

Schnittgeschwindigkeitsempfehlungen, metrische Werte

Die angegebenen Schnittdaten gelten für Anwendungen mit Kühlschmierstoff.

ISO P	CMC-Nr.	Stahl	Spezifische Schnittkraft k_{c1}	Härte Brinell	<<<< VERSCHLEISSFESTIGKEIT			
					CT5015	GC1525	GC4205	GC4315
					$h_{ex}, mm \approx$ Vorschub $f_n, mm/U$			
					Schnittgeschwindigkeit (V_c), m/min			
MC-Nr.		Werkstoff	N/mm ²	HB	0.05-0.1-0.2	0.05-0.1-0.2	0.1-0.4-0.8	0.1-0.4-0.8
P1.1.Z.AN	01.1	Unlegierter Stahl C = 0,1-0,25%	1500	125	650-540-440	560-465-380	620-450-330	570-405-300
P1.2.Z.AN	01.2	C = 0,25-0,55%	1600	150	570-480-385	495-415-335	560-405-295	510-365-265
P1.3.Z.AN	01.3	C = 0,55-0,80%	1700	170	510-425-340	430-365-295	530-385-275	460-330-240
P2.1.Z.AN	02.1	Niedrig legierter Stahl (Legierungsbestandteile <5%) Nicht gehärtet	1700	180	480-400-320	375-320-255	610-410-285	560-370-260
P2.1.Z.AN	02.12	Kugellagerstahl	1800	210	-	-	530-350-250	460-305-215
P2.5.Z.HT	02.2	Vergütet	1850	275	285-235-190	200-165-135	330-230-175	300-210-155
P2.5.Z.HT	02.2	Vergütet	2050	350	230-190-150	160-135-110	265-185-140	240-170-125
P3.0.Z.AN	03.11	Hochlegierter Stahl (Legierungsbestandteile >5%) Geglüht	1950	200	395-330-250	260-215-175	445-295-215	405-270-200
P3.0.Z.HT	03.21	Gehärteter Werkzeugstahl	3000	325	195-165-130	145-115-90	220-140-105	200-130-95
P1.5.C.UT	06.1	Stahlguss Unlegiert	1550	180	260-215-175	225-185-145	335-235-185	300-215-170
P2.6.C.UT	06.2	Niedriglegiert (Legierungsanteile ≤5%)	1600	200	270-225-170	175-145-105	290-205-155	260-185-140
P3.0.C.UT	06.3	Hochlegiert (Legierungsanteile >5%)	2050	225	200-165-125	140-115-85	225-150-115	205-135-105
ISO M	CMC-Nr.	Rostfreier Stahl	Spezifische Schnittkraft k_{c1}	Härte Brinell	<<<< VERSCHLEISSFESTIGKEIT			
					GC1115	GC1125	GC2015	GC15
					$h_{ex}, mm \approx$ Vorschub $f_n, mm/U$			
					Schnittgeschwindigkeit (V_c), m/min			
MC-Nr.		Werkstoff	N/mm ²	HB	0.1-0.2-0.3	0.1-0.2-0.3	0.2-0.4-0.6	0.1-0.2-0.3
P5.0.Z.AN	05.11	Ferritisch/martensitisch Stangen/geschmiedet Nicht gehärtet	1800	200	335-255-200	280-215-170	260-220-200	250-190-150
P5.0.Z.PH	05.12	PH-gehärtet	2850	330	185-150-120	155-125-100	125-100-80	145-115-95
P5.0.Z.HT	05.13	Gehärtet	2350	330	200-160-140	165-135-120	145-120-85	145-120-105
M1.0.Z.AQ	05.21	Austenitisch Stangen/geschmiedet	1800	180	265-215-165	220-180-135	290-240-190	205-165-130
M1.0.Z.PH	05.22	PH-gehärtet	2850	330	185-150-120	155-125-100	130-100-80	145-115-90
M2.0.Z.AQ	05.23	Superaustenitisch	2250	200	220-190-155	185-160-130	160-135-100	170-145-120
M3.1.Z.AQ	05.51	Austenitisch-ferritisch (Duplex) Stangen/geschmiedet Nicht schweißbar ≥ 0,05%C	2000	230	250-205-155	210-170-130	220-185-145	195-160-120
M3.2.Z.AQ	05.52	Schweißbar < 0,05%C	2450	260	230-170-130	190-140-110	190-150-120	175-130-100
P5.0.C.UT	15.11	Ferritisch/martensitisch Gegossen Nicht gehärtet	1700	200	320-265-205	265-220-170	250-210-170	240-200-155
	15.12	PH-gehärtet	2450	330	160-130-95	135-110-80	100-70-55	135-110-80
P5.0.C.HT	15.13	Gehärtet	2150	330	175-145-110	145-120-90	110-90-60	140-115-85
M1.0.C.UT	15.21	Austenitisch Gegossen	1700	180	280-225-170	230-185-145	220-180-140	215-175-135
	15.22	PH-gehärtet	2450	330	160-130-95	135-110-80	105-80-60	135-110-80
M2.0.C.AQ	15.23	Superaustenitisch	2150	200	210-180-150	175-150-125	145-115-95	160-135-115
M3.1.C.AQ	15.51	Austenitisch-ferritisch (Duplex) Gegossen Nicht schweißbar ≥ 0,05%C	1800	230	230-170-120	190-140-100	185-150-135	185-135-95
M3.2.C.AQ	15.52	Schweißbar < 0,05%C	2250	260	205-155-110	170-130-90	160-140-105	170-130-90
ISO K	CMC-Nr.	Temperguss	Spezifische Schnittkraft k_{c1}	Härte Brinell	<<<< VERSCHLEISSFESTIGKEIT			
					CB7525	CB7925	CC6190	CC620
					$h_{ex}, mm \approx$ Vorschub $f_n, mm/U$			
					Schnittgeschwindigkeit (V_c), m/min			
MC-Nr.		Werkstoff	N/mm ²	HB	0.1-0.25-0.4	0.1-0.25-0.4	0.2-0.4-0.6	0.1-0.25-0.4
K1.1.C.NS	07.1	Ferritisch (kurzspanend)	790	130	-	-	810-660-550	800-700-600
	07.2	Perlitisch (langspanend)	900	230	-	-	700-660-550	700-590-500
K2.1.C.UT	08.1	Grauguss Niedrige Festigkeit	890	180	1700-1450-1200	1450-1200-1050	890-720-600	800-700-600
K2.2.C.UT	08.2	Hohe Festigkeit	970	220	1450-1250-1050	1250-1050-890	790-620-500	760-650-540
K3.1.C.UT	09.1	Kugelgraphitguss Ferritisch	900	160	-	-	-	-
K3.3.C.UT	09.2	Perlitisch	1350	250	-	-	-	-
K3.4.C.UT	09.3	Martensitisch	2100	380	-	-	-	-

Schnittgeschwindigkeitsempfehlungen, metrische Werte

ZÄHIGKEIT >>>>									
GC4325	GC4235	GC1515	GC30						
0.1-0.4-0.8	0.1-0.4-0.8	0.1-0.2-0.3	0.15-0.25-0.4						
510-345-245 455-305-215 425-290-205	425-275-200 380-245-180 365-235-170	310-290-255 310-280-245 285-260-230	305-260-215 275-235-195 260-220-185						
460-305-215 395-265-190 255-180-140 205-145-110	300-185-135 250-155-110 185-120-85 150-95-70	295-200-125 - 195-100-40 160-80-34	215-180-150 190-160-130 135-115-95 110-95-80						
300-205-150 135-95-75	240-155-105 110-70-50	- -	- -						
240-180-130 210-140-100 185-125-90	185-140-100 165-100-70 145-95-65	- - -	- - -						
ZÄHIGKEIT >>>>									
GC2025	GC2035	GC235							
0.2-0.4-0.6	0.2-0.4-0.6	0.2-0.4-0.6							
230-175-135 110-70-50 120-80-55	180-160-130 85-65-45 95-70-50	130-110-90 70-55-45 75-60-50							
240-175-130 100-70-55 130-100-75	170-145-115 85-65-45 100-90-70	115-100-85 70-55-45 85-70-60							
190-150-110 150-120-90	160-135-105 130-110-85	105-95-80 95-80-70							
220-160-120 85-55-40 120-80-55	170-145-115 70-50-40 75-60-50	115-100-85 60-45-35 65-50-40							
200-155-115 85-55-40 130-90-65	150-120-95 70-50-40 100-80-60	100-90-75 65-45-33 80-65-55							
150-120-90 125-105-80	130-110-85 105-95-75	95-80-70 90-75-65							
ZÄHIGKEIT >>>>									
CC650	GC3205	GC3210	GC3215	GC3005	GC30	H13A			
0.1-0.25-0.4	0.2-0.4-0.6	0.2-0.4-0.6	0.2-0.4-0.6	0.2-0.4-0.6	0.2-0.4-0.6	0.1-0.3-0.5			
800-700-600 700-600-500	460-380-325 375-310-265	385-315-265 315-255-215	260-215-185 210-175-150	250-210-185 235-190-150	165-165-150 120-110-90	140-125-110 125-110-90			
800-700-600 760-650-540	530-435-375 425-350-300	445-360-305 355-290-245	300-250-210 240-200-170	275-245-225 260-225-200	230-200-160 175-150-120	180-145-110 140-115-95			
610-550-450 510-450-350 350-305-260	390-330-275 350-300-250 265-225-190	360-305-250 325-275-225 245-210-170	240-195-165 215-175-150 165-135-115	265-215-180 240-195-160 185-140-110	170-145-120 120-105-90 65-50-37	135-125-95 125-115-90 100-85-65			

Schnittgeschwindigkeitsempfehlungen, metrische Werte

Die angegebenen Schnittdaten gelten für Anwendungen mit Kühlschmierstoff.

ISO N	CMC-Nr.	NE-Metalle Werkstoff	Spezifische Schnittkraft k_{c1} N/mm ²	Härte Brinell HB	<<<< VERSCHLEISSFESTIGKEIT		
					CD05	CD10	H10
					$h_{ex}, \text{mm} \approx \text{Vorschub } f_n, \text{mm/U}$		
					0.05-0.4	0.05-0.4	0.15-0.8
MC-Nr.					Schnittgeschwindigkeit (V_c), m/min		
N1.2.Z.UT	30.11	Aluminiumlegierungen Gewalzt, nicht ausgehärtet	400	60	-	2 000 (2500-250) ¹⁾	2 000 (2500-250) ¹⁾
N1.2.Z.AG	30.12	Gewalzt oder gewalzt und ausgehärtet	650	100	-	2 000 (2500-250) ¹⁾	2 000 (2500-250) ¹⁾
		Aluminiumlegierungen					
N1.3.C.UT	30.21	Gegossen, nicht gealtert	600	75	2000 (2500-250) ¹⁾	2 000 (2500-250) ¹⁾	2 000 (2500-250) ¹⁾
N1.3.C.AG	30.22	Gegossen oder gegossen und ausgehärtet	700	90	2000 (2500-250) ¹⁾	2 000 (2500-250) ¹⁾	2 000 (2500-250) ¹⁾
		Aluminiumlegierungen					
N1.4.C.NS	30.41	Guss, 13-15% Si	700	130	1550 (1950-195) ¹⁾	1 550 (1950-195) ¹⁾	450 (560-55) ¹⁾
	30.42	Guss, 16-22% Si	700	130	770 (960-95) ¹⁾	770 (960-95) ¹⁾	300 (375-38) ¹⁾
		Kupfer und Kupferlegierungen					
N3.3.U.UT	33.1	Automatenlegierungen, $\geq 1\%$ Pb	550	110	-	500 (630-65) ¹⁾	500 (630-65) ¹⁾
N3.2.C.UT	33.2	Messing, Bleilegierungen, $\leq 1\%$ Pb	550	90	-	500 (630-65) ¹⁾	500 (630-65) ¹⁾
N3.1.U.UT	33.3	Bronze und bleifreies Kupfer, einschl. Elektrolytkupfer	1350	100	-	300 (375-38) ¹⁾	300 (375-38) ¹⁾
ISO S	CMC-Nr.	Warmfeste Werkstückstoffe Werkstoff	Spezifische Schnittkraft k_{c1} N/mm ²	Härte Brinell HB	<<<< VERSCHLEISSFESTIGKEIT		
					CC650	CC6060	CC6065
					$h_{ex}, \text{mm} \approx \text{Vorschub } f_n, \text{mm/U}$		
					0.1 - 0.2	0.1-0.2-0.3	0.1-0.2-0.3
MC-Nr.					Schnittgeschwindigkeit (V_c), m/min		
S1.0.U.AN	20.11	Warmfeste Superlegierungen Fe-basiert Geglüht oder lösungsbehandelt	2400	200	-	-	-
S1.0.U.AG	20.12	Ausgehärtet oder lösungsbehandelt und ausgehärtet	2500	280	-	-	-
		Ni-basiert					
S2.0.Z.AN	20.21	Geglüht oder lösungsbehandelt	2650	250	400-320	400-325-270	330-255-200
S2.0.Z.AG	20.22	Ausgehärtet oder lösungsbehandelt und ausgehärtet	2900	350	340-265	300-235-190	240-175-130
S2.0.C.NS	20.24	Gegossen oder gegossen und ausgehärtet	3000	320	220-160	240-205-175	215-180-150
		Co-basierte Legierungen					
S3.0.Z.AN	20.31	Geglüht oder lösungsbehandelt	2700	200	345-260	-	-
S3.0.Z.AG	20.32	Lösungsbehandelt und ausgehärtet	3000	300	300-225	-	-
S3.0.C.NS	20.33	Gegossen oder gegossen und ausgehärtet	3100	320	285-225	-	-
		Titanlegierungen²⁾		Rm³⁾	H13A	GC1115	GC15
S4.1.Z.UT	23.1	Handelsüblich rein (99.5% Ti)	1300	400	0.1-0.3-0.5	0.1-0.3-0.5	0.1-0.3-0.5
S4.2.Z.AN	23.21	α , ähnlich α und $\alpha + \beta$ Legierungen, geglüht	1400	950	180-150-125	185-155-130	185-155-130
S4.3.Z.AG	23.22	$\alpha + \beta$ Legierungen in ausgehärtetem Zustand, β Legierungen, geglüht oder ausgehärtet	1400	1050	75-60-50	80-65-50	80-65-50
					70-55-45	75-55-45	75-55-45
ISO H	CMC-Nr.	Gehärteter Werkstückstoff Werkstoff	Spezifische Schnittkraft k_{c1} N/mm ²	Härte Brinell HB	<<<< VERSCHLEISSFESTIGKEIT		
					CB7015	CB7025	CB7525
					$h_{ex}, \text{mm} \approx \text{Vorschub } f_n, \text{mm/U}$		
					0.05-0.15-0.25	0.05-0.15-0.25	0.1-0.25-0.4
MC-Nr.					Schnittgeschwindigkeit (V_c), m/min		
H1.1.Z.HA	04.1	Hartstahl Vergütet	2500	45HRC	-	-	-
H1.1.Z.HA	04.1		3050	50HRC	350-265-225	250-210-185	205-165-135
H1.2.Z.HA	04.1		3650	55HRC	295-225-185	210-175-155	175-140-110
		Extra harter Stahl					
H1.3.Z.HA	04.1	Vergütet	4300	60HRC	250-190-160	180-150-135	145-120-95
H1.4.Z.HA	04.1		5000	65HRC	215-165-135	155-130-115	125-100-80
		Kokillenhartguss					
H2.0.C.UT	10.1	Gegossen oder gegossen und ausgehärtet	2250	400	-	-	180-150-120

1) Die in der Tabelle aufgeführten Schnittgeschwindigkeiten sind gültig für alle Vorschübe innerhalb des Vorschubbereiches.

2) 45-60° Einstellwinkel, positive Schneidengeometrie und Kühlschmierstoff sollten verwendet werden.

3) Rm = maximale Festigkeit, gemessen in MPa.

Schnittgeschwindigkeitsempfehlungen, metrische Werte

H13A								ZÄHIGKEIT >>>>						
0.15-0.8														
1 900 (2400-240) ¹⁾														
1 900 (2400-240) ¹⁾														
1 900 (2400-240) ¹⁾														
1 900 (2400-240) ¹⁾														
400 (500-50) ¹⁾														
250 (315-31) ¹⁾														
450 (560-55) ¹⁾														
450 (560-55) ¹⁾														
270 (340-34) ¹⁾														
CC670								S05F	GC1105	GC1115	GC15	H13A	GC1125	ZÄHIGKEIT >>>>
0.1-0.2-0.3								0.1-0.2-0.3	0.1-0.3-0.5	0.1-0.3-0.5	0.1-0.3-0.5	0.1-0.3-0.5	0.1-0.2-0.5	
-	160-135-110	150-100-70	120-80-55	120-80-55	80-65-50	75-60-45								
-	125-105-85	120-80-60	95-65-50	95-65-50	60-50-40	55-45-35								
385-315-270	100-85-70	90-55-30	70-45-24	70-45-24	50-40-30	45-35-25								
325-270-230	90-75-60	80-50-27	65-40-22	65-40-22	40-30-20	35-25-15								
295-245-210	80-65-55	70-45-24	60-37-19	60-37-19	25-20-15	23-17-12								
345-255-205	100-85-70	90-60-30	70-45-24	70-45-24	50-40-30	45-35-25								
300-225-175	90-75-60	80-50-27	65-40-21	65-40-21	40-30-20	35-25-15								
285-225-170	80-65-55	70-45-24	60-37-19	60-37-19	25-20-15	23-17-12								
CB7925								CC6050	CC670	ZÄHIGKEIT >>>>				
0.1-0.25-0.4								0.05-0.15-0.25	0.1-0.25-0.4					
-	290-235-175	205-170-135												
-	240-195-145	165-140-110												
-	200-165-120	140-115-95												
-	170-140-105	120-100-80												
-	145-120-90	105-85-70												
180-150-120	-	120-90-60												

Schnittgeschwindigkeitsempfehlungen, Zoll-Werte

Die angegebenen Schnittdaten gelten für Anwendungen mit Kühlschmierstoff.

ISO P	CMC-Nr.	Stahl Werkstoff	Spezifische Schnittkraft k_{c1} lbs/Zoll ²	Härte Brinell HB	<<<< VERSCHLEISSFESTIGKEIT				
					CT5015	GC1525	GC4205	GC4315	GC4325
					h_{ex} Zoll = Vorschub, f_n Zoll/U bei 0° bis -5° Steigungswinkel				
					Schnittgeschwindigkeit v_c , ft/min				
P1.1.Z.AN	01.1	Unlegierter Stahl C = 0.1-0.25%	216,500	125	2150-1800-1450	1850-1500-1250	2050-1450-1100	1850-1350-990	1650-1150-810
P1.2.Z.AN	01.2	C = 0.25-0.55%	233,000	150	1900-1550-1250	1600-1350-1100	1850-1300-970	1650-1200-880	1500-990-710
P1.3.Z.AN	01.3	C = 0.55-0.80%	247,000	170	1650-1400-1100	1400-1200-960	1750-1250-920	1500-1100-790	1400-940-680
P2.1.Z.AN	02.1	Niedrig legierter Stahl (Legierungsbestandteile <5%) Nicht gehärtet	249,500	180	1550-1300-1050	1250-1050-830	2000-1350-940	1800-1200-860	1500-1000-710
P2.1.Z.AN	02.12	Kugellagerstahl	259,500	210	-	-	1750-1150-820	1500-990-710	1300-870-620
P2.5.Z.HT	02.2	Vergütet	268,000	275	920-770-610	650-540-435	1050-750-570	980-680-510	830-590-455
P2.5.Z.HT	02.2	Vergütet	298,000	350	740-620-495	520-435-350	870-610-460	790-550-415	670-475-365
P3.0.Z.AN	03.11	Hochlegierter Stahl (Legierungsbestandteile >5%) Geglüht	282,000	200	1300-1050-820	840-710-570	1450-970-720	1350-880-650	980-670-500
P3.0.Z.HT	03.21	Gehärteter Werkzeugstahl	435,500	325	640-530-420	465-370-290	710-460-345	650-415-315	445-310-240
P1.5.C.UT	06.1	Stahlguss Unlegiert	225,000	180	850-700-570	740-600-470	1100-770-610	990-700-550	790-580-430
P2.6.C.UT	06.2	Niedriglegiert (Legierungsanteile ≤5%)	230,500	200	880-730-550	580-470-345	950-670-510	860-610-470	690-460-330
P3.0.C.UT	06.3	Hochlegiert (Legierungsanteile >5%)	300,500	225	660-550-410	460-365-280	730-490-380	660-450-345	600-410-295
ISO M	CMC-Nr.	Rostfreier Stahl Werkstoff	Spezifische Schnittkraft k_{c1} lbs/Zoll ²	Härte Brinell HB	<<<< VERSCHLEISSFESTIGKEIT				
					GC1115	GC1125	GC2015	GC15	GC2025
					h_{ex} Zoll = Vorschub, f_n Zoll/U bei 0° bis -5° Steigungswinkel				
					Schnittgeschwindigkeit v_c , ft/min				
P5.0.Z.AN	05.11	Ferritisch/martensitisch Stangen/geschmiedet Nicht gehärtet	262,000	200	1100-840-650	910-700-550	850-720-650	820-620-485	750-570-440
P5.0.Z.PH	05.12	PH-gehärtet	411,500	330	610-490-390	510-405-325	410-325-260	470-380-300	360-225-160
P5.0.Z.HT	05.13	Gehärtet	340,000	330	650-530-460	540-440-385	475-390-275	475-385-340	390-260-175
M1.0.Z.AQ	05.21	Austenitisch Stangen/geschmiedet Austenitisch	259,000	180	870-700-530	730-580-445	950-780-620	680-540-415	790-570-425
M1.0.Z.PH	05.22	PH-gehärtet	414,000	330	610-490-390	510-405-325	425-325-260	470-375-385	330-235-175
M2.0.Z.AQ	05.23	Superaustenitisch	328,000	200	730-630-510	610-520-420	520-440-325	550-475-385	425-325-245
M3.1.Z.AQ	05.51	Austenitisch-ferritisch (Duplex) Stangen/geschmiedet Nicht schweißbar ≥ 0,05%C	286,500	230	830-660-510	690-550-420	720-600-470	640-510-390	620-485-355
M3.2.Z.AQ	05.52	Schweißbar < 0,05%C	356,500	260	740-550-430	620-455-355	620-490-390	570-415-325	490-390-290
P5.0.C.UT	15.11	Ferritisch/martensitisch Gegossen Nicht gehärtet	246,500	200	1050-860-660	870-720-550	820-680-550	790-650-500	720-520-390
P5.0.C.HT	15.12	PH-gehärtet	354,500	330	530-430-310	445-360-260	325-225-180	440-355-255	275-180-130
P5.0.C.HT	15.13	Gehärtet	311,000	330	570-470-350	475-390-290	360-290-195	460-380-280	390-260-175
M1.0.C.UT	15.21	Austenitisch Gegossen Austenitisch	248,000	180	910-730-560	760-610-465	720-590-455	710-570-435	660-500-370
M2.0.C.AQ	15.22	PH-gehärtet	356,000	330	530-430-310	445-360-260	345-260-195	440-355-255	275-180-130
M2.0.C.AQ	15.23	Superaustenitisch	310,500	200	690-590-490	570-490-405	475-375-310	520-440-365	425-290-210
M3.1.C.AQ	15.51	Austenitisch-ferritisch (Duplex) Gegossen Nicht schweißbar ≥ 0,05%C	258,000	230	750-550-390	620-455-325	600-490-440	600-440-315	490-390-290
M3.2.C.AQ	15.52	Schweißbar < 0,05%C	326,000	260	670-510-350	560-420-290	530-455-340	550-420-290	410-340-260
ISO K	CMC-Nr.	Grauguss Werkstoff	Spezifische Schnittkraft k_{c1} lbs/Zoll ²	Härte Brinell HB	<<<< VERSCHLEISSFESTIGKEIT				
					CB7525	CB7925	CC6190	CC620	CC650
					h_{ex} Zoll = Vorschub, f_n Zoll/U bei 0° bis -5° Steigungswinkel				
					Schnittgeschwindigkeit v_c , ft/min				
K1.1.C.NS	07.1	Temperguss Ferritisch (kurzspanend)	115,000	130	-	-	2650-2150-1800	2600-2300-1950	2600-2300-1950
K1.1.C.NS	07.2	Perlitisch (langspanend)	131,000	230	-	-	2300-1800-1450	2300-1950-1650	2300-1950-1600
K2.1.C.UT	08.1	Grauguss Niedrige Festigkeit	130,000	180	5600-4650-3950	4750-3950-3400	2900-2350-1950	2650-2300-1950	2650-2300-1950
K2.2.C.UT	08.2	Hohe Festigkeit	140,500	220	4800-4000-3450	4100-3400-2900	2600-2000-1650	2500-2100-1750	2500-2100-1750
K3.1.C.UT	09.1	Kugelgraphitguss Ferritisch	130,000	160	-	-	-	-	2000-1800-1450
K3.3.C.UT	09.2	Perlitisch	194,500	250	-	-	-	-	1650-1450-1150
K3.4.C.UT	09.3	Martensitisch	307,000	380	-	-	-	-	1150-1000-860

Schnittgeschwindigkeitsempfehlungen, Zoll-Werte

ZÄHIGKEIT >>>>									
GC4235	GC1515	GC30							
.004-.016-.031	.004-.008-.012	.006-.010-.016							
1400-890-660 1250-800-590 1200-760-560	1000-950-830 1000-910-810 940-850-750	990-840-710 890-760-640 850-720-610							
980-600-445 820-500-365 600-385-280 485-310-225	960-650-405 - 640-320-130 520-255-105	700-580-485 620-520-430 450-380-315 360-310-255							
780-500-345 360-225-165	- -	- -							
600-450-335 540-320-235 470-305-220	- - -	- - -							
ZÄHIGKEIT >>>>									
GC2035	GC235								
.008-.016-.024	.008-.016-.024								
590-520-420 280-210-145 310-225-160	425-360-295 230-180-145 245-195-165								
560-470-375 280-210-145 330-295-225	375-325-275 230-180-145 280-230-195								
520-440-340 425-360-275	345-310-260 310-260-230								
560-470-375 230-165-130 240-190-160	375-325-275 195-145-115 215-165-130								
490-390-310 230-165-130 330-260-195	330-295-245 205-145-110 260-210-180								
425-360-275 345-310-245	310-260-230 295-245-210								
ZÄHIGKEIT >>>>									
GC3205	GC3210	GC3215	GC3005	GC30	H13A				
.008-.016-.024	.008-.016-.024	.008-.016-.024	.008-.016-.024	.008-.016-.024	.004-.010-.016				
1500-1250-1050 1250-1000-860	1250-1050-860 1050-830-700	850-700-600 690-570-490	820-690-600 770-620-485	540-485-415 375-295-235	460-410-360 410-360-295				
1750-1400-1200 1400-1150-980	1450-1150-990 1150-950-800	980-820-680 790-650-550	900-810-740 850-730-650	700-530-410 540-390-290	590-470-355 460-375-310				
1300-1100-890 1150-980-810 870-730-620	1200-990-810 1050-900-730 800-680-550	780-640-540 700-570-490 540-440-375	860-690-590 780-630-520 600-455-355	510-385-305 370-295-245 180-120-85	445-470-310 410-375-290 330-275-210				

Schnittgeschwindigkeitsempfehlungen, Zoll-Werte

Die angegebenen Schnittdaten gelten für Anwendungen mit Kühlschmierstoff.

ISO N	CMC-Nr.	NE-Metalle Werkstoff	Spezifische Schnittkraft k_{c1} lbs/Zoll ²	Härte Brinell HB	<<<< VERSCHLEISSFESTIGKEIT		
					CD05	CD10	H10
					h_{ex} , Zoll = Vorschub, f_n Zoll/U bei 0° bis -5° Steigungswinkel		
					.002-.016	.002-.016	.006-.031
					Schnittgeschwindigkeit v_c , ft/min		
N1.2.Z.UT	30.11	Aluminiumlegierungen Gewalzt, nicht ausgehärtet	58,000	60	-	6550 (8200-820) ¹⁾	6550 (8200-820) ¹⁾
N1.2.Z.AG	30.12	Gewalzt oder gewalzt und ausgehärtet	94,500	100	-	6550 (8200-820) ¹⁾	6550 (8200-820) ¹⁾
N1.3.C.UT	30.21	Aluminiumlegierungen Gegossen, nicht gealtert	87,000	75	6550 (8200-820) ¹⁾	6550 (8200-820) ¹⁾	6550 (8200-820) ¹⁾
N1.3.C.AG	30.22	Gegossen oder gegossen und ausgehärtet	101,500	90	6550 (8200-820) ¹⁾	6550 (8200-820) ¹⁾	6550 (8200-820) ¹⁾
N1.4.C.NS	30.41	Aluminiumlegierungen Guss, 13–15% Si	101,500	130	5000 (6250-630) ¹⁾	5000 (6250-630) ¹⁾	1500 (1900-190) ¹⁾
	30.42	Guss, 16–22% Si	101,500	130	2500 (3150-315) ¹⁾	2500 (3150-315) ¹⁾	980 (1250-125) ¹⁾
N3.3.U.UT	33.1	Kupfer und Kupferlegierungen Automatenlegierungen, ≥1% Pb	79,500	110	-	1650 (2050-205) ¹⁾	1650 (2050-205) ¹⁾
N3.2.C.UT	33.2	Messing, Bleilegierungen, ≤1% Pb	80,000	90	-	1650 (2050-205) ¹⁾	1650 (2050-205) ¹⁾
N3.1.U.UT	33.3	Bronze und bleifreies Kupfer, einschl. Elektrolytkupfer	196,000	100	-	980 (1250-125) ¹⁾	980 (1250-125) ¹⁾

ISO S	CMC-Nr.	Warmfeste Werkstückstoffe Werkstoff	Spezifische Schnittkraft k_{c1} lbs/Zoll ²	Härte Brinell HB	<<<< VERSCHLEISSFESTIGKEIT		
					CC650	CC6060	CC6065
					h_{ex} , Zoll = Vorschub, f_n Zoll/U bei 0° bis -5° Steigungswinkel		
					.004-.008	.004-.008-.012	.004-.008-.012
					Schnittgeschwindigkeit v_c , ft/min		
S1.0.U.AN	20.11	Warmfeste Superlegierungen Fe-basiert Geglüht oder lösungsbehandelt	348,000	200			
S1.0.U.AG	20.12	Ausgehärtet oder lösungsbehandelt und ausgehärtet	359,000	280			
S2.0.Z.AN	20.21	Ni-basiert Geglüht oder lösungsbehandelt	383,000	250	1300-1050	1300-1050-880	1100-830-650
	20.22	Ausgehärtet oder lösungsbehandelt und ausgehärtet	420,500	350	1100-860	980-770-620	790-570-420
	20.24	Gegossen oder gegossen und ausgehärtet	436,500	320	720-520	790-660-570	700-580-485
S3.0.Z.AN	20.31	Co-basierte Legierungen Geglüht oder lösungsbehandelt	391,500	200	1150-840		
	20.32	Lösungsbehandelt und ausgehärtet	432,000	300	980-720		
	20.33	Gegossen oder gegossen und ausgehärtet	450,500	320	930-730		
S4.1.Z.UT	23.1	Titanlegierungen²⁾ Handelsüblich rein (99.5% Ti)	188,500	Rm ³⁾ 400	H13A .004-.012-.020	GC1115 .004-.012-.020	GC15 .004-.012-.020
	23.21	α , ähnlich α und $\alpha + \beta$ Legierungen, geglüht	203,000	950	590-485-410	610-500-425	610-500-425
	23.22	$\alpha + \beta$ Legierungen in ausgehärtetem Zustand, β Legierungen, geglüht oder ausgehärtet	203,000	1050	245-200-165	255-205-170	255-205-170
					235-175-150	245-180-155	245-180-155

ISO H	CMC-Nr.	Gehärteter Werkstückstoff Werkstoff	Spezifische Schnittkraft k_{c1} lbs/Zoll ²	Härte	<<<< VERSCHLEISSFESTIGKEIT		
					CB7015	CB7025	CB7525
					h_{ex} , Zoll = Vorschub, f_n Zoll/U bei 0° bis -5° Steigungswinkel		
					.002-.006-.010	.002-.006-.010	.004-.010-.016
					Schnittgeschwindigkeit v_c , ft/min		
H1.1.Z.HA	04.1	Hartstahl Vergütet	366,000	45HRC	-	-	-
H1.1.Z.HA	04.1		445,500	50HRC	1150-870-730	820-690-610	680-540-435
H1.2.Z.HA	04.1		532,000	55HRC	960-730-610	690-580-510	570-455-365
H1.3.Z.HA	04.1	Extra harter Stahl Vergütet	625,500	60HRC	820-620-520	590-490-435	480-385-310
			726,500	65HRC	710-530-450	510-425-375	415-330-270
H2.0.C.UT	10.1	Kokillenhartguss Gegossen oder gegossen und ausgehärtet	326,500	400 HB	-	-	590-480-390

1) Die in der Tabelle aufgeführten Schnittgeschwindigkeiten sind gültig für alle Vorschübe innerhalb des Vorschubbereiches.
 2) 45–60° Einstellwinkel, positive Schneidengeometrie und Kühlschmierstoff sollten verwendet werden.
 3) Rm = maximale Festigkeit, gemessen in MPa.

Schnittgeschwindigkeitsempfehlungen, Zoll-Werte

ZÄHIGKEIT >>>>							
H13A							
.006-.031							
6250 (7800-780) ¹⁾							
6250 (7800-780) ¹⁾							
6250 (7800-780) ¹⁾							
6250 (7800-780) ¹⁾							
1300 (1650-165) ¹⁾							
820 (1050-105) ¹⁾							
1500 (1900-190) ¹⁾							
1500 (1900-190) ¹⁾							
890 (1100-110) ¹⁾							
ZÄHIGKEIT >>>>							
CC670	S05F	GC1105	GC1115	GC15	H13A	GC1125	
.004-.008-.012	.004-.008-.012	.004-.012-.020	.004-.012-.020	.004-.012-.020	.004-.012-.020	.004-.012-.020	
-	520-435-355	490-325-225	395-260-180	395-260-180	260-210-160	245-195-145	
-	410-345-280	390-260-195	315-210-155	315-210-155	195-165-130	180-145-115	
1250-1050-880	325-275-225	295-185-95	235-150-75	235-150-75	165-130-95	150-115-80	
1050-870-740	295-245-200	265-165-85	215-135-70	215-135-70	130-95-65	115-80-50	
970-800-680	260-220-180	235-150-75	190-120-60	190-120-60	80-65-50	75-55-39	
1150-830-660	325-275-225	295-185-95	240-150-75	240-150-75	165-130-95	150-115-80	
980-720-570	290-245-200	265-165-85	210-135-70	210-135-70	130-95-65	115-80-50	
930-730-550	260-220-180	235-150-75	190-120-60	190-120-60	80-65-50	75-55-39	
ZÄHIGKEIT >>>>							
CB7925	CC6050	CC670					
.004-.010-.016	.002-.006-.010	.004-.010-.016					
-	950-770-570	670-550-440					
-	780-630-470	550-450-365					
-	660-530-395	460-375-305					
-	560-450-335	390-320-260					
-	480-390-290	335-275-225					
590-480-390	-	390-290-190					

Schnittdatenempfehlungen für CoroTurn® XS

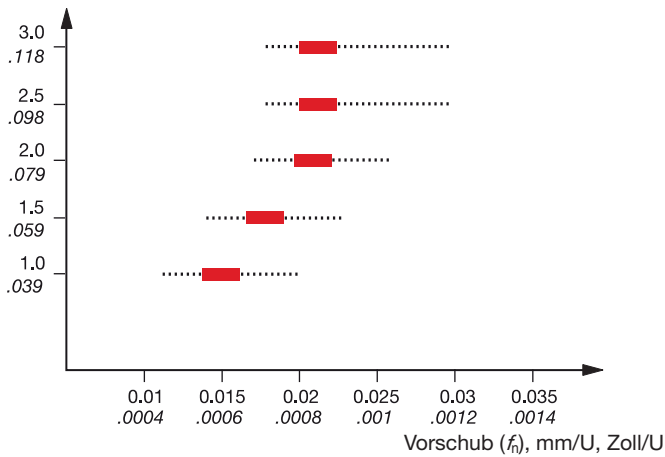
Wendeschneidplatten für die Drehbearbeitung

Größe	Abmessungen, mm, Zoll				Anwendungsbereich							
	Allgemeine Drehbearbeitung/Rückwärtsausdrehen Empf. Schnitttiefe				Empfohlener Vorschub							
d_{m_m}	WB mm	WB inch	RE mm	RE inch	a_p mm	Min - Max	a_p Zoll	Min - Max	f_r mm/U	Min - Max	f_r Zoll/U	Min - Max
04	0.18	.007	-	-	0.05	(0.01 - 0.08)	.0020	(.0004 - .0031)	0.007	(0.050 - 0.015)	.00028	(.00020 - .00059)
04	0.28	.011	-	-	0.06	(0.01 - 0.10)	.0024	(.0004 - .0041)	0.010	(0.050 - 0.014)	.00039	(.00020 - .00059)
04	0.38	.015	-	-	0.08	(0.01 - 0.15)	.0031	(.0004 - .0059)	0.012	(0.008 - 0.017)	.00047	(.00032 - .00067)
04	0.46	.018	-	-	0.09	(0.01 - 0.20)	.0035	(.0004 - .0071)	0.015	(0.010 - 0.020)	.00059	(.00039 - .00079)
04	0.56	.022	-	-	0.12	(0.01 - 0.22)	.0047	(.0004 - .0087)	0.018	(0.010 - 0.025)	.00071	(.00039 - .00098)
04	0.63	.025	-	-	0.15	(0.01 - 0.25)	.0059	(.0004 - .0098)	0.020	(0.012 - 0.025)	.00079	(.00047 - .00098)
04	0.66	.026	0.05	.002	0.15	(0.05 - 0.30)	.0059	(.0020 - .0118)	0.020	(0.012 - 0.030)	.00079	(.00047 - .00118)
04	0.66	.026	0.10	.004	0.15	(0.09 - 0.30)	.0059	(.0039 - .0118)	0.020	(0.015 - 0.080)	.00079	(.00059 - .00315)
04	0.74	.029	-	-	0.15	(0.01 - 0.25)	.0059	(.0004 - .0098)	0.020	(0.012 - 0.025)	.00079	(.00047 - .00098)
04	1.04	.041	0.05	.002	0.18	(0.05 - 0.30)	.0071	(.0020 - .0118)	0.020	(0.012 - 0.030)	.00079	(.00047 - .00118)
04	1.04	.041	0.10	.004	0.18	(0.01 - 0.30)	.0071	(.0004 - .0118)	0.020	(0.015 - 0.080)	.00079	(.00059 - .00315)
04	1.55	.061	0.05	.002	0.20	(0.05 - 0.40)	.0079	(.0020 - .0158)	0.020	(0.012 - 0.030)	.00079	(.00047 - .00118)
04	1.55	.061	0.10	.004	0.20	(0.09 - 0.40)	.0079	(.0039 - .0158)	0.020	(0.015 - 0.080)	.00079	(.00059 - .00315)
04	2.06	.081	0.05	.002	0.25	(0.05 - 0.51)	.0098	(.0020 - .0200)	0.020	(0.012 - 0.030)	.00079	(.00047 - .00118)
04	2.06	.081	0.15	.006	0.25	(0.15 - 0.51)	.0098	(.0059 - .0200)	0.025	(0.015 - 0.050)	.00098	(.00059 - .00197)
04	2.54	.100	0.05	.002	0.30	(0.05 - 0.51)	.0118	(.0020 - .0200)	0.020	(0.015 - 0.030)	.00079	(.00059 - .00118)
04	2.06/2.59	.100/.102	0.15	.006	0.30	(0.15 - 0.51)	.0118	(.0059 - .0200)	0.025	(0.015 - 0.050)	.00098	(.00059 - .00197)
04	2.95	.116	0.15	.006	0.30	(0.15 - 0.51)	.0118	(.0059 - .0200)	0.025	(0.015 - 0.050)	.00098	(.00059 - .00197)
04	3.45	.136	0.05	.002	0.30	(0.05 - 0.51)	.0118	(.0020 - .0200)	0.020	(0.015 - 0.030)	.00079	(.00059 - .00118)
04	3.45	.136	0.15	.006	0.30	(0.15 - 0.51)	.0118	(.0059 - .0200)	0.025	(0.015 - 0.050)	.00098	(.00059 - .00197)
05	3.76	.148	0.15	.006	0.35	(0.15 - 0.60)	.0138	(.0059 - .0236)	0.040	(0.020 - 0.060)	.00157	(.00079 - .00236)
05	3.75/3.81	.148/.150	0.20	.008	0.35	(0.20 - 0.60)	.0138	(.0079 - .0236)	0.040	(0.020 - 0.060)	.00157	(.00079 - .00236)
05	4.19	.165	0.20	.008	0.35	(0.20 - 0.60)	.0138	(.0079 - .0236)	0.040	(0.020 - 0.070)	.00157	(.00079 - .00276)
05	4.24	.167	0.05	.002	0.25	(0.05 - 0.60)	.0098	(.0020 - .0236)	0.030	(0.020 - 0.040)	.00118	(.00079 - .00157)
05	4.24	.167	0.20	.008	0.35	(0.20 - 0.60)	.0138	(.0079 - .0236)	0.040	(0.020 - 0.070)	.00157	(.00079 - .00276)
06	3.96/3.99	.156/.157	0.15	.006	0.35	(0.15 - 0.60)	.0138	(.0059 - .0236)	0.045	(0.020 - 0.070)	.00177	(.00079 - .00276)
06	3.96	.156	0.20	.008	0.35	(0.20 - 0.60)	.0138	(.0079 - .0236)	0.045	(0.020 - 0.070)	.00177	(.00079 - .00276)
06	5.26	.207	0.20	.008	0.40	(0.20 - 0.70)	.0157	(.0079 - .0276)	0.045	(0.020 - 0.080)	.00177	(.00079 - .00315)
07	4.29	.169	0.20	.008	0.35	(0.20 - 0.60)	.0138	(.0079 - .0236)	0.040	(0.020 - 0.070)	.00157	(.00079 - .00276)
07	6.25	.246	0.20	.008	0.50	(0.20 - 0.80)	.0197	(.0079 - .0315)	0.050	(0.030 - 0.080)	.00197	(.00118 - .00315)

Bei Einsatz der CBN Sorte CB7015 sind im Vergleich zu Hartmetallsorten Vorschub und Schnittgeschwindigkeit um 50% zu reduzieren.

