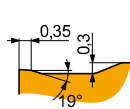




Zalecane początkowe wartości dla prędkości skrawania (vc), posuwu (f) i głębokości skrawania (ap). Więcej opcji można znaleźć w naszej aplikacji Kalkulator Parametrów Skrawania.

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)



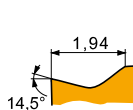
Geometria RM do obróbki w zakresie od półzgrubnej do zgrubnej, do ciągłych i przerywanych warunków pracy.

CNMG 120412E-RM	T5305	1.2	280	0.45	4.0				265	0.45	4.0								
	T5315	1.2	250	0.45	4.0				235	0.45	4.0								
	T6310	1.2	160	0.45	4.0	115	0.41	4.0	125	0.45	4.0								
	T7325	1.2	180	0.45	4.0	140	0.41	4.0											
	T7335	1.2	170	0.45	4.0	130	0.41	4.0											
	T8315	1.2	170	0.45	4.0	100	0.41	4.0	160	0.45	4.0								
	T8330	1.2	160	0.45	4.0	95	0.41	4.0	150	0.45	4.0								
	T8430	1.2	170	0.45	4.0	90	0.41	4.0	135	0.45	4.0								
	T9310	1.2	240	0.45	4.0				225	0.45	4.0								
	T9315	1.2	220	0.45	4.0				205	0.45	4.0								
	T9325	1.2	200	0.45	4.0	120	0.41	4.0	190	0.45	4.0								
	T9335	1.2	175	0.45	4.0	105	0.41	4.0											
	CNMG 120416E-RM	T5305	1.6	280	0.50	4.0				265	0.50	4.0							
T5315		1.6	255	0.50	4.0				240	0.50	4.0								
T7325		1.6	185	0.50	4.0	140	0.45	4.0											
T7335		1.6	175	0.50	4.0	135	0.45	4.0											
T8330		1.6	160	0.50	4.0	95	0.45	4.0	150	0.50	4.0								
T8430		1.6	170	0.50	4.0	90	0.45	4.0	135	0.50	4.0								
T9310		1.6	240	0.50	4.0				225	0.50	4.0								
T9315		1.6	220	0.50	4.0				205	0.50	4.0								
T9325		1.6	205	0.50	4.0	120	0.45	4.0	190	0.50	4.0								
T9335	1.6	175	0.50	4.0	105	0.45	4.0												
CNMG 160608E-RM	T5305	0.8	265	0.40	6.0				250	0.40	6.0								
	T5315	0.8	240	0.40	6.0				225	0.40	6.0								
	T8330	0.8	150	0.40	6.0	90	0.36	6.0	140	0.40	6.0								
	T8430	0.8	155	0.40	6.0	85	0.36	6.0	130	0.40	6.0								
	T9315	0.8	215	0.40	6.0				200	0.40	6.0								
	T9325	0.8	190	0.40	6.0	110	0.36	6.0	180	0.40	6.0								
	T9335	0.8	165	0.40	6.0	95	0.36	6.0											
CNMG 160612E-RM	T5305	1.2	270	0.45	6.0				255	0.45	6.0								
	T5315	1.2	245	0.45	6.0				230	0.45	6.0								
	T6310	1.2	155	0.45	6.0	110	0.41	6.0	125	0.45	6.0								
	T7325	1.2	170	0.45	6.0	130	0.41	6.0											
	T7335	1.2	165	0.45	6.0	125	0.41	6.0											
	T8330	1.2	155	0.45	6.0	90	0.41	6.0	145	0.45	6.0								
	T8430	1.2	155	0.45	6.0	85	0.41	6.0	130	0.45	6.0								
	T9310	1.2	230	0.45	6.0				215	0.45	6.0								
	T9315	1.2	215	0.45	6.0				200	0.45	6.0								
	T9325	1.2	195	0.45	6.0	115	0.41	6.0	185	0.45	6.0								
T9335	1.2	165	0.45	6.0	95	0.41	6.0												
CNMG 160616E-RM	T5305	1.6	270	0.50	6.0				255	0.50	6.0								
	T5315	1.6	245	0.50	6.0				230	0.50	6.0								
	T7325	1.6	175	0.50	6.0	135	0.45	6.0											
	T7335	1.6	165	0.50	6.0	125	0.45	6.0											
	T9310	1.6	225	0.50	6.0				210	0.50	6.0								
	T9315	1.6	215	0.50	6.0				200	0.50	6.0								
	T9325	1.6	190	0.50	6.0	110	0.45	6.0	180	0.50	6.0								
	T9335	1.6	165	0.50	6.0	95	0.45	6.0											
CNMG 190608E-RM	T5305	0.8	260	0.40	7.5				245	0.40	7.5								
	T5315	0.8	230	0.40	7.5				215	0.40	7.5								
	T7335	0.8	155	0.40	7.5	120	0.36	7.5											
	T9315	0.8	210	0.40	7.5				195	0.40	7.5								
	T9325	0.8	190	0.40	7.5	110	0.36	7.5	180	0.40	7.5								
	T9335	0.8	160	0.40	7.5	95	0.36	7.5											



