4.76	5.16	○	○
CNMM12040**4-DIA**		●	1	3.5	0.4	12.7	4.76	5.16	○	○
1QP-CNMM120402	●		1	3.5	0.2	12.7	4.76	5.16	○	○
1QP-CNMM12040**4**	●		1	3.5	0.4	12.7	4.76	5.16	○	○
DNMM-DIA**										
DNMM150402-DIA		●	1	3.3	0.2	12.7	4.76	5.16	○	○
DNMM15040**4-DIA**		●	1	3.1	0.4	12.7	4.76	5.16	○	○
TNMM-DIA**										
TNMM160402-DIA		●	1	3.3	0.2	9.528	4.76	3.81	○	○
TNMM16040**4-DIA**		●	1	3.2	0.4	9.528	4.76	3.81	○	○
1QP-TNMM160402	●		1	3.3	0.2	9.528	4.76	3.81	○	○
1QP-TNMM16040**4**	●		1	3.2	0.4	9.528	4.76	3.81	○	○
VNMM-DIA**										
VNMM160402-DIA		●	1	4.8	0.2	9.528	4.76	3.81	○	○
VNMM16040**4-DIA**		●	1	4.4	0.4	9.528	4.76	3.81	○	○
VNMM16040**8-DIA**		●	1	3.6	0.8	9.528	4.76	3.81	○	○

● Lagerstandard

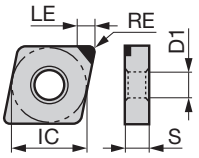
Halter / Außendrehen	→ C016 -	Halter /Innendrehen	→ D021 -
J-Serie Werkzeughalter	→ G044	TungCap	→ K008 -
PINZBOHR®	→ K180 -	Kassetten	→ K199 -

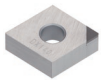
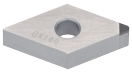
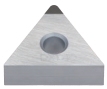
PKD Wendeschneidplatten

● : Kontinuierlicher Schnitt
ᑕ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

Negativ

P	Stahl
M	Rostfreier Stahl
K	Eisenguss
N	Nichteisenmetalle
S	Hitzebest. Legierungen
H	Gehärteter Stahl



	Katalog Nr.	DX140	DX160	Größe (mm) Anzahl Schneiden	LE	RE	IC	S	D1	Mikrogeometrie Scharfe Schneidkante
CNGA-DIA**	**CNGA120404-DIA**	●		1	3.5	0.4	12.7	4.76	5.16	○
	CNGA120408-DIA	●		1	2.8	0.8	12.7	4.76	5.16	○
DNGA-DIA**	**DNGA150404-DIA**	●	●	1	3.1	0.4	12.7	4.76	5.16	○
	DNGA150408-DIA	●		1	2.8	0.8	12.7	4.76	5.16	○
SNGA-DIA**	**SNGA120404-DIA**	●		1	3.6	0.4	12.7	4.76	5.16	○
	SNGA120408-DIA	●		1	3.6	0.8	12.7	4.76	5.16	○
SNGN-DIA**	**SNGN120408-DIA**	●		1	3.6	0.8	12.7	4.76		○
TNGA-DIA**	**TNGA160404-DIA**	●	●	1	3.2	0.4	9.525	4.76	3.81	○
	TNGA160408-DIA	●	●	1	2.9	0.8	9.525	4.76	3.81	○

● Lagerstandard

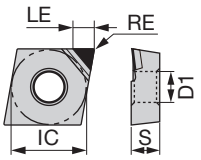
Halter / Außendrehen	→ C016 -	Halter /Innendrehen	→ D021 -
J-Serie Werkzeughalter	→ G044 -	TungCap	→ K008 -
Kassetten	→ K193 -		

PKD Wendeschneidplatten

● : Kontinuierlicher Schnitt
ᑕ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

Positiv mit Spanwinkel

P	Stahl
M	Rostfreier Stahl
K	Eisenguss
N	Nichteisenmetalle
S	Hitzebest. Legierungen
H	Gehärteter Stahl



Katalog Nr.	DX110	DX120	Größe (mm) Anzahl Schneiden	LE	RE	IC	S	D1	Mikrogeometrie Scharfe Schneidkante	Spanwinkel
CCMT-DIA**										
CCMT060202-DIA		●	1	2.4	0.2	6.35	2.38	2.8	○	○
CCMT060204-DIA		●	1	2.4	0.4	6.35	2.38	2.8	○	○
CCMT09T302-DIA		●	1	2.4	0.2	9.525	3.97	4.4	○	○
CCMT09T304-DIA		●	1	2.4	0.4	9.525	3.97	4.4	○	○
1QP-CCMT060204	●		1	2.4	0.4	6.35	2.38	2.8	○	○
1QP-CCMT09T304	●		1	2.4	0.4	6.35	3.97	4.4	○	○
DCMT-DIA**										
DCMT070202-DIA		●	1	2.3	0.2	6.35	2.38	2.8	○	○
DCMT070204-DIA		●	1	2.1	0.4	6.35	2.38	2.8	○	○
DCMT11T302-DIA		●	1	3.2	0.2	9.525	3.97	4.4	○	○
DCMT11T304-DIA		●	1	3.0	0.4	9.525	3.97	4.4	○	○
TCMT-DIA**										
TCMT080202-DIA		●	1	2.2	0.2	4.76	2.38	2.7	○	○
TCMT080204-DIA		●	1	2.0	0.4	4.76	2.38	2.7	○	○
TCMT110202-DIA		●	1	2.4	0.2	6.35	2.38	2.8	○	○
TCMT110204-DIA		●	1	2.2	0.4	6.35	2.38	2.8	○	○
TCMT110302-DIA		●	1	2.4	0.2	6.35	3.18	2.8	○	○
TCMT110304-DIA		●	1	2.2	0.4	6.35	3.18	2.8	○	○
1QP-TCMT110304	●		1	2.2	0.4	6.35	3.18	2.8	○	○
VCMT-DIA**										
VCMT160402-DIA		●	1	4.8	0.2	9.525	4.76	4.4	○	○
VCMT160404-DIA		●	1	4.4	0.4	9.525	4.76	4.4	○	○

