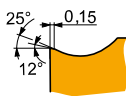




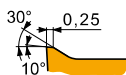
Zalecane początkowe wartości dla prędkości skrawania (vc), posuwu (f) i głębokości skrawania (ap). Więcej opcji można znaleźć w naszej aplikacji Kalkulator Parametrów Skrawania.

| Product | 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) |



Wysoko pozytywna geometria NF zaprojektowana do obróbki od superwykańczającej do średniej, do ciągłych warunków pracy.

| | | | | | | | | | | | | | | | | | | | | |
|-----------------|-------|-----|-----|------|-----|-----|------|-----|-----|------|-----|-----|------|-----|------|------|-----|---|---|---|
| CNMG 120404E-NF | HF7 | 0.4 | – | – | – | 95 | 0.15 | 1.7 | 155 | 0.17 | 1.7 | 495 | 0.20 | 1.7 | – | – | – | – | – | – |
| | T6310 | 0.4 | 180 | 0.17 | 1.7 | 125 | 0.15 | 1.7 | 145 | 0.17 | 1.7 | 540 | 0.20 | 1.7 | 50 | 0.14 | 1.4 | – | – | – |
| | T7325 | 0.4 | 200 | 0.18 | 1.7 | 155 | 0.16 | 1.7 | – | – | – | – | – | – | 65 | 0.16 | 1.4 | – | – | – |
| | T7335 | 0.4 | 195 | 0.18 | 1.7 | 150 | 0.16 | 1.7 | – | – | – | – | – | – | 60 | 0.16 | 1.4 | – | – | – |
| | T8315 | 0.4 | 185 | 0.17 | 1.7 | 110 | 0.15 | 1.7 | 175 | 0.17 | 1.7 | 555 | 0.20 | 1.7 | 45 | 0.14 | 1.4 | – | – | – |
| | T8330 | 0.4 | 180 | 0.17 | 1.7 | 105 | 0.15 | 1.7 | 170 | 0.17 | 1.7 | 540 | 0.20 | 1.7 | 45 | 0.14 | 1.4 | – | – | – |
| | T8430 | 0.4 | 200 | 0.17 | 1.7 | 110 | 0.15 | 1.7 | 165 | 0.17 | 1.7 | 555 | 0.20 | 1.7 | 40 | 0.14 | 1.4 | – | – | – |
| | T9315 | 0.4 | 285 | 0.17 | 1.7 | – | – | – | 270 | 0.17 | 1.7 | – | – | – | – | – | – | – | – | – |
| | T9325 | 0.4 | 250 | 0.18 | 1.7 | 150 | 0.16 | 1.7 | 235 | 0.18 | 1.7 | – | – | – | 55 | 0.16 | 1.4 | – | – | – |
| CNMG 120408E-NF | HF7 | 0.8 | – | – | – | 110 | 0.17 | 1.7 | 180 | 0.19 | 1.7 | 570 | 0.23 | 1.7 | – | – | – | – | – | – |
| | T6310 | 0.8 | 200 | 0.19 | 1.7 | 140 | 0.17 | 1.7 | 160 | 0.19 | 1.7 | 600 | 0.23 | 1.7 | 60 | 0.15 | 1.4 | – | – | – |
| | T7325 | 0.8 | 235 | 0.19 | 1.7 | 180 | 0.17 | 1.7 | – | – | – | – | – | 75 | 0.15 | 1.4 | – | – | – | |
| | T7335 | 0.8 | 225 | 0.19 | 1.7 | 175 | 0.17 | 1.7 | – | – | – | – | – | 70 | 0.15 | 1.4 | – | – | – | |
| | T8315 | 0.8 | 215 | 0.19 | 1.7 | 125 | 0.17 | 1.7 | 200 | 0.19 | 1.7 | 645 | 0.23 | 1.7 | 50 | 0.15 | 1.4 | – | – | – |
| | T8330 | 0.8 | 200 | 0.19 | 1.7 | 120 | 0.17 | 1.7 | 190 | 0.19 | 1.7 | 600 | 0.23 | 1.7 | 50 | 0.15 | 1.4 | – | – | – |
| | T8430 | 0.8 | 235 | 0.19 | 1.7 | 125 | 0.17 | 1.7 | 190 | 0.19 | 1.7 | 645 | 0.23 | 1.7 | 50 | 0.15 | 1.4 | – | – | – |
| | T9315 | 0.8 | 320 | 0.19 | 1.7 | – | – | – | 300 | 0.19 | 1.7 | – | – | – | – | – | – | – | – | – |
| | T9325 | 0.8 | 285 | 0.19 | 1.7 | 170 | 0.17 | 1.7 | 270 | 0.19 | 1.7 | – | – | – | 60 | 0.15 | 1.4 | – | – | – |
| CNMG 120412E-NF | T6310 | 1.2 | 185 | 0.30 | 2.1 | 130 | 0.27 | 2.1 | 145 | 0.30 | 2.1 | 555 | 0.36 | 2.1 | 55 | 0.21 | 1.7 | – | – | – |
| | T7325 | 1.2 | 205 | 0.30 | 2.1 | 155 | 0.27 | 2.1 | – | – | – | – | – | 65 | 0.21 | 1.7 | – | – | – | |
| | T7335 | 1.2 | 200 | 0.30 | 2.1 | 155 | 0.27 | 2.1 | – | – | – | – | – | 65 | 0.21 | 1.7 | – | – | – | |
| | T8330 | 1.2 | 185 | 0.30 | 2.1 | 110 | 0.27 | 2.1 | 175 | 0.30 | 2.1 | 555 | 0.36 | 2.1 | 45 | 0.21 | 1.7 | – | – | – |
| | T8430 | 1.2 | 200 | 0.30 | 2.1 | 110 | 0.27 | 2.1 | 165 | 0.30 | 2.1 | 555 | 0.36 | 2.1 | 40 | 0.21 | 1.7 | – | – | – |
| | T9315 | 1.2 | 275 | 0.30 | 2.1 | – | – | – | 260 | 0.30 | 2.1 | – | – | – | – | – | – | – | – | – |
| | T9325 | 1.2 | 245 | 0.30 | 2.1 | 145 | 0.27 | 2.1 | 230 | 0.30 | 2.1 | – | – | – | 55 | 0.21 | 1.7 | – | – | – |