Einstecken und Axialeinstecken

Wendepplattenbreite (W1), mm, Zoll



Gewindedrehen, (Empfehlungen für Zustellungswerte)

Gewinde	Steigung		a_p mm	a_p Zoll	nap
	mm	TPI			
Metrisch 60° (MM)	0.50		0.26	.0106	7
	0.70		0.38	.0150	8
	0.75		0.40	.0161	8
	0.80		0.43	.0169	8
	1.00		0.55	.0217	11
	1.25		0.68	.0268	11
	1.50		0.81	.0319	13
	1.75		0.95	.0374	14
UN 60°	2.00		1.08	.0425	18
		48	0.29	.0114	7
		36	0.38	.0150	8
		32	0.43	.0169	8
		28	0.49	.0193	9
		24	0.56	.0224	11
		20	0.69	.0272	11
Whitworth 55° (WH)		18	0.76	.0299	12
		16	0.86	.0339	13
		28	0.60	.0236	10
		26	0.65	.0256	11
		24	0.68	.0268	11
NPT 60° (NT)		22	0.74	.0291	12
		20	0.82	.0323	14
		19	0.87	.0343	14
		18	0.95	.0374	14
ISO, trapezförmig 30°	1.50		0.86	.0340	6
	2.00		1.17	.0460	8
	3.00		1.70	.0670	12

a_p = Gesamtgewindetiefe
 nap = Anzahl der Zustellungen

Schnittgeschwindigkeitsempfehlungen

Schnittgeschwindigkeit (v_c), m/min (ft/min)

Sorte 1025 **P** **M** **N** **S**

60-200 (185-655) 60-180 (195-590) 90-400 (295-1310) 20-50 (65-165)

Sorte CB7015 **H**

60-200 (200-600)

Empfohlene Schnitttiefe und Vorschub, metrisch

T-Max® P Wendeschneidplatten zum Drehen

Wendeplatte	Schnitttiefe			Vorschub		
	a_p = mm			f_n = mm/U		
	Empf.	Min.	Max.	Empf.	Min.	Max.
CNMG120404-SGF	0.30	0.10	3.00	0.12	0.05	0.25
CNMG120408-SGF	0.50	0.20	3.00	0.15	0.10	0.30
CNMG120412-SGF	0.80	0.30	4.00	0.18	0.10	0.35
CNMA120404-KR	2.50	0.20	5.00	0.20	0.10	0.30
CNMA120408-KR	4.00	0.20	8.00	0.35	0.15	0.60
CNMA120412-KR	4.00	0.30	8.00	0.45	0.20	0.80
CNMA120416-KR	4.00	0.30	8.00	0.55	0.20	1.00
CNMA160612-KR	5.00	0.30	10.00	0.45	0.20	0.80
CNMA160616-KR	5.00	0.30	10.00	0.55	0.20	1.00
CNMA190608-KR	6.00	0.20	12.00	0.35	0.15	0.60
CNMA190612-KR	6.00	0.30	12.00	0.45	0.20	0.80
CNMA190616-KR	6.00	0.30	12.00	0.55	0.20	1.00
CNMA190624-KR	6.00	0.40	12.00	0.60	0.20	1.40
CNMG090304-MF	1.00	0.50	3.00	0.20	0.10	0.30
CNMG090304-MF ¹⁾	0.40	0.10	1.50	0.15	0.05	0.25
CNMG090304-MM	1.50	0.15	4.00	0.25	0.10	0.40
CNMG090304-PF	0.40	0.25	1.50	0.15	0.07	0.30
CNMG090304-PM	2.00	0.40	4.00	0.20	0.10	0.30
CNMG090304-QM	3.00	1.00	4.50	0.25	0.18	0.30
CNMG090304-WF	0.50	0.30	1.50	0.15	0.05	0.25
CNMG090304-XF	0.75	0.15	3.50	0.15	0.04	0.20
CNMG090308-MF	1.00	0.50	3.00	0.25	0.15	0.50
CNMG090308-MF ¹⁾	0.40	0.10	1.50	0.20	0.10	0.35
CNMG090308-MM	2.00	0.50	4.00	0.25	0.10	0.40
CNMG090308-PF	0.40	0.30	1.50	0.15	0.10	0.30
CNMG090308-PM	2.00	0.50	4.00	0.30	0.15	0.50
CNMG090308-QM	3.00	1.00	4.50	0.35	0.20	0.50
CNMG090308-WF	1.00	0.30	2.00	0.30	0.10	0.50
CNMG090308-XM	2.50	0.50	4.00	0.25	0.10	0.35
CNMG090312-QM	3.00	1.00	4.50	0.35	0.25	0.50
CNMG120404-KF	0.50	0.15	2.00	0.15	0.08	0.25
CNMG120404-LC	0.25	0.10	1.00	0.10	0.05	0.25
CNMG120404-MF	1.00	0.50	4.00	0.20	0.10	0.30
CNMG120404-MF ¹⁾	0.40	0.10	1.50	0.15	0.05	0.30
CNMG120404-MMC	2.00	0.25	3.00	0.25	0.10	0.40
CNMG120404-PF	0.40	0.25	1.50	0.15	0.07	0.30
CNMG120404-PM	3.00	0.40	5.5	0.20	0.10	0.30
CNMG120404-PMC	2.00	0.25	3.00	0.25	0.10	0.40
CNMG120404-QM	3.00	1.00	6.00	0.25	0.18	0.30
CNMG120404-SF	0.40	0.15	1.50	0.12	0.08	0.22
CNMG120404-SM	1.50	0.15	2.50	0.20	0.10	0.30
CNMG120404-SMC	0.50	0.25	3.00	0.20	0.10	0.30
CNMG120404-WF	0.40	0.25	3.00	0.15	0.05	0.25
CNMG120404-WL	0.25	0.10	1.00	0.20	0.10	0.30
CNMG120404-XF	0.75	0.15	4.00	0.15	0.04	0.20
CNMG120404-XM	2.50	0.30	5.00	0.18	0.08	0.30
CNMG120408-KF	0.50	0.15	2.00	0.20	0.10	0.30
CNMG120408-KM	3.00	0.20	6.00	0.35	0.15	0.50
CNMG120408-KR	3.50	0.38	7.00	0.38	0.19	0.53
CNMG120408-KRR	4.00	0.20	8.00	0.35	0.15	0.60
CNMG120408-LC	0.50	0.20	1.50	0.25	0.10	0.35
CNMG120408-MF	1.00	0.50	4.00	0.25	0.15	0.50
CNMG120408-MF ¹⁾	0.40	0.10	1.50	0.20	0.10	0.40
CNMG120408-MM	3.00	0.50	5.7	0.25	0.10	0.45
CNMG120408-MMC	2.00	0.25	3.00	0.30	0.15	0.40
CNMG120408-MR	4.00	1.50	8.00	0.50	0.35	0.55
CNMG120408-MR ¹⁾	3.00	2.00	7.60	0.30	0.15	0.55
CNMG120408-PF	0.40	0.30	1.50	0.20	0.10	0.40
CNMG120408-PM	3.00	0.50	5.5	0.30	0.15	0.50
CNMG120408-PMC	2.00	0.25	3.00	0.30	0.15	0.40
CNMG120408-PR	4.00	0.70	7.00	0.35	0.20	0.50
CNMG120408-QM	3.00	1.00	6.00	0.35	0.20	0.50
CNMG120408-SF	0.50	0.20	1.50	0.15	0.10	0.25
CNMG120408-SM	2.00	0.20	3.00	0.25	0.10	0.35
CNMG120408-SMC	1.00	0.25	3.00	0.25	0.15	0.35
CNMG120408-SMR	2.00	0.50	4.00	0.30	0.10	0.40
CNMG120408-WF	1.00	0.25	4.00	0.30	0.10	0.50
CNMG120408-WL	0.50	0.20	1.50	0.25	0.10	0.45
CNMG120408-WM	3.00	0.50	5.00	0.30	0.15	0.60
CNMG120408-WMX	3.00	0.50	5.00	0.45	0.15	0.70
CNMG120408-XF	1.00	0.20	4.00	0.20	0.05	0.25
CNMG120408-XM	2.50	0.50	5.00	0.25	0.10	0.40

1) Rostfrei.

Wendeplatte	Schnitttiefe			Vorschub		
	a_p = mm			f_n = mm/U		
	Empf.	Min.	Max.	Empf.	Min.	Max.
CNMG120408-XMR	3.00	0.50	6.00	0.30	0.15	0.50
CNMG120412-KF	1.00	0.20	2.50	0.25	0.10	0.35
CNMG120412-KM	3.00	0.30	6.00	0.40	0.15	0.60
CNMG120412-KR	3.50	0.50	7.00	0.50	0.25	0.70
CNMG120412-KRR	4.00	0.30	8.00	0.45	0.20	0.80
CNMG120412-MF	1.00	0.50	4.00	0.30	0.20	0.60
CNMG120412-MF ¹⁾	0.80	0.20	2.50	0.25	0.15	0.50
CNMG120412-MM	3.00	0.50	5.7	0.30	0.10	0.60
CNMG120412-MMC	2.00	0.40	3.00	0.35	0.15	0.50
CNMG120412-MR	4.00	1.50	8.00	0.50	0.35	0.75
CNMG120412-MR ¹⁾	3.00	2.00	7.60	0.35	0.15	0.60
CNMG120412-MRR	4.00	1.00	6.00	0.40	0.25	0.65
CNMG120412-PF	0.80	0.35	1.50	0.25	0.15	0.50
CNMG120412-PM	3.00	0.80	5.5	0.35	0.18	0.60
CNMG120412-PMC	2.00	0.40	3.00	0.35	0.15	0.50
CNMG120412-PR	4.00	1.00	7.00	0.40	0.25	0.70
CNMG120412-QM	3.00	1.00	6.00	0.35	0.25	0.60
CNMG120412-SF	0.80	0.40	2.00	0.17	0.12	0.30
CNMG120412-SM	2.00	0.30	3.50	0.28	0.12	0.38
CNMG120412-SMC	1.50	0.40	3.00	0.30	0.15	0.40
CNMG120412-SMR	2.00	0.50	4.00	0.32	0.12	0.42
CNMG120412-WF	1.50	0.40	4.00	0.50	0.20	0.60
CNMG120412-WM	3.50	0.80	6.00	0.50	0.20	0.90
CNMG120412-WMX	3.50	0.80	6.00	0.50	0.20	0.75
CNMG120412-XM	3.00	0.70	5.00	0.30	0.15	0.45
CNMG120412-XMR	3.00	0.75	6.00	0.32	0.18	0.55
CNMG120416-KM	3.00	0.30	6.00	0.45	0.20	0.70
CNMG120416-KR	3.50	0.75	7.00	0.61	0.28	0.85
CNMG120416-KRR	4.00	0.30	8.00	0.55	0.20	1.00
CNMG120416-MF	1.00	0.50	4.00	0.30	0.25	0.60
CNMG120416-MM	3.00	0.50	5.7	0.37	0.10	0.65
CNMG120416-MR	4.00	1.50	8.00	0.60	0.35	0.90
CNMG120416-MR ¹⁾	3.00	2.00	7.60	0.40	0.15	0.70
CNMG120416-MRR	4.00	1.50	6.00	0.50	0.32	0.70
CNMG120416-PM	3.00	1.00	5.5	0.40	0.23	0.65
CNMG120416-PR	4.00	1.50	7.00	0.50	0.32	0.75
CNMG120416-QM	3.00	1.00	6.00	0.40	0.30	0.65
CNMG120416-SMR	2.00	0.50	4.00	0.35	0.15	0.45
CNMG120416-XMR	3.50	1.00	6.00	0.35	0.21	0.60
CNMG160604-QM	3.00	1.00	8.00	0.25	0.18	0.30
CNMG160608-KM	4.00	0.20	8.00	0.35	0.15	0.50
CNMG160608-MM	4.00	0.50	7.20	0.25	0.10	0.45
CNMG160608-MMC	3.00	0.25	4.00	0.30	0.15	0.40
CNMG160608-MR	6.00	1.50	10.70	0.50	0.35	0.55
CNMG160608-PM	4.00	0.50	7.20	0.30	0.15	0.50
CNMG160608-PMC	3.00	0.25	4.00	0.30	0.15	0.40
CNMG160608-PR	5.00	0.70	8.00	0.35	0.20	0.50
CNMG160608-QM	3.00	1.00	8.00	0.35	0.20	0.50
CNMG160608-SMC	2.00	0.25	3.00	0.30	0.15	0.40
CNMG160608-WM	3.50	0.70	6.50	0.40	0.20	0.70
CNMG160608-WMX	3.00	0.50	5.00	0.45	0.15	0.70
CNMG160612-HM	4.00	1.00	8.00	0.50	0.25	0.80
CNMG160612-KM	4.00	0.30	8.00	0.40	0.15	0.60
CNMG160612-KR	4.70	0.80	9.30	0.55	0.28	0.77
CNMG160612-KRR	5.00	0.30	10.00	0.45	0.20	0.80
CNMG160612-MM	4.00	0.50	7.20	0.30	0.10	0.60
CNMG160612-MMC	3.00	0.50	4.00	0.35	0.15	0.50
CNMG160612-MR	6.00	2.00	10.70	0.60	0.35	0.75
CNMG160612-MR ¹⁾	4.00	2.00	10.00	0.35	0.15	0.60
CNMG160612-MRR	5.00	1.00	7.00	0.40	0.25	0.65
CNMG160612-PM	4.00	0.80	7.20	0.35	0.18	0.60
CNMG160612-PMC	3.00	0.50	4.00	0.35	0.15	0.50
CNMG160612-PR	5.00	1.00	8.00	0.40	0.25	0.70
CNMG160612-QM	3.00	1.00	8.00	0.35	0.25	0.60
CNMG160612-SM	4.00	1.00	6.00	0.25	0.20	0.35
CNMG160612-SMC	2.00	0.25	3.00	0.35	0.15	0.50
CNMG160612-WM	3.50	0.70	6.50	0.40	0.20	0.70
CNMG160612-WMX	3.50	0.80	6.00	0.50	0.20	0.75
CNMG160612-XMR	4.00	1.00	7.00	0.40	0.20	0.65
CNMG160616-HM	4.00	1.50	8.00	0.60	0.30	0.90
CNMG160616-KM	4.00	0.30	8.00	0.45	0.20	0.70
CNMG160616-KR	4.70	1.00	9.30	0.61	0.30	0.85

Empfohlene Schnitttiefe und Vorschub, metrisch**T-Max® P Wendeschneidplatten zum Drehen**

Wendeplatte	Schnitttiefe			Vorschub			Wendeplatte	Schnitttiefe			Vorschub		
	a_p = mm			f_n = mm/U				a_p = mm			f_n = mm/U		
	Empf.	Min.	Max.	Empf.	Min.	Max.		Empf.	Min.	Max.	Empf.	Min.	Max.
CNMG160616-KRR	5.00	0.30	10.00	0.55	0.20	1.00	CNMM160624-QR	6.00	2.00	10.70	0.60	0.35	1.50
CNMG160616-MM	4.00	0.50	7.20	0.37	0.10	0.65	CNMM190608-QR	6.00	2.00	12.00	0.50	0.35	0.60
CNMG160616-MMC	3.00	1.00	4.00	0.40	0.20	0.55	CNMM190612-MR	7.00	1.50	12.00	0.50	0.32	0.70
CNMG160616-MR	4.00	0.30	8.00	0.45	0.20	0.70	CNMM190612-PR	6.00	1.00	12.00	0.50	0.25	0.70
CNMG160616-MR ¹⁾	4.00	2.00	10.00	0.40	0.15	0.70	CNMM190612-QR	6.00	2.00	12.00	0.60	0.35	0.90
CNMG160616-MRR	5.00	1.50	7.00	0.50	0.30	0.75	CNMM190616-HR	10.00	2.40	13.00	0.80	0.50	1.10
CNMG160616-PM	4.00	1.00	7.20	0.40	0.23	0.65	CNMM190616-MR	7.00	1.80	12.00	0.55	0.35	0.90
CNMG160616-PMC	3.00	1.00	4.00	0.40	0.20	0.55	CNMM190616-PR	6.00	1.50	12.00	0.55	0.32	0.90
CNMG160616-PR	5.00	1.50	8.00	0.50	0.30	0.80	CNMM190616-QR	6.00	2.00	12.00	0.60	0.35	1.20
CNMG160616-QM	3.00	1.00	8.00	0.35	0.30	0.55	CNMM190616-WR	3.3	1.60	6.70	1.00	0.48	1.30
CNMG160616-SM	4.00	1.00	6.00	0.30	0.25	0.40	CNMM190624-HR	10.00	3.20	13.00	1.00	0.60	1.60
CNMG160616-SMC	2.00	0.50	3.00	0.40	0.20	0.55	CNMM190624-MR	7.00	2.50	12.00	0.60	0.40	1.20
CNMG160616-SMR	4.00	1.00	6.00	0.40	0.30	0.60	CNMM190624-PR	6.00	2.00	12.00	0.55	0.35	1.20
CNMG160616-XMR	4.00	1.00	7.00	0.45	0.25	0.70	CNMM190624-QR	6.00	2.00	12.00	0.60	0.35	1.20
CNMG160624-PR	5.00	2.00	8.00	0.50	0.32	0.90	CNMM250924-HR	10.00	3.20	17.00	1.00	0.60	1.60
CNMG190604-QM	3.00	1.00	8.00	0.25	0.18	0.30	CNMM250924-MR	9.00	2.50	15.00	0.65	0.45	1.40
CNMG190608-MM	4.00	0.50	8.50	0.25	0.10	0.45	CNMM250924-QR	8.00	2.50	15.00	0.65	0.40	1.30
CNMG190608-MR	6.00	1.50	12.00	0.50	0.35	0.55	CNMM250932-HR	10.00	4.00	17.00	1.00	0.60	1.80
CNMG190608-PM	4.00	0.50	8.60	0.30	0.15	0.50	CNMM250932-MR	3.00	0.80	5.5	0.35	0.18	0.60
CNMG190608-PR	5.00	0.70	10.00	0.35	0.20	0.50	CNMM250932-HR	3.00	0.30	6.00	0.40	0.15	0.60
CNMG190608-QM	3.00	1.00	8.00	0.35	0.20	0.50	CNMM250932-MR	3.00	0.80	5.5	0.35	0.18	0.60
CNMG190612-HM	4.00	1.00	10.00	0.50	0.25	0.80	CNMU120412-KM	3.00	0.30	6.00	0.40	0.15	0.60
CNMG190612-KM	4.50	0.30	9.00	0.40	0.15	0.60	CNMU120412-PM	3.00	0.80	5.5	0.35	0.18	0.60
CNMG190612-KR	7.00	1.00	14.00	0.55	0.28	0.77	CNMU120412-QM	3.00	1.00	6.00	0.35	0.25	0.60
CNMG190612-MM	4.00	0.50	8.50	0.30	0.10	0.60	CNMU120412-PR	4.00	1.50	7.00	0.50	0.32	0.75
CNMG190612-MR	6.00	2.00	12.00	0.60	0.35	0.75	CNMU120612-KM	3.00	0.30	6.00	0.40	0.15	0.60
CNMG190612-MR ¹⁾	4.00	2.00	11.40	0.35	0.15	0.60	CNMU120612-KR	3.50	0.50	7.00	0.50	0.25	0.70
CNMG190612-MRR	5.00	1.00	10.00	0.40	0.25	0.65	CNMU120612-PM	3.00	0.80	5.5	0.35	0.18	0.60
CNMG190612-PM	4.00	0.80	8.60	0.35	0.18	0.60	CNMU120612-PR	4.00	1.50	7.00	0.50	0.32	0.75
CNMG190612-PR	5.00	1.00	10.00	0.40	0.25	0.70	CNMU120612-PR	4.00	1.50	7.00	0.50	0.32	0.75
CNMG190612-QM	3.00	1.00	8.00	0.35	0.25	0.60	CNMU120612-PR	4.00	1.50	7.00	0.50	0.32	0.75
CNMG190612-SMR	6.00	1.00	9.00	0.35	0.25	0.42	CNMU120612-PR	4.00	1.50	7.00	0.50	0.32	0.75
CNMG190612-XMR	4.00	1.00	8.50	0.45	0.25	0.70	CNMU120612-PR	4.00	1.50	7.00	0.50	0.32	0.75
CNMG190616-HM	4.00	1.50	10.00	0.60	0.30	0.90	CNMU120612-PR	4.00	1.50	7.00	0.50	0.32	0.75
CNMG190616-KM	4.50	0.30	9.00	0.45	0.20	0.70	CNMU120612-PR	4.00	1.50	7.00	0.50	0.32	0.75
CNMG190616-KR	7.00	1.50	14.00	0.61	0.30	0.85	CNMU120612-PR	4.00	1.50	7.00	0.50	0.32	0.75
CNMG190616-MM	4.00	0.50	8.50	0.37	0.10	0.65	CNMU120612-PR	4.00	1.50	7.00	0.50	0.32	0.75
CNMG190616-MR	6.00	2.00	12.00	0.60	0.35	0.90	CNMU120612-PR	4.00	1.50	7.00	0.50	0.32	0.75
CNMG190616-MR ¹⁾	4.00	2.00	11.40	0.40	0.15	0.70	CNMU120612-PR	4.00	1.50	7.00	0.50	0.32	0.75
CNMG190616-MRR	5.00	1.50	10.00	0.50	0.30	0.75	CNMU120612-PR	4.00	1.50	7.00	0.50	0.32	0.75
CNMG190616-PM	4.00	1.00	8.60	0.40	0.23	0.65	CNMU120612-PR	4.00	1.50	7.00	0.50	0.32	0.75
CNMG190616-PR	5.00	1.50	10.00	0.50	0.30	0.80	CNMU120612-PR	4.00	1.50	7.00	0.50	0.32	0.75
CNMG190616-QM	3.00	1.00	8.00	0.40	0.30	0.65	CNMU120612-PR	4.00	1.50	7.00	0.50	0.32	0.75
CNMG190616-SM	6.00	1.00	9.00	0.30	0.25	0.40	CNMU120612-PR	4.00	1.50	7.00	0.50	0.32	0.75
CNMG190616-SMR	6.00	1.00	9.00	0.40	0.30	0.65	CNMU120612-PR	4.00	1.50	7.00	0.50	0.32	0.75
CNMG190616-XMR	4.00	1.00	8.50	0.50	0.25	0.80	CNMU120612-PR	4.00	1.50	7.00	0.50	0.32	0.75
CNMG190624-HM	5.00	2.00	10.00	0.60	0.30	1.20	CNMU120612-PR	4.00	1.50	7.00	0.50	0.32	0.75
CNMG190624-MR ¹⁾	4.00	2.00	11.40	0.50	0.15	1.00	CNMU120612-PR	4.00	1.50	7.00	0.50	0.32	0.75
CNMG190624-MRR	5.00	2.00	10.00	0.50	0.32	0.85	CNMU120612-PR	4.00	1.50	7.00	0.50	0.32	0.75
CNMG190624-PR	5.00	2.00	10.00	0.50	0.32	0.90	CNMU120612-PR	4.00	1.50	7.00	0.50	0.32	0.75
CNMG250924-PR	6.00	2.00	15.00	0.60	0.40	1.00	CNMU120612-PR	4.00	1.50	7.00	0.50	0.32	0.75
CNMM120408-MR	5.00	0.70	7.50	0.40	0.25	0.55	CNMU120612-PR	4.00	1.50	7.00	0.50	0.32	0.75
CNMM120408-PR	5.00	0.70	7.50	0.40	0.20	0.55	CNMU120612-PR	4.00	1.50	7.00	0.50	0.32	0.75
CNMM120408-QR	6.00	2.00	8.00	0.50	0.35	0.60	CNMU120612-PR	4.00	1.50	7.00	0.50	0.32	0.75
CNMM120408-WR	2.50	0.80	5.00	0.60	0.30	0.80	CNMU120612-PR	4.00	1.50	7.00	0.50	0.32	0.75
CNMM120412-MR	5.00	1.00	7.50	0.50	0.32	0.70	CNMU120612-PR	4.00	1.50	7.00	0.50	0.32	0.75
CNMM120412-PR	5.00	1.00	7.50	0.50	0.25	0.70	CNMU120612-PR	4.00	1.50	7.00	0.50	0.32	0.75
CNMM120412-QR	6.00	2.00	8.00	0.60	0.35	0.90	CNMU120612-PR	4.00	1.50	7.00	0.50	0.32	0.75
CNMM120412-WR	2.50	1.00	5.00	0.80	0.40	1.10	CNMU120612-PR	4.00	1.50	7.00	0.50	0.32	0.75
CNMM120416-MR	5.00	1.50	7.50	0.55	0.32	0.90	CNMU120612-PR	4.00	1.50	7.00	0.50	0.32	0.75
CNMM120416-PR	5.00	1.50	7.50	0.55	0.32	0.90	CNMU120612-PR	4.00	1.50	7.00	0.50	0.32	0.75
CNMM120416-QR	6.00	2.00	8.00	0.60	0.35	1.20	CNMU120612-PR	4.00	1.50	7.00	0.50	0.32	0.75
CNMM120416-WR	2.50	1.20	5.00	0.80	0.44	1.20	CNMU120612-PR	4.00	1.50	7.00	0.50	0.32	0.75
CNMM160608-PR	6.00	0.70	9.50	0.40	0.20	0.55	CNMU120612-PR	4.00	1.50	7.00	0.50	0.32	0.75
CNMM160608-QR	6.00	2.00	10.70	0.50	0.35	0.60	CNMU120612-PR	4.00	1.50	7.00	0.50	0.32	0.75
CNMM160612-MR	6.00	1.20	9.50	0.45	0.32	0.65	CNMU120612-PR	4.00	1.50	7.00	0.50	0.32	0.75
CNMM160612-PR	6.00	1.00	9.50	0.50	0.25	0.70	CNMU120612-PR	4.00	1.50	7.00	0.50	0.32	0.75
CNMM160612-QR	6.00	2.00	10.70	0.60	0.35	0.90	CNMU120612-PR	4.00	1.50	7.00	0.50	0.32	0.75
CNMM160612-WR	3.00	1.20	6.00	0.80	0.42	1.20	CNMU120612-PR	4.00	1.50	7.00	0.50	0.32	0.75
CNMM160616-MR	6.00	1.50	9.50	0.50	0.35	0.80	CNMU120612-PR	4.00	1.50	7.00	0.50	0.32	0.75
CNMM160616-PR	6.00	1.50	9.50	0.55	0.32	0.90	CNMU120612-PR	4.00	1.50	7.00	0.50	0.32	0.75
CNMM160616-QR	6.00	2.00	10.70	0.60	0.35	1.20	CNMU120612-PR	4.00	1.50	7.00	0.50	0.32	0.75
CNMM160616-WR	3.00	1.40	6.00	0.90	0.46	1.30	CNMU120612-PR	4.00	1.50	7.00	0.50	0.32	0.75

¹⁾ Rostfrei.

Empfohlene Schnitttiefe und Vorschub, metrisch

T-Max® P Wendeschneidplatten zum Drehen

Wendeplatte	Schnitttiefe			Vorschub		
	a_p = mm			f_n = mm/U		
	Empf.	Min.	Max.	Empf.	Min.	Max.
DNMG150404L-K	2.50	0.70	5.00	0.22	0.14	0.30
DNMG150404-MF	1.00	0.50	3.75	0.20	0.10	0.30
DNMG150404-MF ¹⁾	0.40	0.10	1.50	0.15	0.05	0.30
DNMG150404-MMC	2.50	0.25	4.00	0.25	0.10	0.40
DNMG150404-PF	0.40	0.25	1.50	0.15	0.07	0.30
DNMG150404-PM	3.00	0.40	6.00	0.20	0.10	0.30
DNMG150404-PMC	2.50	0.25	4.00	0.25	0.10	0.40
DNMG150404-QM	3.00	1.00	7.50	0.25	0.18	0.30
DNMG150404R-K	2.50	0.70	5.00	0.22	0.14	0.30
DNMG150404-SF	0.40	0.15	1.50	0.12	0.08	0.22
DNMG150404-SM	1.50	0.15	2.00	0.20	0.10	0.25
DNMG150404-SMC	0.50	0.25	3.00	0.20	0.10	0.30
DNMG150404-XF	0.75	0.15	4.00	0.15	0.04	0.20
DNMG150404-XM	2.50	0.30	5.00	0.18	0.08	0.25
DNMG150408-KF	0.50	0.15	2.00	0.20	0.10	0.30
DNMG150408-KM	2.50	0.20	5.00	0.35	0.15	0.50
DNMG150408-KR	3.50	0.38	7.00	0.34	0.17	0.47
DNMG150408-LC	0.50	0.20	1.50	0.20	0.10	0.30
DNMG150408L-K	3.00	0.80	5.00	0.30	0.14	0.50
DNMG150408-MF	1.00	0.50	3.75	0.25	0.15	0.50
DNMG150408-MF ¹⁾	0.40	0.10	1.50	0.20	0.10	0.40
DNMG150408-MM	3.00	0.50	6.40	0.25	0.10	0.45
DNMG150408-MMC	2.50	0.25	4.00	0.30	0.15	0.40
DNMG150408-MR	4.00	1.50	7.50	0.50	0.35	0.55
DNMG150408-MR ¹⁾	3.00	2.00	6.00	0.30	0.15	0.55
DNMG150408-PF	0.40	0.30	1.50	0.20	0.10	0.40
DNMG150408-PM	3.00	0.50	6.00	0.30	0.15	0.50
DNMG150408-PMC	2.50	0.25	4.00	0.30	0.15	0.40
DNMG150408-PR	4.00	0.70	6.00	0.35	0.20	0.50
DNMG150408-QM	3.00	1.00	7.50	0.35	0.20	0.50
DNMG150408R-K	3.00	0.80	5.00	0.30	0.14	0.50
DNMG150408-SF	0.50	0.20	1.50	0.15	0.10	0.25
DNMG150408-SM	2.00	0.20	2.50	0.22	0.10	0.28
DNMG150408-SMC	1.00	0.25	3.00	0.25	0.15	0.35
DNMG150408-SMR	1.50	0.15	2.50	0.20	0.10	0.25
DNMG150408-XF	1.00	0.20	4.00	0.20	0.05	0.25
DNMG150408-XM	2.50	0.50	5.00	0.25	0.10	0.40
DNMG150412-KM	2.50	0.30	5.00	0.40	0.15	0.60
DNMG150412-KR	3.50	0.50	7.00	0.45	0.23	0.63
DNMG150412-MF	1.00	0.50	3.75	0.30	0.20	0.60
DNMG150412-MF ¹⁾	0.80	0.20	2.50	0.25	0.15	0.50
DNMG150412-MM	3.00	0.50	6.40	0.30	0.10	0.60
DNMG150412-MMC	2.50	0.40	4.00	0.35	0.15	0.50
DNMG150412-MR	4.00	2.00	7.50	0.60	0.35	0.75
DNMG150412-MR ¹⁾	3.00	2.00	6.00	0.35	0.15	0.60
DNMG150412-MRR	4.00	1.00	6.00	0.40	0.25	0.65
DNMG150412-PF	0.80	0.35	1.50	0.25	0.15	0.50
DNMG150412-PM	3.00	0.80	6.00	0.35	0.18	0.60
DNMG150412-PMC	2.50	0.40	4.00	0.35	0.15	0.50
DNMG150412-PR	4.00	1.00	6.00	0.40	0.25	0.70
DNMG150412-QM	3.00	1.00	7.50	0.35	0.25	0.60
DNMG150412-SF	0.80	0.40	2.00	0.17	0.12	0.30
DNMG150412-SM	2.00	0.30	3.00	0.25	0.12	0.30
DNMG150412-SMC	1.50	0.40	3.00	0.30	0.15	0.40
DNMG150412-SMR	2.00	0.20	3.00	0.22	0.10	0.30
DNMG150416-MF	1.00	0.50	3.75	0.30	0.25	0.60
DNMG150416-MR ¹⁾	3.00	2.00	6.00	0.40	0.15	0.70
DNMG150416-MRR	4.00	1.50	6.00	0.50	0.30	0.70
DNMG150416-PR	4.00	1.50	6.00	0.50	0.30	0.75
DNMG150604-KF	0.50	0.15	2.00	0.15	0.08	0.25
DNMG150604-LC	0.25	0.10	1.50	0.10	0.05	0.25
DNMG150604L-K	2.50	0.70	5.00	0.22	0.14	0.30
DNMG150604-MF	1.00	0.50	3.75	0.20	0.10	0.30
DNMG150604-MF ¹⁾	0.40	0.10	1.50	0.15	0.05	0.30
DNMG150604-MMC	2.50	0.25	4.00	0.25	0.10	0.40
DNMG150604-PF	0.40	0.25	1.50	0.15	0.07	0.30
DNMG150604-PM	3.00	0.40	6.00	0.20	0.10	0.30
DNMG150604-PMC	2.50	0.25	4.00	0.25	0.10	0.40
DNMG150604-QM	3.00	1.00	7.50	0.25	0.18	0.30
DNMG150604R-K	2.50	0.70	5.00	0.22	0.14	0.30
DNMG150604-SF	0.40	0.15	1.50	0.12	0.08	0.22
DNMG150604-SM	1.50	0.15	2.00	0.20	0.10	0.25
DNMG150604-SMC	0.50	0.25	3.00	0.20	0.10	0.30

1) Rostfrei.

Wendeplatte	Schnitttiefe			Vorschub		
	a_p = mm			f_n = mm/U		
	Empf.	Min.	Max.	Empf.	Min.	Max.
DNMG150604-XF	1.00	0.20	4.00	0.20	0.05	0.25
DNMG150604-XM	2.50	0.50	5.00	0.25	0.10	0.35
DNMG150608-KF	0.50	0.15	2.00	0.20	0.10	0.30
DNMG150608-KM	2.50	0.20	5.00	0.35	0.15	0.50
DNMG150608-KR	3.50	0.38	7.00	0.34	0.17	0.47
DNMG150608-LC	0.50	0.20	1.50	0.20	0.10	0.30
DNMG150608L-K	3.00	0.80	5.00	0.30	0.14	0.50
DNMG150608-MF	1.00	0.50	3.75	0.25	0.15	0.50
DNMG150608-MF ¹⁾	0.40	0.10	1.50	0.20	0.10	0.40
DNMG150608-MM	3.00	0.50	6.40	0.25	0.10	0.45
DNMG150608-MMC	2.50	0.25	4.00	0.30	0.15	0.40
DNMG150608-MR	4.00	1.50	7.50	0.40	0.35	0.55
DNMG150608-MR ¹⁾	3.00	2.00	6.00	0.30	0.15	0.55
DNMG150608-PF	0.40	0.30	1.50	0.20	0.10	0.40
DNMG150608-PM	3.00	0.50	6.00	0.30	0.15	0.50
DNMG150608-PMC	2.50	0.25	4.00	0.30	0.15	0.40
DNMG150608-PR	4.00	0.70	6.00	0.35	0.20	0.50
DNMG150608-QM	3.00	1.00	7.50	0.35	0.20	0.50
DNMG150608R-K	3.00	0.80	5.00	0.30	0.14	0.50
DNMG150608-SF	0.50	0.20	1.50	0.15	0.10	0.25
DNMG150608-SM	2.00	0.20	2.50	0.22	0.10	0.28
DNMG150608-SMC	1.00	0.25	3.00	0.25	0.15	0.35
DNMG150608-SMR	1.50	0.15	2.50	0.20	0.10	0.25
DNMG150608-XF	0.75	0.15	4.00	0.15	0.04	0.20
DNMG150608-XM	2.50	0.30	5.00	0.25	0.10	0.40
DNMG150612-KF	1.00	0.20	2.50	0.25	0.10	0.35
DNMG150612-KM	2.50	0.30	5.00	0.40	0.15	0.60
DNMG150612-KR	3.50	0.50	7.00	0.45	0.23	0.63
DNMG150612-MF	1.00	0.50	3.75	0.30	0.20	0.60
DNMG150612-MF ¹⁾	0.80	0.20	2.50	0.50	0.25	0.60
DNMG150612-MM	3.00	0.50	6.40	0.30	0.10	0.60
DNMG150612-MMC	2.50	0.40	4.00	0.35	0.15	0.50
DNMG150612-MR	4.00	2.00	7.50	0.50	0.35	0.75
DNMG150612-MR ¹⁾	3.00	2.00	6.00	0.35	0.15	0.60
DNMG150612-MRR	4.00	1.00	6.00	0.40	0.25	0.65
DNMG150612-PF	0.80	0.35	1.50	0.25	0.15	0.50
DNMG150612-PM	3.00	0.80	6.00	0.35	0.18	0.60
DNMG150612-PMC	2.50	0.40	4.00	0.35	0.15	0.50
DNMG150612-PR	4.00	1.00	6.00	0.40	0.25	0.70
DNMG150612-QM	3.00	1.00	7.50	0.35	0.25	0.60
DNMG150612-SF	0.80	0.40	2.00	0.17	0.12	0.30
DNMG150612-SM	2.00	0.30	3.00	0.25	0.12	0.30
DNMG150612-SMC	1.50	0.40	3.00	0.30	0.15	0.40
DNMG150612-SMR	2.00	0.20	3.00	0.22	0.10	0.30
DNMG150612-XM	3.00	0.70	5.00	0.28	0.15	0.45
DNMG150612-XMR	3.00	0.75	6.00	0.30	0.18	0.50
DNMG150616-KR	3.50	0.75	7.00	0.50	0.25	0.69
DNMG150616-MR	4.00	2.00	7.50	0.60	0.35	0.90
DNMG150616-MR ¹⁾	3.00	2.00	6.00	0.40	0.15	0.70
DNMG150616-MRR	4.00	1.50	6.00	0.50	0.32	0.70
DNMG150616-PM	3.00	1.00	6.00	0.40	0.23	0.65
DNMG150616-PR	4.00	1.50	6.00	0.50	0.32	0.75
DNMG150616-QM	3.00	1.00	7.50	0.40	0.30	0.65
DNMG150616-SMR	2.00	0.30	3.00	0.25	0.12	0.30
DNMG190608-PR	5.00	1.00	8.00	0.35	0.20	0.50
DNMM190612-PR	5.00	1.20	8.00	0.40	0.25	0.70
DNMM150412-QR	6.00	2.00	9.2	0.60	0.35	0.90
DNMM150608-MR	5.00	0.70	6.00	0.40	0.25	0.55
DNMM150608-PR	5.00	0.70	6.00	0.40	0.20	0.55
DNMM150608-QR	6.00	2.00	9.2	0.50	0.35	0.60
DNMM150612-MR	5.00	1.00	6.00	0.50	0.32	0.70
DNMM150612-PR	5.00	1.00	6.00	0.50	0.25	0.70
DNMM150612-QR	6.00	2.00	9.2	0.60	0.35	0.90
DNMM150616-PR	5.00	1.50	6.00	0.55	0.32	0.90
DNMM150616-QR	6.00	2.00	9.2	0.60	0.35	1.20
DNMX110404-WF	1.00	0.20	1.50	0.20	0.08	0.30
DNMX110408-WF	1.00	0.20	3.00	0.30	0.10	0.40
DNMX110408-WM	1.50	0.50	3.50	0.35	0.15	0.50
DNMX110412-WM	2.00	0.50	4.00	0.45	0.15	0.60
DNMX150404-WF	0.80	0.20	3.00	0.20	0.08	0.30
DNMX150408-WF	1.50	0.20	3.00	0.30	0.10	0.40
DNMX150408-WM	2.00	0.50	4.50	0.35	0.15	0.50
DNMX150408-WMX	3.00	0.50	5.00	0.45	0.15	0.70