● Lagerstandard

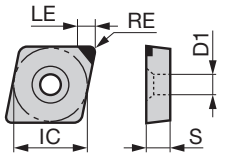
Halter / Außendrehen → C024 -
J-Serie Werkzeughalter → G019 -
PINZBOHR® → K180 -
Halter / Innendrehen → D014 -
TungCap → K016 -

PKD Wendeschneidplatten

● : Kontinuierlicher Schnitt
ᑕ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

Positiv

		DX120	DX140	DX160
P	Stahl		ᑕ	ᑕ
M	Rostfreier Stahl		ᑕ	ᑕ
K	Eisenguss		ᑕ	ᑕ
N	Nichteisenmetalle	ᑕ	ᑕ	ᑕ
S	Hitzebest. Legierungen			
H	Gehärteter Stahl			



	Katalog Nr.	DX120	DX140	DX160	Größe (mm) Anzahl Schneiden	LE	RE	IC	S	D1	Mikrogeometrie Scharfe Schneidkante
CCGW-DIA**	**CCGW060200-DIA**		●		1	2.4	0.05	6.35	2.38	2.8	○
	CCGW060202-DIA		●		1	2.4	0.2	6.35	2.38	2.8	○
	CCGW060204-DIA		●		1	2.4	0.4	6.35	2.38	2.8	○
	CCGW09T302-DIA		●		1	3.5	0.2	9.525	3.97	4.4	○
	CCGW09T304-DIA		●	●	1	3.5	0.4	9.525	3.97	4.4	○
	CCGW09T308-DIA		●		1	3.4	0.8	9.525	3.97	4.4	○
CPGA-DIA**	**CPGA080202-DIA**		●		1	2.4	0.2	9.525	2.38	4.0	○
	CPGA090204-DIA		●		1	3.5	0.4	9.525	2.38	4.0	○
DCGW-DIA**	**DCGW070200-DIA**		●		1	2.4	0.05	6.35	2.38	2.8	○
	DCGW070202-DIA	●	●		1	2.3	0.2	6.35	2.38	2.8	○
	DCGW070204-DIA		●		1	2.1	0.4	6.35	2.38	2.8	○
	DCGW11T302-DIA		●		1	3.2	0.2	9.525	3.97	4.4	○
	DCGW11T304-DIA		●		1	3.0	0.4	9.525	3.97	4.4	○
	DCGW11T308-DIA		●		1	2.7	0.8	9.525	3.97	4.4	○
EPGW-DIA**	**EPGW040102-DIA**		●		1	2.0	0.2	3.97	1.59	2.3	○
	EPGW040104-DIA		●		1	1.9	0.4	3.97	1.59	2.3	○
SPGN-DIA**	**SPGN090308-DIA**		●		1	3.6	0.8	9.525	3.18	-	○
	SPGN120302-DIA		●		1	3.6	0.2	12.7	3.18	-	○
	SPGN120304-DIA		●		1	3.6	0.4	12.7	3.18	-	○
	SPGN120308-DIA		●	●	1	3.6	0.8	12.7	3.18	-	○

● Lagerstandard

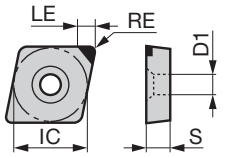
Halter / Außendrehen → C024 -
Halter / Innendrehen → D014 -
Kassetten → K197 -
Bohrstangen → K211 -
Top-Borer Tools → K213

PKD Wendeschneidplatten

● : Kontinuierlicher Schnitt
ᑕ : Leicht unterbrochener Schnitt
✣ : Stark unterbrochener Schnitt

Positiv

		DX120	DX140
P	Stahl		
M	Rostfreier Stahl		
K	Eisenguss		
N	Nichteisenmetalle	●ᑕ	●ᑕ
S	Hitzebest. Legierungen		
H	Gehärteter Stahl		