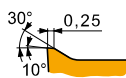
Wysoko pozytywna geometria NM zaprojektowana do obróbki wykańczającej, średniej i zgrubnej, do ciągłych warunków pracy.

| | | | | | | | | | | | | | | | | | | | | |
|-----------------|-------|-----|-----|------|-----|-----|------|-----|---|---|---|-----|------|-----|------|------|-----|---|---|---|
| CNMG 120404E-NM | T7325 | 0.4 | 195 | 0.20 | 2.1 | 150 | 0.18 | 2.1 | – | – | – | – | – | 60 | 0.16 | 1.7 | – | – | – | |
| | T7335 | 0.4 | 190 | 0.20 | 2.1 | 145 | 0.18 | 2.1 | – | – | – | – | – | 60 | 0.16 | 1.7 | – | – | – | |
| | T8315 | 0.4 | 180 | 0.20 | 2.1 | 105 | 0.18 | 2.1 | – | – | – | 540 | 0.24 | 2.1 | 45 | 0.16 | 1.7 | – | – | – |
| | T8330 | 0.4 | 170 | 0.20 | 2.1 | 100 | 0.18 | 2.1 | – | – | – | 510 | 0.24 | 2.1 | 40 | 0.16 | 1.7 | – | – | – |
| | T8430 | 0.4 | 195 | 0.20 | 2.1 | 105 | 0.18 | 2.1 | – | – | – | 540 | 0.24 | 2.1 | 40 | 0.16 | 1.7 | – | – | – |
| | T9315 | 0.4 | 270 | 0.20 | 2.1 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | T9325 | 0.4 | 240 | 0.20 | 2.1 | 140 | 0.18 | 2.1 | – | – | – | – | – | – | 50 | 0.16 | 1.7 | – | – | – |
| CNMG 120408E-NM | T7325 | 0.8 | 215 | 0.25 | 2.1 | 165 | 0.23 | 2.1 | – | – | – | – | – | 65 | 0.20 | 1.7 | – | – | – | |
| | T7335 | 0.8 | 210 | 0.25 | 2.1 | 160 | 0.23 | 2.1 | – | – | – | – | – | 65 | 0.20 | 1.7 | – | – | – | |
| | T8315 | 0.8 | 205 | 0.25 | 2.1 | 120 | 0.23 | 2.1 | – | – | – | 615 | 0.30 | 2.1 | 50 | 0.20 | 1.7 | – | – | – |
| | T8330 | 0.8 | 195 | 0.25 | 2.1 | 115 | 0.23 | 2.1 | – | – | – | 585 | 0.30 | 2.1 | 45 | 0.20 | 1.7 | – | – | – |
| | T8430 | 0.8 | 210 | 0.25 | 2.1 | 115 | 0.23 | 2.1 | – | – | – | 585 | 0.30 | 2.1 | 45 | 0.20 | 1.7 | – | – | – |
| | T9315 | 0.8 | 290 | 0.25 | 2.1 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | T9325 | 0.8 | 260 | 0.25 | 2.1 | 155 | 0.23 | 2.1 | – | – | – | – | – | – | 55 | 0.20 | 1.7 | – | – | – |
| CNMG 120412E-NM | T7325 | 1.2 | 215 | 0.30 | 2.1 | 165 | 0.27 | 2.1 | – | – | – | – | – | 65 | 0.24 | 1.7 | – | – | – | |
| | T7335 | 1.2 | 210 | 0.30 | 2.1 | 160 | 0.27 | 2.1 | – | – | – | – | – | 65 | 0.24 | 1.7 | – | – | – | |
| | T8315 | 1.2 | 205 | 0.30 | 2.1 | 120 | 0.27 | 2.1 | – | – | – | 615 | 0.36 | 2.1 | 50 | 0.24 | 1.7 | – | – | – |
| | T8330 | 1.2 | 195 | 0.30 | 2.1 | 115 | 0.27 | 2.1 | – | – | – | 585 | 0.36 | 2.1 | 45 | 0.24 | 1.7 | – | – | – |
| | T8430 | 1.2 | 210 | 0.30 | 2.1 | 115 | 0.27 | 2.1 | – | – | – | 585 | 0.36 | 2.1 | 45 | 0.24 | 1.7 | – | – | – |
| | T9315 | 1.2 | 285 | 0.30 | 2.1 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | T9325 | 1.2 | 255 | 0.30 | 2.1 | 150 | 0.27 | 2.1 | – | – | – | – | – | – | 55 | 0.24 | 1.7 | – | – | – |
| CNMG 160608E-NM | T7325 | 0.8 | 195 | 0.30 | 3.6 | 150 | 0.27 | 3.6 | – | – | – | – | – | 60 | 0.27 | 2.9 | – | – | – | |
| | T7335 | 0.8 | 190 | 0.30 | 3.6 | 145 | 0.27 | 3.6 | – | – | – | – | – | 60 | 0.27 | 2.9 | – | – | – | |
| | T8315 | 0.8 | 185 | 0.30 | 3.6 | 110 | 0.27 | 3.6 | – | – | – | 555 | 0.36 | 3.6 | 45 | 0.27 | 2.9 | – | – | – |
| | T8330 | 0.8 | 170 | 0.30 | 3.6 | 100 | 0.27 | 3.6 | – | – | – | 510 | 0.36 | 3.6 | 40 | 0.27 | 2.9 | – | – | – |
| | T8430 | 0.8 | 185 | 0.30 | 3.6 | 100 | 0.27 | 3.6 | – | – | – | 510 | 0.36 | 3.6 | 40 | 0.27 | 2.9 | – | – | – |
| | T9325 | 0.8 | 225 | 0.30 | 3.6 | 135 | 0.27 | 3.6 | – | – | – | – | – | – | 50 | 0.27 | 2.9 | – | – | – |



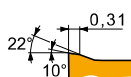
Zalecane początkowe wartości dla prędkości skrawania (vc), posuwu (f) i głębokości skrawania (ap). Więcej opcji można znaleźć w naszej aplikacji Kalkulator Parametrów Skrawania.

| Product | 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) |



Wysoce pozytywna geometria NM zaprojektowana do obróbki wykańczającej, średniej i zgrubnej, do ciągłych warunków pracy.