Empfohlene Schnitttiefe und Vorschub, metrisch**T-Max[®] P Wendeschneidplatten zum Drehen**

Wendeplatte	Schnitttiefe			Vorschub		
	a_p = mm			f_n = mm/U		
	Empf.	Min.	Max.	Empf.	Min.	Max.
DNMX150412-WF	1.50	0.40	3.50	0.40	0.15	0.55
DNMX150412-WM	2.50	0.50	5.00	0.45	0.15	0.60
DNMX150412-WMX	3.50	0.80	6.00	0.50	0.20	0.75
DNMX150416-WM	3.50	0.50	6.00	0.60	0.20	0.80
DNMX150416-WMX	3.50	0.50	6.00	0.50	0.20	0.80
DNMX150604-WF	0.80	0.20	3.00	0.20	0.08	0.30
DNMX150608-WF	1.50	0.20	3.00	0.30	0.10	0.40
DNMX150608-WM	2.00	0.50	4.50	0.35	0.15	0.50
DNMX150608-WMX	3.00	0.50	5.00	0.45	0.15	0.70
DNMX150612-WF	1.50	0.40	3.50	0.40	0.15	0.55
DNMX150612-WM	2.50	0.50	5.00	0.45	0.15	0.60
DNMX150612-WMX	3.50	0.80	6.00	0.50	0.20	0.75
DNMX150616-WM	3.50	0.50	6.00	0.60	0.20	0.80
DNMX150616-WMX	3.50	0.50	6.00	0.50	0.20	0.80
LNMX191940-PM	5.00	2.00	10.00	0.90	0.70	1.20
LNMX301940-PM	7.00	2.00	20.00	0.90	0.70	1.20
LNMX301940-PR	7.00	2.00	20.00	0.90	0.70	1.20
LNMX501432-XH	25.00	5.00	34.00	1.70	1.50	2.50
LNMX191940-PF	5.00	2.00	10.00	0.90	0.70	1.20
LNMX191940-PM	5.00	2.00	10.00	0.90	0.70	1.20
LNMX301940-PR	7.00	2.00	20.00	0.90	0.70	1.20
RNMG090300	2.25	0.90	4.50	0.138	0.061	0.276
RNMG120400	3.00	1.20	4.80	0.184	0.073	0.368
RNMG150600	3.75	1.50	7.50	0.23	0.103	0.461
RNMG190600	4.25	1.90	7.60	0.30	0.12	0.60
RNMG250900	6.25	2.50	10.00	0.392	0.156	0.784
RNMG381200-MR	4.00	1.50	8.00	12.00	4.00	16.00
RNMG5018M0-MR	6.00	2.00	12.00	14.00	7.00	18.00
SNMA090308-KR	2.50	0.38	4.50	0.38	0.19	0.53
SNMA120408-KR	4.00	0.20	8.00	0.35	0.15	0.60
SNMA120412-KR	4.00	0.30	8.00	0.45	0.20	0.80
SNMA120416-KR	4.00	0.30	8.00	0.55	0.20	1.00
SNMA150612-KR	5.00	0.30	10.00	0.45	0.20	0.80
SNMA150616-KR	5.00	0.30	10.00	0.55	0.20	1.00
SNMA190608-KR	6.00	0.20	12.00	0.35	0.15	0.60
SNMA190612-KR	6.00	0.30	12.00	0.45	0.20	0.80
SNMA190616-KR	6.00	0.30	12.00	0.55	0.20	1.00
SNMA250724-KR	6.00	0.40	12.00	0.60	0.20	1.40
SNMG090304-MF	1.00	0.50	3.00	0.20	0.10	0.30
SNMG090304-PM	2.00	0.40	4.50	0.20	0.10	0.30
SNMG090304-QM	3.00	1.00	4.50	0.25	0.18	0.30
SNMG090308-KM	2.50	0.20	4.50	0.35	0.15	0.50
SNMG090308-MF	1.00	0.50	3.00	0.25	0.15	0.50
SNMG090308-PM	2.00	0.50	4.50	0.30	0.15	0.50
SNMG090308-QM	3.00	1.00	4.50	0.35	0.20	0.50
SNMG090312-MF	1.00	0.50	3.00	0.30	0.20	0.60
SNMG090312-QM	3.00	1.00	4.50	0.35	0.25	0.50
SNMG120404-MF	1.00	0.50	4.00	0.20	0.10	0.30
SNMG120404-MF ¹⁾	0.40	0.10	1.50	0.15	0.05	0.30
SNMG120404-MMC	2.00	0.25	3.00	0.25	0.10	0.40
SNMG120404-PM	3.00	0.40	6.00	0.20	0.10	0.30
SNMG120404-PMC	2.00	0.25	3.00	0.25	0.10	0.40
SNMG120404-QM	3.00	1.00	6.00	0.25	0.18	0.30
SNMG120404-SMC	0.50	0.25	3.00	0.20	0.10	0.30
SNMG120408-KM	3.00	0.20	6.00	0.35	0.15	0.50
SNMG120408-KR	3.50	0.38	7.00	0.38	0.19	0.53
SNMG120408-MF	1.00	0.50	4.00	0.25	0.15	0.50
SNMG120408-MF ¹⁾	0.40	0.10	1.50	0.20	0.10	0.40
SNMG120408-MM	3.00	0.50	6.35	0.25	0.10	0.45
SNMG120408-MMC	2.00	0.25	3.00	0.30	0.15	0.40
SNMG120408-MR	4.00	1.50	8.00	0.50	0.35	0.55
SNMG120408-MR ¹⁾	3.00	2.00	7.60	0.30	0.15	0.55
SNMG120408-PF	0.40	0.30	1.50	0.20	0.10	0.40
SNMG120408-PM	3.00	0.50	6.00	0.30	0.15	0.50
SNMG120408-PMC	2.00	0.25	3.00	0.30	0.15	0.40
SNMG120408-PR	4.00	0.70	7.00	0.35	0.20	0.50
SNMG120408-QM	3.00	1.00	6.00	0.35	0.20	0.50
SNMG120408-SM	2.00	0.50	5.00	0.22	0.15	0.40
SNMG120408-SMC	1.00	0.25	3.00	0.25	0.15	0.35
SNMG120408-SMR	2.00	0.50	5.00	0.25	0.15	0.40
SNMG120408-XM	3.00	0.50	6.00	0.30	0.12	0.50
SNMG120408-XMR	3.00	0.50	6.00	0.35	0.15	0.55
SNMG120412-KM	3.00	0.30	6.00	0.40	0.15	0.60

1) Rostfrei.

Wendeplatte	Schnitttiefe			Vorschub		
	a_p = mm			f_n = mm/U		
	Empf.	Min.	Max.	Empf.	Min.	Max.
SNMG120412-KR	3.50	0.50	7.00	0.50	0.28	0.70
SNMG120412-KRR	4.00	0.30	8.00	0.45	0.20	0.80
SNMG120412-MF	1.00	0.50	4.00	0.30	0.20	0.60
SNMG120412-MM	3.00	0.50	6.35	0.30	0.10	0.60
SNMG120412-MMC	2.00	0.40	3.00	0.35	0.15	0.50
SNMG120412-MR	4.00	2.00	8.00	0.60	0.35	0.75
SNMG120412-MR ¹⁾	3.00	2.00	7.60	0.35	0.15	0.60
SNMG120412-MRR	4.00	1.00	6.00	0.40	0.25	0.65
SNMG120412-PF	0.80	0.35	1.50	0.25	0.15	0.50
SNMG120412-PM	3.00	0.80	6.00	0.35	0.18	0.60
SNMG120412-PMC	2.00	0.40	3.00	0.35	0.15	0.50
SNMG120412-PR	4.00	1.00	7.00	0.40	0.25	0.70
SNMG120412-QM	3.00	1.00	6.00	0.35	0.25	0.60
SNMG120412-SM	2.00	0.50	5.00	0.28	0.18	0.45
SNMG120412-SMC	1.50	0.40	3.00	0.30	0.15	0.40
SNMG120412-SMR	2.00	0.50	5.00	0.30	0.18	0.45
SNMG120412-XM	3.50	0.50	6.00	0.35	0.15	0.60
SNMG120412-XMR	3.00	0.75	6.00	0.35	0.18	0.60
SNMG120416-KM	3.00	0.30	6.00	0.45	0.20	0.70
SNMG120416-KR	3.50	0.75	7.00	0.55	0.28	0.77
SNMG120416-KRR	4.00	0.30	8.00	0.55	0.20	1.00
SNMG120416-MF	1.00	0.50	4.00	0.30	0.25	0.60
SNMG120416-MM	3.00	0.50	6.35	0.37	0.10	0.65
SNMG120416-MR	4.00	2.00	8.00	0.60	0.35	0.90
SNMG120416-PM	3.00	1.00	6.00	0.40	0.23	0.65
SNMG120416-PR	4.00	1.50	7.00	0.50	0.32	0.75
SNMG120416-QM	3.00	1.00	6.00	0.40	0.30	0.65
SNMG120416-SM	2.00	0.50	5.00	0.33	0.18	0.50
SNMG120416-SMR	2.00	0.50	5.00	0.35	0.18	0.50
SNMG120416-XM	3.50	1.00	6.00	0.40	0.20	0.65
SNMG150608-PR	5.00	1.50	8.00	0.35	0.20	0.50
SNMG150608-QM	3.00	1.00	8.00	0.35	0.20	0.50
SNMG150612-HM	4.00	1.00	8.00	0.50	0.25	0.80
SNMG150612-KM	4.00	0.30	8.00	0.40	0.15	0.60
SNMG150612-KR	4.4	0.63	8.8	0.55	0.28	0.77
SNMG150612-MM	4.00	0.50	8.00	0.30	0.10	0.60
SNMG150612-MR	6.00	2.00	10.70	0.60	0.35	0.75
SNMG150612-MR ¹⁾	4.00	2.00	9.6	0.35	0.15	0.60
SNMG150612-MRR	5.00	1.00	7.00	0.40	0.25	0.65
SNMG150612-PM	4.00	0.80	7.50	0.35	0.18	0.60
SNMG150612-PR	5.00	1.00	8.00	0.40	0.25	0.70
SNMG150612-QM	3.00	1.00	8.00	0.35	0.25	0.60
SNMG150612-SM	5.00	1.00	8.00	0.30	0.20	0.40
SNMG150616-HM	4.00	1.50	8.00	0.60	0.30	0.90
SNMG150616-KM	4.00	0.30	8.00	0.45	0.20	0.70
SNMG150616-KR	4.4	0.94	8.8	0.61	0.30	0.85
SNMG150616-KRR	5.00	0.30	10.00	0.55	0.20	1.00
SNMG150616-MM	4.00	0.50	8.00	0.37	0.10	0.65
SNMG150616-MR	6.00	2.00	10.70	0.60	0.35	0.90
SNMG150616-MR ¹⁾	4.00	2.00	9.6	0.40	0.15	0.70
SNMG150616-MRR	5.00	1.50	8.00	0.50	0.30	0.75
SNMG150616-PM	4.00	1.00	7.50	0.40	0.23	0.65
SNMG150616-PR	5.00	1.50	8.00	0.50	0.30	0.80
SNMG150616-QM	5.00	1.50	8.00	0.50	0.30	0.80
SNMG150616-SM	5.00	1.00	8.00	0.35	0.25	0.45
SNMG150616-SMR	5.00	1.00	8.00	0.50	0.30	0.70
SNMG150624-PR	5.00	2.00	8.00	0.50	0.32	0.90
SNMG190608-MR	6.00	1.50	12.00	0.50	0.35	0.55
SNMG190608-PR	5.00	0.70	10.00	0.35	0.20	0.50
SNMG190608-QM	5.00	0.70	10.00	0.35	0.20	0.50
SNMG190612-HM	4.00	1.00	10.00	0.50	0.25	0.80
SNMG190612-KM	4.50	0.30	9.00	0.40	0.15	0.60
SNMG190612-MM	4.00	0.50	9.50	0.30	0.10	0.60
SNMG190612-MR	6.00	2.00	12.00	0.60	0.35	0.75
SNMG190612-MR ¹⁾	4.00	2.00	11.40	0.35	0.15	0.60
SNMG190612-MRR	5.00	1.00	10.00	0.40	0.25	0.65
SNMG190612-PR	5.00	1.00	10.00	0.40	0.25	0.70
SNMG190612-QM	5.00	1.00	10.00	0.40	0.25	0.70
SNMG190612-SM	6.00	1.00	9.00	0.35	0.25	0.42
SNMG190612-SMR	5.00	1.00	10.00	0.50	0.25	0.70
SNMG190612-XMR	5.00	1.00	10.00	0.50	0.25	0.70
SNMG190616-HM	4.00	1.50	10.00	0.60	0.30	0.90
SNMG190616-KM	4.50	0.30	9.00	0.45	0.20	0.70
SNMG190616-KR	6.1	1.31	12.3	0.61	0.30	0.85

Empfohlene Schnitttiefe und Vorschub, metrisch**T-Max® P Wendeschneidplatten zum Drehen**

Wendeplatte	Schnitttiefe			Vorschub		
	a_p = mm			f_n = mm/U		
	Empf.	Min.	Max.	Empf.	Min.	Max.
SNMG190616-MM	4.00	0.50	9.50	0.37	0.10	0.65
SNMG190616-MR	6.00	2.00	12.00	0.60	0.35	0.90
SNMG190616-MR ¹⁾	4.00	2.00	11.40	0.40	0.15	0.70
SNMG190616-MRR	5.00	1.50	10.00	0.50	0.30	0.75
SNMG190616-PR	5.00	1.50	10.00	0.50	0.30	0.80
SNMG190616-QM	3.00	1.00	8.00	0.40	0.30	0.65
SNMG190616-SM	7.00	2.00	10.00	0.35	0.25	0.45
SNMG190616-SMR	7.00	1.00	10.00	0.50	0.30	0.70
SNMG190616-XMR	5.00	1.00	10.00	0.55	0.30	0.80
SNMG190624-HM	5.00	2.00	10.00	0.60	0.30	1.20
SNMG190624-MR ¹⁾	4.00	2.00	11.40	0.50	0.15	1.00
SNMG190624-MRR	5.00	2.00	10.00	0.50	0.32	0.85
SNMG190624-PR	5.00	2.00	10.00	0.50	0.32	0.90
SNMG250716-PR	6.00	2.00	15.00	0.80	0.40	1.00
SNMG250724-KR	7.00	2.00	14.00	0.86	0.43	1.21
SNMG250724-MR	6.00	2.00	12.00	0.60	0.40	1.20
SNMG250724-PR	6.00	2.00	15.00	1.00	0.40	1.20
SNMG250924-HM	6.00	2.00	15.00	0.80	0.40	1.20
SNMG250924-MR	6.00	2.00	12.00	0.60	0.40	1.20
SNMG250924-PR	6.00	2.00	15.00	1.00	0.40	1.20
SNMM120408-MR	5.00	0.70	7.50	0.40	0.25	0.55
SNMM120408-PR	5.00	0.70	7.50	0.40	0.20	0.55
SNMM120408-QR	6.00	2.00	8.00	0.50	0.35	0.60
SNMM120412-MR	5.00	1.00	7.50	0.50	0.32	0.70
SNMM120412-PR	5.00	1.00	7.50	0.50	0.25	0.70
SNMM120412-QR	6.00	2.00	8.00	0.60	0.35	0.90
SNMM120416-MR	5.00	1.50	7.50	0.55	0.32	0.90
SNMM120416-QR	6.00	2.00	8.00	0.60	0.35	1.20
SNMM150608-QR	6.00	2.00	10.00	0.50	0.35	0.60
SNMM150612-MR	6.00	1.00	9.00	0.50	0.32	0.70
SNMM150612-PR	6.00	1.00	9.00	0.50	0.25	0.70
SNMM150612-QR	6.00	2.00	10.00	0.60	0.35	0.90
SNMM150616-MR	6.00	1.50	9.00	0.55	0.40	0.90
SNMM150616-PR	6.00	1.50	9.00	0.55	0.32	0.90
SNMM150616-QR	6.00	2.00	10.00	0.60	0.35	1.20
SNMM150624-QR	6.00	2.00	10.00	0.60	0.35	1.50
SNMM190608-QR	6.00	2.00	12.00	0.50	0.35	0.60
SNMM190612-MR	7.00	1.50	12.00	0.50	0.32	0.70
SNMM190612-PR	6.00	1.00	12.00	0.50	0.25	0.70
SNMM190612-QR	6.00	2.00	12.00	0.60	0.35	0.90
SNMM190616-HR	10.00	2.40	13.00	0.80	0.50	1.10
SNMM190616-MR	7.00	1.80	12.00	0.55	0.45	0.90
SNMM190616-PR	6.00	1.50	12.00	0.55	0.32	0.90
SNMM190616-QR	6.00	2.00	12.00	0.60	0.35	1.20
SNMM190624-HR	10.00	3.20	13.00	1.00	0.60	1.60
SNMM190624-MR	7.00	2.50	12.00	0.60	0.40	1.20
SNMM190624-PR	6.00	2.00	12.00	0.55	0.35	1.20
SNMM190624-QR	6.00	2.00	12.00	0.60	0.35	1.50
SNMM190632-MR	6.00	3.50	12.00	0.60	0.45	1.20
SNMM250724	6.00	2.00	12.00	0.60	0.35	1.20
SNMM250724-HR	10.00	3.20	17.00	1.00	0.60	1.60
SNMM250724-MR	9.00	2.80	18.00	0.70	0.45	1.40
SNMM250724-QR	8.00	2.50	15.00	0.65	0.40	1.30
SNMM250732-HR	10.00	4.00	17.00	1.00	0.60	1.80
SNMM250732-MR	8.00	2.00	15.00	0.60	0.45	1.40
SNMM250924-HR	10.00	3.20	17.00	1.00	0.60	1.60
SNMM250924-MR	9.00	2.80	18.00	0.70	0.45	1.40
SNMM250932-HR	10.00	4.00	17.00	1.00	0.60	1.80
SNMU120416-KM	3.00	0.30	6.00	0.45	0.20	0.70
TNMA160404-KR	2.50	0.20	5.00	0.20	0.10	0.30
TNMA160408-KR	3.50	0.20	7.00	0.35	0.15	0.60
TNMA160412-KR	3.50	0.30	7.00	0.45	0.20	0.80
TNMA160416-KR	3.50	0.30	7.00	0.55	0.20	1.00
TNMA220404-KR	2.50	0.20	10.00	0.20	0.10	0.30
TNMA220408-KR	5.00	0.20	10.00	0.35	0.15	0.60
TNMA220412-KR	5.00	0.30	10.00	0.45	0.20	0.80
TNMA220416-KR	5.00	0.30	10.00	0.55	0.20	1.00
TNMA220432-KR	5.00	0.50	10.00	0.60	0.50	1.20
TNMA270616-KR	5.00	0.30	12.00	0.50	0.20	1.00
TNMG110302-MF	1.00	0.50	2.75	0.10	0.07	0.15
TNMG110304-MF	1.00	0.50	2.75	0.20	0.10	0.30
TNMG110304-QM	3.00	1.00	3.85	0.25	0.18	0.30
TNMG110308-MF	1.00	0.50	2.75	0.25	0.15	0.50

1) Rostfrei.

Wendeplatte	Schnitttiefe			Vorschub		
	a_p = mm			f_n = mm/U		
	Empf.	Min.	Max.	Empf.	Min.	Max.
TNMG110308-QM	3.00	1.00	3.85	0.35	0.20	0.50
TNMG110312-MF	1.00	0.50	2.75	0.30	0.20	0.60
TNMG160304-QM	3.00	1.00	5.00	0.25	0.18	0.30
TNMG160308-QM	4.75	1.50	8.00	0.50	0.25	0.56
TNMG160404-KF	0.50	0.15	2.00	0.15	0.08	0.25
TNMG160404-LC	0.25	0.10	1.50	0.10	0.05	0.25
TNMG160404-LK	2.50	0.70	5.00	0.22	0.14	0.30
TNMG160404-MF	1.00	0.50	4.00	0.20	0.10	0.30
TNMG160404-MF ¹⁾	0.40	0.10	1.50	0.15	0.05	0.30
TNMG160404-MMC	2.00	0.25	3.00	0.25	0.10	0.40
TNMG160404-PF	0.40	0.25	1.50	0.15	0.07	0.30
TNMG160404-PM	3.00	0.40	5.00	0.20	0.10	0.30
TNMG160404-PMC	2.00	0.25	3.00	0.25	0.10	0.40
TNMG160404-QM	3.00	1.00	5.60	0.25	0.18	0.30
TNMG160404R-K	2.50	0.70	5.00	0.22	0.14	0.30
TNMG160404-SF	0.40	0.15	1.50	0.12	0.08	0.22
TNMG160404-SMC	0.50	0.25	3.00	0.20	0.10	0.30
TNMG160404-XF	0.75	0.15	4.00	0.15	0.04	0.20
TNMG160404-XM	2.50	0.30	5.00	0.18	0.08	0.30
TNMG160408-KF	0.50	0.15	2.00	0.20	0.10	0.30
TNMG160408-KM	3.00	0.20	5.5	0.35	0.15	0.50
TNMG160408-KR	3.20	0.34	6.20	0.30	0.17	0.42
TNMG160408-KRR	3.50	0.20	7.00	0.35	0.15	0.60
TNMG160408-LC	0.50	0.20	1.50	0.20	0.10	0.30
TNMG160408L-K	3.00	0.80	5.00	0.30	0.14	0.50
TNMG160408-MF	1.00	0.50	4.00	0.25	0.15	0.50
TNMG160408-MF ¹⁾	0.40	0.10	1.50	0.20	0.10	0.40
TNMG160408-MM	3.00	0.50	4.80	0.25	0.10	0.45
TNMG160408-MMC	2.00	0.25	3.00	0.30	0.15	0.40
TNMG160408-MR	3.00	1.50	8.00	0.40	0.25	0.55
TNMG160408-MR ¹⁾	3.00	2.00	5.60	0.30	0.15	0.55
TNMG160408-PF	0.40	0.30	1.50	0.20	0.10	0.40
TNMG160408-PM	3.00	0.50	5.00	0.30	0.15	0.50
TNMG160408-PMC	2.00	0.25	3.00	0.30	0.15	0.40
TNMG160408-PR	3.00	0.70	6.00	0.35	0.20	0.55
TNMG160408-QM	3.00	1.00	5.60	0.35	0.20	0.50
TNMG160408R-K	3.00	0.80	5.00	0.30	0.14	0.50
TNMG160408-SF	0.50	0.20	1.50	0.15	0.10	0.25
TNMG160408-SM	2.00	0.20	3.00	0.22	0.10	0.28
TNMG160408-SMC	1.00	0.25	3.00	0.25	0.15	0.35
TNMG160408-XF	1.00	0.20	4.00	0.20	0.05	0.25
TNMG160408-XM	2.50	0.50	5.00	0.25	0.10	0.40
TNMG160408-XMR	3.00	0.50	5.00	0.27	0.15	0.45
TNMG160412-KM	3.00	0.30	5.5	0.40	0.15	0.60
TNMG160412-KR	3.20	0.45	6.3	0.40	0.20	0.56
TNMG160412-KRR	3.50	0.30	7.00	0.45	0.20	0.80
TNMG160412-MF	1.00	0.50	4.00	0.30	0.20	0.60
TNMG160412-MF ¹⁾	0.80	0.20	2.50	0.25	0.15	0.50
TNMG160412-MM	3.00	0.50	4.80	0.30	0.10	0.60
TNMG160412-MMC	2.00	0.40	3.00	0.35	0.15	0.50
TNMG160412-MR	3.00	2.00	8.00	0.50	0.25	0.65
TNMG160412-MR ¹⁾	3.00	2.00	5.60	0.35	0.15	0.60
TNMG160412-MRR	3.00	1.00	6.00	0.40	0.25	0.60
TNMG160412-PF	0.80	0.35	1.50	0.25	0.15	0.50
TNMG160412-PM	3.00	0.80	5.00	0.35	0.18	0.60
TNMG160412-PMC	2.00	0.40	3.00	0.35	0.15	0.50
TNMG160412-PR	3.00	1.00	6.00	0.40	0.25	0.65
TNMG160412-QM	3.00	1.00	5.60	0.35	0.25	0.60
TNMG160412-SF	0.80	0.40	2.00	0.17	0.12	0.30
TNMG160412-SM	2.00	0.30	3.00	0.25	0.12	0.30
TNMG160412-SMC	1.50	0.40	3.00	0.30	0.15	0.40
TNMG160412-XF	1.25	0.40	4.00	0.25	0.08	0.30
TNMG160412-XM	3.00	0.70	5.00	0.30	0.15	0.45
TNMG160412-XMR	3.00	0.75	5.00	0.30	0.18	0.48
TNMG160416-KR	3.20	0.68	6.20	0.44	0.22	0.62
TNMG160416-MF	1.00	0.50	4.00	0.30	0.25	0.60
TNMG220404-MF	1.00	0.50	4.00	0.20	0.10	0.30
TNMG220404-PM	4.00	0.40	6.60	0.20	0.10	0.30
TNMG220404-QM	3.00	1.00	7.70	0.25	0.18	0.30
TNMG220408-KM	4.00	0.20	8.00	0.35	0.15	0.50
TNMG220408-KR	3.50	0.38	7.00	0.38	0.19	0.53
TNMG220408-MF	1.00	0.50	4.00	0.25	0.15	0.50
TNMG220408-MM	4.00	0.50	6.60	0.25	0.10	0.45

Empfohlene Schnitttiefe und Vorschub, metrisch

B T-Max® P Wendeschneidplatten zum Drehen

Wendeplatte	Schnitttiefe			Vorschub		
	a_p = mm			f_n = mm/U		
	Empf.	Min.	Max.	Empf.	Min.	Max.
TNMG220408-MR	5.00	1.50	11.00	0.50	0.35	0.55
TNMG220408-MR ¹⁾	4.00	2.00	7.70	0.30	0.15	0.55
TNMG220408-PF	0.40	0.30	1.50	0.20	0.10	0.40
TNMG220408-PM	4.00	0.50	6.60	0.30	0.15	0.50
TNMG220408-PR	4.00	0.70	7.00	0.35	0.20	0.55
TNMG220408-QM	3.00	1.00	7.70	0.35	0.20	0.50
TNMG220408-SM	2.00	0.20	4.00	0.22	0.10	0.28
TNMG220412-KM	4.00	0.30	8.00	0.40	0.15	0.60
TNMG220412-KR	3.50	0.50	7.00	0.50	0.25	0.70
TNMG220412-MF	1.00	0.50	4.00	0.30	0.20	0.60
TNMG220412-MM	4.00	0.50	6.60	0.30	0.10	0.60
TNMG220412-MR	6.00	2.00	11.00	0.60	0.35	0.75
TNMG220412-MR ¹⁾	4.00	2.00	7.70	0.35	0.15	0.60
TNMG220412-MRR	4.00	1.00	7.00	0.40	0.25	0.60
TNMG220412-PF	0.80	0.35	1.50	0.25	0.15	0.50
TNMG220412-PM	4.00	0.80	6.60	0.35	0.18	0.60
TNMG220412-PR	4.00	1.00	7.00	0.40	0.25	0.65
TNMG220412-QM	3.00	1.00	7.70	0.35	0.25	0.60
TNMG220412-SM	2.00	0.30	4.00	0.25	0.12	0.30
TNMG220416-KM	4.00	0.30	8.00	0.45	0.20	0.70
TNMG220416-MM	4.00	0.50	6.60	0.37	0.10	0.65
TNMG220416-MR	6.00	2.00	11.00	0.60	0.35	0.90
TNMG220416-MR ¹⁾	4.00	2.00	7.70	0.40	0.15	0.70
TNMG220416-MRR	4.00	1.50	7.00	0.50	0.32	0.70
TNMG220416-PM	4.00	1.00	6.60	0.40	0.23	0.65
TNMG220416-PR	4.00	1.50	7.00	0.50	0.32	0.75
TNMG220416-QM	3.00	1.00	7.70	0.40	0.30	0.65
TNMG220424-MR	4.00	1.50	7.00	0.50	0.32	0.75
TNMG270608-MR	6.00	1.50	12.00	0.50	0.35	0.55
TNMG270608-PR	6.00	1.50	12.00	0.50	0.35	0.55
TNMG270608-QM	3.00	1.00	8.00	0.35	0.20	0.50
TNMG270612-HM	6.00	2.00	12.00	0.60	0.35	0.75
TNMG270612-MR	6.00	2.00	12.00	0.60	0.35	0.75
TNMG270612-PR	6.00	2.00	12.00	0.60	0.35	0.75
TNMG270612-QM	3.00	1.00	8.00	0.35	0.25	0.60
TNMG270616-HM	6.00	2.00	12.00	0.60	0.35	0.75
TNMG270616-KR	4.4	0.94	8.8	0.66	0.33	0.92
TNMG270616-MR	6.00	2.00	12.00	0.60	0.35	0.90
TNMG270616-PR	6.00	2.00	12.00	0.60	0.35	0.70
TNMG330716-PR	3.00	1.50	8.00	0.60	0.40	0.75
TNMG330924-HM	7.00	3.00	15.00	0.60	0.45	0.90
TNMG330924-MR	7.00	3.00	15.00	0.65	0.50	0.90
TNMG330924-PR	7.00	3.00	15.00	0.60	0.45	0.90
TNMM160408-MR	5.00	0.70	7.50	0.40	0.25	0.55
TNMM160408-PR	4.00	0.70	6.00	0.40	0.20	0.55
TNMM160408-QR	6.00	2.00	8.00	0.50	0.35	0.60
TNMM160412-PR	4.00	1.00	6.00	0.50	0.25	0.70
TNMM160412-QR	6.00	2.00	8.00	0.60	0.35	0.90
TNMM220408-MR	5.00	0.70	8.00	0.40	0.25	0.55
TNMM220408-PR	5.00	0.70	8.00	0.40	0.20	0.55
TNMM220408-QR	6.00	2.00	11.00	0.50	0.35	0.60
TNMM220412-MR	5.00	1.00	8.00	0.50	0.32	0.70
TNMM220412-PR	5.00	1.00	8.00	0.50	0.25	0.70
TNMM220412-QR	6.00	2.00	11.00	0.60	0.35	0.90
TNMM220416-MR	5.00	1.50	8.00	0.55	0.32	0.90
TNMM220416-PR	5.00	1.50	8.00	0.55	0.32	0.90
TNMM220416-QR	6.00	2.00	11.00	0.60	0.35	1.20
TNMM270612-MR	6.00	1.00	9.00	0.50	0.32	0.70
TNMM270612-QR	6.00	2.00	11.00	0.60	0.35	0.90
TNMM270616-HR	10.00	2.40	13.00	0.80	0.50	1.10
TNMM270616-MR	6.00	1.50	9.00	0.55	0.40	0.90
TNMM270616-QR	6.00	2.00	11.00	0.60	0.35	1.20
TNMM270624-HR	10.00	3.20	13.00	1.00	0.60	1.60
TNMM270624-MR	6.00	2.00	9.00	0.55	0.40	1.00
TNMU160408-PF	0.40	0.30	1.50	0.20	0.10	0.40
TNMU160412-KM	3.00	0.30	5.5	0.40	0.15	0.60
TNMU160412-WM	3.50	0.80	6.00	0.50	0.20	0.90
TNMX1106-2	1.00	0.50	2.50	6.00	2.00	8.50
TNMX1509-2	2.25	0.75	3.50	10.00	4.00	13.00
TNMX160404-WF	1.00	0.20	3.00	0.20	0.08	0.30
TNMX160408-WF	1.50	0.20	3.00	0.30	0.10	0.40
TNMX160408-WM	2.00	0.50	4.50	0.35	0.15	0.50
TNMX160408-WMX	3.00	0.50	5.00	0.45	0.15	0.70

¹⁾ Rostfrei.

Wendeplatte	Schnitttiefe			Vorschub		
	a_p = mm			f_n = mm/U		
	Empf.	Min.	Max.	Empf.	Min.	Max.
TNMX160412-WM	2.50	0.50	5.00	0.40	0.15	0.60
TNMX160412-WMX	3.50	0.80	6.00	0.50	0.20	0.75
TNMX220412-WR	2.50	1.00	5.00	0.80	0.40	1.10
TNMX220416-WR	2.50	1.20	5.00	0.90	0.44	1.20
TNMX330931-MF	0.75	0.20	1.30	11.00	4.00	16.00
TNMX330932-PF	0.75	0.20	1.30	11.00	7.00	16.00
TNMX440901-MR	2.80	1.00	5.00	7.00	4.00	11.00
TNMX491051-MF	1.50	0.50	2.50	12.00	4.00	16.00
WNGG080404-SGF	0.30	0.10	3.00	0.12	0.05	0.25
WNGG080408-SGF	0.50	0.20	3.00	0.15	0.10	0.30
VNGG160404-SGF	0.30	0.10	3.00	0.12	0.05	0.15
VNGG160408-SGF	0.50	0.20	3.00	0.15	0.07	0.20
VNGG160412-SGF	0.80	0.30	3.00	0.18	0.10	0.25
WNMA060408-KR	2.50	0.20	4.00	0.35	0.15	0.60
WNMA060412-KR	2.50	0.30	4.00	0.45	0.20	0.80
WNMA080408-KR	3.00	0.20	5.00	0.35	0.15	0.60
WNMA080412-KR	3.00	0.30	5.00	0.45	0.20	0.80
WNMA080416-KR	3.00	0.30	5.00	0.55	0.20	1.00
WWMG060404-KF	0.50	0.15	2.00	0.15	0.08	0.25
WWMG060404-LC	0.25	0.10	1.00	0.10	0.05	0.25
WWMG060404-MF	1.00	0.50	3.00	0.20	0.10	0.30
WWMG060404-MF ¹⁾	0.40	0.10	1.50	0.15	0.05	0.30
WWMG060404-XF	0.40	0.25	1.50	0.15	0.07	0.30
WWMG060404-SM	1.00	0.20	2.50	0.18	0.10	0.25
WWMG060404-WF	0.40	0.25	2.00	0.15	0.05	0.25
WWMG060404-WL	0.25	0.10	1.00	0.20	0.05	0.30
WWMG060404-XM	0.75	0.15	3.00	0.15	0.04	0.20
WWMG060404-XM	2.50	0.50	4.00	0.25	0.10	0.35
WWMG060408-KF	0.50	0.15	2.00	0.20	0.10	0.30
WWMG060408-KM	2.00	0.20	4.00	0.35	0.15	0.50
WWMG060408-KR	2.2	0.24	4.50	0.30	0.17	0.42
WWMG060408-LC	0.50	0.20	1.50	0.20	0.10	0.30
WWMG060408-MF	1.00	0.50	3.00	0.25	0.15	0.50
WWMG060408-MF ¹⁾	0.60	0.10	1.50	0.20	0.10	0.40
WWMG060408-MM	2.00	0.50	3.00	0.25	0.10	0.45
WWMG060408-MR ¹⁾	2.00	1.50	3.00	0.30	0.15	0.55
WWMG060408-PF	0.40	0.30	1.50	0.20	0.10	0.40
WWMG060408-PM	2.00	0.50	3.00	0.30	0.15	0.50
WWMG060408-PR	3.00	0.70	3.50	0.30	0.20	0.45
WWMG060408-QM	3.00	1.00	3.00	0.35	0.20	0.50
WWMG060408-SM	1.50	0.20	2.50	0.20	0.10	0.30
WWMG060408-WF	1.00	0.25	3.00	0.30	0.10	0.50
WWMG060408-WL	0.50	0.20	1.50	0.25	0.10	0.45
WWMG060408-WM	1.50	0.50	3.50	0.30	0.15	0.60
WWMG060408-WMX	3.00	0.50	5.00	0.45	0.15	0.70
WWMG060408-XF	1.00	0.20	3.00	0.20	0.05	0.25
WWMG060408-XM	2.50	0.50	4.00	0.25	0.10	0.35
WWMG060408-XMR	2.50	0.50	4.00	0.30	0.15	0.40
WWMG060412-KM	2.00	0.30	4.00	0.40	0.15	0.60
WWMG060412-KR	2.2	0.32	4.50	0.40	0.20	0.56
WWMG060412-MM	2.00	0.50	3.00	0.30	0.10	0.60
WWMG060412-MR ¹⁾	2.00	1.50	3.00	0.35	0.15	0.60
WWMG060412-MRR	3.00	0.80	3.50	0.35	0.25	0.50
WWMG060412-PF	0.80	0.40	1.50	0.25	0.15	0.50
WWMG060412-PM	2.00	0.80	3.00	0.35	0.18	0.60
WWMG060412-PR	3.00	0.80	3.50	0.35	0.25	0.55
WWMG060412-QM	3.00	1.00	3.00	0.35	0.25	0.60
WWMG060412-WM	1.50	0.80	3.50	0.50	0.20	0.90
WWMG060412-WMX	3.50	0.80	6.00	0.50	0.20	0.75
WWMG060412-XM	2.50	0.70	4.00	0.30	0.15	0.40
WWMG060412-XMR	2.50	0.75	4.00	0.32	0.18	0.42
WWMG080404-KF	0.50	0.15	2.00	0.15	0.08	0.25
WWMG080404-MF	1.00	0.50	2.00	0.20	0.10	0.30
WWMG080404-MF ¹⁾	0.40	0.10	1.50	0.15	0.05	0.30
WWMG080404-MMC	2.00	0.25	3.00	0.25	0.10	0.40
WWMG080404-PF	0.40	0.25	1.50	0.15	0.07	0.30
WWMG080404-PMC	2.00	0.25	3.00	0.25	0.10	0.40
WWMG080404-QM	3.00	1.00	4.00	0.20	0.18	0.25
WWMG080404-SF	0.40	0.15	1.50	0.12	0.08	0.22
WWMG080404-SM	1.50	0.15	2.50	0.20	0.10	0.30
WWMG080404-SMC	0.50	0.25	3.00	0.20	0.10	0.30
WWMG080404-WF	0.40	0.25	3.00	0.15	0.05	0.25
WWMG080404-XF	0.75	0.15	4.00	0.15	0.04	0.20

Empfohlene Schnitttiefe und Vorschub, metrisch

T-Max® P Wendeschneidplatten zum Drehen

Wendeplatte	Schnitttiefe			Vorschub		
	$a_p = \text{mm}$			$f_n = \text{mm/U}$		
	Empf.	Min.	Max.	Empf.	Min.	Max.
WNMG080404-XM	2.50	0.30	5.00	0.18	0.08	0.30
WNMG080408-KF	0.50	0.15	2.00	0.20	0.10	0.30
WNMG080408-KM	2.50	0.20	5.00	0.35	0.15	0.50
WNMG080408-KR	2.70	0.29	5.5	0.34	0.17	0.47
WNMG080408-KRR	3.00	0.20	5.00	0.35	0.15	0.60
WNMG080408-LC	0.50	0.20	1.50	0.20	0.10	0.30
WNMG080408-MF	1.00	0.50	2.00	0.25	0.15	0.50
WNMG080408-MF ¹⁾	0.40	0.10	1.50	0.20	0.10	0.40
WNMG080408-MM	2.50	0.50	4.00	0.25	0.10	0.45
WNMG080408-MMC	2.00	0.25	3.00	0.30	0.15	0.40
WNMG080408-MR	3.50	1.50	5.00	0.50	0.35	0.55
WNMG080408-MR ¹⁾	2.50	2.00	4.00	0.30	0.15	0.55
WNMG080408-PF	0.40	0.30	1.50	0.20	0.10	0.40
WNMG080408-PM	2.50	0.50	4.00	0.30	0.15	0.50
WNMG080408-PMC	2.00	0.25	3.00	0.30	0.15	0.40
WNMG080408-PR	4.00	0.70	5.00	0.35	0.20	0.55
WNMG080408-QM	3.00	1.00	4.00	0.35	0.20	0.50
WNMG080408-SF	0.50	0.20	1.50	0.15	0.10	0.25
WNMG080408-SM	2.00	0.20	3.00	0.25	0.10	0.35
WNMG080408-SMC	1.00	0.25	3.00	0.25	0.15	0.35
WNMG080408-SMR	2.00	0.50	4.00	0.30	0.10	0.40
WNMG080408-WF	1.00	0.25	4.00	0.30	0.10	0.50
WNMG080408-WL	0.50	0.20	1.50	0.25	0.10	0.45
WNMG080408-WM	3.00	0.50	5.00	0.30	0.15	0.60
WNMG080408-WMX	3.00	0.50	5.00	0.45	0.15	0.70
WNMG080408-XF	1.00	0.20	4.00	0.20	0.05	0.25
WNMG080408-XM	2.50	0.50	5.00	0.25	0.10	0.40
WNMG080412-KF	1.00	0.20	2.50	0.25	0.10	0.35
WNMG080412-KM	2.50	0.30	5.00	0.40	0.15	0.60
WNMG080412-KR	2.70	0.39	5.5	0.45	0.23	0.63
WNMG080412-KRR	3.00	0.30	5.00	0.45	0.20	0.80
WNMG080412-MM	2.50	0.50	4.00	0.30	0.10	0.60
WNMG080412-MMC	2.00	0.40	3.00	0.35	0.15	0.50
WNMG080412-MR	3.50	2.00	5.00	0.60	0.35	0.75
WNMG080412-MR ¹⁾	2.50	2.00	4.00	0.35	0.15	0.60
WNMG080412-MRR	4.00	1.00	5.00	0.40	0.25	0.65
WNMG080412-PF	0.80	0.40	1.50	0.25	0.15	0.50
WNMG080412-PM	2.50	0.80	4.00	0.35	0.18	0.60
WNMG080412-PMC	2.00	0.40	3.00	0.35	0.15	0.50
WNMG080412-PR	4.00	1.00	5.00	0.40	0.25	0.70
WNMG080412-QM	3.00	1.00	4.00	0.35	0.25	0.60
WNMG080412-SF	0.80	0.40	2.00	0.17	0.12	0.30
WNMG080412-SM	2.00	0.30	3.50	0.28	0.12	0.38
WNMG080412-SMC	1.50	0.40	3.00	0.30	0.15	0.40
WNMG080412-SMR	2.00	0.50	4.00	0.32	0.12	0.42
WNMG080412-WF	1.50	0.40	4.00	0.50	0.20	0.60
WNMG080412-WM	3.50	0.80	6.00	0.50	0.20	0.90
WNMG080412-WMX	3.50	0.80	6.00	0.50	0.20	0.75
WNMG080412-XM	3.00	0.70	5.00	0.30	0.15	0.45
WNMG080412-XMR	3.00	0.75	5.00	0.32	0.18	0.48
WNMG080416-KM	2.50	0.30	5.00	0.45	0.20	0.70
WNMG080416-MR	3.50	2.00	5.00	0.60	0.35	0.90
WNMG080416-PM	3.00	1.00	4.00	0.40	0.23	0.65
WNMG080416-PR	4.00	1.50	5.00	0.50	0.32	0.75
WNMG080416-QM	4.00	1.50	5.00	0.50	0.32	0.75
VNMG160404-LC	0.25	0.10	1.00	0.10	0.05	0.20
VNMG160404-MF	1.00	0.50	4.00	0.20	0.10	0.30
VNMG160404-MF ¹⁾	0.40	0.10	1.50	0.15	0.05	0.30
VNMG160404-MMC	2.00	0.25	3.00	0.17	0.10	0.25
VNMG160404-PF	0.40	0.25	1.50	0.15	0.07	0.30
VNMG160404-PMC	2.00	0.25	3.00	0.17	0.10	0.25
VNMG160404-QM	3.00	1.00	4.00	0.25	0.18	0.30
VNMG160404-SF	0.40	0.15	1.50	0.12	0.08	0.20
VNMG160404-SM	1.00	0.15	2.00	0.18	0.05	0.20
VNMG160404-SMC	0.50	0.25	3.00	0.17	0.10	0.25
VNMG160408-KM	2.00	0.20	3.50	0.30	0.15	0.40
VNMG160408-LC	0.50	0.20	1.50	0.20	0.10	0.25
VNMG160408-MF	1.00	0.50	4.00	0.25	0.15	0.50
VNMG160408-MF ¹⁾	0.80	0.20	2.50	0.15	0.08	0.30
VNMG160408-MM	2.00	0.50	4.00	0.25	0.10	0.45
VNMG160408-MMC	2.00	0.25	3.00	0.17	0.10	0.25
VNMG160408-PF	0.40	0.30	1.50	0.20	0.10	0.40
VNMG160408-PM	2.00	0.50	4.00	0.30	0.15	0.50

1) Rostfrei.