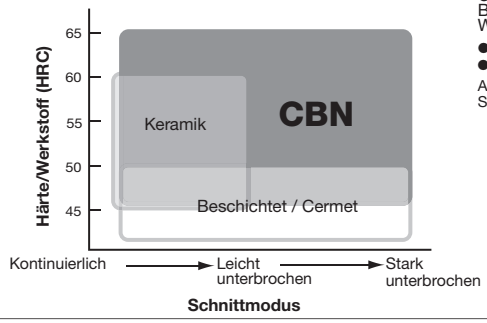
	Katalog Nr.	DX120	DX140	Anzahl Schneiden	LE	RE	IC	S	D1	Mikrogeometrie: Scharfe Schneidkante
				Größe (mm)						
TPGA-DIA**	**TPGA090202-DIA**		●	1	2.4	0.2	5.56	2.38	2.5	○
	TPGA090204-DIA		●	1	2.2	0.4	5.56	2.38	2.5	○
	TPGA110202-DIA		●	1	2.4	0.2	6.35	2.38	2.8	○
	TPGA110204-DIA		●	1	2.2	0.4	6.35	2.38	2.8	○
	TPGA110302-DIA		●	1	2.4	0.2	6.35	3.18	3.0	○
	TPGA110304-DIA		●	1	2.2	0.4	6.35	3.18	3.0	○
	TPGA110308-DIA		●	1	2.9	0.8	6.35	3.18	3.0	○
	TPGA160302-DIA		●	1	3.3	0.2	9.525	3.18	4.0	○
	TPGA160304-DIA		●	1	3.2	0.4	9.525	3.18	4.0	○
	TPGA160308-DIA		●	1	2.9	0.8	9.525	3.18	4.0	○
TPGN-DIA**	**TPGN090204-DIA**		●	1	2.2	0.4	5.56	2.38	-	○
	TPGN110304-DIA	●	●	1	3.2	0.4	6.35	3.18	-	○
	TPGN110308-DIA		●	1	2.9	0.8	6.35	3.18	-	○
	TPGN160302-DIA		●	1	3.3	0.2	9.525	3.18	-	○
	TPGN160304-DIA	●	●	1	3.2	0.4	9.525	3.18	-	○
	TPGN160308-DIA		●	1	2.9	0.8	9.525	3.18	-	○
TPGW-DIA**	**TPGW080202-DIA**		●	1	2.4	0.2	4.76	2.38	2.3	○
	TPGW080204-DIA		●	1	2.3	0.4	4.76	2.38	2.3	○
	TPGW090202-DIA	●	●	1	2.4	0.2	5.56	2.38	2.5	○
	TPGW090204-DIA		●	1	2.2	0.4	5.56	2.38	2.5	○
	TPGW110202-DIA	●	●	1	2.4	0.2	6.35	2.38	2.8	○
	TPGW110204-DIA		●	1	2.2	0.4	6.35	2.38	2.8	○
	TPGW130302-DIA	●	●	1	3.3	0.2	7.94	3.18	3.4	○
	TPGW130304-DIA		●	1	3.2	0.4	7.94	3.18	3.4	○
	TPGW16T302-DIA		●	1	3.3	0.2	9.525	3.97	4.4	○
	TPGW16T304-DIA		●	1	3.2	0.4	9.525	3.97	4.4	○
	TPGW16T308-DIA		●	1	2.9	0.8	9.525	3.97	4.4	○
VCGW-DIA**	**VCGW160402-DIA**		●	1	4.8	0.2	9.525	4.76	4.4	○
	VCGW160404-DIA		●	1	4.4	0.4	9.525	4.76	4.4	○

● Lagerstandard

Halter / Außendrehen → C063 -
Halter / Innendrehen → D043 -
Kassetten → K193 -
Bohrstangen → K209 -

H CBN-Serie für gehärteten Stahl und harte Werkstoffe

Anwendungsgebiet

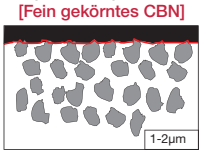


Anforderungen an CBN-Schneidstoffe

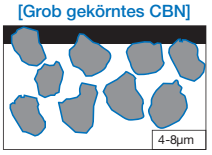
Grundregel zur Bearbeitung des Werkstoffs: Härte des Schneidstoffs ≥ Härte des Werkstoffs X 3

- Gehärteter Stahl (60HRC) → 700 Hv ● Hartmetall 1600 Hv
- PCBN (BX360) → 3300 Hv

Auswirkung der CBN-Korngröße auf die Oberflächenrauheit und die Schnittgeschwindigkeit

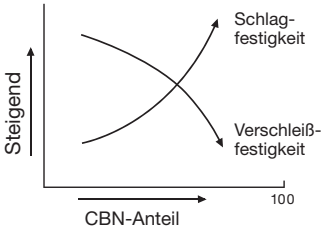


Fein gekörntes CBN für scharfe Schneidkante.
Hohe Oberflächenrauheit



Grob gekörntes CBN. CBN-Partikel fest gebunden.
Für Hochgeschwindigkeitsbearbeitung

● Eigenschaften CBN-Schneidstoffe zur Bearbeitung von gehärtetem Stahl und anderen harten Werkstoffen



Niedriger CBN-Anteil ⇨ Erhöhte Verschleißfestigkeit
Hoher CBN-Anteil ⇨ Erhöhte Schlagfestigkeit