| | | | | | | | | | | | | | | | | | | | | |
|-----------------|-------|-----|-----|------|-----|-----|------|-----|---|---|---|-----|------|-----|----|------|-----|---|---|---|
| CNMG 160612E-NM | T7325 | 1.2 | 205 | 0.30 | 3.6 | 155 | 0.27 | 3.6 | - | - | - | - | - | - | 65 | 0.27 | 2.9 | - | - | - |
| | T7335 | 1.2 | 200 | 0.30 | 3.6 | 155 | 0.27 | 3.6 | - | - | - | - | - | - | 65 | 0.27 | 2.9 | - | - | - |
| | T8315 | 1.2 | 195 | 0.30 | 3.6 | 115 | 0.27 | 3.6 | - | - | - | 585 | 0.36 | 3.6 | 45 | 0.27 | 2.9 | - | - | - |
| | T9325 | 1.2 | 240 | 0.30 | 3.6 | 140 | 0.27 | 3.6 | - | - | - | - | - | - | 50 | 0.27 | 2.9 | - | - | - |
| CNMG 190612E-NM | T7325 | 1.2 | 195 | 0.35 | 4.2 | 150 | 0.32 | 4.2 | - | - | - | - | - | - | 60 | 0.32 | 3.4 | - | - | - |
| | T7335 | 1.2 | 180 | 0.35 | 4.2 | 140 | 0.32 | 4.2 | - | - | - | - | - | - | 55 | 0.32 | 3.4 | - | - | - |
| | T8315 | 1.2 | 180 | 0.35 | 4.2 | 105 | 0.32 | 4.2 | - | - | - | 540 | 0.42 | 4.2 | 45 | 0.32 | 3.4 | - | - | - |
| | T8330 | 1.2 | 170 | 0.35 | 4.2 | 100 | 0.32 | 4.2 | - | - | - | 510 | 0.42 | 4.2 | 40 | 0.32 | 3.4 | - | - | - |
| | T8430 | 1.2 | 180 | 0.35 | 4.2 | 95 | 0.32 | 4.2 | - | - | - | 495 | 0.42 | 4.2 | 35 | 0.32 | 3.4 | - | - | - |
| | T9325 | 1.2 | 220 | 0.35 | 4.2 | 130 | 0.32 | 4.2 | - | - | - | - | - | - | 45 | 0.32 | 3.4 | - | - | - |



Pozytywna geometria NMR zaprojektowana do obróbki od średniej do zgrubnej, do ciągłych warunków pracy.