Wendeplatte	Schnitttiefe			Vorschub		
	$a_p = \text{mm}$			$f_n = \text{mm/U}$		
	Empf.	Min.	Max.	Empf.	Min.	Max.
VNMG160408-PMC	2.00	0.25	3.00	0.17	0.10	0.25
VNMG160408-QM	3.00	1.00	4.00	0.35	0.20	0.50
VNMG160408-SF	0.50	0.20	1.50	0.15	0.10	0.22
VNMG160408-SM	1.50	0.20	2.50	0.20	0.07	0.23
VNMG160408-SMC	0.80	0.25	3.00	0.17	0.10	0.25
VNMG160412-KM	2.00	0.30	3.50	0.35	0.15	0.50
VNMG160412-MF	1.00	0.50	4.00	0.30	0.20	0.60
VNMG160412-MMC	2.00	0.40	3.00	0.20	0.10	0.30
VNMG160412-PM	2.00	0.80	4.00	0.35	0.18	0.60
VNMG160412-PMC	2.00	0.40	3.00	0.20	0.10	0.30
VNMG160412-QM	3.00	1.00	4.00	0.35	0.25	0.50
VNMG160412-SF	0.80	0.40	2.00	0.17	0.12	0.25
VNMG160412-SM	1.50	0.30	3.00	0.22	0.10	0.25
VNMG160412-SMC	1.50	0.40	3.00	0.20	0.10	0.30
WNMT150931-PM	1.50	0.50	3.0	6.00	2.00	10.00
WNMU080412-KM	2.50	0.30	5.00	0.40	0.15	0.60
WNMU080412-WM	3.50	0.80	6.00	0.50	0.20	0.90
WNMU080612-WM	3.50	0.80	6.00	0.50	0.20	0.90
WNMX150931-MM	1.75	0.50	3.00	7.00	4.00	10.00
WNMX211251-MM	3.00	0.50	5.00	8.00	4.00	11.00
175.32-191940-25	5.00	2.00	10.00	0.90	0.70	1.20

Empfohlene Schnitttiefe und Vorschub, metrisch

CoroTurn® 107 Wendeschneidplatten zum Drehen

Wendeplatte	Schnitttiefe			Vorschub			Wendeplatte	Schnitttiefe			Vorschub		
	$a_p = \text{mm}$			$f_n = \text{mm/U}$				$a_p = \text{mm}$			$f_n = \text{mm/U}$		
	Empf.	Min.	Max.	Empf.	Min.	Max.		Empf.	Min.	Max.	Empf.	Min.	Max.
CCET060201-UM	0.30	0.10	4.00	0.03	0.01	0.06	CCMT09T308-PMC	2.00	0.25	3.00	0.20	0.10	0.30
CCET060202-UM	0.50	0.20	4.00	0.03	0.01	0.06	CCMT09T308-PR	2.00	1.00	4.00	0.25	0.12	0.35
CCET060204-UM	1.00	0.50	4.00	0.03	0.01	0.06	CCMT09T308-SMC	0.80	0.25	3.00	0.20	0.10	0.30
CCGT060201-UM	0.30	0.10	1.00	0.03	0.01	0.06	CCMT09T308-UM	1.25	0.50	4.00	0.25	0.12	0.40
CCGT060202-UM	0.50	0.10	1.50	0.07	0.02	0.12	CCMT09T308-UR	2.00	1.00	4.00	0.30	0.15	0.50
CCGT060204-UM	1.00	0.50	2.00	0.20	0.08	0.30	CCMT09T308-WF	1.00	0.30	3.00	0.25	0.12	0.50
CCGT09T301-UM	0.30	0.10	1.00	0.03	0.01	0.06	CCMT09T308-WM	1.50	0.70	4.00	0.30	0.15	0.50
CCGT09T302-UM	0.50	0.10	1.50	0.07	0.02	0.12	CCMT09T308-XF	0.35	0.15	2.00	0.15	0.08	0.30
CCGT09T304-UM	1.25	0.50	3.00	0.15	0.08	0.25	CCMT09T308-XM	0.80	0.50	3.00	0.20	0.10	0.30
CCGT09T308-UM	1.25	0.50	3.00	0.20	0.12	0.35	CCMT09T308-XR	2.00	1.00	4.00	0.25	0.12	0.35
CCGT120404-UM	1.50	0.50	4.00	0.15	0.08	0.25	CCMT09T312-KR	2.00	1.20	4.00	0.30	0.14	0.42
CCGT120408-UM	1.50	0.50	4.00	0.20	0.12	0.35	CCMT09T312-MR	2.00	1.20	4.00	0.30	0.14	0.42
CCGX060202-AL	1.00	0.30	3.00	0.12	0.05	0.15	CCMT09T312-PR	2.00	1.20	4.00	0.30	0.14	0.42
CCGX060204-AL	1.00	0.30	3.00	0.12	0.05	0.15	CCMT09T312-XR	2.00	1.20	4.00	0.30	0.14	0.42
CCGX09T304-AL	1.50	0.50	5.00	0.20	0.10	0.30	CCMT120404-KF	0.42	0.14	2.40	0.14	0.07	0.27
CCGX09T308-AL	1.50	0.50	5.00	0.30	0.15	0.60	CCMT120404-KM	0.96	0.30	3.60	0.18	0.09	0.27
CCGX120404-AL	1.50	0.50	7.00	0.20	0.10	0.30	CCMT120404-MF	0.42	0.14	2.40	0.14	0.07	0.27
CCGX120408-AL	1.50	0.50	7.00	0.30	0.15	0.60	CCMT120404-MM	0.96	0.30	3.60	0.18	0.09	0.27
CCMT060202-KF	0.30	0.06	1.70	0.06	0.03	0.11	CCMT120404-PF	0.42	0.14	2.40	0.14	0.07	0.27
CCMT060202-MF	0.30	0.06	1.70	0.06	0.03	0.11	CCMT120404-PM	0.96	0.30	3.60	0.18	0.09	0.27
CCMT060202-PF	0.30	0.06	1.70	0.06	0.03	0.11	CCMT120404-WM	2.00	0.50	4.00	0.25	0.15	0.40
CCMT060202-UF	0.40	0.20	1.50	0.07	0.05	0.15	CCMT120408-KM	0.96	0.60	3.60	0.24	0.12	0.36
CCMT060202-WF	0.30	0.10	1.50	0.10	0.03	0.15	CCMT120408-KR	2.40	1.20	4.80	0.30	0.14	0.42
CCMT060204-KF	0.30	0.10	1.70	0.08	0.05	0.17	CCMT120408-MM	0.96	0.60	3.60	0.24	0.12	0.36
CCMT060204-KM	0.64	0.20	2.40	0.11	0.06	0.17	CCMT120408-MR	2.40	1.20	4.80	0.30	0.14	0.42
CCMT060204-MF	0.30	0.10	1.70	0.08	0.05	0.17	CCMT120408-PM	0.96	0.60	3.60	0.24	0.12	0.36
CCMT060204-MM	0.64	0.20	2.40	0.11	0.06	0.17	CCMT120408-PR	2.40	1.20	4.80	0.30	0.14	0.42
CCMT060204-PF	0.30	0.10	1.70	0.08	0.05	0.17	CCMT120408-UM	1.50	0.50	4.00	0.25	0.12	0.40
CCMT060204-PM	0.64	0.20	2.40	0.11	0.06	0.17	CCMT120408-UR	2.50	1.00	4.00	0.30	0.15	0.50
CCMT060204-UF	0.40	0.20	1.50	0.10	0.05	0.20	CCMT120408-WM	2.00	0.70	4.00	0.30	0.15	0.50
CCMT060204-UM	1.00	0.50	2.50	0.20	0.08	0.30	CCMT120412-KR	2.40	1.44	4.80	0.36	0.17	0.50
CCMT060204-UR	1.50	1.00	2.50	0.25	0.15	0.30	CCMT120412-MM	0.96	0.72	3.60	0.29	0.14	0.43
CCMT060204-WF	0.80	0.30	2.00	0.12	0.05	0.30	CCMT120412-MR	2.40	1.44	4.80	0.36	0.17	0.50
CCMT060208-KM	0.64	0.40	2.40	0.15	0.08	0.23	CCMT120412-PM	0.96	0.72	3.60	0.29	0.14	0.43
CCMT060208-KR	1.60	0.80	3.20	0.19	0.09	0.26	CCMT120412-PR	2.40	1.44	4.80	0.36	0.17	0.50
CCMT060208-MM	0.64	0.40	2.40	0.15	0.08	0.23	CCMT380932-XH	1.50	1.20	2.00	12.00	5.00	17.00
CCMT060208-MR	1.60	0.80	3.20	0.19	0.09	0.26	DCET070200-UM	0.30	0.10	4.00	0.03	0.01	0.06
CCMT060208-PM	0.64	0.40	2.40	0.15	0.08	0.23	DCET070201-UM	0.30	0.10	4.00	0.03	0.01	0.06
CCMT060208-PR	1.60	0.80	3.20	0.19	0.09	0.26	DCET11T301-UM	0.30	0.10	4.00	0.03	0.01	0.06
CCMT060208-UF	0.40	0.20	1.50	0.10	0.05	0.25	DCET11T302-UM	0.30	0.20	4.00	0.03	0.01	0.06
CCMT060208-UM	1.00	0.50	2.50	0.25	0.12	0.40	DCET11T304-UM	1.25	0.50	4.00	0.05	0.02	0.10
CCMT060208-WF	0.80	0.30	2.00	0.15	0.09	0.35	DCGT070201-UM	0.30	0.10	1.00	0.03	0.01	0.06
CCMT060208-WM	1.20	0.50	2.50	0.20	0.10	0.40	DCGT070202-UM	0.50	0.10	1.50	0.07	0.02	0.12
CCMT09T302-KF	0.35	0.08	2.00	0.08	0.04	0.15	DCGT070204-UM	1.00	0.50	2.50	0.15	0.08	0.25
CCMT09T302-MF	0.35	0.08	2.00	0.08	0.04	0.15	DCGT070208-UM	1.00	0.50	2.50	0.20	0.12	0.35
CCMT09T302-PF	0.35	0.08	2.00	0.08	0.04	0.15	DCGT11T301-UM	1.00	0.10	1.00	0.03	0.01	0.06
CCMT09T302-UF	0.40	0.20	2.00	0.07	0.05	0.15	DCGT11T302-UM	0.50	0.10	1.50	0.03	0.01	0.06
CCMT09T302-WF	0.30	0.10	1.50	0.10	0.03	0.15	DCGT11T304-UM	1.25	0.50	3.00	0.15	0.08	0.25
CCMT09T304-KF	0.35	0.11	2.00	0.11	0.06	0.23	DCGT11T308-UM	1.25	0.50	3.00	0.20	0.12	0.35
CCMT09T304-KM	0.64	0.25	3.00	0.15	0.08	0.23	DCGX070202-AL	1.00	0.30	4.00	0.12	0.05	0.15
CCMT09T304-MF	0.35	0.11	2.00	0.11	0.06	0.23	DCGX070204-AL	1.50	0.50	4.00	0.20	0.10	0.30
CCMT09T304-MM	0.64	0.25	3.00	0.15	0.08	0.23	DCGX11T302-AL	1.00	0.30	5.5	0.12	0.05	0.15
CCMT09T304-MMC	2.00	0.25	3.00	0.20	0.10	0.30	DCGX11T304-AL	1.50	0.50	5.5	0.20	0.10	0.30
CCMT09T304-PF	0.35	0.11	2.00	0.11	0.06	0.23	DCGX11T308-AL	1.50	0.50	5.5	0.30	0.15	0.60
CCMT09T304-PM	0.64	0.25	3.00	0.15	0.08	0.23	DCMT070202-KF	0.26	0.06	1.50	0.06	0.03	0.11
CCMT09T304-PMC	2.00	0.25	3.00	0.20	0.10	0.30	DCMT070202-MF	0.26	0.06	1.50	0.06	0.03	0.11
CCMT09T304-SMC	0.50	0.25	3.00	0.20	0.10	0.30	DCMT070202-PF	0.26	0.06	1.50	0.06	0.03	0.11
CCMT09T304-UF	0.40	0.20	2.00	0.10	0.05	0.20	DCMT070202-UF	0.40	0.20	1.50	0.07	0.05	0.15
CCMT09T304-UM	1.25	0.50	4.00	0.20	0.08	0.30	DCMT070204-KF	0.26	0.08	1.50	0.08	0.05	0.17
CCMT09T304-UR	2.00	1.00	4.00	0.25	0.15	0.30	DCMT070204-KM	0.60	0.19	2.25	0.11	0.06	0.17
CCMT09T304-WF	1.00	0.30	3.00	0.20	0.07	0.30	DCMT070204-MF	0.26	0.08	1.50	0.08	0.05	0.17
CCMT09T304-WM	1.50	0.50	4.00	0.25	0.12	0.40	DCMT070204-MM	0.60	0.19	2.25	0.11	0.06	0.17
CCMT09T304-XF	0.35	0.11	2.00	0.11	0.06	0.23	DCMT070204-PF	0.26	0.08	1.50	0.08	0.05	0.17
CCMT09T304-XM	0.64	0.25	3.00	0.15	0.08	0.23	DCMT070204-PM	0.60	0.19	2.25	0.11	0.06	0.17
CCMT09T308-KM	0.80	0.50	3.00	0.20	0.10	0.30	DCMT070204-UF	0.40	0.20	1.50	0.10	0.05	0.20
CCMT09T308-KR	2.00	1.00	4.00	0.25	0.12	0.35	DCMT070204-UM	1.00	0.50	2.50	0.20	0.08	0.30
CCMT09T308-MF	0.35	0.15	2.00	0.15	0.08	0.30	DCMT070208-KM	0.60	0.38	2.25	0.15	0.08	0.23
CCMT09T308-MM	0.80	0.50	3.00	0.20	0.10	0.30	DCMT070208-MM	0.60	0.38	2.25	0.15	0.08	0.23
CCMT09T308-MMC	2.00	0.25	3.00	0.20	0.10	0.30	DCMT070208-PM	0.60	0.38	2.25	0.15	0.08	0.23
CCMT09T308-MR	2.00	1.00	4.00	0.25	0.12	0.35	DCMT070208-UM	1.00	0.50	2.50	0.25	0.12	0.35
CCMT09T308-PF	0.35	0.15	2.00	0.15	0.08	0.30	DCMT11T302-KF	0.35	0.08	2.00	0.08	0.04	0.15
CCMT09T308-PM	0.80	0.50	3.00	0.20	0.10	0.30	DCMT11T302-MF	0.35	0.08	2.00	0.08	0.04	0.15

Empfohlene Schnitttiefe und Vorschub, metrisch

CoroTurn® 107 Wendeschneidplatten zum Drehen

Wendeplatte	Schnitttiefe			Vorschub			Wendeplatte	Schnitttiefe			Vorschub		
	a_p = mm			f_n = mm/U				a_p = mm			f_n = mm/U		
	Empf.	Min.	Max.	Empf.	Min.	Max.		Empf.	Min.	Max.	Empf.	Min.	Max.
DCMT11T302-PF	0.35	0.08	2.00	0.08	0.04	0.15	RCMT190600-M0	4.00	2.00	8.00	0.456	0.128	0.648
DCMT11T304-KF	0.35	0.11	2.00	0.11	0.06	0.23	RCMT2006M0	4.00	2.00	8.00	0.447	0.126	0.632
DCMT11T304-KM	0.80	0.25	3.00	0.15	0.08	0.23	RCMT2507M0	5.00	2.50	10.00	0.559	0.158	0.791
DCMT11T304-MF	0.35	0.11	2.00	0.11	0.06	0.23	RCMT3209M0	6.00	3.20	12.80	0.693	0.202	1.012
DCMT11T304-MM	0.80	0.25	3.00	0.15	0.08	0.23	RCMX100300	2.50	1.00	4.00	0.158	0.063	0.316
DCMT11T304-MMC	2.00	0.25	3.00	0.20	0.12	0.30	RCMX100300E	2.50	1.00	4.00	0.158	0.063	0.316
DCMT11T304-PF	0.35	0.11	2.00	0.11	0.06	0.23	RCMX120400	3.00	1.20	4.80	0.189	0.075	0.379
DCMT11T304-PM	0.80	0.25	3.00	0.15	0.08	0.23	RCMX120400E	3.00	1.20	4.80	0.189	0.075	0.379
DCMT11T304-PMC	2.00	0.25	3.00	0.20	0.12	0.30	RCMX160600	4.00	1.60	6.40	0.253	0.101	0.506
DCMT11T304-SMC	0.50	0.25	3.00	0.18	0.12	0.30	RCMX200600	5.00	2.00	8.00	0.316	0.126	0.632
DCMT11T304-UF	0.40	0.20	2.00	0.10	0.05	0.20	RCMX250700	1.00	0.25	2.50	3.00	1.50	8.00
DCMT11T304-UM	1.25	0.50	4.00	0.20	0.08	0.30	RCMX320900	1.00	0.25	2.50	4.00	2.50	10.00
DCMT11T304-UR	2.00	1.00	4.00	0.25	0.15	0.30	SBMT381232-XH	15.00	5.00	25.00	1.80	1.40	2.40
DCMT11T304-XF	0.35	0.11	2.00	0.11	0.06	0.23	SCGX09T308-AL	1.50	0.50	5.00	0.30	0.15	0.60
DCMT11T304-XM	0.80	0.25	3.00	0.15	0.08	0.23	SCMT09T304-KF	0.35	0.11	2.00	0.11	0.06	0.23
DCMT11T308-KM	0.80	0.50	3.00	0.20	0.10	0.30	SCMT09T304-KM	0.80	0.25	3.00	0.15	0.08	0.23
DCMT11T308-KR	2.00	1.00	4.00	0.25	0.12	0.35	SCMT09T304-MF	0.35	0.11	2.00	0.11	0.06	0.23
DCMT11T308-MF	0.35	0.15	2.00	0.15	0.08	0.30	SCMT09T304-MM	0.80	0.25	3.00	0.15	0.08	0.23
DCMT11T308-MM	0.80	0.50	3.00	0.20	0.10	0.30	SCMT09T304-MMC	2.00	0.25	3.00	0.20	0.10	0.30
DCMT11T308-MMC	2.00	0.25	3.00	0.22	0.12	0.30	SCMT09T304-PF	0.35	0.11	2.00	0.11	0.06	0.23
DCMT11T308-MR	2.00	1.00	4.00	0.25	0.12	0.35	SCMT09T304-PM	0.80	0.25	3.00	0.15	0.08	0.23
DCMT11T308-PF	0.35	0.15	2.00	0.15	0.08	0.30	SCMT09T304-PMC	2.00	0.25	3.00	0.20	0.10	0.30
DCMT11T308-PM	0.80	0.50	3.00	0.20	0.10	0.30	SCMT09T304-SMC	2.00	0.25	3.00	0.20	0.10	0.30
DCMT11T308-PMC	2.00	0.25	3.00	0.22	0.12	0.30	SCMT09T308-KF	0.35	0.15	2.00	0.15	0.08	0.30
DCMT11T308-PR	2.00	1.00	4.00	0.25	0.12	0.35	SCMT09T308-KM	0.80	0.50	3.00	0.20	0.10	0.30
DCMT11T308-SMC	1.00	0.25	3.00	0.20	0.12	0.30	SCMT09T308-KR	2.00	1.00	4.00	0.25	0.12	0.35
DCMT11T308-UF	0.40	0.20	2.00	0.10	0.05	0.25	SCMT09T308-MF	0.35	0.15	2.00	0.15	0.08	0.30
DCMT11T308-UM	1.25	0.50	4.00	0.25	0.12	0.40	SCMT09T308-MM	0.80	0.50	3.00	0.20	0.10	0.30
DCMT11T308-UR	2.00	1.00	4.00	0.30	0.15	0.50	SCMT09T308-MMC	2.00	0.25	3.00	0.20	0.10	0.30
DCMT11T308-XF	0.35	0.15	2.00	0.15	0.08	0.30	SCMT09T308-MR	2.00	1.00	4.00	0.25	0.12	0.35
DCMT11T308-XM	0.80	0.50	3.00	0.20	0.10	0.30	SCMT09T308-PF	0.35	0.15	2.00	0.15	0.08	0.30
DCMT11T308-XR	2.00	1.00	4.00	0.25	0.12	0.35	SCMT09T308-PM	0.80	0.50	3.00	0.20	0.10	0.30
DCMT11T312-KR	2.00	1.20	4.00	0.30	0.14	0.42	SCMT09T308-PMC	2.00	0.25	3.00	0.20	0.10	0.30
DCMT11T312-MM	0.80	0.60	3.00	0.24	0.12	0.36	SCMT09T308-PR	2.00	1.00	4.00	0.25	0.12	0.35
DCMT11T312-MMC	2.00	0.40	3.00	0.25	0.12	0.35	SCMT09T308-SMC	2.00	0.25	3.00	0.20	0.10	0.30
DCMT11T312-MR	2.00	1.20	4.00	0.30	0.14	0.42	SCMT09T308-UF	0.40	0.20	2.00	0.10	0.05	0.25
DCMT11T312-PM	0.80	0.60	3.00	0.24	0.12	0.36	SCMT09T308-UM	1.25	0.50	4.00	0.25	0.12	0.40
DCMT11T312-PMC	2.00	0.40	3.00	0.25	0.12	0.35	SCMT09T308-UR	2.00	1.00	4.00	0.30	0.15	0.50
DCMT11T312-PR	2.00	1.20	4.00	0.30	0.14	0.42	SCMT09T312-KR	2.00	1.20	4.00	0.30	0.14	0.42
DCMT11T312-SMC	1.50	0.40	3.00	0.22	0.12	0.30	SCMT09T312-MR	2.00	1.20	4.00	0.30	0.14	0.42
DCMT11T312-UR	2.00	1.00	4.00	0.30	0.20	0.50	SCMT09T312-PR	2.00	1.20	4.00	0.30	0.14	0.42
DCMT11T312-XR	2.00	1.20	4.00	0.30	0.14	0.42	SCMT120404-MM	0.96	0.30	3.60	0.18	0.09	0.27
DCMX070202-WF	0.30	0.10	1.50	0.10	0.03	0.15	SCMT120404-PM	0.96	0.30	3.60	0.18	0.09	0.27
DCMX070204-WF	0.70	0.30	2.00	0.12	0.05	0.25	SCMT120404-UR	2.50	1.00	5.00	0.25	0.15	0.30
DCMX070208-WF	0.70	0.30	2.00	0.15	0.09	0.35	SCMT120408-KM	0.96	0.60	3.60	0.24	0.12	0.36
DCMX11T302-WF	0.30	0.10	1.50	0.10	0.03	0.15	SCMT120408-KR	2.40	1.20	4.80	0.30	0.14	0.42
DCMX11T304-WF	1.00	0.30	3.00	0.20	0.07	0.30	SCMT120408-MM	0.96	0.60	3.60	0.24	0.12	0.36
DCMX11T304-WM	1.50	0.50	4.00	0.25	0.12	0.40	SCMT120408-MR	2.40	1.20	4.80	0.30	0.14	0.42
DCMX11T308-WF	1.00	0.30	3.00	0.25	0.12	0.40	SCMT120408-PM	0.96	0.60	3.60	0.24	0.12	0.36
DCMX11T308-WM	1.50	0.50	4.00	0.30	0.15	0.50	SCMT120408-PR	2.40	1.20	4.80	0.30	0.14	0.42
RCGX0602M0-AL	1.00	0.60	2.40	0.245	0.126	0.379	SCMT120408-UM	1.50	0.50	4.00	0.25	0.12	0.40
RCGX0803M0-AL	1.50	0.80	3.20	0.346	0.158	0.538	SCMT120408-UR	2.50	1.00	4.00	0.30	0.15	0.50
RCGX10T3M0-AL	2.00	1.00	4.00	0.358	0.158	0.632	SCMT120412-KR	2.40	1.44	4.80	0.36	0.17	0.50
RCGX1204M0-AL	2.50	1.20	4.80	0.455	0.19	0.79	SCMT120412-MM	0.96	0.72	3.60	0.29	0.14	0.43
RCMT0502M0	1.00	0.50	2.00	0.112	0.032	0.158	SCMT120412-MR	2.40	1.44	4.80	0.36	0.17	0.50
RCMT0602M0	1.50	0.50	2.40	0.15	0.038	0.173	SCMT120412-PM	0.96	0.72	3.60	0.29	0.14	0.43
RCMT060300	1.50	0.50	2.40	0.15	0.038	0.173	SCMT120412-PR	2.40	1.44	4.80	0.36	0.17	0.50
RCMT060300-SM	0.80	0.26	1.60	0.07	0.075	0.05	SCMT120412-UM	1.50	0.50	4.00	0.25	0.15	0.40
RCMT0803M0	2.00	0.80	3.20	0.20	0.051	0.253	SCMT380932-XH	18.00	5.00	25.00	1.70	1.40	2.00
RCMT0803M0-SM	1.00	0.33	2.00	0.07	0.075	0.06	SCMT380932-XL	18.00	5.00	25.00	1.70	0.80	2.00
RCMT09T300	2.50	1.00	4.00	0.25	0.063	0.316	SCMT380932-XM	18.00	7.00	25.00	1.30	1.20	1.80
RCMT09T300-M0	2.50	1.00	4.00	0.25	0.063	0.316	TCEX050100L-F	0.15	0.05	0.80	0.06	0.02	0.10
RCMT09T300-SM	1.50	0.40	2.50	0.10	0.09	0.081	TCEX050100R-F	0.15	0.05	0.80	0.06	0.02	0.10
RCMT10T3M0	2.50	1.00	4.00	0.25	0.063	0.316	TCEX050101L-F	0.15	0.05	0.80	0.06	0.02	0.10
RCMT10T3M0-SM	1.50	0.40	2.50	0.095	0.09	0.08	TCEX050101R-F	0.15	0.05	0.80	0.06	0.02	0.10
RCMT1204M0	3.00	1.20	4.80	0.30	0.076	0.379	TCEX06T100L-F	0.20	0.05	1.50	0.08	0.02	0.12
RCMT1204M0-SM	2.00	0.50	3.00	0.124	0.10	0.102	TCEX06T100R-F	0.20	0.05	1.50	0.08	0.02	0.12
RCMT120400	3.00	1.20	4.80	0.30	0.076	0.379	TCEX06T101L-F	0.20	0.05	1.50	0.08	0.02	0.12
RCMT120400-M0	3.00	1.20	4.80	0.294	0.076	0.369	TCEX06T101R-F	0.20	0.05	1.50	0.08	0.02	0.12
RCMT120400-SM	2.00	0.50	3.00	0.158	0.095	0.10	TCEX06T102L-F	0.20	0.05	0.50	0.08	0.02	0.12
RCMT1606M0	3.50	1.60	6.40	0.374	0.101	0.506	TCEX090200L-F	0.30	0.05	3.00	0.10	0.02	0.15
RCMT1606M0-SM	2.50	0.65	4.00	0.157	0.15	0.12	TCEX090200R-F	0.30	0.05	3.00	0.10	0.02	0.15
RCMT190600	4.00	2.00	8.00	0.447	0.126	0.632	TCEX090201L-F	0.30	0.05	3.00	0.10	0.02	0.15

Empfohlene Schnitttiefe und Vorschub, metrisch

CoroTurn® 107 Wendeschneidplatten zum Drehen

Wendeplatte	Schnitttiefe			Vorschub		
	a_p = mm			f_n = mm/U		
	Empf.	Min.	Max.	Empf.	Min.	Max.
TCEX090201R-F	0.30	0.05	3.00	0.10	0.02	0.15
TCEX090202L-F	0.20	0.05	0.50	0.10	0.02	0.15
TCEX110300L-F	0.40	0.05	4.00	0.10	0.02	0.15
TCEX110300R-F	0.40	0.05	4.00	0.10	0.02	0.15
TCEX110301L-F	0.40	0.05	4.00	0.10	0.02	0.15
TCEX110301R-F	0.40	0.05	4.00	0.10	0.02	0.15
TCEX110302L-F	0.20	0.05	0.50	0.10	0.02	0.20
TCGT06T102L-K	0.30	0.10	1.00	0.05	0.03	0.15
TCGT06T102R-K	0.30	0.10	1.00	0.05	0.03	0.15
TCGT06T104L-K	0.50	0.15	1.00	0.07	0.03	0.20
TCGT06T104R-K	0.50	0.15	1.00	0.07	0.03	0.20
TCGT090202L-K	0.30	0.10	1.20	0.05	0.03	0.15
TCGT090202R-K	0.30	0.10	1.20	0.05	0.03	0.15
TCGT090204L-K	0.50	0.15	1.20	0.10	0.03	0.20
TCGT090204R-K	0.50	0.15	1.20	0.10	0.03	0.20
TCGT090204-UM	1.00	0.50	2.25	0.20	0.08	0.30
TCGT110201-UM	0.30	0.10	1.00	0.03	0.01	0.06
TCGT110202L-K	0.30	0.10	1.50	0.05	0.03	0.15
TCGT110202R-K	0.30	0.10	1.50	0.05	0.03	0.15
TCGT110202-UM	0.50	0.10	1.50	0.07	0.02	0.12
TCGT110204L-K	0.50	0.15	1.50	0.10	0.03	0.25
TCGT110204R-K	0.50	0.15	1.50	0.10	0.03	0.25
TCGT110204-UM	1.25	0.50	2.50	0.15	0.08	0.25
TCGT110208-UM	1.25	0.50	2.50	0.20	0.12	0.35
TCGT110301-UM	0.30	0.10	1.00	0.03	0.01	0.06
TCGT110302L-K	0.30	0.10	1.50	0.05	0.03	0.15
TCGT110302R-K	0.30	0.10	1.50	0.05	0.03	0.15
TCGT110302-UM	0.50	0.10	1.50	0.07	0.02	0.12
TCGT110304L-K	0.50	0.15	1.50	0.10	0.03	0.25
TCGT110304R-K	0.50	0.15	1.50	0.10	0.03	0.25
TCGT110304-UM	1.25	0.50	2.50	0.15	0.08	0.25
TCGT110308-UM	1.25	0.50	2.50	0.20	0.12	0.35
TCGT16T304-UM	1.50	0.50	4.00	0.15	0.08	0.25
TCGT16T308-UM	1.50	0.50	4.00	0.20	0.12	0.35
TCGX06T104-AL	1.00	0.50	2.00	0.20	0.10	0.30
TCGX06T104L-WK	0.50	0.15	1.00	0.15	0.03	0.25
TCGX06T104R-WK	0.50	0.15	1.00	0.15	0.03	0.25
TCGX090202-AL	1.00	0.30	4.00	0.12	0.05	0.15
TCGX090204-AL	1.50	0.50	4.00	0.20	0.10	0.30
TCGX090204L-WK	0.50	0.15	1.20	0.20	0.04	0.28
TCGX090204R-WK	0.50	0.15	1.20	0.20	0.04	0.28
TCGX110202-AL	1.00	0.30	5.00	0.12	0.05	0.15
TCGX110204-AL	1.50	0.50	5.00	0.20	0.10	0.30
TCGX110204L-WK	0.50	0.15	1.50	0.20	0.05	0.30
TCGX110204R-WK	0.50	0.15	1.50	0.20	0.05	0.30
TCGX110208-AL	1.50	0.50	5.00	0.30	0.15	0.60
TCGX110302-AL	1.00	0.30	5.00	0.12	0.05	0.15
TCGX110304-AL	1.50	0.50	5.00	0.20	0.10	0.30
TCGX110304L-WK	0.50	0.15	1.50	0.20	0.05	0.30
TCGX110304R-WK	0.50	0.15	1.50	0.20	0.05	0.30
TCGX110308-AL	1.50	0.50	5.00	0.30	0.15	0.60
TCGX16T304-AL	1.50	0.50	7.00	0.20	0.10	0.30
TCGX16T308-AL	1.50	0.50	7.00	0.30	0.15	0.60
TCMT06T102-KF	0.26	0.06	1.50	0.06	0.03	0.11
TCMT06T102-MF	0.26	0.06	1.50	0.06	0.03	0.11
TCMT06T102-PF	0.26	0.06	1.50	0.06	0.03	0.11
TCMT06T102-UF	0.40	0.20	1.50	0.07	0.05	0.15
TCMT06T104-KF	0.26	0.08	1.50	0.08	0.05	0.17
TCMT06T104-MF	0.26	0.08	1.50	0.08	0.05	0.17
TCMT06T104-PF	0.26	0.08	1.50	0.08	0.05	0.17
TCMT06T104-UF	0.40	0.20	1.50	0.10	0.05	0.20
TCMT06T108-KF	0.26	0.11	1.50	0.11	0.06	0.23
TCMT06T108-MF	0.26	0.11	1.50	0.11	0.06	0.23
TCMT06T108-PF	0.26	0.11	1.50	0.11	0.06	0.23
TCMT090202-KF	0.30	0.06	1.70	0.06	0.03	0.13
TCMT090202-MF	0.30	0.06	1.70	0.06	0.03	0.13
TCMT090202-PF	0.30	0.06	1.70	0.06	0.03	0.13
TCMT090204-KF	0.30	0.10	1.70	0.10	0.05	0.19
TCMT090204-KM	0.60	0.19	2.25	0.11	0.06	0.17
TCMT090204-MF	0.30	0.10	1.70	0.10	0.05	0.19
TCMT090204-MM	0.60	0.19	2.25	0.11	0.06	0.17
TCMT090204-PF	0.30	0.10	1.70	0.10	0.05	0.19
TCMT090204-PM	0.60	0.19	2.25	0.11	0.06	0.17

Wendeplatte	Schnitttiefe			Vorschub		
	a_p = mm			f_n = mm/U		
	Empf.	Min.	Max.	Empf.	Min.	Max.
TCMT090204-UF	0.40	0.20	1.50	0.10	0.05	0.20
TCMT090204-UM	1.00	0.50	2.50	0.20	0.08	0.30
TCMT090208-KM	0.60	0.38	2.25	0.15	0.08	0.23
TCMT090208-MM	0.60	0.38	2.25	0.15	0.08	0.23
TCMT090208-PM	0.60	0.38	2.25	0.15	0.08	0.23
TCMT090208-UF	0.40	0.20	1.50	0.10	0.05	0.25
TCMT090208-UM	1.00	0.50	2.50	0.25	0.12	0.40
TCMT110202-UF	0.40	0.20	2.00	0.07	0.05	0.15
TCMT110204-UF	0.40	0.20	2.00	0.10	0.05	0.20
TCMT110204-UM	1.25	0.50	3.00	0.20	0.08	0.30
TCMT110204-UR	2.00	1.00	3.00	0.25	0.15	0.30
TCMT110208-UF	0.40	0.20	2.00	0.10	0.05	0.25
TCMT110208-UM	1.25	0.50	3.00	0.25	0.12	0.40
TCMT110208-UR	2.00	1.00	3.00	0.30	0.15	0.40
TCMT110302-KF	0.30	0.06	1.70	0.06	0.03	0.13
TCMT110302-MF	0.30	0.06	1.70	0.06	0.03	0.13
TCMT110302-PF	0.30	0.06	1.70	0.06	0.03	0.13
TCMT110304-KF	0.30	0.10	1.70	0.10	0.05	0.19
TCMT110304-KM	0.67	0.21	2.50	0.13	0.06	0.19
TCMT110304-MF	0.30	0.10	1.70	0.10	0.05	0.19
TCMT110304-MM	0.67	0.21	2.50	0.13	0.06	0.19
TCMT110304-PF	0.30	0.10	1.70	0.10	0.05	0.19
TCMT110304-PM	0.67	0.21	2.50	0.13	0.06	0.19
TCMT110304-XF	0.30	0.10	1.70	0.10	0.05	0.19
TCMT110304-XM	0.67	0.21	2.50	0.13	0.06	0.19
TCMT110308-KM	0.67	0.42	2.50	0.17	0.09	0.26
TCMT110308-KR	1.50	0.75	3.00	0.21	0.10	0.30
TCMT110308-MF	0.30	0.13	1.70	0.13	0.07	0.26
TCMT110308-MM	0.67	0.42	2.50	0.17	0.09	0.26
TCMT110308-MR	1.50	0.75	3.00	0.21	0.10	0.30
TCMT110308-PF	0.30	0.13	1.70	0.13	0.07	0.26
TCMT110308-PM	0.67	0.42	2.50	0.17	0.09	0.26
TCMT110308-PR	1.50	0.75	3.00	0.21	0.10	0.30
TCMT110308-XF	0.30	0.13	1.70	0.13	0.07	0.26
TCMT110308-XM	0.67	0.42	2.50	0.17	0.09	0.26
TCMT110312-KR	1.50	0.90	3.00	0.26	0.12	0.36
TCMT110312-PM	0.67	0.50	2.50	0.20	0.10	0.31
TCMT110312-PR	1.50	0.90	3.00	0.26	0.12	0.36
TCMT16T304-KF	0.35	0.11	2.00	0.11	0.06	0.23
TCMT16T304-KM	0.80	0.25	3.00	0.15	0.08	0.23
TCMT16T304-MF	0.35	0.11	2.00	0.11	0.06	0.23
TCMT16T304-MM	0.80	0.25	3.00	0.15	0.08	0.23
TCMT16T304-PF	0.35	0.11	2.00	0.11	0.06	0.23
TCMT16T304-PM	0.80	0.25	3.00	0.15	0.08	0.23
TCMT16T304-UM	1.50	0.50	4.00	0.20	0.08	0.30
TCMT16T304-UR	2.50	1.00	4.00	0.25	0.15	0.30
TCMT16T308-KM	0.80	0.50	3.00	0.20	0.10	0.30
TCMT16T308-KR	2.00	1.00	4.00	0.25	0.12	0.35
TCMT16T308-MM	0.80	0.50	3.00	0.20	0.10	0.30
TCMT16T308-MR	2.00	1.00	4.00	0.25	0.12	0.35
TCMT16T308-PM	0.80	0.50	3.00	0.20	0.10	0.30
TCMT16T308-PR	2.00	1.00	4.00	0.25	0.12	0.35
TCMT16T308-UF	0.40	0.20	2.00	0.10	0.05	0.25
TCMT16T308-UM	1.50	0.50	4.00	0.25	0.12	0.40
TCMT16T308-UR	2.50	1.00	4.00	0.30	0.15	0.50
TCMT16T308-XR	2.00	1.00	4.00	0.25	0.12	0.35
TCMT16T312-KM	0.80	0.60	3.00	0.24	0.12	0.36
TCMT16T312-KR	2.00	1.20	4.00	0.30	0.14	0.42
TCMT16T312-MM	0.80	0.60	3.00	0.24	0.12	0.36
TCMT16T312-MR	2.00	1.20	4.00	0.30	0.14	0.42
TCMT16T312-PM	0.80	0.60	3.00	0.24	0.12	0.36
TCMT16T312-PR	2.00	1.20	4.00	0.30	0.14	0.42
TCMT16T312-UR	2.50	1.00	4.00	0.30	0.20	0.50
TCMT16T312-XR	2.00	1.20	4.00	0.30	0.14	0.42
TCMT220408-KM	0.96	0.60	3.60	0.24	0.12	0.36
TCMT220408-KR	2.40	1.20	4.80	0.30	0.14	0.42
TCMT220408-MM	0.96	0.60	3.60	0.24	0.12	0.36
TCMT220408-MR	2.40	1.20	4.80	0.30	0.14	0.42
TCMT220408-PM	0.96	0.60	3.60	0.24	0.12	0.36
TCMT220408-PR	2.40	1.20	4.80	0.30	0.14	0.42
TCMT220412-KR	2.40	1.44	4.80	0.36	0.17	0.50
TCMT220412-MR	2.40	1.44	4.80	0.36	0.17	0.50
TCMT220412-PR	2.40	1.44	4.80	0.36	0.17	0.50