Auswahlsystem CBN-Schneidstoffe für gehärteten Stahl und harte Werkstoffe

● Beschichtete CBN-Schneidstoffe

BXM10 HSC-Zerspanung

BXM20 Allgemeine Anwendung, größer als *Vc* = 180 m/min

BXA20 Allgemeine Anwendung, kleiner als *Vc* = 180 m/min

● Unbeschichtete CBN-Schneidstoffe

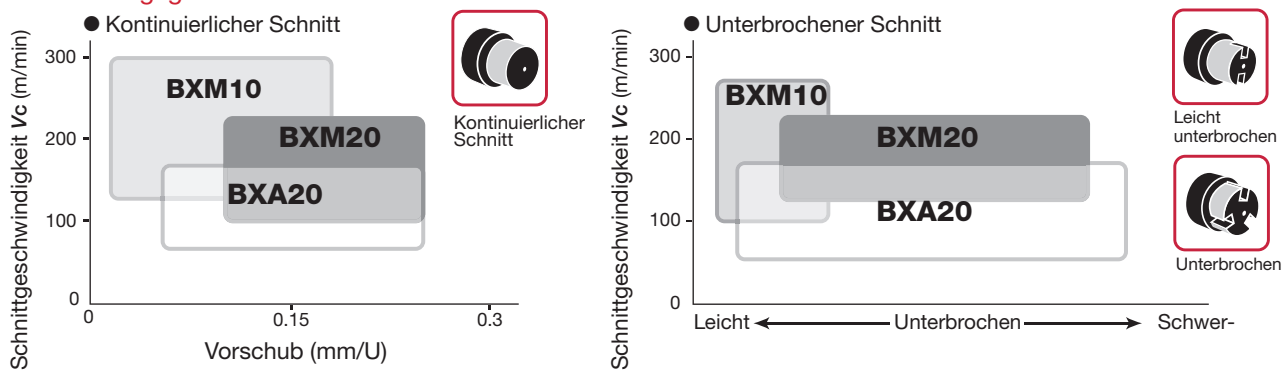
BX310 HSC-Zerspanung – Hohe Verschleißfestigkeit im kontinuierlichen Schnitt

BX330 Mittlere Schnittgeschwindigkeit, hohe Oberflächengüte

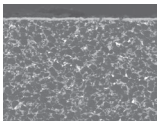
BX360 Niedrige bis mittlere Schnittgeschwindigkeit, allgemeine Anwendung – exzellente Bruchfestigkeit

BX380 Niedrige bis mittlere Schnittgeschwindigkeit, hohe Schlagfestigkeit im stark unterbrochenen Schnitt

Anwendungsgebiete von beschichtetem CBN



Eigenschaften beschichteter CBN-Schneidstoffe



Beschichtung auf hartem CBN

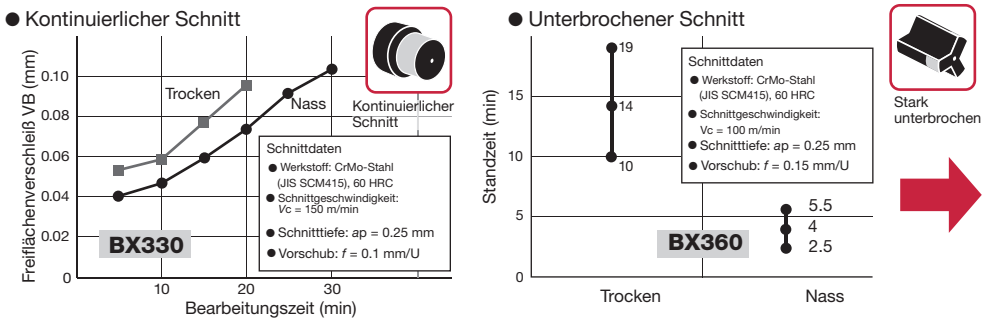
Härte: CBN > Beschichtung

● **Erhöht die Oxidationsbeständigkeit von CBN**
Da die Beschichtung luftundurchlässig ist, findet keine Oxidation von CBN statt.

● **Kein Ablösen der Beschichtung**
Das harte und deformationsresistente CBN ist ein exzellentes Trägermaterial.

➡ **Erhöhte Beständigkeit gegenüber Freiflächenverschleiß**

Einfluss der Kühlung bei der Bearbeitung von gehärtetem Stahl



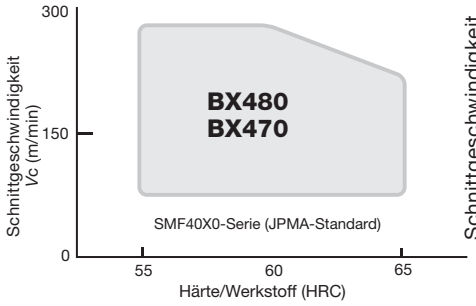
- Für hohe Standzeiten und zur Vermeidung von vorzeitigem Verschleiß ist im kontinuierlichen Schnitt die Nassbearbeitung vorzuziehen.
- Für hohe Standzeiten und zur Vermeidung von vorzeitigem Bruch ist im unterbrochenen Schnitt die Trockenbearbeitung vorzuziehen.