| | | | | | | | | | | | | | | | | | | | | | |
|------------------|-------|-----|-----|------|-----|-----|------|-----|---|---|---|---|---|---|----|------|-----|---|---|---|---|
| CNMG 090308E-NMR | T7325 | 0.8 | 175 | 0.35 | 1.6 | 135 | 0.32 | 1.6 | - | - | - | - | - | - | 55 | 0.25 | 1.3 | - | - | - | |
| | T7335 | 0.8 | 170 | 0.35 | 1.6 | 130 | 0.32 | 1.6 | - | - | - | - | - | - | 55 | 0.25 | 1.3 | - | - | - | |
| | T9325 | 0.8 | 200 | 0.35 | 1.6 | 120 | 0.32 | 1.6 | - | - | - | - | - | - | 45 | 0.25 | 1.3 | - | - | - | |
| CNMG 120404E-NMR | T6310 | 0.4 | 140 | 0.25 | 2.7 | 100 | 0.23 | 2.7 | - | - | - | - | - | - | 40 | 0.20 | 2.2 | - | - | - | |
| | T7325 | 0.4 | 155 | 0.25 | 2.7 | 120 | 0.23 | 2.7 | - | - | - | - | - | - | 50 | 0.20 | 2.2 | - | - | - | |
| | T7335 | 0.4 | 155 | 0.25 | 2.0 | 120 | 0.23 | 2.0 | - | - | - | - | - | - | 50 | 0.20 | 1.6 | - | - | - | |
| | T8330 | 0.4 | 140 | 0.25 | 2.0 | 80 | 0.23 | 2.0 | - | - | - | - | - | - | 35 | 0.20 | 1.6 | - | - | - | |
| | T8430 | 0.4 | 150 | 0.25 | 2.7 | 80 | 0.23 | 2.7 | - | - | - | - | - | - | 30 | 0.20 | 2.2 | - | - | - | |
| | T9315 | 0.4 | 215 | 0.25 | 2.0 | - | - | - | - | - | - | - | - | - | - | - | - | - | - | - | - |
| | T9325 | 0.4 | 190 | 0.25 | 2.0 | 110 | 0.23 | 2.0 | - | - | - | - | - | - | 40 | 0.20 | 1.6 | - | - | - | |
| CNMG 120408E-NMR | T6310 | 0.8 | 150 | 0.35 | 2.7 | 105 | 0.32 | 2.7 | - | - | - | - | - | - | 45 | 0.25 | 2.2 | - | - | - | |
| | T7325 | 0.8 | 170 | 0.35 | 2.7 | 130 | 0.32 | 2.7 | - | - | - | - | - | - | 55 | 0.25 | 2.2 | - | - | - | |
| | T7335 | 0.8 | 160 | 0.35 | 2.7 | 120 | 0.32 | 2.7 | - | - | - | - | - | - | 50 | 0.25 | 2.2 | - | - | - | |
| | T8330 | 0.8 | 150 | 0.35 | 2.7 | 90 | 0.32 | 2.7 | - | - | - | - | - | - | 35 | 0.25 | 2.2 | - | - | - | |
| | T8430 | 0.8 | 155 | 0.35 | 2.7 | 85 | 0.32 | 2.7 | - | - | - | - | - | - | 30 | 0.25 | 2.2 | - | - | - | |
| | T9315 | 0.8 | 210 | 0.35 | 2.7 | - | - | - | - | - | - | - | - | - | - | - | - | - | - | - | - |
| | T9325 | 0.8 | 190 | 0.35 | 2.7 | 110 | 0.32 | 2.7 | - | - | - | - | - | - | 40 | 0.25 | 2.2 | - | - | - | |