Empfohlene Schnitttiefe und Vorschub, metrisch

CoroTurn® 107 Wendeschneidplatten zum Drehen

Wendeplatte	Schnitttiefe			Vorschub		
	a_p = mm			f_n = mm/U		
	Empf.	Min.	Max.	Empf.	Min.	Max.
TCMX090202-WF	0.30	0.10	1.50	0.10	0.03	0.15
TCMX090204-WF	0.70	0.30	2.00	0.12	0.05	0.30
TCMX090208-WF	0.70	0.30	2.00	0.25	0.10	0.35
TCMX110302-WF	0.30	0.10	1.50	0.10	0.03	0.15
TCMX110304-WF	1.00	0.30	2.50	0.20	0.07	0.30
TCMX110304-WM	1.20	0.50	3.00	0.25	0.12	0.35
TCMX110308-WF	1.00	0.30	2.50	0.25	0.12	0.40
TCMX110308-WM	1.20	0.50	3.00	0.30	0.15	0.50
TCMX16T304-WF	1.20	0.30	3.50	0.20	0.07	0.35
TCMX16T308-WF	1.20	0.30	3.50	0.25	0.12	0.50
TCMX16T308-WM	1.50	0.50	4.00	0.30	0.15	0.50
VBGT160401-UM	0.30	0.10	1.00	0.03	0.01	0.06
VBGT160402-UM	0.50	0.10	1.50	0.07	0.02	0.12
VBGT160404-UM	1.25	0.50	4.00	0.20	0.08	0.30
VBGT160408-UM	1.25	0.50	4.00	0.25	0.12	0.40
VBMT110202-UF	0.40	0.20	1.50	0.07	0.05	0.15
VBMT110204-UF	0.40	0.20	1.50	0.10	0.05	0.20
VBMT110208-UF	0.40	0.20	1.50	0.10	0.05	0.25
VBMT110302-KF	0.30	0.06	1.70	0.06	0.03	0.13
VBMT110302-MF	0.30	0.06	1.70	0.06	0.03	0.13
VBMT110302-PF	0.30	0.06	1.70	0.06	0.03	0.13
VBMT110304-KF	0.30	0.10	1.70	0.10	0.05	0.19
VBMT110304-MF	0.30	0.10	1.70	0.10	0.05	0.19
VBMT110304-PF	0.30	0.10	1.70	0.10	0.05	0.19
VBMT110308-KF	0.30	0.13	1.70	0.13	0.07	0.26
VBMT110308-MF	0.30	0.13	1.70	0.13	0.07	0.26
VBMT110308-PF	0.30	0.13	1.70	0.13	0.07	0.26
VBMT110312-PF	0.30	0.13	1.70	0.15	0.08	0.31
VBMT160402-KF	0.32	0.07	1.80	0.07	0.04	0.14
VBMT160402-MF	0.32	0.07	1.80	0.07	0.04	0.14
VBMT160402-PF	0.32	0.07	1.80	0.07	0.04	0.14
VBMT160404-KF	0.32	0.10	1.80	0.10	0.05	0.20
VBMT160404-KM	0.72	0.23	2.70	0.14	0.07	0.20
VBMT160404-MF	0.32	0.10	1.80	0.10	0.05	0.20
VBMT160404-MM	0.72	0.23	2.70	0.14	0.07	0.20
VBMT160404-MMC	2.00	0.25	3.00	0.17	0.10	0.25
VBMT160404-PF	0.32	0.10	1.80	0.10	0.05	0.20
VBMT160404-PM	0.72	0.23	2.70	0.14	0.07	0.20
VBMT160404-PMC	2.00	0.25	3.00	0.17	0.10	0.25
VBMT160404-SMC	0.50	0.25	3.00	0.17	0.10	0.25
VBMT160404-UM	1.25	0.50	4.00	0.20	0.08	0.30
VBMT160404-UR	2.00	1.00	4.00	0.25	0.15	0.30
VBMT160404-XF	0.32	0.10	1.80	0.10	0.05	0.20
VBMT160404-XM	0.72	0.23	2.70	0.14	0.07	0.20
VBMT160408-KF	0.32	0.14	1.80	0.14	0.07	0.27
VBMT160408-KM	0.72	0.45	2.70	0.18	0.09	0.27
VBMT160408-KR	1.80	0.90	3.60	0.23	0.11	0.32
VBMT160408-MF	0.32	0.14	1.80	0.14	0.07	0.27
VBMT160408-MM	0.72	0.45	2.70	0.18	0.09	0.27
VBMT160408-MMC	2.00	0.25	3.00	0.17	0.10	0.25
VBMT160408-MR	1.80	0.90	3.60	0.23	0.11	0.32
VBMT160408-PF	0.32	0.14	1.80	0.14	0.07	0.27
VBMT160408-PM	0.72	0.45	2.70	0.18	0.09	0.27
VBMT160408-PMC	2.00	0.25	3.00	0.17	0.10	0.25
VBMT160408-PR	1.80	0.90	3.60	0.23	0.11	0.32
VBMT160408-SMC	0.80	0.25	3.00	0.17	0.10	0.25
VBMT160408-UM	1.25	0.50	4.00	0.25	0.12	0.40
VBMT160408-UR	2.00	1.00	4.00	0.30	0.15	0.50
VBMT160408-XF	0.32	0.14	1.80	0.14	0.07	0.27
VBMT160408-XM	0.72	0.45	2.70	0.18	0.09	0.27
VBMT160408-XR	1.80	0.90	3.60	0.23	0.11	0.32
VBMT160412-KM	0.72	0.54	2.70	0.22	0.11	0.32
VBMT160412-KR	1.80	1.08	3.60	0.27	0.13	0.38
VBMT160412-MF	0.32	0.14	1.80	0.16	0.09	0.32
VBMT160412-MM	0.72	0.54	2.70	0.22	0.11	0.32
VBMT160412-MMC	2.00	0.40	3.00	0.20	0.10	0.30
VBMT160412-MR	1.80	1.08	3.60	0.27	0.13	0.38
VBMT160412-PF	0.32	0.14	1.80	0.16	0.09	0.32
VBMT160412-PM	0.72	0.54	2.70	0.22	0.11	0.32
VBMT160412-PMC	2.00	0.40	3.00	0.20	0.10	0.30
VBMT160412-PR	1.80	1.08	3.60	0.27	0.13	0.38
VBMT160412-SMC	2.00	0.40	3.00	0.20	0.10	0.30
VBMT160412-UM	1.25	0.50	4.00	0.25	0.10	0.40

Wendeplatte	Schnitttiefe			Vorschub		
	a_p = mm			f_n = mm/U		
	Empf.	Min.	Max.	Empf.	Min.	Max.
VBMT160412-UR	2.00	1.00	4.00	0.30	0.20	0.50
VBMT160412-XR	1.80	1.08	3.60	0.27	0.13	0.38
VCET110301-UM	0.30	0.10	4.00	0.03	0.01	0.06
VCET110302-UM	0.50	0.20	4.00	0.03	0.02	0.08
VCEX110300L-F	1.00	0.03	4.00	0.05	0.01	0.20
VCEX110300R-F	1.00	0.03	4.00	0.05	0.01	0.20
VCEX110301L-F	1.00	0.05	4.00	0.10	0.01	0.30
VCEX110301R-F	1.00	0.05	4.00	0.10	0.01	0.30
VCGT110301-UM	0.30	0.10	1.00	0.03	0.01	0.06
VCGT110302-UM	0.50	0.10	1.50	0.07	0.02	0.12
VCGT110304-UM	1.25	0.50	3.00	0.15	0.08	0.25
VCGX110202-AL	1.00	0.30	3.00	0.12	0.05	0.15
VCGX110204-AL	1.50	0.50	3.00	0.20	0.10	0.30
VCGX110302-AL	1.00	0.30	3.00	0.12	0.05	0.15
VCGX110304-AL	1.50	0.50	3.00	0.20	0.10	0.30
VCGX160404-AL	1.50	0.50	5.00	0.20	0.10	0.30
VCGX160408-AL	1.50	0.50	5.00	0.30	0.15	0.60
VCGX160412-AL	1.50	0.50	5.00	0.40	0.15	0.80
VCGX220520-AL	1.50	0.50	7.00	0.60	0.25	1.00
VCGX220530-AL	1.50	0.50	7.00	0.60	0.25	1.00
VCMT110302-MF	0.30	0.07	1.50	0.07	0.03	0.13
VCMT110302-PF	0.30	0.07	1.50	0.07	0.03	0.13
VCMT110304-KF	0.30	0.10	1.50	0.10	0.05	0.20
VCMT110304-MF	0.30	0.10	1.50	0.10	0.05	0.20
VCMT110304-MM	0.77	0.31	2.55	0.15	0.10	0.25
VCMT110304-PF	0.30	0.10	1.50	0.10	0.05	0.20
VCMT110304-PM	0.77	0.31	2.55	0.15	0.10	0.25
VCMT110308-KM	0.77	0.61	2.55	0.20	0.13	0.33
VCMT110308-MM	0.77	0.61	2.55	0.20	0.13	0.33
VCMT110308-PM	0.77	0.61	2.55	0.20	0.13	0.33

Empfohlene Schnitttiefe und Vorschub, metrisch

CoroTurn® 111 Wendeschneidplatten zum Drehen

Wendeplatte	Schnitttiefe			Vorschub		
	$a_p = \text{mm}$			$f_n = \text{mm/U}$		
	Empf.	Min.	Max.	Empf.	Min.	Max.
CPMT060202-MF	0.30	0.07	1.50	0.06	0.03	0.12
CPMT060202-PF	0.30	0.07	1.50	0.06	0.03	0.12
CPMT060204-KF	0.30	0.10	1.50	0.09	0.04	0.18
CPMT060204-KM	0.72	0.29	2.40	0.13	0.09	0.22
CPMT060204-MF	0.30	0.10	1.50	0.09	0.04	0.18
CPMT060204-MM	0.72	0.29	2.40	0.13	0.09	0.22
CPMT060204-PF	0.30	0.10	1.50	0.09	0.04	0.18
CPMT060204-PM	0.72	0.29	2.40	0.13	0.09	0.22
CPMT060204-UM	0.64	0.20	2.40	0.11	0.06	0.17
CPMT060208-KM	0.72	0.58	2.40	0.18	0.12	0.29
CPMT060208-MM	0.72	0.58	2.40	0.18	0.12	0.29
CPMT060208-PM	0.72	0.58	2.40	0.18	0.12	0.29
CPMT060208-UM	0.64	0.20	2.40	0.11	0.06	0.17
CPMT09T302-MF	0.35	0.08	2.00	0.08	0.04	0.15
CPMT09T302-PF	0.35	0.11	2.00	0.11	0.06	0.23
CPMT09T302-UM	0.64	0.20	2.40	0.11	0.06	0.17
CPMT09T304-MF	0.35	0.12	1.77	0.12	0.06	0.24
CPMT09T304-MM	0.90	0.36	3.00	0.18	0.12	0.30
CPMT09T304-PF	0.35	0.11	2.00	0.11	0.06	0.23
CPMT09T304-PM	0.64	0.25	3.00	0.15	0.08	0.23
CPMT09T304-UM	1.25	0.50	4.00	0.20	0.08	0.30
CPMT09T308-MF	0.35	0.12	1.77	0.18	0.09	0.36
CPMT09T308-MM	0.90	0.72	3.00	0.24	0.16	0.39
CPMT09T308-PF	0.35	0.15	2.00	0.15	0.08	0.30
CPMT09T308-PM	0.80	0.50	3.00	0.20	0.10	0.30
CPMT09T308-UM	1.25	0.50	4.00	0.25	0.12	0.40
DPMT070202-MF	0.26	0.06	1.32	0.06	0.03	0.12
DPMT070202-PF	0.26	0.06	1.32	0.06	0.03	0.12
DPMT070204-KF	0.26	0.09	1.32	0.09	0.04	0.18
DPMT070204-KM	0.68	0.27	2.25	0.13	0.09	0.22
DPMT070204-MF	0.26	0.09	1.32	0.09	0.04	0.18
DPMT070204-MM	0.68	0.27	2.25	0.13	0.09	0.22
DPMT070204-PF	0.26	0.09	1.32	0.09	0.04	0.18
DPMT070204-PM	0.68	0.27	2.25	0.13	0.09	0.22
DPMT070208-KM	0.68	0.54	2.25	0.18	0.12	0.29
DPMT070208-MM	0.68	0.54	2.25	0.18	0.12	0.29
DPMT070208-PM	0.68	0.54	2.25	0.18	0.12	0.29
DPMT11T304-KM	0.90	0.36	3.00	0.18	0.12	0.30
DPMT11T304-MM	0.90	0.36	3.00	0.18	0.12	0.30
DPMT11T304-PM	0.90	0.36	3.00	0.18	0.12	0.30
DPMT11T308-KM	0.90	0.72	3.00	0.24	0.16	0.39
DPMT11T308-MM	0.90	0.72	3.00	0.24	0.16	0.39
DPMT11T308-PM	0.90	0.72	3.00	0.24	0.16	0.39
SPMT09T308-UM	0.80	0.50	3.00	0.20	0.10	0.30
SPMT120408-UM	0.96	0.60	3.60	0.24	0.12	0.36
TPMT06T102-MF	0.26	0.06	1.32	0.06	0.03	0.12
TPMT06T102-PF	0.26	0.06	1.32	0.06	0.03	0.12
TPMT06T104-KF	0.26	0.09	1.32	0.09	0.04	0.18
TPMT06T104-MF	0.26	0.09	1.32	0.09	0.04	0.18
TPMT06T104-PF	0.26	0.09	1.32	0.09	0.04	0.18
TPMT090202-MF	0.30	0.07	1.50	0.07	0.03	0.13
TPMT090202-PF	0.30	0.07	1.50	0.07	0.03	0.13
TPMT090204-KF	0.30	0.10	1.50	0.10	0.05	0.20
TPMT090204-KM	0.68	0.27	2.25	0.13	0.09	0.22
TPMT090204-MF	0.30	0.10	1.50	0.10	0.05	0.20
TPMT090204-MM	0.68	0.27	2.25	0.13	0.09	0.22
TPMT090204-PF	0.30	0.10	1.50	0.10	0.05	0.20
TPMT090204-PM	0.68	0.27	2.25	0.13	0.09	0.22
TPMT090208-KM	0.68	0.54	2.25	0.18	0.12	0.29
TPMT090208-PM	0.68	0.54	2.25	0.18	0.12	0.29
TPMT110204-UM	0.67	0.21	2.50	0.13	0.06	0.19
TPMT110208-UM	0.67	0.42	2.50	0.17	0.09	0.26
TPMT110302-MF	0.30	0.07	1.50	0.07	0.03	0.13
TPMT110302-PF	0.30	0.07	1.50	0.07	0.03	0.13
TPMT110304-KF	0.30	0.10	1.50	0.10	0.05	0.20
TPMT110304-MF	0.30	0.10	1.50	0.10	0.05	0.20
TPMT110304-MM	0.75	0.30	2.50	0.15	0.10	0.25
TPMT110304-PF	0.30	0.10	1.50	0.10	0.05	0.20
TPMT110304-PM	0.75	0.30	2.50	0.15	0.10	0.25
TPMT110308-KM	0.75	0.60	2.50	0.20	0.13	0.33
TPMT110308-MM	0.75	0.60	2.50	0.20	0.13	0.33
TPMT110308-PM	0.75	0.60	2.50	0.20	0.13	0.33

Wendeplatte	Schnitttiefe			Vorschub		
	$a_p = \text{mm}$			$f_n = \text{mm/U}$		
	Empf.	Min.	Max.	Empf.	Min.	Max.
TPMT16T304-KF	0.35	0.12	1.77	0.12	0.06	0.24
TPMT16T304-MF	0.35	0.12	1.77	0.12	0.06	0.24
TPMT16T304-MM	0.90	0.36	3.00	0.18	0.12	0.30
TPMT16T304-PF	0.35	0.12	1.77	0.12	0.06	0.24
TPMT16T304-PM	0.90	0.36	3.00	0.18	0.12	0.30
TPMT16T308-KM	0.90	0.72	3.00	0.24	0.16	0.39
TPMT16T308-MM	0.90	0.72	3.00	0.24	0.16	0.39
TPMT16T308-PM	0.90	0.72	3.00	0.24	0.16	0.39
TPMT16T308-UM	0.80	0.50	3.00	0.20	0.10	0.30
TPMT16T312-KM	0.90	0.86	3.00	0.28	0.19	0.47
TPMT220408-UM	0.96	0.60	3.60	0.24	0.12	0.36
WPMT020102-MF	0.18	0.04	0.89	0.03	0.02	0.07
WPMT020102-PF	0.18	0.04	0.89	0.03	0.02	0.07
WPMT020104-MF	0.18	0.06	0.89	0.05	0.03	0.10
WPMT020104-PF	0.18	0.06	0.89	0.05	0.03	0.10
WPMT040202-MF	0.26	0.06	1.32	0.05	0.02	0.10
WPMT040202-PF	0.26	0.06	1.32	0.05	0.02	0.10
WPMT040204-KF	0.26	0.09	1.32	0.08	0.04	0.15
WPMT040204-MF	0.26	0.09	1.32	0.08	0.04	0.15
WPMT040204-MM	0.68	0.27	2.25	0.13	0.09	0.22
WPMT040204-PF	0.26	0.09	1.32	0.08	0.04	0.15
WPMT040204-PM	0.68	0.27	2.25	0.13	0.09	0.22
WPMT040208-MM	0.68	0.54	2.25	0.18	0.12	0.29
WPMT040208-PM	0.68	0.54	2.25	0.18	0.12	0.29

CoroTurn® TR Wendeschneidplatten zum Drehen

TR-DC1304-F	1.00	0.15	3.00	0.20	0.08	0.30
TR-DC1308-F	1.00	0.15	3.00	0.24	0.10	0.40
TR-DC1308-M	2.00	0.50	5.00	0.25	0.10	0.40
TR-DC1312-M	2.00	0.50	5.00	0.30	0.15	0.50
TR-VB1302-F	0.30	0.05	1.00	0.07	0.03	0.13
TR-VB1304-F	0.80	0.10	2.00	0.15	0.06	0.35
TR-VB1308-F	0.80	0.10	2.00	0.20	0.09	0.40
TR-VB1312-F	0.80	0.10	2.00	0.20	0.09	0.40

Wendeschneidplatte zum Drehschälen

190.1-381200	6.50	3.00	10.00	4.00	1.50	8.00
--------------	------	------	-------	------	------	------

Empfohlene Schnitttiefe und Vorschub, Zoll

T-Max® P Wendeschneidplatten zum Drehen

Table with 7 columns: Wendeplatte, Schnitttiefe (a_p = Zoll), Vorschub (f_n = Zoll/U). Rows include various plate models like CNGG431-SGF, CNMA431-KR, etc.

Table with 7 columns: Wendeplatte, Schnitttiefe (a_p = Zoll), Vorschub (f_n = Zoll/U). Rows include various plate models like CNMG432-XMR, CNMG433-KF, etc.

1) Rostfrei.

GER TURN

Empfohlene Schnitttiefe und Vorschub, Zoll

T-Max® P Wendeschneidplatten zum Drehen

Wendeplatte	Schnitttiefe			Vorschub		
	a _p = Zoll			f _n = Zoll/U		
	Empf.	Min.	Max.	Empf.	Min.	Max.
CNMG544-KRR	.197	.012	.394	.0217	.0079	.0394
CNMG544-MM	.157	.02	.283	.0146	.0039	.0256
CNMG544-MMC	.118	.039	.157	.0157	.0079	.0217
CNMG544-MR	.157	.012	.315	.0177	.0079	.0276
CNMG544-MR ¹⁾	.157	.079	.394	.0157	.0059	.0276
CNMG544-MRR	.197	.059	.276	.0197	.0118	.0295
CNMG544-PM	.157	.039	.283	.0157	.0091	.0256
CNMG544-PMC	.118	.039	.157	.0157	.0079	.0217
CNMG544-PR	.197	.059	.315	.0197	.0118	.0315
CNMG544-QM	.118	.039	.315	.0138	.0118	.0217
CNMG544-SM	.157	.039	.236	.0118	.0098	.0157
CNMG544-SMC	.079	.02	.118	.0157	.0079	.0217
CNMG544-SMR	.157	.039	.236	.0157	.0118	.0236
CNMG544-XMR	.157	.039	.276	.0177	.0098	.0276
CNMG546-PR	.197	.079	.315	.0197	.0126	.0354
CNMG641-QM	.118	.039	.315	.0098	.0071	.0118
CNMG642-MM	.157	.02	.335	.0098	.0039	.0177
CNMG642-MR	.236	.059	.472	.0197	.0138	.0217
CNMG642-PM	.157	.02	.339	.0118	.0059	.0197
CNMG642-PR	.197	.028	.394	.0138	.0079	.0197
CNMG642-QM	.118	.039	.315	.0138	.0079	.0197
CNMG643-HM	.157	.039	.394	.0197	.0098	.0315
CNMG643-KM	.177	.012	.354	.0157	.0059	.0236
CNMG643-KR	.276	.039	.551	.0217	.011	.0303
CNMG643-MM	.157	.02	.335	.0118	.0039	.0236
CNMG643-MR	.236	.079	.472	.0236	.0138	.0295
CNMG643-MR ¹⁾	.157	.079	.449	.0138	.0059	.0236
CNMG643-MRR	.197	.039	.394	.0157	.0098	.0256
CNMG643-PM	.157	.031	.339	.0138	.0071	.0236
CNMG643-PR	.197	.039	.394	.0157	.0098	.0276
CNMG643-QM	.118	.039	.315	.0138	.0098	.0236
CNMG643-SMR	.236	.039	.354	.0138	.0098	.0165
CNMG643-XMR	.157	.039	.335	.0177	.0098	.0276
CNMG644-HM	.157	.059	.394	.0236	.0118	.0354
CNMG644-KM	.177	.012	.354	.0177	.0079	.0276
CNMG644-KR	.276	.059	.551	.024	.0118	.0335
CNMG644-MM	.157	.02	.335	.0146	.0039	.0256
CNMG644-MR	.236	.079	.472	.0236	.0138	.0354
CNMG644-MR ¹⁾	.157	.079	.449	.0157	.0059	.0276
CNMG644-MRR	.197	.059	.394	.0197	.0118	.0295
CNMG644-PM	.157	.039	.339	.0157	.0091	.0256
CNMG644-PR	.197	.059	.394	.0197	.0118	.0315
CNMG644-QM	.118	.039	.315	.0157	.0118	.0256
CNMG644-SM	.236	.039	.354	.0118	.0098	.0157
CNMG644-SMR	.236	.039	.354	.0157	.0118	.0256
CNMG644-XMR	.157	.039	.335	.0197	.0098	.0315
CNMG646-HM	.197	.079	.394	.0236	.0118	.0472
CNMG646-MR ¹⁾	.157	.079	.449	.0197	.0059	.0394
CNMG646-MRR	.197	.079	.394	.0197	.0126	.0335
CNMG646-PR	.197	.079	.394	.0197	.0126	.0354
CNMG866-PR	.236	.079	.591	.0236	.0157	.0394
CNMM432-MR	.197	.028	.295	.0157	.0098	.0217
CNMM432-PR	.197	.028	.295	.0157	.0079	.0217
CNMM432-QR	.236	.079	.315	.0197	.0138	.0236
CNMM432-WR	.098	.031	.197	.0236	.0118	.0315
CNMM433-MR	.197	.039	.295	.0197	.0126	.0276
CNMM433-PR	.197	.039	.295	.0197	.0098	.0276
CNMM433-QR	.236	.079	.315	.0236	.0138	.0354
CNMM433-WR	.098	.039	.197	.0315	.0157	.0433
CNMM434-MR	.197	.059	.295	.0217	.0126	.0354
CNMM434-PR	.197	.059	.295	.0217	.0126	.0354
CNMM434-QR	.236	.079	.315	.0236	.0138	.0472
CNMM434-WR	.098	.047	.197	.0315	.0173	.0472
CNMM542-PR	.236	.028	.374	.0157	.0079	.0217
CNMM542-QR	.236	.079	.421	.0197	.0138	.0236
CNMM543-MR	.236	.047	.374	.0177	.0126	.0256
CNMM543-PR	.236	.039	.374	.0197	.0098	.0276
CNMM543-QR	.236	.079	.421	.0236	.0138	.0354
CNMM543-WR	.118	.047	.236	.0315	.0165	.0472
CNMM544-MR	.236	.059	.374	.0197	.0138	.0315
CNMM544-PR	.236	.059	.374	.0217	.0126	.0354
CNMM544-QR	.236	.079	.421	.0236	.0138	.0472
CNMM544-WR	.118	.055	.236	.0354	.0181	.0512

1) Rostfrei.

Wendeplatte	Schnitttiefe			Vorschub		
	a _p = Zoll			f _n = Zoll/U		
	Empf.	Min.	Max.	Empf.	Min.	Max.
CNMM546-QR	.236	.079	.421	.0236	.0138	.0591
CNMM546-QR	.236	.079	.472	.0236	.0138	.0472
CNMM642-QR	.236	.079	.472	.0197	.0138	.0236
CNMM643-MR	.276	.059	.472	.0197	.0126	.0276
CNMM643-PR	.236	.039	.472	.0197	.0098	.0276
CNMM643-QR	.236	.079	.472	.0236	.0138	.0354
CNMM644-HR	.394	.094	.512	.0315	.0197	.0433
CNMM644-MR	.276	.071	.472	.0217	.0138	.0354
CNMM644-PR	.236	.059	.472	.0217	.0126	.0354
CNMM644-QR	.236	.079	.472	.0236	.0138	.0472
CNMM644-WR	.13	.063	.264	.0394	.0189	.0512
CNMM646-HR	.394	.126	.512	.0394	.0236	.063
CNMM646-MR	.276	.098	.472	.0236	.0157	.0472
CNMM646-PR	.236	.079	.472	.0217	.0138	.0472
CNMM866-HR	.394	.126	.669	.0394	.0236	.063
CNMM866-MR	.354	.098	.591	.0256	.0177	.0551
CNMM866-QR	.315	.098	.591	.0256	.0157	.0512
CNMM868-HR	.394	.157	.669	.0394	.0236	.0709
CNMM868-PR	.118	.031	.217	.0138	.0071	.0236
CNMU432-QM	.118	.039	.236	.0138	.0098	.0236
CNMU433-KM	.118	.012	.236	.0157	.0059	.0236
CNMU433-PM	.118	.031	.217	.0138	.0071	.0236
CNMU434-PR	.157	.059	.276	.0197	.0126	.0295
CNMU443-KM	.118	.012	.236	.0157	.0059	.0236
CNMU443-KR	.138	.02	.276	.0197	.0098	.0276
CNMU443-PM	.118	.031	.217	.0138	.0071	.0236
CNMU444-PR	.157	.059	.276	.0197	.0126	.0295
CNMX43A1-SM	.246	.098	.394	.0154	.0061	.0309
CNMX43A2-SM	.039	.008	.098	.0071	.0039	.0098
CNMX191140-PF	.098	.012	.197	.0394	.0197	.0591
DNGG431-SGF	.012	.004	.118	.0047	.002	.0079
DNGG432-SGF	.02	.008	.118	.0059	.0039	.0098
DNGG433-SGF	.031	.012	.118	.0071	.0039	.0118
DNGG441-SGF	.012	.004	.118	.0047	.002	.0079
DNGG442-SGF	.02	.008	.118	.0059	.0039	.0098
DNGG443-SGF	.031	.012	.118	.0071	.0039	.0118
DNMA432-KR	.118	.008	.236	.0138	.0059	.0236
DNMA433-KR	.118	.012	.236	.0177	.0079	.0315
DNMA442-KR	.118	.008	.236	.0138	.0059	.0236
DNMA443-KR	.118	.012	.236	.0177	.0079	.0315
DNMA444-KR	.118	.012	.236	.0217	.0079	.0394
DNMG331-KF	.02	.006	.079	.0059	.0031	.0098
DNMG331-LC	.01	.004	.039	.0039	.002	.0079
DNMG331-MF	.039	.02	.108	.0079	.0039	.0118
DNMG331-MF ¹⁾	.016	.004	.059	.0059	.002	.0118
DNMG331-MMC	.079	.01	.118	.0098	.0039	.0157
DNMG331-PM	.016	.01	.059	.0059	.0028	.0118
DNMG331-PR	.079	.016	.197	.0079	.0039	.0118
DNMG331-PMC	.079	.01	.118	.0098	.0039	.0157
DNMG331-QM	.118	.039	.217	.0098	.0071	.0118
DNMG331-SF	.016	.006	.059	.0047	.0031	.0087
DNMG331-SMC	.02	.01	.118	.0079	.0039	.0118
DNMG332-KF	.02	.006	.079	.0079	.0039	.0118
DNMG332-KM	.079	.008	.138	.0138	.0059	.0197
DNMG332-LC	.02	.008	.039	.0079	.0039	.0118
DNMG332-MF	.039	.02	.108	.0098	.0059	.0197
DNMG332-MF ¹⁾	.016	.004	.059	.0079	.0039	.0157
DNMG332-MM	.079	.02	.173	.0098	.0039	.0177
DNMG332-MMC	.079	.01	.118	.0118	.0059	.0157
DNMG332-PF	.016	.012	.059	.0079	.0039	.0157
DNMG332-PM	.079	.02	.197	.0118	.0059	.0197
DNMG332-PMC	.079	.01	.118	.0118	.0059	.0157
DNMG332-QM	.118	.039	.217	.0138	.0079	.0197
DNMG332-SF	.02	.008	.059	.0059	.0039	.0098
DNMG332-SMC	.039	.01	.118	.0098	.0059	.0138
DNMG333-KM	.079	.012	.138	.0157	.0059	.0236
DNMG333-MF	.039	.02	.108	.0118	.0079	.0236
DNMG333-MM	.079	.02	.173	.0118	.0039	.0236
DNMG333-PM	.031	.014	.059	.0098	.0059	.0197
DNMG333-PR	.079	.031	.197	.0138	.0071	.0197
DNMG333-QM	.118	.039	.217	.0138	.0098	.0236
DNMG431-KF	.02	.006	.079	.0059	.0031	.0098
DNMG431-LC	.01	.004	.059	.0039	.002	.0098

Empfohlene Schnitttiefe und Vorschub, Zoll

T-Max® P Wendeschneidplatten zum Drehen

Wendeplatte	Schnitttiefe			Vorschub		
	a _p = Zoll			f _n = Zoll/U		
	Empf.	Min.	Max.	Empf.	Min.	Max.
DNMG431L-K	.098	.028	.197	.0087	.0055	.0118
DNMG431-MF	.039	.02	.148	.0079	.0039	.0118
DNMG431-MF ¹⁾	.016	.004	.059	.0059	.002	.0118
DNMG431-MMC	.098	.01	.157	.0098	.0039	.0157
DNMG431-PF	.016	.01	.059	.0059	.0028	.0118
DNMG431-PM	.118	.016	.236	.0079	.0039	.0118
DNMG431-PMC	.098	.01	.157	.0098	.0039	.0157
DNMG431-QM	.118	.039	.295	.0098	.0071	.0118
DNMG431R-K	.098	.028	.197	.0087	.0055	.0118
DNMG431-SF	.016	.006	.059	.0047	.0031	.0087
DNMG431-SM	.059	.006	.079	.0079	.0039	.0098
DNMG431-SMC	.02	.01	.118	.0079	.0039	.0118
DNMG431-XF	.03	.006	.157	.0059	.0016	.0079
DNMG431-XM	.098	.012	.197	.0071	.0031	.0098
DNMG432-KF	.02	.006	.079	.0079	.0039	.0118
DNMG432-KM	.098	.008	.197	.0138	.0059	.0197
DNMG432-KR	.138	.015	.276	.0134	.0067	.0185
DNMG432-LC	.02	.008	.059	.0079	.0039	.0118
DNMG432L-K	.118	.031	.197	.0118	.0055	.0197
DNMG432-MF	.039	.02	.148	.0098	.0059	.0197
DNMG432-MF ¹⁾	.016	.004	.059	.0079	.0039	.0157
DNMG432-MM	.118	.02	.252	.0098	.0039	.0177
DNMG432-MMC	.098	.01	.157	.0118	.0059	.0157
DNMG432-MR	.157	.059	.295	.0197	.0138	.0217
DNMG432-MR ¹⁾	.118	.079	.236	.0118	.0059	.0217
DNMG432-PF	.016	.012	.059	.0079	.0039	.0157
DNMG432-PM	.118	.02	.236	.0118	.0059	.0197
DNMG432-PMC	.098	.01	.157	.0118	.0059	.0157
DNMG432-PR	.157	.028	.236	.0138	.0079	.0197
DNMG432-QM	.118	.039	.295	.0138	.0079	.0197
DNMG432R-K	.118	.031	.197	.0118	.0055	.0197
DNMG432-SF	.02	.008	.059	.0059	.0039	.0098
DNMG432-SM	.079	.008	.098	.0087	.0039	.011
DNMG432-SMC	.039	.01	.118	.0098	.0059	.0138
DNMG432-SMR	.059	.006	.098	.0079	.0039	.0098
DNMG432-XF	.039	.008	.157	.0079	.002	.0098
DNMG432-XM	.098	.02	.197	.0098	.0039	.0157
DNMG433-KM	.098	.012	.197	.0157	.0059	.0236
DNMG433-KR	.138	.02	.276	.0177	.0091	.0248
DNMG433-MF	.039	.02	.148	.0118	.0079	.0236
DNMG433-MF ¹⁾	.031	.008	.098	.0098	.0059	.0197
DNMG433-MM	.118	.02	.252	.0118	.0039	.0236
DNMG433-MMC	.098	.016	.157	.0138	.0059	.0197
DNMG433-MR	.157	.079	.295	.0236	.0138	.0295
DNMG433-MR ¹⁾	.118	.079	.236	.0138	.0059	.0236
DNMG433-MRR	.157	.039	.236	.0157	.0098	.0256
DNMG433-PF	.031	.014	.059	.0098	.0059	.0197
DNMG433-PM	.118	.031	.236	.0138	.0071	.0236
DNMG433-PMC	.098	.016	.157	.0138	.0059	.0197
DNMG433-PR	.157	.039	.236	.0157	.0098	.0276
DNMG433-QM	.118	.039	.295	.0138	.0098	.0236
DNMG433-SF	.031	.016	.079	.0067	.0047	.0118
DNMG433-SM	.079	.012	.118	.0098	.0047	.0118
DNMG433-SMC	.059	.016	.118	.0118	.0059	.0157
DNMG433-SMR	.079	.008	.118	.0087	.0039	.0118
DNMG434-MF	.039	.02	.148	.0118	.0098	.0236
DNMG434-MR ¹⁾	.118	.079	.236	.0157	.0059	.0276
DNMG434-MRR	.157	.059	.236	.0197	.0118	.0276
DNMG434-PR	.157	.059	.236	.0197	.0118	.0295
DNMG441-KF	.02	.006	.079	.0059	.0031	.0098
DNMG441-LC	.01	.004	.059	.0039	.002	.0098
DNMG441L-K	.098	.028	.197	.0087	.0055	.0118
DNMG441-MF	.039	.02	.148	.0079	.0039	.0118
DNMG441-MF ¹⁾	.016	.004	.059	.0059	.002	.0118
DNMG441-MMC	.098	.01	.157	.0098	.0039	.0157
DNMG441-PF	.016	.01	.059	.0059	.0028	.0118
DNMG441-PM	.118	.016	.236	.0079	.0039	.0118
DNMG441-PMC	.098	.01	.157	.0098	.0039	.0157
DNMG441-QM	.118	.039	.295	.0098	.0071	.0118
DNMG441R-K	.098	.028	.197	.0087	.0055	.0118
DNMG441-SF	.016	.006	.059	.0047	.0031	.0087
DNMG441-SM	.059	.006	.079	.0079	.0039	.0098
DNMG441-SMC	.02	.01	.118	.0079	.0039	.0118

1) Rostfrei.