Technische Informationen

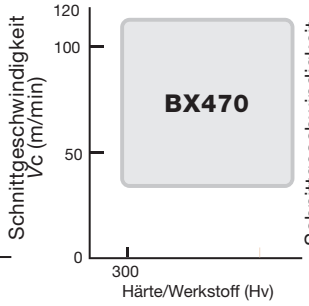
CBN für die Bearbeitung von Sintermetall

■ Anwendungsgebiet

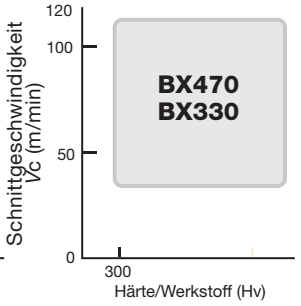
● Eisen-Sintermetall



● Ventilsitz (Plunging)



● Ventilsitz (Längsdrehen)

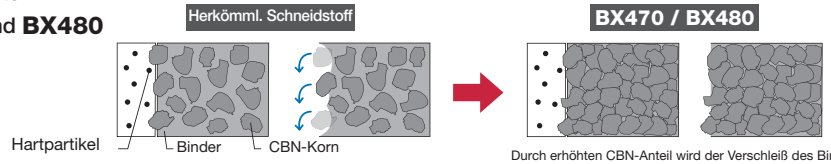


BX470
Geringe Gratbildung und hohe Oberflächengüte

BX480
Hohe Verschleißfestigkeit und vielseitig einsetzbar

Eigenschaften BX470 und BX480

● Bearbeitung von Sintermetall mit Hartpartikeln



Binderphase durch Anteil an Hartpartikeln verschlissen.
⇨ Erhöhter Verschleiß durch Ausfall an CBN-Körnern

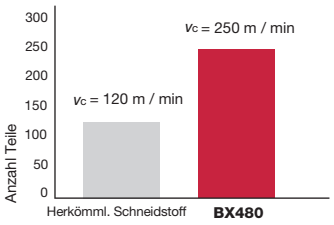
Durch erhöhten CBN-Anteil wird der Verschleiß des Binders unterbunden.
⇨ Erhöhte Verschleißfestigkeit

● Eigenschaften **BX470** und **BX480**

CBN-Anteil: 95 vol%
Hv = 4100 ~ 4300

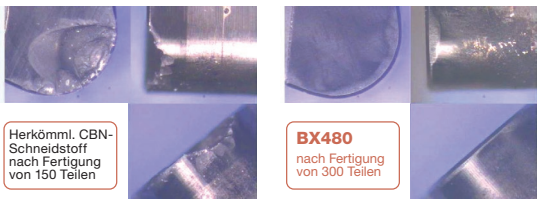
Weltweit höchster CBN-Anteil in handelsüblichem Substrat

■ BX480 (Planen von Getrieben)



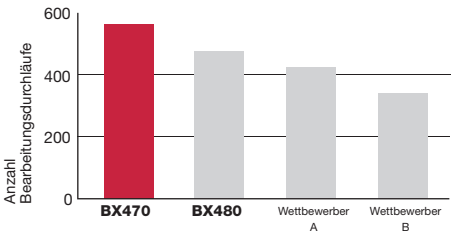
Schnittdaten
- Werkstoff: Sintermetall (> HRA60)
- Wendeschneidplatte: DCMW11T308
- Schnitttiefe: ap = 0.2 ~ 0.5 mm
- Vorschub: *f* = 0.07 mm/U
- Kühlung: Emulsion
- Unterbrochener Schnitt

■ BX470/BX480 Besonders geeignet für Sintermetall



Schnittdaten
- Werkstoff: Sintermetall (> HRA60), nitriert, gehärtet
- Schnittgeschwindigkeit: *Vc* = 110 m/min
- Schnitttiefe: ap = 0.15 mm
- Vorschub: f = 0.1 mm/U
- Kühlung: Emulsion
- Unterbrochener Schnitt

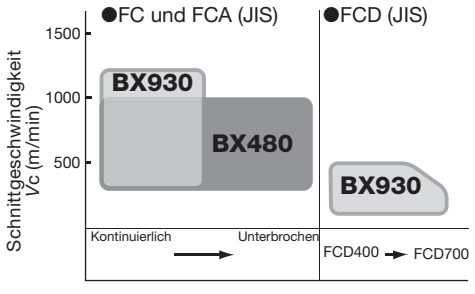
■ BX470 (Standzeitkriterium: Gratbildung)



Schnittdaten
- Werkstoff: Eisen-Sintermetall
- Schnittgeschwindigkeit: Vc = 100 m/min
- Schnitttiefe: ap = 0.15 ~ 0.3 mm
- Vorschub: f = 0.07 ~ 0.25 mm/U
- Unterbrochener Schnitt – Trockenbearbeitung