| CNMG 120412E-NMR | T6310 | 1.2 | 150 | 0.40 | 2.7 | 105 | 0.36 | 2.7 | - | - | - | - | - | - | 45 | 0.28 | 2.2 | - | - | - | |
| | T7325 | 1.2 | 170 | 0.40 | 2.7 | 130 | 0.36 | 2.7 | - | - | - | - | - | - | 55 | 0.28 | 2.2 | - | - | - | |
| | T7335 | 1.2 | 160 | 0.40 | 2.7 | 120 | 0.36 | 2.7 | - | - | - | - | - | - | 50 | 0.28 | 2.2 | - | - | - | |
| | T8330 | 1.2 | 150 | 0.40 | 2.7 | 90 | 0.36 | 2.7 | - | - | - | - | - | - | 35 | 0.28 | 2.2 | - | - | - | |
| | T8430 | 1.2 | 155 | 0.40 | 2.7 | 85 | 0.36 | 2.7 | - | - | - | - | - | - | 30 | 0.28 | 2.2 | - | - | - | |
| CNMG 120416E-NMR | T7325 | 1.6 | 170 | 0.45 | 2.7 | 130 | 0.41 | 2.7 | - | - | - | - | - | - | 55 | 0.32 | 2.2 | - | - | - | |
| | T7335 | 1.6 | 160 | 0.45 | 2.7 | 120 | 0.41 | 2.7 | - | - | - | - | - | - | 50 | 0.32 | 2.2 | - | - | - | |
| | T9325 | 1.6 | 190 | 0.45 | 2.7 | 110 | 0.41 | 2.7 | - | - | - | - | - | - | 40 | 0.32 | 2.2 | - | - | - | |
| CNMG 160608E-NMR | T7325 | 0.8 | 160 | 0.35 | 4.0 | 120 | 0.32 | 4.0 | - | - | - | - | - | - | 50 | 0.25 | 3.2 | - | - | - | |
| | T7335 | 0.8 | 150 | 0.35 | 4.0 | 115 | 0.32 | 4.0 | - | - | - | - | - | - | 45 | 0.25 | 3.2 | - | - | - | |
| | T9315 | 0.8 | 205 | 0.35 | 4.0 | - | - | - | - | - | - | - | - | - | - | - | - | - | - | - | |
| | T9325 | 0.8 | 185 | 0.35 | 4.0 | 110 | 0.32 | 4.0 | - | - | - | - | - | - | 40 | 0.25 | 3.2 | - | - | - | |
| CNMG 160612E-NMR | T7325 | 1.2 | 165 | 0.40 | 4.0 | 125 | 0.36 | 4.0 | - | - | - | - | - | - | 50 | 0.28 | 3.2 | - | - | - | |
| | T7335 | 1.2 | 155 | 0.40 | 4.0 | 120 | 0.36 | 4.0 | - | - | - | - | - | - | 50 | 0.28 | 3.2 | - | - | - | |
| | T8330 | 1.2 | 145 | 0.40 | 4.0 | 85 | 0.36 | 4.0 | - | - | - | - | - | - | 35 | 0.28 | 3.2 | - | - | - | |
| | T8430 | 1.2 | 150 | 0.40 | 4.0 | 80 | 0.36 | 4.0 | - | - | - | - | - | - | 30 | 0.28 | 3.2 | - | - | - | |
| | T9315 | 1.2 | 205 | 0.40 | 4.0 | - | - | - | - | - | - | - | - | - | - | - | - | - | - | - | |
| | T9325 | 1.2 | 185 | 0.40 | 4.0 | 110 | 0.36 | 4.0 | - | - | - | - | - | - | 40 | 0.28 | 3.2 | - | - | - | |