Wendeplatte	Schnitttiefe			Vorschub		
	a _p = Zoll			f _n = Zoll/U		
	Empf.	Min.	Max.	Empf.	Min.	Max.
DNMG441-XF	.039	.008	.157	.0079	.002	.0098
DNMG441-XM	.098	.02	.197	.0098	.0039	.0138
DNMG442-KF	.02	.006	.079	.0079	.0039	.0118
DNMG442-KM	.098	.008	.197	.0138	.0059	.0197
DNMG442-KR	.138	.015	.276	.0134	.0067	.0185
DNMG442-LC	.02	.008	.059	.0079	.0039	.0118
DNMG442L-K	.118	.031	.197	.0118	.0055	.0197
DNMG442-MF	.039	.02	.148	.0098	.0059	.0197
DNMG442-MF ¹⁾	.016	.004	.059	.0079	.0039	.0157
DNMG442-MM	.118	.02	.252	.0098	.0039	.0177
DNMG442-MMC	.098	.01	.157	.0118	.0059	.0157
DNMG442-MR	.157	.059	.295	.0157	.0138	.0217
DNMG442-MR ¹⁾	.118	.079	.236	.0118	.0059	.0217
DNMG442-PF	.016	.012	.059	.0079	.0039	.0157
DNMG442-PM	.118	.02	.236	.0118	.0059	.0197
DNMG442-PMC	.098	.01	.157	.0118	.0059	.0157
DNMG442-PR	.157	.028	.236	.0138	.0079	.0197
DNMG442-QM	.118	.039	.295	.0138	.0079	.0197
DNMG442R-K	.118	.031	.197	.0118	.0055	.0197
DNMG442-SF	.02	.008	.059	.0059	.0039	.0098
DNMG442-SM	.079	.008	.098	.0087	.0039	.011
DNMG442-SMC	.039	.01	.118	.0098	.0059	.0138
DNMG442-SMR	.059	.006	.098	.0079	.0039	.0098
DNMG442-XF	.03	.006	.157	.0059	.0016	.0079
DNMG442-XM	.098	.012	.197	.0098	.0039	.0157
DNMG443-KF	.039	.008	.098	.0098	.0039	.0138
DNMG443-KM	.098	.012	.197	.0157	.0059	.0236
DNMG443-KR	.138	.02	.276	.0177	.0091	.0248
DNMG443-MF	.039	.02	.148	.0118	.0079	.0236
DNMG443-MF ¹⁾	.031	.008	.098	.0098	.0059	.0197
DNMG443-MM	.118	.02	.252	.0118	.0039	.0236
DNMG443-MMC	.098	.016	.157	.0138	.0059	.0197
DNMG443-MR	.157	.079	.295	.0236	.0138	.0295
DNMG443-MR ¹⁾	.118	.079	.236	.0138	.0059	.0236
DNMG443-MRR	.157	.039	.236	.0157	.0098	.0256
DNMG443-PF	.031	.014	.059	.0098	.0059	.0197
DNMG443-PM	.118	.031	.236	.0138	.0071	.0236
DNMG443-PMC	.098	.016	.157	.0138	.0059	.0197
DNMG443-PR	.157	.039	.236	.0157	.0098	.0276
DNMG443-QM	.118	.039	.295	.0138	.0098	.0236
DNMG443-SF	.031	.016	.079	.0067	.0047	.0118
DNMG443-SM	.079	.012	.118	.0098	.0047	.0118
DNMG443-SMC	.059	.016	.118	.0118	.0059	.0157
DNMG443-SMR	.079	.008	.118	.0087	.0039	.0118
DNMG443-SMR ¹⁾	.118	.028	.197	.011	.0059	.0177
DNMG443-XMR	.118	.03	.236	.0118	.0071	.0197
DNMG444-KR	.138	.03	.276	.0197	.0098	.0272
DNMG444-MR	.157	.079	.295	.0236	.0138	.0354
DNMG444-MR ¹⁾	.118	.079	.236	.0157	.0059	.0276
DNMG444-MRR	.157	.059	.236	.0197	.0126	.0276
DNMG444-PM	.118	.039	.236	.0157	.0091	.0256
DNMG444-PR	.157	.059	.236	.0197	.0126	.0295
DNMG444-QM	.118	.039	.295	.0157	.0118	.0256
DNMG444-SMR	.079	.012	.118	.0098	.0047	.0118
DNMG542-PR	.197	.039	.315	.0138	.0079	.0197
DNMM543-PR	.197	.047	.315	.0157	.0098	.0276
DNMM433-QR	.236	.079	.362	.0236	.0138	.0354
DNMM442-MR	.197	.028	.236	.0157	.0098	.0217
DNMM442-PR	.197	.028	.236	.0157	.0079	.0217
DNMM442-QR	.236	.079	.362	.0197	.0138	.0236
DNMM443-MR	.197	.039	.236	.0197	.0126	.0276
DNMM443-PR	.197	.039	.236	.0197	.0098	.0276
DNMM443-QR	.236	.079	.362	.0236	.0138	.0354
DNMM444-PR	.197	.059	.236	.0217	.0126	.0354
DNMM444-QR	.236	.079	.362	.0236	.0138	.0472
DNMX331-WF	.039	.008	.059	.0079	.0031	.0118
DNMX332-WF	.039	.008	.118	.0118	.0039	.0157
DNMX332-WM	.059	.02	.138	.0138	.0059	.0197
DNMX333-WM	.079	.02	.157	.0177	.0059	.0236
DNMX431-WF	.031	.008	.118	.0079	.0031	.0118
DNMX432-WF	.059	.008	.118	.0118	.0039	.0157
DNMX432-WM	.079	.02	.177	.0138	.0059	.0197
DNMX432-WMX	.118	.02	.197	.0177	.0059	.0276

Empfohlene Schnitttiefe und Vorschub, Zoll

T-Max® P Wendeschneidplatten zum Drehen

Wendeplatte	Schnitttiefe			Vorschub		
	a _p = Zoll			f _n = Zoll/U		
	Empf.	Min.	Max.	Empf.	Min.	Max.
DNMX433-WF	.059	.016	.138	.0157	.0059	.0217
DNMX433-WM	.098	.02	.197	.0177	.0059	.0236
DNMX433-WMX	.138	.031	.236	.0197	.0079	.0295
DNMX434-WM	.059	.008	.098	.0079	.0039	.0118
DNMX434-WMX	.138	.02	.236	.0197	.0079	.0315
DNMX441-WF	.031	.008	.118	.0079	.0031	.0118
DNMX442-WF	.059	.008	.118	.0118	.0039	.0157
DNMX442-WM	.079	.02	.177	.0138	.0059	.0197
DNMX442-WMX	.118	.02	.197	.0177	.0059	.0276
DNMX443-WF	.059	.016	.138	.0157	.0059	.0217
DNMX443-WM	.098	.02	.197	.0177	.0059	.0236
DNMX443-WMX	.138	.031	.236	.0197	.0079	.0295
DNMX444-WM	.138	.02	.236	.0236	.0079	.0315
DNMX444-WMX	.138	.02	.236	.0197	.0079	.0315
LNMX191940-PM	.197	.079	.394	.0354	.0276	.0472
LNMX301940-PM	.276	.079	.787	.0354	.0276	.0472
LNMX301940-PR	.276	.079	.787	.0354	.0276	.0472
LNMX501432-XH	.984	.197	1.339	.0669	.0591	.0984
LNMX191940-PF	.197	.079	.394	.0354	.0276	.0472
LNMX191940-PM	.197	.079	.394	.0354	.0276	.0472
LNMX301940-PR	.276	.079	.787	.0354	.0276	.0472
RNMG32	.059	.02	.094	.0059	.0015	.0068
RNMG43	.031	.01	.063	.0028	.003	.002
RNMG54	.098	.039	.157	.0098	.0025	.0124
RNMG64	.098	.039	.157	.0098	.0025	.0124
RNMG86	.059	.016	.098	.0039	.0035	.0032
RNMX381200-MR	.157	.059	.315	.4724	.1575	.6299
RNMX5018M0-MR	.236	.079	.472	.5512	.2756	.7087
SNMA322-KR	.098	.015	.177	.015	.0075	.0209
SNMA432-KR	.157	.008	.315	.0138	.0059	.0236
SNMA433-KR	.157	.012	.315	.0177	.0079	.0315
SNMA434-KR	.157	.012	.315	.0217	.0079	.0394
SNMA543-KR	.197	.012	.394	.0177	.0079	.0315
SNMA544-KR	.197	.012	.394	.0217	.0079	.0394
SNMA642-KR	.236	.008	.472	.0138	.0059	.0236
SNMA643-KR	.236	.012	.472	.0177	.0079	.0315
SNMA644-KR	.236	.012	.472	.0217	.0079	.0394
SNMA856-KR	.236	.016	.472	.0236	.0079	.0551
SNMG321-MF	.039	.02	.118	.0079	.0039	.0118
SNMG321-PM	.079	.016	.177	.0079	.0039	.0118
SNMG321-QM	.118	.039	.177	.0098	.0071	.0118
SNMG322-KM	.098	.008	.177	.0138	.0059	.0197
SNMG322-MF	.039	.02	.118	.0098	.0059	.0197
SNMG322-PM	.079	.02	.177	.0118	.0059	.0197
SNMG322-QM	.118	.039	.177	.0138	.0079	.0197
SNMG323-MF	.039	.02	.118	.0118	.0079	.0236
SNMG323-QM	.118	.039	.177	.0138	.0098	.0197
SNMG431-MF	.039	.02	.157	.0079	.0039	.0118
SNMG431-MF ¹⁾	.016	.004	.059	.0059	.002	.0118
SNMG431-MMC	.079	.01	.118	.0098	.0039	.0157
SNMG431-PM	.118	.016	.236	.0079	.0039	.0118
SNMG431-PMC	.079	.01	.118	.0098	.0039	.0157
SNMG431-QM	.118	.039	.236	.0098	.0071	.0118
SNMG431-SMC	.02	.01	.118	.0079	.0039	.0118
SNMG432-KM	.118	.008	.236	.0138	.0059	.0197
SNMG432-KR	.138	.015	.276	.015	.0075	.0209
SNMG432-MF	.039	.02	.157	.0098	.0059	.0197
SNMG432-MF ¹⁾	.016	.004	.059	.0079	.0039	.0157
SNMG432-MM	.118	.02	.25	.0098	.0039	.0177
SNMG432-MMC	.079	.01	.118	.0118	.0059	.0157
SNMG432-MR	.157	.059	.315	.0197	.0138	.0217
SNMG432-MR ¹⁾	.118	.079	.299	.0118	.0059	.0217
SNMG432-PF	.016	.012	.059	.0079	.0039	.0157
SNMG432-PM	.118	.02	.236	.0118	.0059	.0197
SNMG432-PMC	.079	.01	.118	.0118	.0059	.0157
SNMG432-PR	.157	.028	.276	.0138	.0079	.0197
SNMG432-QM	.118	.039	.236	.0138	.0079	.0197
SNMG432-SM	.079	.02	.197	.0087	.0059	.0157
SNMG432-SMC	.039	.01	.118	.0098	.0059	.0138
SNMG432-SMR	.079	.02	.197	.0098	.0059	.0157
SNMG432-XM	.118	.02	.236	.0118	.0047	.0197
SNMG432-XMR	.118	.02	.236	.0138	.0059	.0217
SNMG433-KM	.118	.012	.236	.0157	.0059	.0236

1) Rostfrei.

Wendeplatte	Schnitttiefe			Vorschub		
	a _p = Zoll			f _n = Zoll/U		
	Empf.	Min.	Max.	Empf.	Min.	Max.
SNMG433-KR	.138	.02	.276	.0197	.011	.0276
SNMG433-KRR	.157	.012	.315	.0177	.0079	.0315
SNMG433-MF	.039	.02	.157	.0118	.0079	.0236
SNMG433-MM	.118	.02	.25	.0118	.0039	.0236
SNMG433-MMC	.079	.016	.118	.0138	.0059	.0197
SNMG433-MR	.157	.079	.315	.0236	.0138	.0295
SNMG433-MR ¹⁾	.118	.079	.299	.0138	.0059	.0236
SNMG433-MRR	.157	.039	.236	.0157	.0098	.0256
SNMG433-PF	.031	.014	.059	.0098	.0059	.0197
SNMG433-PM	.118	.031	.236	.0138	.0071	.0236
SNMG433-PMC	.079	.016	.118	.0138	.0059	.0197
SNMG433-PR	.157	.039	.276	.0157	.0098	.0276
SNMG433-QM	.118	.039	.236	.0138	.0098	.0236
SNMG433-SM	.079	.02	.197	.011	.0071	.0177
SNMG433-SMC	.059	.016	.118	.0118	.0059	.0157
SNMG433-SMR	.079	.02	.197	.0118	.0071	.0177
SNMG433-XM	.138	.02	.236	.0138	.0059	.0236
SNMG433-XMR	.118	.03	.236	.0138	.0071	.0236
SNMG434-KM	.118	.012	.236	.0177	.0079	.0276
SNMG434-KR	.138	.03	.276	.0217	.011	.0303
SNMG434-KRR	.157	.012	.315	.0217	.0079	.0394
SNMG434-MF	.039	.02	.157	.0118	.0098	.0236
SNMG434-MM	.118	.02	.25	.0146	.0039	.0256
SNMG434-MR	.157	.079	.315	.0236	.0138	.0354
SNMG434-PM	.118	.039	.236	.0157	.0091	.0256
SNMG434-PR	.157	.059	.276	.0197	.0126	.0295
SNMG434-QM	.118	.039	.236	.0157	.0118	.0256
SNMG434-SM	.079	.02	.197	.013	.0071	.0197
SNMG434-SMR	.079	.02	.197	.0138	.0071	.0197
SNMG434-XMR	.138	.039	.236	.0157	.0079	.0256
SNMG542-PR	.197	.059	.315	.0138	.0079	.0197
SNMG542-QM	.118	.039	.315	.0138	.0079	.0197
SNMG543-HM	.157	.039	.315	.0197	.0098	.0315
SNMG543-KM	.157	.012	.315	.0157	.0059	.0236
SNMG543-KR	.173	.025	.346	.0217	.011	.0303
SNMG543-MM	.157	.02	.315	.0118	.0039	.0236
SNMG543-MR	.236	.079	.421	.0236	.0138	.0295
SNMG543-MR ¹⁾	.157	.079	.378	.0138	.0059	.0236
SNMG543-MRR	.197	.039	.276	.0157	.0098	.0256
SNMG543-PM	.157	.031	.295	.0138	.0071	.0236
SNMG543-PR	.197	.039	.315	.0157	.0098	.0276
SNMG543-QM	.118	.039	.315	.0138	.0098	.0236
SNMG543-SM	.197	.039	.315	.0118	.0079	.0157
SNMG544-HM	.157	.059	.315	.0236	.0118	.0354
SNMG544-KM	.157	.012	.315	.0177	.0079	.0276
SNMG544-KR	.173	.037	.346	.024	.0118	.0335
SNMG544-KRR	.197	.012	.394	.0217	.0079	.0394
SNMG544-MM	.157	.02	.315	.0146	.0039	.0256
SNMG544-MR	.236	.079	.421	.0236	.0138	.0354
SNMG544-MR ¹⁾	.157	.079	.378	.0157	.0059	.0276
SNMG544-MRR	.197	.059	.315	.0197	.0118	.0295
SNMG544-PM	.157	.039	.295	.0157	.0091	.0256
SNMG544-PR	.197	.059	.315	.0197	.0118	.0315
SNMG544-QM	.197	.059	.315	.0197	.0118	.0315
SNMG544-SM	.197	.039	.315	.0138	.0098	.0177
SNMG544-SMR	.197	.039	.315	.0197	.0118	.0276
SNMG546-PR	.197	.079	.315	.0197	.0126	.0354
SNMG642-MR	.236	.059	.472	.0197	.0138	.0217
SNMG642-PR	.197	.028	.394	.0138	.0079	.0197
SNMG642-QM	.197	.028	.394	.0138	.0079	.0197
SNMG643-HM	.157	.039	.394	.0197	.0098	.0315
SNMG643-KM	.177	.012	.354	.0157	.0059	.0236
SNMG643-MM	.157	.02	.374	.0118	.0039	.0236
SNMG643-MR	.236	.079	.472	.0236	.0138	.0295
SNMG643-MR ¹⁾	.157	.079	.449	.0138	.0059	.0236
SNMG643-MRR	.197	.039	.394	.0157	.0098	.0256
SNMG643-PR	.197	.039	.394	.0157	.0098	.0276
SNMG643-QM	.197	.039	.394	.0157	.0098	.0276
SNMG643-SMR	.236	.039	.354	.0138	.0098	.0165
SNMG643-XMR	.197	.039	.394	.0197	.0098	.0276
SNMG644-HM	.157	.059	.394	.0236	.0118	.0354
SNMG644-KM	.177	.012	.354	.0177	.0079	.0276
SNMG644-KR	.24	.052	.484	.024	.0118	.0335

Empfohlene Schnitttiefe und Vorschub, Zoll

T-Max® P Wendeschneidplatten zum Drehen

Wendeplatte	Schnitttiefe			Vorschub		
	a _p = Zoll			f _n = Zoll/U		
	Empf.	Min.	Max.	Empf.	Min.	Max.
SNMG644-MM	.157	.02	.374	.0146	.0039	.0256
SNMG644-MR	.236	.079	.472	.0236	.0138	.0354
SNMG644-MR ¹⁾	.157	.079	.449	.0157	.0059	.0276
SNMG644-MRR	.197	.059	.394	.0197	.0118	.0295
SNMG644-PR	.197	.059	.394	.0197	.0118	.0315
SNMG644-QM	.118	.039	.315	.0157	.0118	.0256
SNMG644-SM	.276	.079	.394	.0138	.0098	.0177
SNMG644-SMR	.276	.039	.394	.0197	.0118	.0276
SNMG644-XMR	.197	.039	.394	.0217	.0118	.0315
SNMG646-HM	.197	.079	.394	.0236	.0118	.0472
SNMG646-MR ¹⁾	.157	.079	.449	.0197	.0059	.0394
SNMG646-MRR	.197	.079	.394	.0197	.0126	.0335
SNMG646-PR	.197	.079	.394	.0197	.0126	.0354
SNMG854-PR	.236	.079	.591	.0315	.0157	.0394
SNMG856-KR	.276	.079	.551	.0339	.0169	.0476
SNMG856-MR	.236	.079	.472	.0236	.0157	.0472
SNMG856-PR	.236	.079	.591	.0394	.0157	.0472
SNMG866-HM	.236	.079	.591	.0315	.0157	.0472
SNMG866-MR	.236	.079	.472	.0236	.0157	.0472
SNMG866-PR	.236	.079	.591	.0394	.0157	.0472
SNMM432-MR	.197	.028	.295	.0157	.0098	.0217
SNMM432-PR	.197	.028	.295	.0157	.0079	.0217
SNMM432-QR	.236	.079	.315	.0197	.0138	.0236
SNMM433-MR	.197	.039	.295	.0197	.0126	.0276
SNMM433-PR	.197	.039	.295	.0197	.0098	.0276
SNMM433-QR	.236	.079	.315	.0236	.0138	.0354
SNMM434-MR	.197	.059	.295	.0217	.0126	.0354
SNMM434-QR	.236	.079	.315	.0236	.0138	.0472
SNMM542-QR	.236	.079	.394	.0197	.0138	.0236
SNMM543-MR	.236	.039	.354	.0197	.0126	.0276
SNMM543-PR	.236	.039	.354	.0197	.0098	.0276
SNMM543-QR	.236	.079	.394	.0236	.0138	.0354
SNMM544-MR	.236	.059	.354	.0217	.0157	.0354
SNMM544-PR	.236	.059	.354	.0217	.0126	.0354
SNMM544-QR	.236	.079	.394	.0236	.0138	.0472
SNMM546-QR	.236	.079	.394	.0236	.0138	.0591
SNMM642-QR	.236	.079	.472	.0197	.0138	.0236
SNMM643-MR	.276	.059	.472	.0197	.0126	.0276
SNMM643-PR	.236	.039	.472	.0197	.0098	.0276
SNMM643-QR	.236	.079	.472	.0236	.0138	.0354
SNMM644-HR	.394	.094	.512	.0315	.0197	.0433
SNMM644-MR	.276	.071	.472	.0217	.0177	.0354
SNMM644-PR	.236	.059	.472	.0217	.0126	.0354
SNMM644-QR	.236	.079	.472	.0236	.0138	.0472
SNMM646-HR	.394	.126	.512	.0394	.0236	.063
SNMM646-MR	.276	.098	.472	.0236	.0157	.0472
SNMM646-PR	.236	.079	.472	.0217	.0138	.0472
SNMM646-QR	.236	.079	.472	.0236	.0138	.0591
SNMM648-MR	.236	.138	.472	.0236	.0177	.0472
SNMM856	.236	.079	.472	.0236	.0138	.0472
SNMM856-HR	.394	.126	.669	.0394	.0236	.063
SNMM856-MR	.354	.11	.709	.0276	.0177	.0551
SNMM856-QR	.315	.098	.591	.0256	.0157	.0512
SNMM858-HR	.394	.157	.669	.0394	.0236	.0709
SNMM858-MR	.315	.079	.591	.0236	.0177	.0551
SNMM866-HR	.394	.126	.669	.0394	.0236	.063
SNMM866-MR	.354	.11	.709	.0276	.0177	.0551
SNMM868-HR	.394	.157	.669	.0394	.0236	.0709
SNMU434-KM	.118	.012	.236	.0177	.0079	.0276
TNMA331-KR	.098	.008	.197	.0079	.0039	.0118
TNMA332-KR	.138	.008	.276	.0138	.0059	.0236
TNMA333-KR	.138	.012	.276	.0177	.0079	.0315
TNMA334-KR	.138	.012	.276	.0217	.0079	.0394
TNMA431-KR	.098	.008	.394	.0079	.0039	.0118
TNMA432-KR	.197	.008	.394	.0138	.0059	.0236
TNMA433-KR	.197	.012	.394	.0177	.0079	.0315
TNMA434-KR	.197	.012	.394	.0217	.0079	.0394
TNMA438-KR	.197	.02	.394	.0236	.0197	.0472
TNMA544-KR	.197	.012	.472	.0197	.0079	.0394
TNMG220-MF	.039	.02	.108	.0039	.0028	.0059
TNMG221-MF	.039	.02	.108	.0079	.0039	.0118
TNMG221-QM	.118	.039	.152	.0098	.0071	.0118
TNMG222-MF	.039	.02	.108	.0098	.0059	.0197

1) Rostfrei.

Wendeplatte	Schnitttiefe			Vorschub		
	a _p = Zoll			f _n = Zoll/U		
	Empf.	Min.	Max.	Empf.	Min.	Max.
TNMG222-QM	.118	.039	.152	.0138	.0079	.0197
TNMG223-MF	.039	.02	.108	.0118	.0079	.0236
TNMG321-QM	.118	.039	.197	.0098	.0071	.0118
TNMG322-QM	.187	.059	.315	.0197	.0098	.022
TNMG331-KF	.02	.006	.079	.0059	.0031	.0098
TNMG331-LC	.01	.004	.059	.0039	.002	.0098
TNMG331L-K	.098	.028	.197	.0087	.0055	.0118
TNMG331-MF	.039	.02	.157	.0079	.0039	.0118
TNMG331-MF ¹⁾	.016	.004	.059	.0059	.002	.0118
TNMG331-MMC	.079	.01	.118	.0098	.0039	.0157
TNMG331-PF	.016	.01	.059	.0059	.0028	.0118
TNMG331-PM	.118	.016	.197	.0079	.0039	.0118
TNMG331-PMC	.079	.01	.118	.0098	.0039	.0157
TNMG331-QM	.118	.039	.22	.0098	.0071	.0118
TNMG331R-K	.098	.028	.197	.0087	.0055	.0118
TNMG331-SF	.016	.006	.059	.0047	.0031	.0087
TNMG331-SMC	.02	.01	.118	.0079	.0039	.0118
TNMG331-XF	.03	.006	.157	.0059	.0016	.0079
TNMG331-XM	.098	.012	.197	.0071	.0031	.0118
TNMG332-KF	.02	.006	.079	.0079	.0039	.0118
TNMG332-KM	.118	.008	.217	.0138	.0059	.0197
TNMG332-KR	.126	.013	.244	.0118	.0067	.0165
TNMG332-KRR	.138	.008	.276	.0138	.0059	.0236
TNMG332-LC	.02	.008	.059	.0079	.0039	.0118
TNMG332L-K	.118	.031	.197	.0118	.0055	.0197
TNMG332-MF	.039	.02	.157	.0098	.0059	.0197
TNMG332-MF ¹⁾	.016	.004	.059	.0079	.0039	.0157
TNMG332-MM	.118	.02	.189	.0098	.0039	.0177
TNMG332-MMC	.079	.01	.118	.0118	.0059	.0157
TNMG332-MR	.118	.059	.315	.0157	.0098	.0217
TNMG332-MR ¹⁾	.118	.079	.22	.0118	.0059	.0217
TNMG332-PF	.016	.012	.059	.0079	.0039	.0157
TNMG332-PM	.118	.02	.197	.0118	.0059	.0197
TNMG332-PMC	.079	.01	.118	.0118	.0059	.0157
TNMG332-PR	.118	.028	.236	.0138	.0079	.0217
TNMG332-QM	.118	.039	.22	.0138	.0079	.0197
TNMG332R-K	.118	.031	.197	.0118	.0055	.0197
TNMG332-SF	.02	.008	.059	.0059	.0039	.0098
TNMG332-SM	.079	.008	.118	.0087	.0039	.011
TNMG332-SMC	.039	.01	.118	.0098	.0059	.0138
TNMG332-XF	.039	.008	.157	.0079	.002	.0098
TNMG332-XM	.098	.02	.197	.0098	.0039	.0157
TNMG332-XMR	.118	.02	.197	.0106	.0059	.0177
TNMG333-KM	.118	.012	.217	.0157	.0059	.0236
TNMG333-KR	.126	.018	.248	.0157	.0079	.022
TNMG333-KRR	.138	.012	.276	.0177	.0079	.0315
TNMG333-MF	.039	.02	.157	.0118	.0079	.0236
TNMG333-MF ¹⁾	.031	.008	.098	.0098	.0059	.0197
TNMG333-MM	.118	.02	.189	.0118	.0039	.0236
TNMG333-MMC	.079	.016	.118	.0138	.0059	.0197
TNMG333-MR	.118	.079	.315	.0197	.0098	.0256
TNMG333-MR ¹⁾	.118	.079	.22	.0138	.0059	.0236
TNMG333-MRR	.118	.039	.236	.0157	.0098	.0236
TNMG333-PF	.031	.014	.059	.0098	.0059	.0197
TNMG333-PM	.118	.031	.197	.0138	.0071	.0236
TNMG333-PMC	.079	.016	.118	.0138	.0059	.0197
TNMG333-PR	.118	.039	.236	.0157	.0098	.0256
TNMG333-QM	.118	.039	.22	.0138	.0098	.0236
TNMG333-SF	.031	.016	.079	.0067	.0047	.0118
TNMG333-SM	.079	.012	.118	.0098	.0047	.0118
TNMG333-SMC	.059	.016	.118	.0118	.0059	.0157
TNMG333-XF	.049	.016	.157	.0098	.0031	.0118
TNMG333-XM	.118	.028	.197	.0118	.0059	.0177
TNMG333-XMR	.118	.03	.197	.0118	.0071	.0189
TNMG334-KR	.126	.027	.244	.0173	.0087	.0244
TNMG334-MF	.039	.02	.157	.0118	.0098	.0236
TNMG431-MF	.039	.02	.157	.0079	.0039	.0118
TNMG431-PM	.157	.016	.26	.0079	.0039	.0118
TNMG431-QM	.118	.039	.303	.0098	.0071	.0118
TNMG432-KM	.157	.008	.315	.0138	.0059	.0197
TNMG432-KR	.138	.015	.276	.015	.0075	.0209
TNMG432-MF	.039	.02	.157	.0098	.0059	.0197
TNMG432-MM	.157	.02	.26	.0098	.0039	.0177

Empfohlene Schnitttiefe und Vorschub, Zoll

T-Max® P Wendeschneidplatten zum Drehen

Wendeplatte	Schnitttiefe $a_p = \text{Zoll}$			Vorschub $f_n = \text{Zoll/U}$		
	Empf.	Min.	Max.	Empf.	Min.	Max.
TNMG432-MR	.197	.059	.433	.0197	.0138	.0217
TNMG432-MR ¹⁾	.157	.079	.303	.0118	.0059	.0217
TNMG432-PF	.016	.012	.059	.0079	.0039	.0157
TNMG432-PM	.157	.02	.26	.0118	.0059	.0197
TNMG432-PR	.157	.028	.276	.0138	.0079	.0217
TNMG432-QM	.118	.039	.303	.0138	.0079	.0197
TNMG432-SM	.079	.008	.157	.0087	.0039	.011
TNMG433-KM	.157	.012	.315	.0157	.0059	.0236
TNMG433-KR	.138	.02	.276	.0197	.0098	.0276
TNMG433-MF	.039	.02	.157	.0118	.0079	.0236
TNMG433-MM	.157	.02	.26	.0118	.0039	.0236
TNMG433-MR	.236	.079	.433	.0236	.0138	.0295
TNMG433-MR ¹⁾	.157	.079	.303	.0138	.0059	.0236
TNMG433-MRR	.157	.039	.276	.0157	.0098	.0236
TNMG433-PF	.031	.014	.059	.0098	.0059	.0197
TNMG433-PM	.157	.031	.26	.0138	.0071	.0236
TNMG433-PR	.157	.039	.276	.0157	.0098	.0256
TNMG433-QM	.118	.039	.303	.0138	.0098	.0236
TNMG433-SM	.079	.012	.157	.0098	.0047	.0118
TNMG434-KM	.157	.012	.315	.0177	.0079	.0276
TNMG434-MM	.157	.02	.26	.0146	.0039	.0256
TNMG434-MR	.236	.079	.433	.0236	.0138	.0354
TNMG434-MR ¹⁾	.157	.079	.303	.0157	.0059	.0276
TNMG434-MRR	.157	.059	.276	.0197	.0126	.0276
TNMG434-PM	.157	.039	.26	.0157	.0091	.0256
TNMG434-PR	.157	.059	.276	.0197	.0126	.0295
TNMG434-QM	.118	.039	.303	.0157	.0118	.0256
TNMG436-MR	.157	.059	.276	.0197	.0126	.0295
TNMG542-MR	.236	.059	.472	.0197	.0138	.0217
TNMG542-PR	.236	.059	.472	.0197	.0138	.0217
TNMG542-QM	.118	.039	.315	.0138	.0079	.0197
TNMG543-HM	.236	.079	.472	.0236	.0138	.0295
TNMG543-MR	.236	.079	.472	.0236	.0138	.0295
TNMG543-PR	.236	.079	.472	.0236	.0138	.0295
TNMG543-QM	.118	.039	.315	.0138	.0098	.0236
TNMG544-HM	.236	.079	.472	.0236	.0138	.0295
TNMG544-KR	.173	.037	.346	.026	.013	.0362
TNMG544-MR	.236	.079	.472	.0236	.0138	.0354
TNMG544-PR	.236	.079	.472	.0236	.0138	.0276
TNMG654-PR	.118	.059	.315	.0236	.0157	.0295
TNMG666-HM	.276	.118	.591	.0236	.0177	.0354
TNMG666-MR	.276	.118	.591	.0256	.0197	.0354
TNMG666-PR	.276	.118	.591	.0236	.0177	.0354
TNMM332-MR	.197	.028	.295	.0157	.0098	.0217
TNMM332-PR	.157	.028	.236	.0157	.0079	.0217
TNMM332-QR	.236	.079	.315	.0197	.0138	.0236
TNMM333-PR	.157	.039	.236	.0197	.0098	.0276
TNMM333-QR	.236	.079	.315	.0236	.0138	.0354
TNMM432-MR	.197	.028	.315	.0157	.0098	.0217
TNMM432-PR	.197	.028	.315	.0157	.0079	.0217
TNMM432-QR	.236	.079	.433	.0197	.0138	.0236
TNMM433-MR	.197	.039	.315	.0197	.0126	.0276
TNMM433-PR	.197	.039	.315	.0197	.0098	.0276
TNMM433-QR	.236	.079	.433	.0236	.0138	.0354
TNMM434-MR	.197	.059	.315	.0217	.0126	.0354
TNMM434-PR	.197	.059	.315	.0217	.0126	.0354
TNMM434-QR	.236	.079	.433	.0236	.0138	.0472
TNMM543-MR	.236	.039	.354	.0197	.0126	.0276
TNMM543-QR	.236	.079	.433	.0236	.0138	.0354
TNMM544-HR	.394	.094	.512	.0315	.0197	.0433
TNMM544-MR	.236	.059	.354	.0217	.0157	.0354
TNMM544-QR	.236	.079	.433	.0236	.0138	.0472
TNMM546-HR	.394	.126	.512	.0394	.0236	.063
TNMM546-MR	.236	.079	.354	.0217	.0157	.0394
TNMM546-PR	.016	.012	.059	.0079	.0039	.0157
TNMM546-QR	.118	.012	.217	.0157	.0059	.0236
TNMX333-WM	.138	.031	.236	.0197	.0079	.0354
TNMX1106-2	.039	.02	.098	.2362	.0787	.3346
TNMX1509-2	.089	.03	.138	.3937	.1575	.5118
TNMX330931-MF	.03	.008	.051	.4331	.1575	.6299
TNMX330932-PF	.03	.008	.051	.4331	.2756	.6299
TNMX331-WF	.039	.008	.118	.0079	.0031	.0118
TNMX332-WF	.059	.008	.118	.0118	.0039	.0157

1) Rostfrei.

Wendeplatte	Schnitttiefe $a_p = \text{Zoll}$			Vorschub $f_n = \text{Zoll/U}$		
	Empf.	Min.	Max.	Empf.	Min.	Max.
TNMX332-WM	.079	.02	.177	.0138	.0059	.0197
TNMX332-WMX	.118	.02	.197	.0177	.0059	.0276
TNMX333-WM	.098	.02	.197	.0157	.0059	.0236
TNMX333-WMX	.138	.031	.236	.0197	.0079	.0295
TNMX433-WR	.098	.039	.197	.0315	.0157	.0433
TNMX434-WR	.098	.047	.197	.0354	.0173	.0472
TNMX440901-MR	.11	.039	.197	.2756	.1575	.4331
TNMX491051-MF	.059	.02	.098	.4724	.1575	.6299
VNMG331-SGF	.012	.004	.118	.0047	.002	.0059
VNMG332-SGF	.02	.008	.118	.0059	.0028	.0079
VNMG333-SGF	.031	.012	.118	.0071	.0039	.0098
WNGG431-SGF	.012	.004	.118	.0047	.002	.0098
WNGG432-SGF	.02	.008	.118	.0059	.0039	.0118
WNMA332-KR	.098	.008	.157	.0138	.0059	.0236
WNMA333-KR	.098	.012	.157	.0177	.0079	.0315
WNMA432-KR	.118	.008	.197	.0138	.0059	.0236
WNMA433-KR	.118	.012	.197	.0177	.0079	.0315
WNMA434-KR	.118	.012	.197	.0217	.0079	.0394
WNMG331-KF	.02	.006	.079	.0059	.0031	.0098
VNMG331-LC	.01	.004	.039	.0039	.002	.0079
WNMG331-LC	.01	.004	.039	.0039	.002	.0098
VNMG331-MF	.039	.02	.118	.0079	.0039	.0118
VNMG331-MF ¹⁾	.016	.004	.059	.0059	.002	.0118
WNMG331-MF	.039	.02	.118	.0079	.0039	.0118
WNMG331-MF ¹⁾	.016	.004	.059	.0059	.002	.0118
VNMG331-MMC	.079	.01	.118	.0067	.0039	.0098
VNMG331-PF	.016	.01	.059	.0059	.0028	.0118
WNMG331-PF	.016	.01	.059	.0059	.0028	.0118
VNMG331-PMC	.079	.01	.118	.0067	.0039	.0098
VNMG331-QM	.118	.039	.157	.0098	.0071	.0118
VNMG331-SF	.016	.006	.059	.0047	.0031	.0079
VNMG331-SM	.039	.006	.079	.0071	.002	.0079
WNMG331-SM	.118	.047	.189	.0118	.003	.0149
VNMG331-SMC	.02	.01	.118	.0067	.0039	.0098
WNMG331-WF	.016	.01	.079	.0059	.002	.0098
WNMG331-WL	.01	.004	.039	.0079	.002	.0118
WNMG331-XF	.03	.006	.118	.0059	.0016	.0079
WNMG331-XM	.098	.02	.157	.0098	.0039	.0138
WNMG332-KF	.02	.006	.079	.0079	.0039	.0118
VNMG332-KM	.079	.008	.138	.0118	.0059	.0157
WNMG332-KR	.087	.009	.177	.0118	.0067	.0165
VNMG332-LC	.02	.008	.059	.0079	.0039	.0098
WNMG332-MF	.039	.02	.157	.0098	.0059	.0197
VNMG332-MF ¹⁾	.031	.008	.098	.0059	.0031	.0118
WNMG332-MF	.039	.02	.118	.0098	.0059	.0197
WNMG332-MF ¹⁾	.016	.004	.059	.0079	.0039	.0157
VNMG332-MM	.079	.02	.118	.0098	.0039	.0177
WNMG332-MM	.079	.02	.118	.0098	.0039	.0177
VNMG332-MMC	.079	.01	.118	.0067	.0039	.0098
WNMG332-MR ¹⁾	.079	.059	.118	.0118	.0059	.0217
VNMG332-PF	.016	.012	.059	.0079	.0039	.0157
WNMG332-PF	.016	.012	.059	.0079	.0039	.0157
VNMG332-PM	.079	.02	.157	.0118	.0059	.0197
WNMG332-PM	.079	.02	.118	.0118	.0059	.0197
VNMG332-PMC	.079	.01	.118	.0067	.0039	.0098
WNMG332-PR	.118	.028	.138	.0118	.0079	.0177
VNMG332-QM	.118	.039	.157	.0138	.0079	.0197
WNMG332-QM	.118	.039	.118	.0138	.0079	.0197
VNMG332-SF	.02	.008	.059	.0059	.0039	.0087
VNMG332-SM	.059	.008	.098	.0079	.0028	.0091
WNMG332-SM	.118	.047	.189	.0116	.003	.0145
VNMG332-SMC	.031	.01	.118	.0067	.0039	.0098
WNMG332-SMC	.039	.01	.118	.0118	.0039	.0197
VNMG332-WL	.02	.008	.059	.0098	.0039	.0177
WNMG332-WL	.019	.02	.138	.0118	.0059	.0236
WNMG332-WMX	.118	.02	.197	.0177	.0059	.0276
WNMG332-XF	.039	.008	.118	.0079	.002	.0098
WNMG332-XM	.098	.02	.157	.0098	.0039	.0138
WNMG332-XMR	.098	.02	.157	.0118	.0059	.0157
VNMG333-KM	.079	.012	.138	.0138	.0059	.0197
WNMG333-KM	.079	.012	.157	.0157	.0059	.0236

Empfohlene Schnitttiefe und Vorschub, Zoll

T-Max® P Wendeschneidplatten zum Drehen

Wendeplatte	Schnitttiefe			Vorschub		
	$a_p = \text{Zoll}$			$f_n = \text{Zoll/U}$		
	Empf.	Min.	Max.	Empf.	Min.	Max.
WNMG333-KR	.087	.013	.177	.0157	.0079	.022
VNMG333-MF	.039	.02	.157	.0118	.0079	.0236
WNMG333-MM	.079	.02	.118	.0118	.0039	.0236
VNMG333-MMC	.079	.016	.118	.0079	.0039	.0118
WNMG333-MR	.079	.059	.118	.0138	.0059	.0236
WNMG333-MRR	.118	.031	.138	.0138	.0098	.0197
WNMG333-PF	.031	.016	.059	.0098	.0059	.0197
VNMG333-PM	.079	.031	.157	.0138	.0071	.0236
WNMG333-PM	.079	.031	.118	.0138	.0071	.0236
VNMG333-PMC	.079	.016	.118	.0079	.0039	.0118
WNMG333-PR	.118	.031	.138	.0138	.0098	.0217
VNMG333-QM	.118	.039	.157	.0138	.0098	.0197
WNMG333-QM	.118	.039	.118	.0138	.0098	.0236
VNMG333-SF	.031	.016	.079	.0067	.0047	.0098
VNMG333-SM	.059	.012	.118	.0087	.0039	.0098
VNMG333-SMC	.059	.016	.118	.0079	.0039	.0118
WNMG333-WM	.059	.031	.138	.0197	.0079	.0354
WNMG333-WMX	.138	.031	.236	.0197	.0079	.0295
WNMG333-XM	.098	.028	.157	.0118	.0059	.0157
WNMG333-XMR	.098	.03	.157	.0126	.0071	.0165
WNMG431-KF	.02	.006	.079	.0059	.0031	.0098
WNMG431-MF	.039	.02	.079	.0079	.0039	.0118
WNMG431-MF ¹⁾	.016	.004	.059	.0059	.002	.0118
WNMG431-MMC	.079	.01	.118	.0098	.0039	.0157
WNMG431-PF	.016	.01	.059	.0059	.0028	.0118
WNMG431-PMC	.079	.01	.118	.0098	.0039	.0157
WNMG431-QM	.118	.039	.157	.0079	.0071	.0098
WNMG431-SF	.016	.006	.059	.0047	.0031	.0087
WNMG431-SM	.059	.006	.098	.0079	.0039	.0118
WNMG431-SMC	.02	.01	.118	.0079	.0039	.0118
WNMG431-WF	.016	.01	.118	.0059	.002	.0098
WNMG431-XF	.03	.006	.157	.0059	.0016	.0079
WNMG431-XM	.098	.012	.197	.0071	.0031	.0118
WNMG432-KF	.02	.006	.079	.0079	.0039	.0118
WNMG432-KM	.098	.008	.197	.0138	.0059	.0197
WNMG432-KR	.106	.011	.217	.0134	.0067	.0185
WNMG432-KRR	.118	.008	.197	.0138	.0059	.0236
WNMG432-LC	.02	.008	.059	.0079	.0039	.0118
WNMG432-MF	.039	.02	.079	.0098	.0059	.0197
WNMG432-MF ¹⁾	.016	.004	.059	.0079	.0039	.0157
WNMG432-MM	.098	.02	.157	.0098	.0039	.0177
WNMG432-MMC	.079	.01	.118	.0118	.0059	.0157
WNMG432-MR	.138	.059	.197	.0197	.0138	.0217
WNMG432-MR ¹⁾	.098	.079	.157	.0118	.0059	.0217
WNMG432-PF	.016	.012	.059	.0079	.0039	.0157
WNMG432-PM	.098	.02	.157	.0118	.0059	.0197
WNMG432-PMC	.079	.01	.118	.0118	.0059	.0157
WNMG432-PR	.157	.028	.197	.0138	.0079	.0217
WNMG432-QM	.118	.039	.157	.0138	.0079	.0197
WNMG432-SF	.02	.008	.059	.0059	.0039	.0098
WNMG432-SM	.079	.008	.118	.0098	.0039	.0138
WNMG432-SMC	.039	.01	.118	.0098	.0059	.0138
WNMG432-SMR	.079	.02	.157	.0118	.0039	.0157
WNMG432-WF	.039	.01	.157	.0118	.0039	.0197
WNMG432-WL	.02	.008	.059	.0098	.0039	.0177
WNMG432-WM	.118	.02	.197	.0118	.0059	.0236
WNMG432-WMX	.118	.02	.197	.0177	.0059	.0276
WNMG432-XF	.039	.008	.157	.0079	.002	.0098
WNMG432-XM	.098	.02	.197	.0098	.0039	.0157
WNMG433-KF	.039	.008	.098	.0098	.0039	.0138
WNMG433-KM	.098	.012	.197	.0157	.0059	.0236
WNMG433-KR	.106	.015	.217	.0177	.0091	.0248
WNMG433-KRR	.118	.012	.197	.0177	.0079	.0315
WNMG433-MM	.098	.02	.157	.0118	.0039	.0236
WNMG433-MMC	.079	.016	.118	.0138	.0059	.0197
WNMG433-MR	.138	.079	.197	.0236	.0138	.0295
WNMG433-MR ¹⁾	.098	.079	.157	.0138	.0059	.0236
WNMG433-MRR	.157	.039	.197	.0157	.0098	.0256
WNMG433-PF	.031	.016	.059	.0098	.0059	.0197
WNMG433-PM	.098	.031	.157	.0138	.0071	.0236
WNMG433-PMC	.079	.016	.118	.0138	.0059	.0197
WNMG433-PR	.157	.039	.197	.0157	.0098	.0276
WNMG433-QM	.118	.039	.157	.0138	.0098	.0236

1) Rostfrei.

