
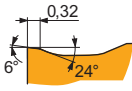


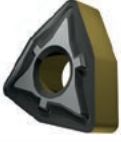
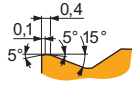


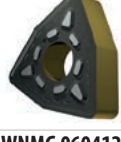
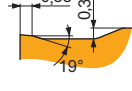


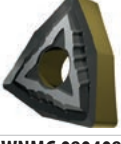
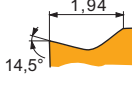


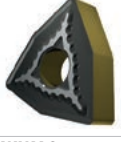
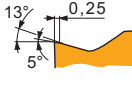



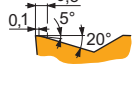



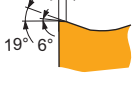






Zalecane początkowe wartości dla prędkości skrawania (vc), posuwu (f) i głębokości skrawania (ap). Więcej opcji można znaleźć w naszej aplikacji Kalkulator Parametrów Skrawania.

| Produkt | RE (mm) | P | | | M | | | K | | | N | | | S | | | H | | |
|--|---|---|---|--|---------------|---------------|------------|---------------|---------------|------------|---------------|---------------|------------|---------------|---------------|------------|---------------|---------------|------------|
| | | vc (m/min) | f (mm/rev) | ap (mm) | vc (m/min) | f (mm/rev) | ap (mm) | vc (m/min) | f (mm/rev) | ap (mm) | vc (m/min) | f (mm/rev) | ap (mm) | vc (m/min) | f (mm/rev) | ap (mm) | vc (m/min) | f (mm/rev) | ap (mm) |
|  |  |  |  | Pozytywna geometria NRM zaprojektowana do obróbki półzgrubnej i zgrubnej, do ciągłych i umiarkowanie przerywanych warunków pracy. | | | | | | | | | | | | | | | |
| WNMG 080408-NRM | T9415 0.8 | 255 | 0.35 | 2.7 | - | - | - | - | - | - | - | - | - | - | - | - | - | - | - |
| WNMG 080412-NRM | T8430 1.2 | 155 | 0.40 | 2.7 | 85 | 0.36 | 2.7 | - | - | - | - | - | - | 30 | 0.28 | 2.2 | - | - | - |
| | T9415 1.2 | 255 | 0.40 | 2.7 | - | - | - | - | - | - | - | - | - | - | - | - | - | - | - |
|  |  |  |  | Geometria R do obróbki od średniozgrubnej do zgrubnej, do ciągłych i przerywanych warunków pracy. | | | | | | | | | | | | | | | |
| WNMG 080408E-R | T9415 0.8 | 235 | 0.40 | 3.5 | - | - | - | 220 | 0.40 | 3.5 | - | - | - | - | - | - | 45 | 0.20 | 0.7 |
| WNMG 080412E-R | T9415 1.2 | 240 | 0.45 | 3.5 | - | - | - | 225 | 0.45 | 3.5 | - | - | - | - | - | - | 45 | 0.23 | 1.0 |
|  |  |  |  | Geometria RM do obróbki w zakresie od półzgrubnej do zgrubnej, do ciągłych i przerywanych warunków pracy. | | | | | | | | | | | | | | | |
| WNMG 060412E-RM | T9415 1.2 | 280 | 0.45 | 3.0 | - | - | - | 265 | 0.45 | 3.0 | - | - | - | - | - | - | - | - | - |
| WNMG 080408E-RM | T9415 0.8 | 265 | 0.40 | 4.0 | - | - | - | 250 | 0.40 | 4.0 | - | - | - | - | - | - | - | - | - |
| WNMG 080412E-RM | T9415 1.2 | 270 | 0.45 | 4.0 | - | - | - | 255 | 0.45 | 4.0 | - | - | - | - | - | - | - | - | - |
| WNMG 080416E-RM | T9415 1.6 | 275 | 0.50 | 4.0 | - | - | - | 260 | 0.50 | 4.0 | - | - | - | - | - | - | - | - | - |
|  |  |  |  | Pozytywna geometria SF zaprojektowana do dokładnej obróbki wykańczającej i toczenia elementów cienkościennych, do ciągłych warunków pracy. | | | | | | | | | | | | | | | |
| WNMG 080408E-SF | T9415 0.8 | 355 | 0.20 | 1.0 | - | - | - | 335 | 0.20 | 1.0 | - | - | - | - | - | - | 70 | 0.13 | 0.7 |
|  |  |  |  | Pozytywna konstrukcja geometrii SM do obróbki średniej, do ciągłych i przerywanych warunków pracy. | | | | | | | | | | | | | | | |
| WNMG 080404E-SM | T9415 0.4 | 280 | 0.20 | 2.0 | - | - | - | 265 | 0.20 | 2.0 | - | - | - | - | - | - | 55 | 0.13 | 0.3 |
| WNMG 080408E-SM | T9415 0.8 | 305 | 0.25 | 2.0 | - | - | - | 285 | 0.25 | 2.0 | - | - | - | - | - | - | 60 | 0.13 | 0.7 |
| WNMG 080412E-SM | T9415 1.2 | 300 | 0.30 | 2.0 | - | - | - | 285 | 0.30 | 2.0 | - | - | - | - | - | - | 60 | 0.15 | 1.0 |
|  |  |  |  | Geometria W-M wiper do obróbki średniozgrubnej i zgrubnej, do zwiększonych posuwów i lepszej jakości powierzchni. | | | | | | | | | | | | | | | |
| WNMG 060408W-M | T9415 0.8 | 255 | 0.45 | 1.2 | - | - | - | 240 | 0.45 | 1.2 | - | - | - | - | - | - | - | - | - |
| WNMG 060412W-M | T9415 1.2 | 250 | 0.55 | 1.2 | - | - | - | 235 | 0.55 | 1.2 | - | - | - | - | - | - | - | - | - |
| WNMG 080408W-M | T9415 0.8 | 245 | 0.45 | 1.5 | - | - | - | 230 | 0.45 | 1.5 | - | - | - | - | - | - | - | - | - |
|  |  |  |  | Geometria W-MR wiper do obróbki zgrubnej i zwiększonych posuwów oraz lepszej jakości powierzchni. | | | | | | | | | | | | | | | |
| WNMG 060408W-MR | T9415 0.8 | 255 | 0.45 | 1.2 | - | - | - | 240 | 0.45 | 1.2 | - | - | - | - | - | - | - | - | - |
| WNMG 080404W-MR | T9415 0.4 | 240 | 0.30 | 1.5 | - | - | - | 225 | 0.30 | 1.5 | - | - | - | - | - | - | - | - | - |
| WNMG 080408W-MR | T9415 0.8 | 245 | 0.45 | 1.5 | - | - | - | 230 | 0.45 | 1.5 | - | - | - | - | - | - | - | - | - |
| WNMG 080412W-MR | T9415 1.2 | 245 | 0.55 | 1.5 | - | - | - | 230 | 0.55 | 1.5 | - | - | - | - | - | - | - | - | - |