K CBN für die Bearbeitung von Grau- und Kugelgraphitguss

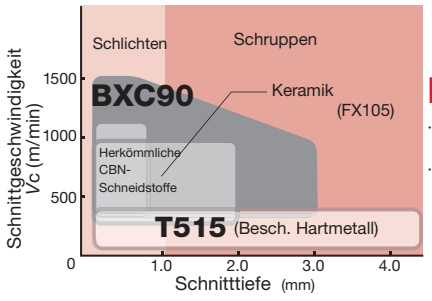
■ Anwendungsgebiet



BX930
Allgemeine Anwendungen, 1. Wahl
· Speziell geeignet für die Zerspanung von Kugelgraphitguss

BX480
· Geeignet für unterbrochenen Schnitt
· Außergewöhnliche Schlagfestigkeit

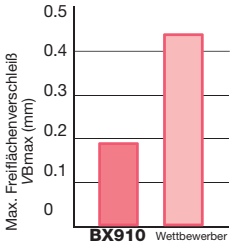
● Beschichtete Voll-CBN-Schneidstoffe



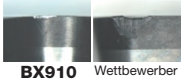
BXC90
· Einteilig, hohe Schlagfestigkeit
· Für kleine bis große Schnitttiefen

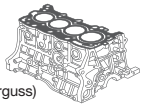
■ Bearbeitung von Zylinderbuchsen (Beispiel: BX910)

● Freiflächenverschleiß nach 120 Teilen



● Bruch nach 120 Teilen

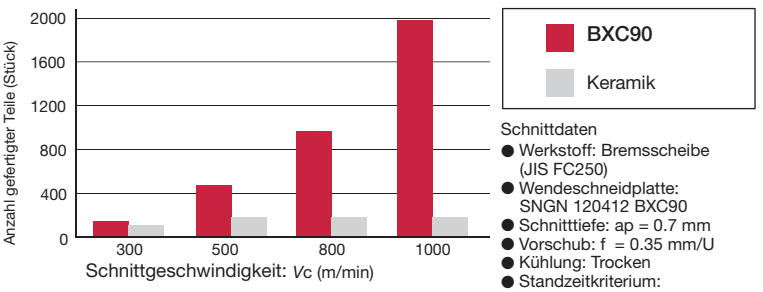




Schnittdaten
- Werkstoff: Zylinderbuchse (Schleuderguss) Bearbeitung: Feinbohren
- Schnittgeschwindigkeit: Vc = 1,000 m/min
- Maschine: Sondermaschine
- Kühlung: Emulsion

BX910 Für die Bearbeitung von Zylinderbuchsen

■ Standzeitvergleich: Schlichten von Bremsscheiben



Schnittdaten
- Werkstoff: Bremsscheibe (JIS FC250)
- Wendeschneidplatte: SNGN 120412 BXC90
- Schnitttiefe: ap = 0.7 mm
- Vorschub: f = 0.35 mm/U
- Kühlung: Trocken
- Standzeitkriterium: Oberflächengüte

CBN

Mikrogeometrie

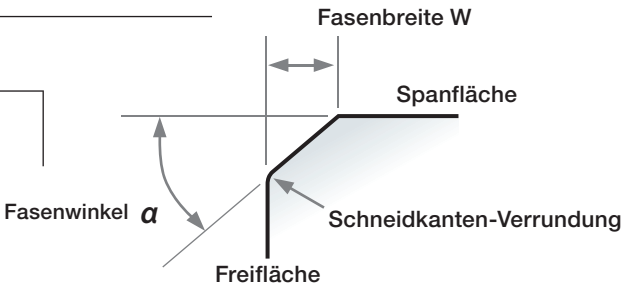
● CBN Wendeschneidplatten mit spezieller Mikrogeometrie werden auf Bestellung gefertigt. Beachten Sie die folgenden Angaben.

Nomenklatur für Mikrogeometrie

Beispiel:
Fasenbreite: 0.15 mm
Fasenwinkel: -30°
Mit Schneidkantenverrundung

S	0	1	3	2	5

Fasenbreite (W) — Fasenwinkel (α)



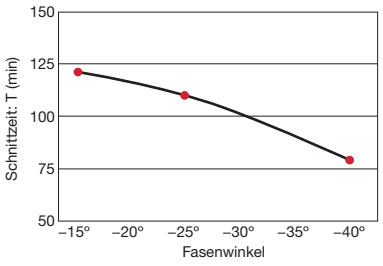
T ··· Gefast
S ··· Gefast + verrundet
E ··· Verrundet
F ··· Scharfkantig

W	Fasenbreite (mm)
005	0.05
010	0.10
013	0.13
015	0.15
018	0.18

α	Fasenwinkel
10°	-10°
15°	-15°
20°	-20°
25°	-25°
30°	-30°
35°	-35°
40°	-40°

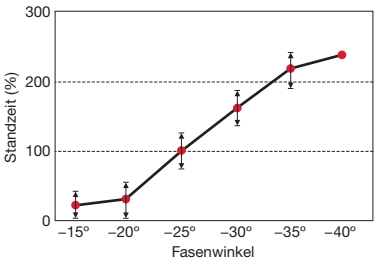
● Wählbare Mikrogeometrien für die hier aufgeführten Artikel.
● Verrundete Wendeschneidplatten ebenfalls erhältlich.