Wendeplatte	Schnitttiefe			Vorschub		
	$a_p = \text{Zoll}$			$f_n = \text{Zoll/U}$		
	Empf.	Min.	Max.	Empf.	Min.	Max.
WNMG433-SF	.031	.016	.079	.0067	.0047	.0118
WNMG433-SM	.079	.012	.138	.011	.0047	.015
WNMG433-SMC	.059	.016	.118	.0118	.0059	.0157
WNMG433-SMR	.079	.02	.157	.0126	.0047	.0165
WNMG433-WF	.059	.016	.157	.0197	.0079	.0236
WNMG433-WM	.138	.031	.236	.0197	.0079	.0354
WNMG433-WMX	.138	.031	.236	.0197	.0079	.0295
WNMG433-XM	.118	.028	.197	.0118	.0059	.0177
WNMG433-XMR	.118	.03	.197	.0126	.0071	.0189
WNMG434-KM	.098	.012	.197	.0177	.0079	.0276
WNMG434-MR	.138	.079	.197	.0236	.0138	.0354
WNMG434-PM	.118	.039	.157	.0157	.0091	.0256
WNMG434-PR	.157	.059	.197	.0197	.0126	.0295
WNMG434-QM	.157	.059	.197	.0197	.0126	.0295
WNMT150931-PM	.059	.02	.118	.2362	.0787	.3937
WNMU433-KM	.098	.012	.197	.0157	.0059	.0236
WNMU433-WM	.138	.031	.236	.0197	.0079	.0354
WNMU443-WM	.138	.031	.236	.0197	.0079	.0354
WNMX150931-MM	.069	.02	.118	.2756	.1575	.3937
WNMX211251-MM	.118	.02	.197	.315	.1575	.4331
175.32-191940-25	.197	.079	.394	.0354	.0276	.0472

Empfohlene Schnitttiefe und Vorschub, Zoll

B CoroTurn® 107 Wendeschneidplatten zum Drehen

Wendeplatte	Schnitttiefe			Vorschub			Wendeplatte	Schnitttiefe			Vorschub		
	a _p = Zoll			f _n = Zoll/U				a _p = Zoll			f _n = Zoll/U		
	Empf.	Min.	Max.	Empf.	Min.	Max.		Empf.	Min.	Max.	Empf.	Min.	Max.
CCET2(1.5)03-UM	.012	.004	.157	.0012	.0004	.0024	CCMT3(2.5)2-PMC	.079	.01	.118	.0079	.0039	.0118
CCET2(1.5)0-UM	.02	.008	.157	.0012	.0004	.0024	CCMT3(2.5)2-PR	.079	.039	.157	.0098	.0047	.0138
CCET2(1.5)1-UM	.039	.02	.157	.0012	.0004	.0024	CCMT3(2.5)2-SMC	.031	.01	.118	.0079	.0039	.0118
CCGT2(1.5)03-UM	.012	.004	.039	.0012	.0004	.0024	CCMT3(2.5)2-UM	.049	.02	.157	.0098	.0047	.0157
CCGT2(1.5)0-UM	.02	.004	.059	.0028	.0008	.0047	CCMT3(2.5)2-UR	.079	.039	.157	.0118	.0059	.0197
CCGT2(1.5)1-UM	.039	.02	.079	.0079	.0031	.0118	CCMT3(2.5)2-WF	.039	.012	.118	.0098	.0047	.0197
CCGT3(2.5)03-UM	.012	.004	.039	.0012	.0004	.0024	CCMT3(2.5)2-WM	.059	.028	.157	.0118	.0059	.0197
CCGT3(2.5)0-UM	.02	.004	.059	.0028	.0008	.0047	CCMT3(2.5)2-XF	.014	.006	.079	.0059	.0031	.0118
CCGT3(2.5)1-UM	.049	.02	.118	.0059	.0031	.0098	CCMT3(2.5)2-XM	.031	.02	.118	.0079	.0039	.0118
CCGT3(2.5)2-UM	.049	.02	.118	.0079	.0047	.0138	CCMT3(2.5)2-XR	.079	.039	.157	.0098	.0047	.0138
CCGT431-UM	.059	.02	.157	.0059	.0031	.0098	CCMT3(2.5)3-KR	.079	.047	.157	.0118	.0055	.0165
CCGT432-UM	.059	.02	.157	.0079	.0047	.0138	CCMT3(2.5)3-MR	.079	.047	.157	.0118	.0055	.0165
CCGX2(1.5)0-AL	.039	.012	.118	.0047	.002	.0059	CCMT3(2.5)3-PR	.079	.047	.157	.0118	.0055	.0165
CCGX2(1.5)1-AL	.039	.012	.118	.0047	.002	.0059	CCMT3(2.5)3-XR	.079	.047	.157	.0118	.0055	.0165
CCGX3(2.5)1-AL	.059	.02	.197	.0079	.0039	.0118	CCMT380932-XH	.059	.047	.079	.4724	.1969	.6693
CCGX3(2.5)2-AL	.059	.02	.197	.0118	.0059	.0236	CCMT431-KF	.017	.006	.094	.0055	.0028	.0106
CCGX431-AL	.059	.02	.276	.0079	.0039	.0118	CCMT431-KM	.038	.012	.142	.0071	.0035	.0106
CCGX432-AL	.059	.02	.276	.0118	.0059	.0236	CCMT431-MM	.017	.006	.094	.0055	.0028	.0106
CCMT2(1.5)0-KF	.012	.002	.067	.0024	.0012	.0043	CCMT431-MF	.038	.012	.142	.0071	.0035	.0106
CCMT2(1.5)0-MF	.012	.002	.067	.0024	.0012	.0043	CCMT431-PF	.017	.006	.094	.0055	.0028	.0106
CCMT2(1.5)0-PF	.012	.002	.067	.0024	.0012	.0043	CCMT431-PM	.038	.012	.142	.0071	.0035	.0106
CCMT2(1.5)0-UF	.016	.008	.059	.0028	.002	.0059	CCMT431-WM	.079	.02	.157	.0098	.0059	.0157
CCMT2(1.5)0-WF	.012	.004	.059	.0039	.0012	.0059	CCMT432-KM	.038	.024	.142	.0094	.0047	.0142
CCMT2(1.5)1-KF	.012	.004	.067	.0031	.002	.0067	CCMT432-KR	.094	.047	.189	.0118	.0055	.0165
CCMT2(1.5)1-KM	.025	.008	.094	.0043	.0024	.0067	CCMT432-MM	.038	.024	.142	.0094	.0047	.0142
CCMT2(1.5)1-MF	.012	.004	.067	.0031	.002	.0067	CCMT432-MR	.094	.047	.189	.0118	.0055	.0165
CCMT2(1.5)1-MM	.025	.008	.094	.0043	.0024	.0067	CCMT432-PM	.038	.024	.142	.0094	.0047	.0142
CCMT2(1.5)1-PF	.012	.004	.067	.0031	.002	.0067	CCMT432-PR	.094	.047	.189	.0118	.0055	.0165
CCMT2(1.5)1-PM	.025	.008	.094	.0043	.0024	.0067	CCMT432-UM	.059	.02	.157	.0098	.0047	.0157
CCMT2(1.5)1-UF	.016	.008	.059	.0039	.002	.0079	CCMT432-UR	.098	.039	.157	.0118	.0059	.0197
CCMT2(1.5)1-UM	.039	.02	.098	.0079	.0031	.0118	CCMT432-WM	.079	.028	.157	.0118	.0059	.0197
CCMT2(1.5)1-UR	.059	.039	.098	.0098	.0059	.0118	CCMT433-KR	.094	.057	.189	.0142	.0067	.0197
CCMT2(1.5)1-WF	.031	.012	.079	.0047	.002	.0118	CCMT433-MM	.038	.028	.142	.0114	.0055	.0169
CCMT2(1.5)2-KM	.025	.016	.094	.0059	.0031	.0091	CCMT433-MR	.094	.057	.189	.0142	.0067	.0197
CCMT2(1.5)2-KR	.063	.031	.126	.0075	.0035	.0102	CCMT433-PM	.038	.028	.142	.0114	.0055	.0169
CCMT2(1.5)2-MM	.025	.016	.094	.0059	.0031	.0091	CCMT433-PR	.094	.057	.189	.0142	.0067	.0197
CCMT2(1.5)2-MR	.063	.031	.126	.0075	.0035	.0102	DCET2(1.5)00-UM	.012	.004	.157	.0012	.0004	.0024
CCMT2(1.5)2-PM	.025	.016	.094	.0059	.0031	.0091	DCET2(1.5)03-UM	.012	.004	.157	.0012	.0004	.0024
CCMT2(1.5)2-PR	.063	.031	.126	.0075	.0035	.0102	DCET3(2.5)03-UM	.012	.004	.157	.0012	.0004	.0024
CCMT2(1.5)2-UF	.016	.008	.059	.0039	.002	.0098	DCET3(2.5)0-UM	.012	.008	.157	.0012	.0004	.0024
CCMT2(1.5)2-UF	.039	.02	.098	.0098	.0047	.0157	DCET3(2.5)1-UM	.049	.02	.157	.002	.0008	.0039
CCMT2(1.5)2-WF	.031	.012	.079	.0059	.0035	.0138	DCTG2(1.5)03-UM	.012	.004	.039	.0012	.0004	.0024
CCMT2(1.5)2-WM	.047	.02	.098	.0079	.0039	.0157	DCTG2(1.5)0-UM	.02	.004	.059	.0028	.0008	.0047
CCMT3(2.5)0-KF	.014	.003	.079	.0031	.0016	.0059	DCTG2(1.5)1-UM	.039	.02	.098	.0059	.0031	.0098
CCMT3(2.5)0-MF	.014	.003	.079	.0031	.0016	.0059	DCTG2(1.5)2-UM	.039	.02	.098	.0079	.0047	.0138
CCMT3(2.5)0-PF	.014	.003	.079	.0031	.0016	.0059	DCTG3(2.5)03-UM	.012	.004	.039	.0012	.0004	.0024
CCMT3(2.5)0-UF	.016	.008	.079	.0028	.002	.0059	DCTG3(2.5)0-UM	.02	.004	.059	.0012	.0004	.0024
CCMT3(2.5)0-WF	.012	.004	.059	.0039	.0012	.0059	DCTG3(2.5)1-UM	.049	.02	.118	.0059	.0031	.0098
CCMT3(2.5)1-KF	.014	.004	.079	.0043	.0024	.0091	DCTG3(2.5)2-UM	.049	.02	.118	.0079	.0047	.0138
CCMT3(2.5)1-KM	.025	.01	.118	.0059	.0031	.0091	DCGX2(1.5)0-AL	.039	.012	.157	.0047	.002	.0059
CCMT3(2.5)1-MF	.014	.004	.079	.0043	.0024	.0091	DCGX2(1.5)1-AL	.059	.02	.157	.0079	.0039	.0118
CCMT3(2.5)1-MM	.025	.01	.118	.0059	.0031	.0091	DCGX3(2.5)0-AL	.039	.012	.217	.0047	.002	.0059
CCMT3(2.5)1-MMC	.079	.01	.118	.0079	.0039	.0118	DCGX3(2.5)1-AL	.059	.02	.217	.0079	.0039	.0118
CCMT3(2.5)1-PF	.014	.004	.079	.0043	.0024	.0091	DCGX3(2.5)2-AL	.059	.02	.217	.0118	.0059	.0236
CCMT3(2.5)1-PM	.025	.01	.118	.0059	.0031	.0091	DCMT2(1.5)0-KF	.01	.002	.059	.0024	.0012	.0043
CCMT3(2.5)1-PMC	.079	.01	.118	.0079	.0039	.0118	DCMT2(1.5)0-MF	.01	.002	.059	.0024	.0012	.0043
CCMT3(2.5)1-SMC	.02	.01	.118	.0079	.0039	.0118	DCMT2(1.5)0-PF	.01	.002	.059	.0024	.0012	.0043
CCMT3(2.5)1-UF	.016	.008	.079	.0039	.002	.0079	DCMT2(1.5)0-UF	.016	.008	.059	.0028	.002	.0059
CCMT3(2.5)1-UM	.049	.02	.157	.0079	.0031	.0118	DCMT2(1.5)1-KF	.01	.003	.059	.0031	.002	.0067
CCMT3(2.5)1-UR	.079	.039	.157	.0098	.0059	.0118	DCMT2(1.5)1-KM	.024	.007	.089	.0043	.0024	.0067
CCMT3(2.5)1-WF	.039	.012	.118	.0079	.0028	.0118	DCMT2(1.5)1-MF	.01	.003	.059	.0031	.002	.0067
CCMT3(2.5)1-WM	.059	.02	.157	.0098	.0047	.0157	DCMT2(1.5)1-MM	.024	.007	.089	.0043	.0024	.0067
CCMT3(2.5)1-XF	.014	.004	.079	.0043	.0024	.0091	DCMT2(1.5)1-PF	.01	.003	.059	.0031	.002	.0067
CCMT3(2.5)1-XM	.025	.01	.118	.0059	.0031	.0091	DCMT2(1.5)1-PM	.024	.007	.089	.0043	.0024	.0067
CCMT3(2.5)2-KM	.031	.02	.118	.0079	.0039	.0118	DCMT2(1.5)1-UF	.016	.008	.059	.0039	.002	.0079
CCMT3(2.5)2-KR	.079	.039	.157	.0098	.0047	.0138	DCMT2(1.5)1-UM	.039	.02	.098	.0079	.0031	.0118
CCMT3(2.5)2-MF	.014	.006	.079	.0059	.0031	.0118	DCMT2(1.5)2-KM	.024	.015	.089	.0059	.0031	.0091
CCMT3(2.5)2-MM	.031	.02	.118	.0079	.0039	.0118	DCMT2(1.5)2-MM	.024	.015	.089	.0059	.0031	.0091
CCMT3(2.5)2-MMC	.079	.01	.118	.0079	.0039	.0118	DCMT2(1.5)2-PM	.024	.015	.089	.0059	.0031	.0091
CCMT3(2.5)2-MR	.079	.039	.157	.0098	.0047	.0138	DCMT2(1.5)2-UM	.039	.02	.098	.0098	.0047	.0138
CCMT3(2.5)2-PF	.014	.006	.079	.0059	.0031	.0118	DCMT3(2.5)0-KF	.014	.003	.079	.0031	.0016	.0059
CCMT3(2.5)2-PM	.031	.02	.118	.0079	.0039	.0118	DCMT3(2.5)0-MF	.014	.003	.079	.0031	.0016	.0059

Empfohlene Schnitttiefe und Vorschub, Zoll

CoroTurn® 107 Wendeschneidplatten zum Drehen

Wendeplatte	Schnitttiefe			Vorschub		
	$a_p = \text{Zoll}$			$f_n = \text{Zoll/U}$		
	Empf.	Min.	Max.	Empf.	Min.	Max.
DCMT3(2.5)0-PF	.014	.003	.079	.0031	.0016	.0059
DCMT3(2.5)1-KF	.014	.004	.079	.0043	.0024	.0091
DCMT3(2.5)1-KM	.031	.01	.118	.0059	.0031	.0091
DCMT3(2.5)1-MF	.014	.004	.079	.0043	.0024	.0091
DCMT3(2.5)1-MM	.031	.01	.118	.0059	.0031	.0091
DCMT3(2.5)1-MMC	.079	.01	.118	.0079	.0047	.0118
DCMT3(2.5)1-PF	.014	.004	.079	.0043	.0024	.0091
DCMT3(2.5)1-PM	.031	.01	.118	.0059	.0031	.0091
DCMT3(2.5)1-PMC	.079	.01	.118	.0079	.0047	.0118
DCMT3(2.5)1-SMC	.02	.01	.118	.0071	.0047	.0118
DCMT3(2.5)1-UF	.016	.008	.079	.0039	.002	.0079
DCMT3(2.5)1-UM	.049	.02	.157	.0079	.0031	.0118
DCMT3(2.5)1-UR	.079	.039	.157	.0098	.0059	.0118
DCMT3(2.5)1-XF	.014	.004	.079	.0043	.0024	.0091
DCMT3(2.5)1-XM	.031	.01	.118	.0059	.0031	.0091
DCMT3(2.5)2-KM	.031	.02	.118	.0079	.0039	.0118
DCMT3(2.5)2-KR	.079	.039	.157	.0098	.0047	.0138
DCMT3(2.5)2-MF	.014	.006	.079	.0059	.0031	.0118
DCMT3(2.5)2-MM	.031	.02	.118	.0079	.0039	.0118
DCMT3(2.5)2-MMC	.079	.01	.118	.0087	.0047	.0118
DCMT3(2.5)2-MR	.079	.039	.157	.0098	.0047	.0138
DCMT3(2.5)2-PF	.014	.006	.079	.0059	.0031	.0118
DCMT3(2.5)2-PM	.031	.02	.118	.0079	.0039	.0118
DCMT3(2.5)2-PMC	.079	.01	.118	.0087	.0047	.0118
DCMT3(2.5)2-PR	.079	.039	.157	.0098	.0047	.0138
DCMT3(2.5)2-SMC	.039	.01	.118	.0079	.0047	.0118
DCMT3(2.5)2-UF	.016	.008	.079	.0039	.002	.0098
DCMT3(2.5)2-UM	.049	.02	.157	.0098	.0047	.0157
DCMT3(2.5)2-UR	.079	.039	.157	.0118	.0059	.0197
DCMT3(2.5)2-XF	.014	.006	.079	.0059	.0031	.0118
DCMT3(2.5)2-XM	.031	.02	.118	.0079	.0039	.0118
DCMT3(2.5)2-XR	.079	.039	.157	.0098	.0047	.0138
DCMT3(2.5)3-KR	.079	.047	.157	.0118	.0055	.0165
DCMT3(2.5)3-MM	.031	.024	.118	.0094	.0047	.0142
DCMT3(2.5)3-MMC	.079	.016	.118	.0098	.0047	.0138
DCMT3(2.5)3-MR	.079	.047	.157	.0118	.0055	.0165
DCMT3(2.5)3-PM	.031	.024	.118	.0094	.0047	.0142
DCMT3(2.5)3-PMC	.079	.016	.118	.0098	.0047	.0138
DCMT3(2.5)3-PR	.079	.047	.157	.0118	.0055	.0165
DCMT3(2.5)3-SMC	.059	.016	.118	.0087	.0047	.0118
DCMT3(2.5)3-UR	.079	.039	.157	.0118	.0079	.0197
DCMT3(2.5)3-XR	.079	.047	.157	.0118	.0055	.0165
DCMX2(1.5)0-WF	.012	.004	.059	.0039	.0012	.0059
DCMX2(1.5)1-WF	.028	.012	.079	.0047	.002	.0098
DCMX2(1.5)2-WF	.028	.012	.079	.0059	.0035	.0138
DCMX3(2.5)0-WF	.012	.004	.059	.0039	.0012	.0059
DCMX3(2.5)1-WF	.039	.012	.118	.0079	.0028	.0118
DCMX3(2.5)1-WM	.059	.02	.157	.0098	.0047	.0157
DCMX3(2.5)2-WF	.039	.012	.118	.0098	.0047	.0157
DCMX3(2.5)2-WM	.059	.02	.157	.0118	.0059	.0197
RCGX0602M0-AL	.039	.024	.094	.0096	.005	.0149
RCGX0803M0-AL	.059	.031	.126	.0136	.0062	.0212
RCGX10T3M0-AL	.079	.039	.157	.0141	.0062	.0249
RCGX1204M0-AL	.098	.047	.189	.0179	.0075	.0311
RCMT0502M0	.039	.02	.079	.0044	.0013	.0062
RCMT0602M0	.059	.02	.094	.0059	.0015	.0068
RCMT0803M0	.079	.031	.126	.0079	.002	.01
RCMT0803M0-SM	.039	.013	.079	.0028	.003	.0024
RCMT3(2.5)	.157	.079	.315	.018	.005	.0255
RCMT3(2.5)-SM	.098	.039	.157	.0062	.0025	.0124
RCMT3(2.5)M0	.098	.039	.157	.0062	.0025	.0124
RCMT10T3M0	.098	.039	.157	.0098	.0025	.0124
RCMT10T3M0-SM	.059	.016	.098	.0037	.0035	.0031
RCMT22	.079	.02	.118	.0062	.0037	.0039
RCMT22-SM	.157	.079	.315	.0176	.005	.0249
RCMT43	.118	.047	.189	.0074	.003	.0149
RCMT43-SM	.118	.047	.189	.0074	.003	.0149
RCMT43M0	.157	.063	.252	.01	.004	.0199
RCMT64	.197	.079	.315	.0124	.005	.0249
RCMT64M0	.014	.004	.079	.0043	.0024	.0091
RCMT1204M0	.118	.047	.189	.0118	.003	.0149
RCMT1204M0-SM	.079	.02	.118	.0049	.0039	.004
RCMT1606M0	.138	.063	.252	.0147	.004	.0199

Wendeplatte	Schnitttiefe			Vorschub		
	$a_p = \text{Zoll}$			$f_n = \text{Zoll/U}$		
	Empf.	Min.	Max.	Empf.	Min.	Max.
RCMT1606M0-SM	.098	.026	.157	.0062	.0059	.0047
RCMT2006M0	.157	.079	.315	.0176	.005	.0249
RCMT2507M0	.197	.098	.394	.022	.0062	.0311
RCMT3209M0	.236	.126	.504	.0273	.008	.0398
RCMX100300	.026	.008	.098	.0051	.0024	.0075
RCMX100300E	.026	.017	.098	.0067	.0035	.0102
RCMX120400	.118	.047	.189	.0074	.003	.0149
RCMX120400E	.118	.047	.189	.0074	.003	.0149
RCMX160600	.157	.063	.252	.01	.004	.0199
RCMX200600	.197	.079	.315	.0124	.005	.0249
RCMX250700	.039	.01	.098	.1181	.0591	.315
RCMX320900	.039	.01	.098	.1575	.0984	.3937
SBMT381232-XH	.591	.197	.984	.0709	.0551	.0945
SCGX3(2.5)2-AL	.059	.02	.197	.0118	.0059	.0236
SCMT3(2.5)1-KF	.014	.004	.079	.0043	.0024	.0091
SCMT3(2.5)1-KM	.031	.01	.118	.0059	.0031	.0091
SCMT3(2.5)1-MF	.014	.004	.079	.0043	.0024	.0091
SCMT3(2.5)1-MM	.031	.01	.118	.0059	.0031	.0091
SCMT3(2.5)1-MMC	.079	.01	.118	.0079	.0039	.0118
SCMT3(2.5)1-PM	.031	.01	.118	.0059	.0031	.0091
SCMT3(2.5)1-PMC	.079	.01	.118	.0079	.0039	.0118
SCMT3(2.5)1-SMC	.079	.01	.118	.0079	.0039	.0118
SCMT3(2.5)2-KF	.014	.006	.079	.0059	.0031	.0118
SCMT3(2.5)2-KM	.031	.02	.118	.0079	.0039	.0118
SCMT3(2.5)2-KR	.079	.039	.157	.0098	.0047	.0138
SCMT3(2.5)2-MF	.014	.006	.079	.0059	.0031	.0118
SCMT3(2.5)2-MM	.031	.02	.118	.0079	.0039	.0118
SCMT3(2.5)2-MMC	.079	.01	.118	.0079	.0039	.0118
SCMT3(2.5)2-MR	.079	.039	.157	.0098	.0047	.0138
SCMT3(2.5)2-PM	.031	.02	.118	.0079	.0039	.0118
SCMT3(2.5)2-PMC	.079	.01	.118	.0079	.0039	.0118
SCMT3(2.5)2-PR	.079	.039	.157	.0098	.0047	.0138
SCMT3(2.5)2-SMC	.079	.01	.118	.0079	.0039	.0118
SCMT3(2.5)2-UF	.016	.008	.079	.0039	.002	.0098
SCMT3(2.5)2-UM	.049	.02	.157	.0098	.0047	.0157
SCMT3(2.5)2-UR	.079	.039	.157	.0118	.0059	.0197
SCMT3(2.5)3-KR	.079	.047	.157	.0118	.0055	.0165
SCMT3(2.5)3-MR	.079	.047	.157	.0118	.0055	.0165
SCMT3(2.5)3-PR	.079	.047	.157	.0118	.0055	.0165
SCMT380932-XH	.709	.197	.984	.0669	.0551	.0787
SCMT380932-XL	.709	.197	.984	.0669	.0315	.0787
SCMT380932-XM	.709	.276	.984	.0512	.0472	.0709
SCMT431-MM	.038	.012	.142	.0071	.0035	.0106
SCMT431-PM	.038	.012	.142	.0071	.0035	.0106
SCMT431-UR	.098	.039	.197	.0098	.0059	.0118
SCMT432-KM	.038	.024	.142	.0094	.0047	.0142
SCMT432-KR	.094	.047	.189	.0118	.0055	.0165
SCMT432-MM	.038	.024	.142	.0094	.0047	.0142
SCMT432-MR	.094	.047	.189	.0118	.0055	.0165
SCMT432-PM	.038	.024	.142	.0094	.0047	.0142
SCMT432-PR	.094	.047	.189	.0118	.0055	.0165
SCMT432-UM	.059	.02	.157	.0098	.0047	.0157
SCMT432-UR	.098	.039	.157	.0118	.0059	.0197
SCMT433-KR	.094	.057	.189	.0142	.0067	.0197
SCMT433-MM	.038	.028	.142	.0114	.0055	.0169
SCMT433-MR	.094	.057	.189	.0142	.0067	.0197
SCMT433-PM	.038	.028	.142	.0114	.0055	.0169
SCMT433-PR	.094	.057	.189	.0142	.0067	.0197
SCMT433-UM	.059	.02	.157	.0098	.0059	.0157
TCEX1(1)00L-F	.006	.002	.031	.0024	.0008	.0039
TCEX1(1)00R-F	.006	.002	.031	.0024	.0008	.0039
TCEX1(1)03L-F	.006	.002	.031	.0024	.0008	.0039
TCEX1(1)03R-F	.006	.002	.031	.0024	.0008	.0039
TCEX1.2(1.2)00L-F	.008	.002	.059	.0031	.0008	.0047
TCEX1.2(1.2)00R-F	.008	.002	.059	.0031	.0008	.0047
TCEX1.2(1.2)03L-F	.008	.002	.059	.0031	.0008	.0047
TCEX1.2(1.2)03R-F	.008	.002	.059	.0031	.0008	.0047
TCEX1.2(1.2)0L-F	.008	.002	.02	.0031	.0008	.0047
TCEX1.8(1.5)00L-F	.012	.002	.118	.0039	.0008	.0059
TCEX1.8(1.5)00R-F	.012	.002	.118	.0039	.0008	.0059
TCEX1.8(1.5)03L-F	.012	.002	.118	.0039	.0008	.0059
TCEX1.8(1.5)03R-F	.012	.002	.118	.0039	.0008	.0059

Empfohlene Schnitttiefe und Vorschub, Zoll

CoroTurn® 107 Wendeschneidplatten zum Drehen

Wendeplatte	Schnitttiefe			Vorschub		
	a _p = Zoll			f _n = Zoll/U		
	Empf.	Min.	Max.	Empf.	Min.	Max.
TCEX1.8(1.5)03R-F	.012	.002	.118	.0039	.0008	.0059
TCEX1.8(1.5)0L-F	.008	.002	.02	.0039	.0008	.0059
TCEX22(00)L-F	.016	.002	.157	.0039	.0008	.0059
TCEX22(00)R-F	.016	.002	.157	.0039	.0008	.0059
TCEX22(03)L-F	.016	.002	.157	.0039	.0008	.0059
TCEX22(03)R-F	.016	.002	.157	.0039	.0008	.0059
TCEX220L-F	.008	.002	.02	.0039	.0008	.0079
TCGT1.2(1.2)0L-K	.012	.004	.039	.002	.0012	.0059
TCGT1.2(1.2)0R-K	.012	.004	.039	.002	.0012	.0059
TCGT1.2(1.2)1L-K	.02	.006	.039	.0028	.0012	.0079
TCGT1.2(1.2)1R-K	.02	.006	.039	.0028	.0012	.0079
TCGT1.8(1.5)0L-K	.012	.004	.047	.002	.0012	.0059
TCGT1.8(1.5)0R-K	.012	.004	.047	.002	.0012	.0059
TCGT1.8(1.5)1L-K	.02	.006	.047	.0039	.0012	.0079
TCGT1.8(1.5)1R-K	.02	.006	.047	.0039	.0012	.0079
TCGT1.8(1.5)1-UM	.039	.02	.089	.0079	.0031	.0118
TCGT2(1.5)03-UM	.012	.004	.039	.0012	.0004	.0024
TCGT2(1.5)0L-K	.012	.004	.059	.002	.0012	.0059
TCGT2(1.5)0R-K	.012	.004	.059	.002	.0012	.0059
TCGT2(1.5)0-UM	.02	.004	.059	.0028	.0008	.0047
TCGT2(1.5)1L-K	.02	.006	.059	.0039	.0012	.0098
TCGT2(1.5)1R-K	.02	.006	.059	.0039	.0012	.0098
TCGT2(1.5)1-UM	.049	.02	.098	.0059	.0031	.0098
TCGT2(1.5)2-UM	.049	.02	.098	.0079	.0047	.0138
TCGT22(03)-UM	.012	.004	.039	.0012	.0004	.0024
TCGT220L-K	.012	.004	.059	.002	.0012	.0059
TCGT220R-K	.012	.004	.059	.002	.0012	.0059
TCGT220-UM	.02	.004	.059	.0028	.0008	.0047
TCGT221L-K	.02	.006	.059	.0039	.0012	.0098
TCGT221R-K	.02	.006	.059	.0039	.0012	.0098
TCGT221-UM	.049	.02	.098	.0059	.0031	.0098
TCGT222-UM	.049	.02	.098	.0079	.0047	.0138
TCGT3(2.5)1-UM	.059	.02	.157	.0059	.0031	.0098
TCGT3(2.5)2-UM	.059	.02	.157	.0079	.0047	.0138
TCGX1.2(1.2)1-AL	.039	.02	.079	.0079	.0039	.0118
TCGX1.2(1.2)1L-WK	.02	.006	.039	.0059	.0012	.0098
TCGX1.2(1.2)1R-WK	.02	.006	.039	.0059	.0012	.0098
TCGX1.8(1.5)0-AL	.039	.012	.157	.0047	.002	.0059
TCGX1.8(1.5)1-AL	.059	.02	.157	.0079	.0039	.0118
TCGX1.8(1.5)1L-WK	.02	.006	.047	.0079	.0016	.011
TCGX1.8(1.5)1R-WK	.02	.006	.047	.0079	.0016	.011
TCGX2(1.5)0-AL	.039	.012	.197	.0047	.002	.0059
TCGX2(1.5)1-AL	.059	.02	.197	.0079	.0039	.0118
TCGX2(1.5)1L-WK	.02	.006	.059	.0079	.002	.0118
TCGX2(1.5)1R-WK	.02	.006	.059	.0079	.002	.0118
TCGX2(1.5)2-AL	.059	.02	.197	.0118	.0059	.0236
TCGX220-AL	.039	.012	.197	.0047	.002	.0059
TCGX221-AL	.059	.02	.197	.0079	.0039	.0118
TCGX221L-WK	.02	.006	.059	.0079	.002	.0118
TCGX221R-WK	.02	.006	.059	.0079	.002	.0118
TCGX222-AL	.059	.02	.197	.0118	.0059	.0236
TCGX3(2.5)1-AL	.059	.02	.276	.0079	.0039	.0118
TCGX3(2.5)2-AL	.059	.02	.276	.0118	.0059	.0236
TCMT1.2(1.2)0-KF	.01	.002	.059	.0024	.0012	.0043
TCMT1.2(1.2)0-MF	.01	.002	.059	.0024	.0012	.0043
TCMT1.2(1.2)0-PF	.01	.002	.059	.0024	.0012	.0043
TCMT1.2(1.2)0-UF	.016	.008	.059	.0028	.002	.0059
TCMT1.2(1.2)1-KF	.01	.003	.059	.0031	.002	.0067
TCMT1.2(1.2)1-MF	.01	.003	.059	.0031	.002	.0067
TCMT1.2(1.2)1-PF	.01	.003	.059	.0031	.002	.0067
TCMT1.2(1.2)1-UF	.016	.008	.059	.0039	.002	.0079
TCMT1.2(1.2)2-KF	.01	.004	.059	.0043	.0024	.0091
TCMT1.2(1.2)2-MF	.01	.004	.059	.0043	.0024	.0091
TCMT1.2(1.2)2-PF	.01	.004	.059	.0043	.0024	.0091
TCMT1.8(1.5)0-KF	.012	.002	.067	.0024	.0012	.0051
TCMT1.8(1.5)0-MF	.012	.002	.067	.0024	.0012	.0051
TCMT1.8(1.5)0-PF	.012	.002	.067	.0024	.0012	.0051
TCMT1.8(1.5)1-KF	.012	.004	.067	.0039	.002	.0075
TCMT1.8(1.5)1-KM	.024	.007	.089	.0043	.0024	.0067
TCMT1.8(1.5)1-MF	.012	.004	.067	.0039	.002	.0075
TCMT1.8(1.5)1-MM	.024	.007	.089	.0043	.0024	.0067
TCMT1.8(1.5)1-PF	.012	.004	.067	.0039	.002	.0075
TCMT1.8(1.5)1-PM	.024	.007	.089	.0043	.0024	.0067

Wendeplatte	Schnitttiefe			Vorschub		
	a _p = Zoll			f _n = Zoll/U		
	Empf.	Min.	Max.	Empf.	Min.	Max.
TCMT1.8(1.5)1-UF	.016	.008	.059	.0039	.002	.0079
TCMT1.8(1.5)1-UM	.039	.02	.098	.0079	.0031	.0118
TCMT1.8(1.5)2-KM	.024	.015	.089	.0059	.0031	.0091
TCMT1.8(1.5)2-MM	.024	.015	.089	.0059	.0031	.0091
TCMT1.8(1.5)2-PM	.024	.015	.089	.0059	.0031	.0091
TCMT1.8(1.5)2-UF	.016	.008	.059	.0039	.002	.0098
TCMT1.8(1.5)2-UM	.039	.02	.098	.0079	.0031	.0118
TCMT2(1.5)0-UF	.016	.008	.079	.0028	.002	.0059
TCMT2(1.5)1-UF	.016	.008	.079	.0039	.002	.0079
TCMT2(1.5)1-UM	.049	.02	.118	.0079	.0031	.0118
TCMT2(1.5)1-UR	.079	.039	.118	.0098	.0059	.0118
TCMT2(1.5)2-UF	.016	.008	.079	.0039	.002	.0098
TCMT2(1.5)2-UM	.049	.02	.118	.0098	.0047	.0157
TCMT2(1.5)2-UR	.079	.039	.118	.0118	.0059	.0157
TCMT220-KF	.012	.002	.067	.0024	.0012	.0051
TCMT220-MF	.012	.002	.067	.0024	.0012	.0051
TCMT220-PF	.012	.002	.067	.0024	.0012	.0051
TCMT221-KF	.012	.004	.067	.0039	.002	.0075
TCMT221-KM	.026	.008	.098	.0051	.0024	.0075
TCMT221-MF	.012	.004	.067	.0039	.002	.0075
TCMT221-MM	.026	.008	.098	.0051	.0024	.0075
TCMT221-PF	.012	.004	.067	.0039	.002	.0075
TCMT221-PM	.026	.008	.098	.0051	.0024	.0075
TCMT221-XF	.012	.004	.067	.0039	.002	.0075
TCMT221-XM	.026	.008	.098	.0051	.0024	.0075
TCMT222-KM	.026	.017	.098	.0067	.0035	.0102
TCMT222-KR	.059	.03	.118	.0083	.0039	.0118
TCMT222-MF	.012	.005	.067	.0051	.0028	.0102
TCMT222-MM	.026	.017	.098	.0067	.0035	.0102
TCMT222-MR	.059	.03	.118	.0083	.0039	.0118
TCMT222-PF	.012	.005	.067	.0051	.0028	.0102
TCMT222-PM	.026	.017	.098	.0067	.0035	.0102
TCMT222-PR	.059	.03	.118	.0083	.0039	.0118
TCMT222-XF	.012	.005	.067	.0051	.0028	.0102
TCMT222-XM	.026	.017	.098	.0067	.0035	.0102
TCMT223-KR	.059	.035	.118	.0102	.0047	.0142
TCMT223-PM	.026	.02	.098	.0079	.0039	.0122
TCMT223-PR	.059	.035	.118	.0102	.0047	.0142
TCMT3(2.5)1-KF	.014	.004	.079	.0043	.0024	.0091
TCMT3(2.5)1-KM	.031	.01	.118	.0059	.0031	.0091
TCMT3(2.5)1-MF	.014	.004	.079	.0043	.0024	.0091
TCMT3(2.5)1-MM	.031	.01	.118	.0059	.0031	.0091
TCMT3(2.5)1-PF	.014	.004	.079	.0043	.0024	.0091
TCMT3(2.5)1-PM	.031	.01	.118	.0059	.0031	.0091
TCMT3(2.5)1-UM	.059	.02	.157	.0079	.0031	.0118
TCMT3(2.5)1-UR	.098	.039	.157	.0098	.0059	.0118
TCMT3(2.5)2-KM	.031	.02	.118	.0079	.0039	.0118
TCMT3(2.5)2-KR	.079	.039	.157	.0098	.0047	.0138
TCMT3(2.5)2-MM	.031	.02	.118	.0079	.0039	.0118
TCMT3(2.5)2-MR	.079	.039	.157	.0098	.0047	.0138
TCMT3(2.5)2-PM	.031	.02	.118	.0079	.0039	.0118
TCMT3(2.5)2-PR	.079	.039	.157	.0098	.0047	.0138
TCMT3(2.5)2-UF	.016	.008	.079	.0039	.002	.0098
TCMT3(2.5)2-UM	.059	.02	.157	.0079	.0031	.0118
TCMT3(2.5)2-UR	.098	.039	.157	.0118	.0059	.0197
TCMT3(2.5)2-XR	.079	.039	.157	.0098	.0047	.0138
TCMT3(2.5)3-KM	.031	.024	.118	.0094	.0047	.0142
TCMT3(2.5)3-KR	.079	.047	.157	.0118	.0055	.0165
TCMT3(2.5)3-MM	.031	.024	.118	.0094	.0047	.0142
TCMT3(2.5)3-MR	.079	.047	.157	.0118	.0055	.0165
TCMT3(2.5)3-PM	.031	.024	.118	.0094	.0047	.0142
TCMT3(2.5)3-PR	.079	.047	.157	.0118	.0055	.0165
TCMT3(2.5)3-UR	.098	.039	.157	.0118	.0079	.0197
TCMT3(2.5)3-XR	.079	.047	.157	.0118	.0055	.0165
TCMT432-KM	.038	.024	.142	.0094	.0047	.0142
TCMT432-KR	.094	.047	.189	.0118	.0055	.0165
TCMT432-MM	.038	.024	.142	.0094	.0047	.0142
TCMT432-MR	.094	.047	.189	.0118	.0055	.0165
TCMT432-PM	.038	.024	.142	.0094	.0047	.0142
TCMT432-PR	.094	.047	.189	.0118	.0055	.0165
TCMT433-KR	.094	.057	.189	.0142	.0067	.0197
TCMT433-MR	.094	.057	.189	.0142	.0067	.0197
TCMT433-PR	.094	.057	.189	.0142	.0067	.0197

Empfohlene Schnitttiefe und Vorschub, Zoll

CoroTurn® 107 Wendeschneidplatten zum Drehen

Wendeplatte	Schnitttiefe			Vorschub		
	$a_p = \text{Zoll}$			$f_n = \text{Zoll/U}$		
	Empf.	Min.	Max.	Empf.	Min.	Max.
TCMX1.8(1.5)0-WF	.012	.004	.059	.0039	.0012	.0059
TCMX1.8(1.5)1-WF	.028	.012	.079	.0047	.002	.0118
TCMX1.8(1.5)2-WF	.028	.012	.079	.0098	.0039	.0138
TCMX220-WF	.012	.004	.059	.0039	.0012	.0059
TCMX221-WF	.039	.012	.098	.0079	.0028	.0118
TCMX221-WM	.047	.02	.118	.0098	.0047	.0138
TCMX222-WF	.039	.012	.098	.0098	.0047	.0157
TCMX222-WM	.047	.02	.118	.0118	.0059	.0197
TCMX3(2.5)1-WF	.047	.012	.138	.0079	.0028	.0138
TCMX3(2.5)2-WF	.047	.012	.138	.0098	.0047	.0197
TCMX3(2.5)2-WM	.059	.02	.157	.0118	.0059	.0197
VBGT3303-UM	.012	.004	.039	.0012	.0004	.0024
VBGT330-UM	.02	.004	.059	.0028	.0008	.0047
VBGT331-UM	.049	.02	.157	.0079	.0031	.0118
VBGT332-UM	.049	.02	.157	.0098	.0047	.0157
VBMT2(1.5)0-UF	.016	.008	.059	.0028	.002	.0059
VBMT2(1.5)1-UF	.016	.008	.059	.0039	.002	.0079
VBMT2(1.5)2-UF	.016	.008	.059	.0039	.002	.0098
VBMT220-KF	.012	.002	.067	.0024	.0012	.0051
VBMT220-MF	.012	.002	.067	.0024	.0012	.0051
VBMT220-PF	.012	.002	.067	.0024	.0012	.0051
VBMT221-KF	.012	.004	.067	.0039	.002	.0075
VBMT221-MF	.012	.004	.067	.0039	.002	.0075
VBMT221-PF	.012	.004	.067	.0039	.002	.0075
VBMT222-KF	.012	.005	.067	.0051	.0028	.0102
VBMT222-MF	.012	.005	.067	.0051	.0028	.0102
VBMT222-PF	.012	.005	.067	.0051	.0028	.0102
VBMT223-PF	.012	.005	.067	.0059	.0031	.0122
VBMT330-KF	.013	.003	.071	.0028	.0016	.0055
VBMT330-MF	.013	.003	.071	.0028	.0016	.0055
VBMT330-PF	.013	.003	.071	.0028	.0016	.0055
VBMT331-KF	.013	.004	.071	.0039	.002	.0079
VBMT331-KM	.028	.009	.106	.0055	.0028	.0079
VBMT331-MF	.013	.004	.071	.0039	.002	.0079
VBMT331-MM	.028	.009	.106	.0055	.0028	.0079
VBMT331-MMC	.079	.01	.118	.0067	.0039	.0098
VBMT331-PF	.013	.004	.071	.0039	.002	.0079
VBMT331-PM	.028	.009	.106	.0055	.0028	.0079
VBMT331-PMC	.079	.01	.118	.0067	.0039	.0098
VBMT331-SMC	.02	.01	.118	.0067	.0039	.0098
VBMT331-UM	.049	.02	.157	.0079	.0031	.0118
VBMT331-UR	.079	.039	.157	.0098	.0059	.0118
VBMT331-XF	.013	.004	.071	.0039	.002	.0079
VBMT331-XM	.028	.009	.106	.0055	.0028	.0079
VBMT332-KF	.013	.006	.071	.0055	.0028	.0106
VBMT332-KM	.028	.018	.106	.0071	.0035	.0106
VBMT332-KR	.071	.035	.142	.0091	.0043	.0126
VBMT332-MF	.013	.006	.071	.0055	.0028	.0106
VBMT332-MM	.028	.018	.106	.0071	.0035	.0106
VBMT332-MMC	.079	.01	.118	.0067	.0039	.0098
VBMT332-MR	.071	.035	.142	.0091	.0043	.0126
VBMT332-PF	.013	.006	.071	.0055	.0028	.0106
VBMT332-PM	.028	.018	.106	.0071	.0035	.0106
VBMT332-PMC	.079	.01	.118	.0067	.0039	.0098
VBMT332-PR	.071	.035	.142	.0091	.0043	.0126
VBMT332-SMC	.031	.01	.118	.0067	.0039	.0098
VBMT332-UM	.049	.02	.157	.0098	.0047	.0157
VBMT332-UR	.079	.039	.157	.0118	.0059	.0197
VBMT332-XF	.013	.006	.071	.0055	.0028	.0106
VBMT332-XM	.028	.018	.106	.0071	.0035	.0106
VBMT332-XR	.071	.035	.142	.0091	.0043	.0126
VBMT333-KM	.028	.021	.106	.0087	.0043	.0126
VBMT333-KR	.071	.043	.142	.0106	.0051	.015
VBMT333-MF	.013	.006	.071	.0063	.0035	.0126
VBMT333-MM	.028	.021	.106	.0087	.0043	.0126
VBMT333-MMC	.079	.016	.118	.0079	.0039	.0118
VBMT333-MR	.071	.043	.142	.0106	.0051	.015
VBMT333-PF	.013	.006	.071	.0063	.0035	.0126
VBMT333-PM	.028	.021	.106	.0087	.0043	.0126
VBMT333-PMC	.079	.016	.118	.0079	.0039	.0118
VBMT333-PR	.071	.043	.142	.0106	.0051	.015
VBMT333-SMC	.079	.016	.118	.0079	.0039	.0118
VBMT333-UM	.049	.02	.157	.0098	.0039	.0157

Wendeplatte	Schnitttiefe			Vorschub		
	$a_p = \text{Zoll}$			$f_n = \text{Zoll/U}$		
	Empf.	Min.	Max.	Empf.	Min.	Max.
VBMT333-UR	.079	.039	.157	.0118	.0079	.0197
VBMT333-XR	.071	.043	.142	.0106	.0051	.015
VCET22(03)-UM	.012	.004	.157	.0012	.0004	.0024
VCET220-UM	.02	.008	.157	.0012	.0008	.0031
VCET22(00)L-F	.039	.001	.157	.002	.0004	.0079
VCEX22(00)R-F	.039	.001	.157	.002	.0004	.0079
VCEX22(03)L-F	.039	.002	.157	.0039	.0004	.0118
VCEX22(03)R-F	.039	.002	.157	.0039	.0004	.0118
VCGT2203-UM	.012	.004	.039	.0012	.0004	.0024
VCGT220-UM	.02	.004	.059	.0028	.0008	.0047
VCGT221-UM	.049	.02	.118	.0059	.0031	.0098
VCGX2(1.5)0-AL	.039	.012	.118	.0047	.002	.0059
VCGX2(1.5)1-AL	.059	.02	.118	.0079	.0039	.0118
VCGX220520-AL	.059	.02	.276	.0236	.0098	.0394
VCGX220530-AL	.059	.02	.276	.0236	.0098	.0394
VCGX220-AL	.039	.012	.118	.0047	.002	.0059
VCGX221-AL	.059	.02	.118	.0079	.0039	.0118
VCGX331-AL	.059	.02	.197	.0079	.0039	.0118
VCGX332-AL	.059	.02	.197	.0118	.0059	.0236
VCGX333-AL	.059	.02	.197	.0157	.0059	.0315
VCMT220-MF	.012	.003	.059	.0028	.0012	.0051
VCMT220-PF	.012	.003	.059	.0028	.0012	.0051
VCMT221-KF	.012	.004	.059	.0039	.002	.0079
VCMT221-MF	.012	.004	.059	.0039	.002	.0079
VCMT221-MM	.03	.012	.1	.0059	.0039	.0098
VCMT221-PF	.012	.004	.059	.0039	.002	.0079
VCMT221-PM	.03	.012	.1	.0059	.0039	.0098
VCMT222-KM	.03	.024	.1	.0079	.0051	.013
VCMT222-MM	.03	.024	.1	.0079	.0051	.013
VCMT222-PM	.03	.024	.1	.0079	.0051	.013

Empfohlene Schnitttiefe und Vorschub, Zoll

CoroTurn® 111 Wendeschneidplatten zum Drehen

Wendeplatte	Schnitttiefe			Vorschub		
	a _p = Zoll			f _n = Zoll/U		
	Empf.	Min.	Max.	Empf.	Min.	Max.
CPMT2(1.5)0-MF	.012	.003	.059	.0024	.0012	.0047
CPMT2(1.5)0-PF	.012	.003	.059	.0024	.0012	.0047
CPMT2(1.5)1-KF	.012	.004	.059	.0035	.0016	.0071
CPMT2(1.5)1-KM	.028	.011	.094	.0051	.0035	.0087
CPMT2(1.5)1-MF	.012	.004	.059	.0035	.0016	.0071
CPMT2(1.5)1-MM	.028	.011	.094	.0051	.0035	.0087
CPMT2(1.5)1-PF	.012	.004	.059	.0035	.0016	.0071
CPMT2(1.5)1-PM	.028	.011	.094	.0051	.0035	.0087
CPMT2(1.5)1-UM	.025	.008	.094	.0043	.0024	.0067
CPMT2(1.5)2-KM	.028	.023	.094	.0071	.0047	.0114
CPMT2(1.5)2-MM	.028	.023	.094	.0071	.0047	.0114
CPMT2(1.5)2-PM	.028	.023	.094	.0071	.0047	.0114
CPMT2(1.5)2-UM	.025	.008	.094	.0043	.0024	.0067
CPMT3(2.5)0-MF	.014	.003	.079	.0031	.0016	.0059
CPMT3(2.5)0-PF	.014	.004	.079	.0043	.0024	.0091
CPMT3(2.5)0-UM	.025	.008	.094	.0043	.0024	.0067
CPMT3(2.5)1-MF	.014	.005	.07	.0047	.0024	.0094
CPMT3(2.5)1-MM	.035	.014	.118	.0071	.0047	.0118
CPMT3(2.5)1-PF	.014	.004	.079	.0043	.0024	.0091
CPMT3(2.5)1-PM	.025	.01	.118	.0059	.0031	.0091
CPMT3(2.5)1-UM	.049	.02	.157	.0079	.0031	.0118
CPMT3(2.5)2-MF	.014	.005	.07	.0071	.0035	.0142
CPMT3(2.5)2-MM	.035	.028	.118	.0094	.0063	.0154
CPMT3(2.5)2-PF	.014	.006	.079	.0059	.0031	.0118
CPMT3(2.5)2-PM	.031	.02	.118	.0079	.0039	.0118
CPMT3(2.5)2-UM	.049	.02	.157	.0098	.0047	.0157
DPMT2(1.5)0-MF	.01	.002	.052	.0024	.0012	.0047
DPMT2(1.5)0-PF	.01	.002	.052	.0024	.0012	.0047
DPMT2(1.5)1-KF	.01	.004	.052	.0035	.0016	.0071
DPMT2(1.5)1-KM	.027	.011	.089	.0051	.0035	.0087
DPMT2(1.5)1-MF	.01	.004	.052	.0035	.0016	.0071
DPMT2(1.5)1-MM	.027	.011	.089	.0051	.0035	.0087
DPMT2(1.5)1-PF	.01	.004	.052	.0035	.0016	.0071
DPMT2(1.5)1-PM	.027	.011	.089	.0051	.0035	.0087
DPMT2(1.5)2-KM	.027	.021	.089	.0071	.0047	.0114
DPMT2(1.5)2-MM	.027	.021	.089	.0071	.0047	.0114
DPMT2(1.5)2-PM	.027	.021	.089	.0071	.0047	.0114
DPMT3(2.5)1-KM	.035	.014	.118	.0071	.0047	.0118
DPMT3(2.5)1-MM	.035	.014	.118	.0071	.0047	.0118
DPMT3(2.5)1-PM	.035	.014	.118	.0071	.0047	.0118
DPMT3(2.5)2-KM	.035	.028	.118	.0094	.0063	.0154
DPMT3(2.5)2-MM	.035	.028	.118	.0094	.0063	.0154
DPMT3(2.5)2-PM	.035	.028	.118	.0094	.0063	.0154
SPMT3(2.5)2-UM	.031	.02	.118	.0079	.0039	.0118
SPMT432-UM	.038	.024	.142	.0094	.0047	.0142
TPMT1.2(1.2)0-MF	.01	.002	.052	.0024	.0012	.0047
TPMT1.2(1.2)0-PF	.01	.002	.052	.0024	.0012	.0047
TPMT1.2(1.2)1-KF	.01	.004	.052	.0035	.0016	.0071
TPMT1.2(1.2)1-MF	.01	.004	.052	.0035	.0016	.0071
TPMT1.2(1.2)1-PF	.01	.004	.052	.0035	.0016	.0071
TPMT1.8(1.5)0-MF	.012	.003	.059	.0028	.0012	.0051
TPMT1.8(1.5)0-PF	.012	.003	.059	.0028	.0012	.0051
TPMT1.8(1.5)1-KF	.012	.004	.059	.0039	.002	.0079
TPMT1.8(1.5)1-KM	.027	.011	.089	.0051	.0035	.0087
TPMT1.8(1.5)1-MF	.012	.004	.059	.0039	.002	.0079
TPMT1.8(1.5)1-MM	.027	.011	.089	.0051	.0035	.0087
TPMT1.8(1.5)1-PF	.012	.004	.059	.0039	.002	.0079
TPMT1.8(1.5)1-PM	.027	.011	.089	.0051	.0035	.0087
TPMT1.8(1.5)2-KM	.027	.021	.089	.0071	.0047	.0114
TPMT1.8(1.5)2-PM	.027	.021	.089	.0071	.0047	.0114
TPMT2(1.5)1-UM	.026	.008	.098	.0051	.0024	.0075
TPMT2(1.5)2-UM	.026	.017	.098	.0067	.0035	.0102
TPMT220-MF	.012	.003	.059	.0028	.0012	.0051
TPMT220-PF	.012	.003	.059	.0028	.0012	.0051
TPMT221-KF	.012	.004	.059	.0039	.002	.0079
TPMT221-MF	.012	.004	.059	.0039	.002	.0079
TPMT221-MM	.03	.012	.098	.0059	.0039	.0098
TPMT221-PF	.012	.004	.059	.0039	.002	.0079
TPMT221-PM	.03	.012	.098	.0059	.0039	.0098
TPMT222-KM	.03	.024	.098	.0079	.0051	.013
TPMT222-MM	.03	.024	.098	.0079	.0051	.013
TPMT222-PM	.03	.024	.098	.0079	.0051	.013

Wendeplatte	Schnitttiefe			Vorschub		
	a _p = Zoll			f _n = Zoll/U		
	Empf.	Min.	Max.	Empf.	Min.	Max.
TPMT3(2.5)1-KF	.014	.005	.07	.0047	.0024	.0094
TPMT3(2.5)1-MF	.014	.005	.07	.0047	.0024	.0094
TPMT3(2.5)1-MM	.035	.014	.118	.0071	.0047	.0118
TPMT3(2.5)1-PF	.014	.005	.07	.0047	.0024	.0094
TPMT3(2.5)1-PM	.035	.014	.118	.0071	.0047	.0118
TPMT3(2.5)2-KM	.035	.028	.118	.0094	.0063	.0154
TPMT3(2.5)2-MM	.035	.028	.118	.0094	.0063	.0154
TPMT3(2.5)2-PM	.035	.028	.118	.0094	.0063	.0154
TPMT3(2.5)2-UM	.031	.02	.118	.0079	.0039	.0118
TPMT3(2.5)3-KM	.035	.034	.118	.011	.0075	.0185
TPMT432-UM	.038	.024	.142	.0094	.0047	.0142
WPMT1.2(1)0-MF	.007	.002	.035	.0012	.0008	.0028
WPMT1.2(1)0-PF	.007	.002	.035	.0012	.0008	.0028
WPMT1.2(1)1-MF	.007	.002	.035	.002	.0012	.0039
WPMT1.2(1)1-PF	.007	.002	.035	.002	.0012	.0039
WPMT2(1.5)0-MF	.01	.002	.052	.002	.0008	.0039
WPMT2(1.5)0-PF	.01	.002	.052	.002	.0008	.0039
WPMT2(1.5)1-KF	.01	.004	.052	.0031	.0016	.0059
WPMT2(1.5)1-MF	.01	.004	.052	.0031	.0016	.0059
WPMT2(1.5)1-MM	.027	.011	.089	.0051	.0035	.0087
WPMT2(1.5)1-PF	.01	.004	.052	.0031	.0016	.0059
WPMT2(1.5)1-PM	.027	.011	.089	.0051	.0035	.0087
WPMT2(1.5)2-MM	.027	.021	.089	.0071	.0047	.0114
WPMT2(1.5)2-PM	.027	.021	.089	.0071	.0047	.0114

CoroTurn® TR Wendeschneidplatten zum Drehen

TR-DC1304-F	.039	.006	.118	.0079	.0031	.0118
TR-DC1308-F	.039	.006	.118	.0094	.0039	.0157
TR-DC1308-M	.079	.02	.197	.0098	.0039	.0157
TR-DC1312-M	.079	.02	.197	.0118	.0059	.0197
TR-VB1302-F	.012	.002	.039	.0028	.0012	.0051
TR-VB1304-F	.031	.004	.079	.0059	.0024	.0138
TR-VB1308-F	.031	.004	.079	.0079	.0035	.0157
TR-VB1312-F	.031	.004	.079	.0079	.0035	.0157

Wendeschneidplatte zum Drehschälen

190.1-381200	.256	.118	.394	.1575	.0591	.315
--------------	------	------	------	-------	-------	------

Sorten für allgemeine Drehbearbeitungen

	ISO	ANSI					
P Stahl	01	C8	GC 4205	▲			
	10	C7	GC 4315				
	20	C6	GC 4325				
	30	C6	GC 4235				
	40	C5	GC 3005				
	50	C5	GC 1515				
M Rostfreier Stahl	10	-	GC 2015	▲			
	20	-	GC 2025				
	30	-	GC 2035				
	40	-	GC 1115				
		-	GC 1125				
K Grauguss	01	C4	CC 6190	▲			
	10	C3	GC 3205				
	20	C2	GC 3210				
	30	C1	GC 3215				
	40		GC 30				
N NE-Metalle	01	C4	H10	▲			
	10	C3	CD 10				
	20	C2	CD 05				
	30	C1	H13A				
S Warmfeste Legierungen und Titanlegierungen	01	-	Ni-basiert	Ti-basiert	▲		
	10	-	CC 670	CC 650			
	20	-	CC 6060	S05F		GC 1105	H13A
	30	-	GC 1115	CC 6065		GC 1125	GC 15
	40	-	GC 30				H13A
		-					GC 1115
H Gehärtete Werkstoffe	01	C4	CB 7015	▲			
	10	C3	CB 7025				
	20	C2	CC 6050				
	30	C1	CB 7525				

Lage und Form der Sortensymbole geben die für die jeweilige Sorte empfohlenen Anwendungsbereiche an.

Schwerpunkt des Anwendungsbereiches.

Empfohlener Anwendungsbereich.

▲ Verschleißfestigkeit

▼ Zähigkeit



= Hauptsorten



= Ergänzende Sorten

Sorten für allgemeine Drehbearbeitungen

P Stahl, Stahlguss, ferritisch/martensitischer rostfreier Stahl, langspanender Temporguss

Hauptsorten

GC4205 (HC) – P05 (P01-P15)

Eine CVD-beschichtete Sorte mit ausgezeichnetem Widerstand gegen Kolkverschleiss und plastische Verformung. Empfohlen für stabile Bedingungen, wenn höhere Zerspanungsrate bei der mittleren bis groben Bearbeitung gefragt ist. Hält bei der Nass- und Trockenbearbeitung hohen Temperaturen stand, ohne die Schneidkantensicherheit zu gefährden.

GC4315 (HC) - P15 (P05-P25)

CVD-beschichtete Hartmetallsorte zum Schlichten bis zum Schruppen bei der Drehbearbeitung von Stahl und Stahlguss. Diese Sorte empfiehlt sich für kontinuierliche Schnitte sowie Bearbeitungen mit leichter Schnittunterbrechung. Eine Sorte für hohe Zerspanungsraten. Mit der neuen Inveio Schneidstofftechnologie.

GC4325 (HC) - P25 (P15 - P35)

Sorte erster Wahl zum Drehen von Stahl. CVD-beschichtete Hartmetallsorte zum Schlichten bis zum Schruppen von Stahl, Stahlguss und ferritisch/martensitischem Stahl und rostfreien Stahl. Diese Sorte empfiehlt sich für kontinuierliche Schnitte sowie Bearbeitungen mit Schnittunterbrechung. Eine Sorte für einen breiten Anwendungsbereich. Mit der neuen Inveio Schneidstofftechnologie.

GC4235 (HC) - P35 (P25-P45)

Eine CVD-beschichtete Hartmetallsorte zum Schruppen von Stahl, Stahlguss und ferritisch/martensitischem rostfreien Stahl bei ungünstigen Bedingungen. Die Schneidkantensicherheit ermöglicht unterbrochene Schnitte bei hohem Zeitspanvolumen.

Ergänzende Sorten

GC3005 (HC) - P10 (P01-P25)

CVD-beschichtete Sorte mit einer verschleißfesten Beschichtung, die über eine sehr gute Haftung zu einem harten Substrat verfügt. Die Sorte bietet einen optimalen Widersand gegen hohe Temperaturen. Zum Schlichten und Vorschlichten in hochlegierten Stählen mit hohen Schnittgeschwindigkeiten.

GC15 (HC) - P20 (P15-P25)

Eine PVD-beschichtete Hartmetallsorte für zähigkeitsfordernde Operationen in Stahlwerkstoffen. Kleine Bauteile, unterbrochene Schnitte, Plandreihen gegen Mitte oder Schultern bei mittleren bis niedrigen Schnittdaten.

GC1125 (HC) – P25 (P10-P30)

Eine PVD-beschichtete Sorte, die sich als Ergänzung zu GC1515 zum Schlichten von Stählen mit niedrigem Kohlenstoffgehalt bei niedrigem Vorschub oder geringer Schnittgeschwindigkeit empfiehlt.

GC2015 (HC) – P25 (P20-P30)

CVD-beschichtete Sorte. Durch die Geometrie-Ausführungen für eine scharfe Schneidkante empfiehlt sich diese Sorte zum Schlichten bis zum leichten Schruppen von Kohlenstoffstählen und anderen „klebenden“ Legierungsstählen.

GC2025 (HC) – P35 (P25-P40)

CVD-beschichtete Hartmetallsorte. Alternative für Stahl, wenn eine hohe Zähigkeit gefordert ist.

GC30 (HC) - P30 (P25-P40)

Zähe CVD-beschichtete Hartmetallsorte zum mittleren Schruppen bis Schlichten. Erste Wahl für Stahl bei mittleren bis niedrigen Schnittdaten.

Ergänzende Sorten

CT5015 (HT) – P10 (P01-P20)

Eine unbeschichtete Cermetsorte mit exzellenter Festigkeit gegen Aufbauschneidenbildung und plastische Deformation. Zum Schlichten bei Anforderung an hohe Oberflächengüte und/oder niedrige Schnittkräfte. $f_n \times a_p < 0,35 \text{ mm}^2$

GC1525 (HC) – P15 (P05-P25)

Eine PVD-beschichtete Cermetsorte. Sehr hohe Verschleißfestigkeit und gute Schneidkantenzähigkeit. Zum Schlichten und Vorschlichten niedrig legierten Stählen sowie Stahl mit niedrigem Kohlenstoffgehalt. Einzusetzen, wenn eine hohe Oberflächengüte bei mittleren bis hohen Schnittgeschwindigkeiten gefordert wird. $f_n \times a_p < 0,35 \text{ mm}^2$.

GC1515 (HC) - P25 P10-P30)

Eine Feinstkorn-Hartmetallsorte mit dünner CVD-Beschichtung. Empfiehlt sich zum Schlichten von niedriglegiertem Stahl und Stahl mit niedrigem Kohlenstoffgehalt und weiteren zu Aufschweißung neigenden Stahllegierungen, einzusetzen bei mittleren bis niedrigen Schnittgeschwindigkeiten. Ausgezeichnet geeignet, wenn hohe Oberflächengüte oder scharfe Schneidwirkung gefragt ist. Dank des sehr guten Widerstands gegen Thermoschock eignet sich diese Sorte für Bearbeitungen mit leichten Schnittunterbrechungen.

Abkürzungen und Definition der Schneidstoffe:

Schneidstoffe:

HW	Unbeschichtetes Hartmetall, vornehmlich aus Wolframkarbid (WC)
HT	Unbeschichtetes Hartmetall, auch Cermet genannt, hauptsächlich aus Titaniumkarbid
HC	Schneidstoff wie oben, jedoch beschichtet

Keramik:

CA	Oxidkeramik hauptsächlich aus Aluminiumoxid (Al_2O_3).
CM	Mischkeramik hauptsächlich aus Aluminiumoxid (Al_2O_3) und mit anderen oxidfremden Anteilen.
CN	Nitridkeramik hauptsächlich aus Siliziumnitrid (Si_3N_4).
CC	Keramik wie oben, aber beschichtet.

Diamant:

DP	Polykristalliner Diamant ¹⁾
----	--

Bornitrid:

BN	Polykristallines Bornitrid ¹⁾
----	--

¹⁾ Polykristalliner Diamant und polykristallines Bornitrid werden auch als superharte Schneidstoffe bezeichnet.

Sorten für allgemeine Drehbearbeitungen



Austenititischer rostfreier Stahl, Stahlguss, Manganstahl, Gusslegierungen, Temperguss, Automatenstahl.

Hauptsorten

GC2015 (HC) – M15 (M05-M25)

Eine CVD-beschichtete Hartmetallsorte zum Schlichten und leichtem Schruppen. Die Sorte verfügt über eine gute Warmfestigkeit und ist in Kombination mit einer verschleißfesten Beschichtung und ist so eine gute Wahl für Bearbeitungen ohne Schnittunterbrechung bei moderaten bis hohen Schnittgeschwindigkeiten.

GC2025 (HC) – M25 (M15-M35)

Die erste Wahl. Eine CVD-beschichtete Sorte, optimiert zum Vorschlichten bis zum Schruppen. Die gute Widerstandsfähigkeit gegen thermische und mechanische Belastungen bietet exzellente Schneidkantensicherheit auch bei unterbrochenen Schnitten.

GC2035 (HC) – M35 (M25-M40)

PVD-beschichtete Hartmetallsorte. Zum Vorschlichten bis Schruppen von austenitischer rostfreier Stahl und Duplexstählen bei niedrigen bis mittleren Schnittgeschwindigkeiten. Durch ihre hohe Wärmewechselfestigkeit eignet sich die Sorte ideal für Bearbeitungen mit schnellen Schnittunterbrechungen.

Ergänzende Sorten

GC4235 - M25 (M15-M30)

Eine CVD-beschichtete Hartmetallsorte zum Schruppen von ferritisch/martensitischem rostfreiem Stahl bei ungünstigen Bedingungen.

GC1115 (HC) – M15 (M05-M25)

Eine PVD-beschichtete Hartmetallsorte. Für hohe Schneidkantenstabilität und exzellente Verschleißfestigkeit bei der Bearbeitung von klebenden Werkstoffen. In Kombination mit einer scharfen Schneidengeometrie liefert die Sorte eine gute Leistung bei gleichmäßigem Verschleißverhalten.

GC1125 (HC) – M25 (M10-M30)

Eine PVD-beschichtete Hartmetallsorte. Zum Schlichten bei mittleren bis niedrigen Schnittgeschwindigkeiten. Eine exzellente Sorte, wenn eine scharfe Schneidwirkung in Kombination mit besserer Schneidkantenzähigkeit oder hoher Oberflächengüte gefordert wird. Durch hervorragenden Widerstand gegen Thermoschock ist die Sorte sehr geeignet zum Vorschlichten bei kurzen Eingriffen.

GC235 (HC) – M40 (M25-M40)

CVD-beschichtete Hartmetallsorte zum Schruppen in rostfreien Stählen und Stahlguss mit schwieriger Gusshaut. Das zähe Substrat bietet eine extrem gute Schneidkantensicherheit für schwere Bearbeitungen mit Schnittunterbrechung bei niedrigen bis mittleren Schnittgeschwindigkeiten.

Ergänzende Sorten

GC1105 (HC) - M15 (M05 - M20)

Eine PVD-beschichtete Hartmetallsorte mit hoher Festigkeit und gutem Widerstand gegen plastische Deformation für gleichmäßigen Verschleiß und vorsagbare Leistung. Geeignet zum Schlichten bei hohen Schnittgeschwindigkeiten.

GC1515 (HC) – M20 (M10-M25)

Eine CVD-beschichtete Sorte zum Schlichten aller rostfreien Stähle und eine gute Ergänzung zu GC1125, wenn Verschleißfestigkeit gegenüber Schneidkantenzähigkeit Priorität hat.

GC1525 (HC) – M10 (M05-M15)

PVD-beschichtetes Cermet. Sehr hohe Verschleißfestigkeit und gute Schneidkantenzähigkeit. Minimale Neigung zum Kleben. Eignet sich hervorragend zum Schlichten von rostfreiem Stahl unter günstigen Bedingungen. Für hohe Schnittgeschwindigkeiten und relativ niedrige Vorschübe.

$f_n \times a_p < 0,35 \text{ mm}^2$

GC15 (HC) - M15 (M05-M25)

Eine PVD-beschichtete Hartmetallsorte für die mittlere Schruppbearbeitung bis zum Schlichten bei mittleren bis niedrigen Schnittdaten.

GC30 (HC) - M20 (M15-M25)

Ergänzende Sorte zu GC15 in rostfreiem Stahl für große Bauteile, lange Eingriffzeiten und mittleren bis niedrigen Schnittdaten.

Sorten für allgemeine Drehbearbeitungen



Grauguss, Kokillenhartguss, kurzspanender Temperguss.

Hauptsorten

CC6190 (CN) – K10 (K01 – K20)

Eine Siliziumnitrid-basierte Keramiksorte mit guter Verschleißfestigkeit für hohe Temperaturen. Für Hochgeschwindigkeits-Schrupp- bis Schlichtbearbeitungen von Gusswerkstoffen unter guten Bedingungen. Mit Einschränkungen auch für die Bearbeitung mit Schnittunterbrechung zu verwenden.

GC3205 (HC) – K05 (K01-K15)

CVD-beschichtete Sorte aus einer verschleißfesten Beschichtung und einem sehr harten Substrat. Besonders empfehlenswert für Drehbearbeitung von Grauguss (GCI) mit hohen Schnittgeschwindigkeiten.

GC3210 (HC) – K05 (K01-K20)

CVD-beschichtete Sorte aus einer dicken, glatten, verschleißfesten Beschichtung und einem sehr harten Substrat. Besonders empfehlenswert für Drehbearbeitung von Kugelgraphitguss (NCI) mit hohen Schnittgeschwindigkeiten.

GC3215 (HC) – K15 (K01-K25)

Die erste Wahl. CVD-beschichtete Hartmetallsorte, gut geeignet für anspruchsvolle Bearbeitungen mit Schnittunterbrechungen. Zum Schruppen bis Schlichten aller Arten von Gusseisen bei niedrigen bis mittleren Schnittgeschwindigkeiten.

Ergänzende Sorten

CB7525 (BN) - K05 (K01-K10)

Eine extrem harte CBN-Sorte. Durch die hohe Schneidkantenstabilität gepaart mit guter Verschleißfestigkeit ist dieser Schneidstoff optimal geeignet für Schlichtbearbeitungen in Grauguss mit hohen Schnittgeschwindigkeiten, mit und ohne Schnittunterbrechungen.

CC650 (CM) – K01 (K01-K05)

Al₂O₃-Mischkeramik, die sich zum Hochgeschwindigkeits-Schlichtbearbeitung von Grauguss und gehärtetem Grauguss unter stabilen Bedingungen eignet. GC3005 (HC) - K10 (K01-K20) CVD-beschichtete Sorte mit einer verschleißfesten Beschichtung, die über eine sehr gute Haftung zu einem harten Substrat verfügt. Die Sorte bietet eine hohe Widerstandsfähigkeit gegen hohe Temperaturen. Zum Schlichten und bis hin zum Schruppen von Kugelgraphitguss, Temperguss mit hoher Zugfestigkeit und "Klebendem" (legierten) Grauguss.

CB7925 (BN) - K05 (K01-K10)

Eine gute CBN-Sorte mit hoher Schneidkantenstabilität und guter Verschleißfestigkeit. CB7925 eignet sich sowohl für Bearbeitungen mit und ohne Schnittunterbrechungen in Grauguss und Kokillenhartguss.

GC4315 (HC) - K15 (K10-K25)

CVD-beschichtete Hartmetallsorte zum Schlichten bis Schruppen bei der Drehbearbeitung von Grauguss und Kugelgraphitguss. Mit der neuen Inveio Schneidstofftechnologie.

CC620 (CA) – K01 (K01-K05)

Al₂O₃-basierte Reinkeramiksorte zum Hochgeschwindigkeitsschlichten von Grauguss unter stabilen Bedingungen in der Trockenbearbeitung.

CT5015 (HT) – K05 (K01-K10)

Eine unbeschichtete Cermetsorte mit exzellentem Widerstand gegen Aufbauschneidenbildung und plastische Verformung. Zum Schlichten in Kugelgraphitguss, wenn eine hohe Oberflächengüte, enge Toleranzen und/oder niedrige Schnittkräfte erforderlich sind.

$f_n \times a_p < 0.35 \text{ mm}^2$

GC15 (HC) - K10 (K05-K15)

Eine PVD-beschichtete Hartmetallsorte für Ausdreh- und Fertigbearbeitungen.

H13A (HW) – K20 (K10-K30)

Eine unbeschichtete Hartmetallsorte mit guter Abrasivverschleißfestigkeit und Zähigkeit. Eine gute Wahl zum Schruppen von Gusswerkstoffen mit mittleren bis niedrigen Schnittgeschwindigkeiten und hohen Vorschüben in Grauguss.

GC30 (HC) - K40 (K25-K40)

Eine CVD-beschichtete Hartmetallsorte für die mittlere Bearbeitung und bis zum Schlichten bei mittleren bis niedrigen Schnittdaten.



NE-Metalle

Hauptsorten

H10 (HW) – N15 (N01-N25)

Unbeschichtete Hartmetallsorte. Verbindet exzellente Verschleißfestigkeit mit hervorragender Schneidkantenschärfe. Zum Schruppen hin zum Schlichten von Aluminiumlegierungen.

CD10 (DP) – N05 (N01-N10)

Die erste Wahl. Eine PKD-Sorte zum Schlichten und Vorschlichten von NE-Metallen sowie nichtmetallischen Werkstoffen. Für lange Standzeiten, saubere Schnitte und hohe Oberflächengüte.

CD05 – N01 (N01-N10)

Eine PKD-Sorte zum Schlichten und Vorschlichten von hoch abrasiven NE-Metallen sowie nichtmetallischen Werkstoffen. Anwendungsbeispiele sind das Drehen von Aluminiumlegierungen mit hohem Siliziumgehalt, Metallmatrix-Verbundwerkstoffe (MMC), Glasfaser, Faserplatten und Holzlaminat.

Ergänzende Sorten

H13A (HW) – N15 (N05-N25)

Unbeschichtete Hartmetallsorte mit guter Abrasivverschleißfestigkeit und Zähigkeit für die mittlere bis schwere Drehbearbeitung von Aluminiumlegierungen.

GC1125 (HC) – N25 (N15-N30)

Eine PVD-beschichtete Hartmetallsorte für Operationen, die eine scharfe Schneidwirkung in Verbindung mit sehr guter Schneidkanten Zähigkeit erfordern.

Sorten für allgemeine Drehbearbeitungen

S Warmfeste Legierungen und Titanlegierungen

Hauptsorten

CC670 (CA) – S15 (S05-S25)

Eine Keramiksorte mit SiC-Whiskerverstärkung und ausgezeichneter Grundzähigkeit. Sie empfiehlt sich hauptsächlich für warmfeste Superlegierungen und gehärtete Werkstoffe bei schwierigen Bedingungen.

CC6060 (CA) - S10 (S05-S20)

Eine SiAlON-basierte Keramiksorte zur Prozessoptimierung in vorbearbeiteten Werkstoffen bei stabilen Bedingungen. Für beste Sicherheit und berechenbaren Verschleiß durch hohen Widerstand gegen Kerbverschleiß

S05F– S05 (S05-S15)

Eine CVD-beschichtete Hartmetallsorte zum Hochgeschwindigkeitsschlichten in warmfesten Superlegierungen oder Bearbeitungen mit langer Eingriffszeit bei niedrigeren Schnittgeschwindigkeiten. Bei Anwendungen, in denen Kerbverschleiß kein Problem darstellt, z. B. runden Wendeplatten, kleiner Einstellwinkel und weichere Materialien kann diese Sorte auch zum Schruppen verwendet werden.

GC 1105 (GC) - S15 (S05 - S20)

Die erste Wahl. PVD-beschichtete Sorte mit hoher Verschleißfestigkeit und gutem Widerstand gegen plastische Deformation. Für gleichmäßige vorhersehbare Verschleißentwicklung und herausragende Leistung.

GC1115 (HC) - S20 (S15-S25)

Eine PVD-beschichtete Hartmetallsorte mit hoher Verschleißfestigkeit und gutem Widerstand gegen plastische Deformation in Kombination mit idealer Schneidkantenstabilität. In Verbindung mit scharfer Schneidengeometrie bietet diese Sorte gute Prozessergebnisse bei klebenden/schmierenden Werkstoffen. Für die mittlere Drehbearbeitung bis zum Schruppen.

CC6065 (CA) - S15 (S05-S20)

Eine SiAlON-basierte Keramik für hohe Zähigkeit und Sicherheit. Sehr gut geeignet für die Vorbearbeitung in Anwendungen mit mittlerer Schnittunterbrechung sowie bei Werkstoffen mit Schmiedehaut und anderen zähigkeitsfordernden Operationen.

Ergänzende Sorten

GC1125 (HC) – S25 (S20-S30)

Eine PVD-beschichtete Hartmetallsorte für niedrige Schnittgeschwindigkeiten oder leichte Schnittunterbrechung. Durch den hohen Widerstand gegen Kerbverschleiß und Thermoschock lässt sich die Sorte gut bei der mittleren Bearbeitung oder für Operationen mit kurzen Eingriffszeiten einsetzen.

GC15 (HC) - S20 (S15-S25)

Eine PVD-beschichtete Hartmetallsorte zum Schruppen bis zum Schlichten ausgehärteter Ni- und Ti-basierten Legierungen.

GC30 (HC) - S35 (S35-S45)

Eine CVD-beschichtete Hartmetallsorte für Ni- und Ti-basierte Legierungen im weichen/nicht ausgehärteten Zustand.

H13A (HW) – S15 (S10-S30)

Unbeschichtete Hartmetallsorte mit guter Abrasivverschleißfestigkeit und Zähigkeit. Eine gute Wahl für die mittlere bis grobe Drehbearbeitung von warmfesten Super- und Titanlegierungen.

CC650 (CA) – S05 (S01-S10)

Al₂O₃-basierte Mischkeramik. Einzusetzen bei mittleren Bearbeitungen warmfester Aluminiumlegierungen mit geringem Anspruch an die Schneidkantenstabilität.

Titanlegierungen

Hauptsorten

H13A (HW) – S15 (S10-S30)

Unbeschichtete Hartmetallsorte mit guter Abrasivverschleißfestigkeit und Zähigkeit. Eine gute Wahl für die mittlere bis grobe Drehbearbeitung von warmfesten Super- und Titanlegierungen.

Ergänzende Sorten

GC1115 (HC) - S20 (S15-S25)

Eine PVD-beschichtete Hartmetallsorte mit hoher Verschleißfestigkeit und gutem Widerstand gegen plastische Deformation in Kombination mit idealer Schneidkantenstabilität. In Verbindung mit scharfer Schneidengeometrie bietet diese Sorte gute Prozessergebnisse bei klebenden/schmierenden Werkstoffen. Für die mittlere Drehbearbeitung bis zum Schruppen.

GC15 (HC) - S20 (S15-S25)

Eine PVD-beschichtete Hartmetallsorte zum Schruppen bis zum Schlichten ausgehärteter Ni- und Ti-basierten Legierungen.

Sorten für allgemeine Drehbearbeitungen

Gehärtete Werkstoffe



Hauptsorten

CB7015 (BN) - H10 (H05 - H15)

Eine Sorte aus kubischem Bornitrid mit niedrigem cBN-Gehalt. Einsatz bei kontinuierlichen Schnitten oder Bearbeitung mit leichten Schnittunterbrechungen in einsatzgehärteten Stählen bei hohen Schnittgeschwindigkeiten.

CB7025 (BN) - H15 (H10-H20)

Die erste Wahl. Eine Sorte aus kubischem Bornitrid mit mittlerem cBN-Anteil. Geeignet für Bearbeitungen mit wesentlichen Anteilen an schwerer Schnittunterbrechung wie z. B. lange Eingriffe bei mittleren Schnittgeschwindigkeiten in einsatzgehärteten Stählen.

Ergänzende Sorten

CB7525 (BN) - H25 (H20-H30)

Eine extrem harte CBN-Sorte. Durch ihre hohe Schneidkantenzähigkeit gut als ergänzende Sorte für Bearbeitungen mit Schnittunterbrechungen in gehärtetem Stahl geeignet.

CC6050 (CC) - H05 (H01 - H10)

Eine α -O₃-basierte Mischkeramik. Gute Warmfestigkeit und Verschleißfestigkeit. Sie empfiehlt sich in erster Linie für leichte Schlichtbearbeitungen ohne Schnittunterbrechung.

CC670 (CA) - H10 (H05-H15)

Eine Whisker-verstärkte SiAlON basierte Keramik mit einer exzellenten Gesamtzähigkeit. Primär empfohlen für einsatzgehärtete Stähle bei ungünstigen Bearbeitungsbedingungen.