● Verhältnis Fasenwinkel und Standzeit im kontinuierlichen Schnitt



Schnittdaten
Werkstoff:
CrMo-Stahl
(JIS SCM415), 60 HRC
Wendeschneidplatte: TNGN160404 BX360
Schnittgeschw.: *Vc* = 100 m/min
Vorschub: *f* = 0.15 mm/U
Schnitttiefe: *ap* = 0.25 mm
Kühlung: ohne
Standzeitkriterium: VBmax = 0.15 mm
Schliff: -□□°+ runde Fase

● Verhältnis Fasenwinkel und Standzeit im unterbrochenen Schnitt



Schnittdaten
Werkstoff:
CrMo-Stahl
(JIS SCM415), 60 HRC
Wendeschneidplatte:
TNGN160404 BX360
Schnittgeschw.:
Vc = 100 m/min
Vorschub: *f* = 0.15 mm/U
Schnitttiefe: *ap* = 0.25 mm
Kühlung: ohne
Standzeitrkriterium: Bruch
Schliff: -□□°+ runde Fase

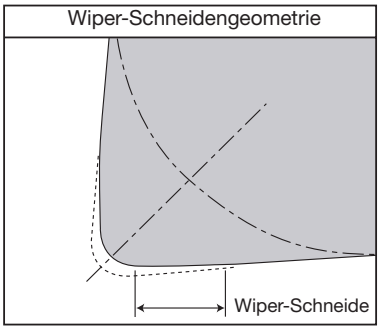
• Im kontinuierlichen Schnitt minimiert ein kleiner Fasenwinkel vorzeitigen Verschleiß.
• Im unterbrochenen Schnitt vermeidet ein großer Fasenwinkel vorzeitigen Bruch.

● Standard-Mikrogeometrie

Schneidstoffe	BXM10	BXM20	BXA20	BXC50	BX310	BX330	BX360	BX380	BX470	BX480	BX910	BX930
Negative Wendeschneidplatten	S01325	S01325	S01325	S01325	S01325	S01325	S01325	S01325	T01315	S01325	S01315	S01315
Positive Wendeschneidplatten	S01325	S01325	S01325	–	S00515	S00515	S00515	–	T01315	S00515	S01315	S00515

Wiper-Wendeschneidplatten

● Die Wiper-Kurve wird am Scheitelpunkt des Eckenradius gebildet.

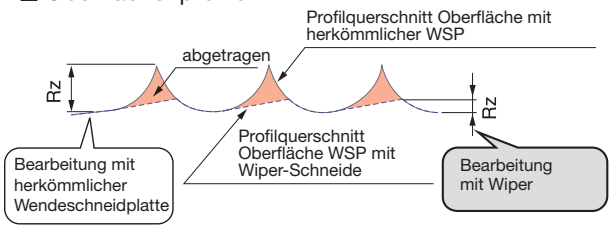


■ Wirkung der Wiper-Schneide

● Doppelte Produktivität → Reduzierte Bearbeitungszeit
Durch den Einsatz der Wiper-Schneide kann der Vorschub verdoppelt und eine exzellente Oberflächengüte erzielt werden. (Hinweis: Vorschub **f* < 0.3 mm/U)

● Verbesserte Oberflächengüte → Kombinierte Schrupp-/Schlichtbearbeitung in einem Zerspanungsprozess
Im Vergleich zu herkömmlichen Wendeschneidplatten mit normalem Eckenradius erzeugt die Wiper-Schneide eine bessere Oberflächengüte.

■ Oberflächenprofile



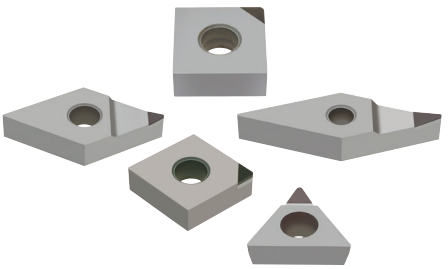
■ Empfohlene Klemmhalter

	2QP-CNGA1204**WL	3QP-WNGA080408WL	2QP-DNGA1504**WJ	3QP-TNGA1604**WG
Anstellwinkel	95°		93°	91°
Halter/ Außen-bearbeitung	ACLNR/L**12-A	AWLNR/L**08-A	ADJNR/L**15-A	ATGNR/L**16-A ATFNR/L**16-A
	DCLNR/L**12	DWLNR/L**08	DDJNR/L**15	DTGNR/L**16 DTFNR/L**16
Halter/ Innen-bearbeitung	A**-ACLNR/L12-D...	A**-AWLNR/L08-D...	A**-ADUNR/L15-D...	A**-ATFNR/L16-D...

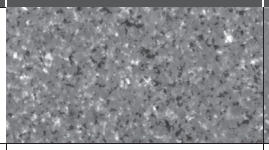
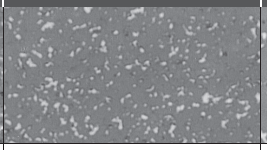
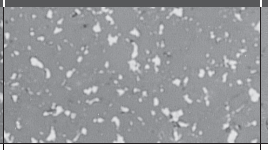
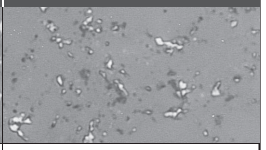
Technische Informationen

PKD-Schneidstoffe

Erweiterte Produktpalette für unterschiedlichste Werkstoffe und Schnittbedingungen.

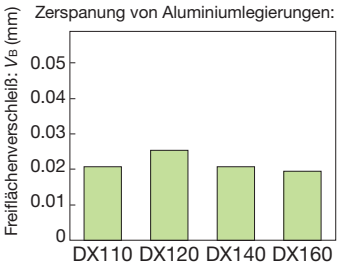


Eigenschaften und Anwendungen (Physikalische und mechanische Eigenschaften)

	DX110	DX120	DX140	DX160
Schneidstoff				
Eigenschaft	**Sehr feinkörniges Substrat** für ausgezeichnete Oberflächengüte	**Feinkörnige Struktur** für extrem hohe Oberflächengüte	**1. Wahl für allgemeine** Anwendungen	**Schneidstoff mit hoher Reinheit** für Hartmetalle und harte Werkstoffe
Größe (ca.) Diamantkorn (µm)	< 1	5	13	28
Härte (Hv)	8500 →			10000 (Härter)
Verschleißfestigkeit	→			Höher
Schleifbarkeit (Scharfe Schneidkante)	Besser ←			

Schnittleistung (Verschleißfestigkeit)

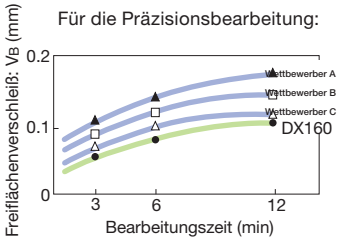
Zerspanung von Aluminiumlegierungen:



Außendrehen, kontinuierlicher Schnitt

- Werkstoff: 10 % Si, Aluminiumlegierung
- Wendeschneidplatte: SPGN120308-DIA
- Werkzeughalter: CSBPR2525M4
- Schnittgeschwindigkeit: v_c = 500 m/min
- Vorschub: f = 0.1 mm/U
- Schnitttiefe: a_p = 0.5 mm
- Kühlung: ohne
- Schnittzeit: 30 Min.

Für die Präzisionsbearbeitung:



Planfräsen

- Werkstoff: Faserverstärkter Kunststoff (FRP)
- Wendeschneidplatte: SFCN42ZFN-DIA
- Fräser: THF4408RIA
- Schnittgeschwindigkeit: v_c = 942 m/min
- Vorschub: f = 0.1 mm/U
- Schnitttiefe: a_p = 1.5 mm
- Kühlung: ohne

Schneidstoffauswahl

1. Wahl
Ausgezeichnete Oberflächengüte
DX110

Geeignet für das Schlichten von Aluminium- und Kupferlegierungen

Geeignet für funkenerosive Bearbeitungsverfahren

Hoher Diamantanteil im Vergleich zu DX110. Für die Hochgeschwindigkeitsbearbeitung

Komplex geformte Werkzeuge
DX120

Hochgeschwindigkeitsbearbeitung
DX140

Für die Zerspanung von harten Werkstoffen Gleichzeitige Bearbeitung von Aluminiumlegierungen und Gusseisen

Hohe Verschleißfestigkeit
DX160

STANDARD SCHNITTBEDINGUNGEN

ISO	Werkstoff	Schneidstoffe DX110	DX120	DX140	DX160	Schnittgeschwindigkeit v_c (m/min)	Schnitttiefe a_p (mm)	Vorschub f (mm/U)
N	Aluminiumlegierungen (Si < 12 %)	◎	○	○		1500 (1000 - 2500)	0.5 (0.05 - 2.0)	0.1 (0.05 - 0.2)
	Aluminiumlegierungen (Si ≥ 12 %)	◎	○	○	○	600 (400 - 800)	0.5 (0.05 - 2.0)	0.1 (0.05 - 0.2)
	Kupfer, Messing	◎	○			800 (500 - 1500)	0.5 (0.05 - 2.0)	0.1 (0.05 - 0.2)
	Phosphorbronze	◎	○	○		400 (300 - 500)	0.5 (0.05 - 2.0)	0.1 (0.05 - 0.2)
	Karbon, Graphit		○	○	◎	400 (300 - 500)	0.5 (0.05 - 2.0)	0.1 (0.05 - 0.2)
	Faserverstärkter Kunststoff (FRP)		○	○	◎	700 (500 - 1000)	0.2 (0.05 - 0.5)	0.05 (0.03 - 0.1)
	Kunststoff	◎	○	○		700 (500 - 1000)	0.2 (0.05 - 0.5)	0.03 (0.01 - 0.05)
	Hartmetall			○	◎	15 (10 - 20)	0.1 (0.05 - 0.2)	0.03 (0.01 - 0.05)
	Halbgesinterte Keramikwerkstoffe			○	◎	130 (100 - 150)	0.5 (0.05 - 2.0)	0.05 (0.03 - 0.1)

◎: 1. Wahl ○: 2. Wahl