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)
CNMG 190612E-RM	T5305	1.2	260	0.45	7.5	–	–	–	245	0.45	7.5	–	–	–	–	–	–	–	–
	T5315	1.2	240	0.45	7.5	–	–	–	225	0.45	7.5	–	–	–	–	–	–	–	–
	T6310	1.2	155	0.45	7.5	110	0.41	7.5	125	0.45	7.5	–	–	–	–	–	–	–	–
	T7325	1.2	170	0.45	7.5	130	0.41	7.5	–	–	–	–	–	–	–	–	–	–	–
	T7335	1.2	160	0.45	7.5	120	0.41	7.5	–	–	–	–	–	–	–	–	–	–	–
	T8330	1.2	155	0.45	7.5	90	0.41	7.5	145	0.45	7.5	–	–	–	–	–	–	–	–
	T8430	1.2	150	0.45	7.5	80	0.41	7.5	125	0.45	7.5	–	–	–	–	–	–	–	–
	T9310	1.2	220	0.45	7.5	–	–	–	205	0.45	7.5	–	–	–	–	–	–	–	–
	T9315	1.2	210	0.45	7.5	–	–	–	195	0.45	7.5	–	–	–	–	–	–	–	–
	T9325	1.2	185	0.45	7.5	110	0.41	7.5	175	0.45	7.5	–	–	–	–	–	–	–	–
	T9335	1.2	165	0.45	7.5	95	0.41	7.5	–	–	–	–	–	–	–	–	–	–	–
CNMG 190616E-RM	T5305	1.6	265	0.50	7.5	–	–	–	250	0.50	7.5	–	–	–	–	–	–	–	–
	T5315	1.6	240	0.50	7.5	–	–	–	225	0.50	7.5	–	–	–	–	–	–	–	–
	T6310	1.6	155	0.50	7.5	110	0.45	7.5	125	0.50	7.5	–	–	–	–	–	–	–	
	T7325	1.6	175	0.50	7.5	135	0.45	7.5	–	–	–	–	–	–	–	–	–	–	
	T7335	1.6	160	0.50	7.5	120	0.45	7.5	–	–	–	–	–	–	–	–	–	–	
	T9310	1.6	225	0.50	7.5	–	–	–	210	0.50	7.5	–	–	–	–	–	–	–	–
	T9315	1.6	210	0.50	7.5	–	–	–	195	0.50	7.5	–	–	–	–	–	–	–	–
	T9325	1.6	190	0.50	7.5	110	0.45	7.5	180	0.50	7.5	–	–	–	–	–	–	–	–
	T9335	1.6	160	0.50	7.5	95	0.45	7.5	–	–	–	–	–	–	–	–	–	–	–
CNMG 250924E-RM	T7325	2.4	105	0.80	12.0	80	0.72	12.0	–	–	–	–	–	–	–	–	–	–	
	T7335	2.4	100	0.80	12.0	75	0.72	12.0	–	–	–	–	–	–	–	–	–	–	
	T9226	2.4	90	0.80	12.0	50	0.72	12.0	85	0.80	12.0	–	–	–	–	–	–	–	
	T9315	2.4	120	0.80	12.0	–	–	–	110	0.80	12.0	–	–	–	–	–	–	–	–
	T9325	2.4	105	0.80	12.0	60	0.72	12.0	95	0.80	12.0	–	–	–	–	–	–	–	–
	T9335	2.4	85	0.80	12.0	50	0.72	12.0	–	–	–	–	–	–	–	–	–	–	–



Pozytywna geometria SF zaprojektowana do dokładnej obróbki wykańczającej elementów cienkościennych, do ciągłych warunków pracy.

CNMG 120404E-SF	H07	0.4	–	–	–	90	0.14	1.0	145	0.15	1.0	470	0.18	1.0	45	0.12	0.8	–	–	–
	T6310	0.4	180	0.15	1.0	125	0.14	1.0	145	0.15	1.0	540	0.18	1.0	50	0.12	0.8	35	0.15	1.0
	T7325	0.4	205	0.17	1.0	155	0.15	1.0	–	–	–	–	–	–	65	0.15	0.8	–	–	–
	T7335	0.4	200	0.17	1.0	155	0.15	1.0	–	–	–	–	–	–	65	0.15	0.8	–	–	–
	T8315	0.4	195	0.15	1.0	115	0.14	1.0	185	0.15	1.0	585	0.18	1.0	45	0.12	0.8	35	0.15	1.0
	T8330	0.4	180	0.15	1.0	105	0.14	1.0	170	0.15	1.0	540	0.18	1.0	45	0.12	0.8	35	0.15	1.0
	T8430	0.4	220	0.15	1.0	120	0.14	1.0	180	0.15	1.0	600	0.18	1.0	45	0.12	0.8	35	0.15	1.0
	T9315	0.4	300	0.15	1.0	–	–	–	285	0.15	1.0	–	–	–	–	–	–	60	0.15	1.0
	T9325	0.4	255	0.17	1.0	150	0.15	1.0	240	0.17	1.0	–	–	–	55	0.15	0.8	–	–	–
CNMG 120408E-SF	H07	0.8	–	–	–	95	0.18	1.0	155	0.20	1.0	495	0.24	1.0	50	0.14	0.8	–	–	–
	T6310	0.8	200	0.20	1.0	140	0.18	1.0	160	0.20	1.0	600	0.24	1.0	60	0.14	0.8	40	0.15	1.0
	T7325	0.8	230	0.20	1.0	175	0.18	1.0	–	–	–	–	–	–	70	0.16	0.8	–	–	–
	T7335	0.8	220	0.20	1.0	170	0.18	1.0	–	–	–	–	–	–	70	0.16	0.8	–	–	–
	T8315	0.8	210	0.20	1.0	125	0.18	1.0	195	0.20	1.0	630	0.24	1.0	50	0.14	0.8	40	0.15	1.0
	T8330	0.8	200	0.20	1.0	120	0.18	1.0	190	0.20	1.0	600	0.24	1.0	50	0.14	0.8	40	0.15	1.0
	T8430	0.8	230	0.20	1.0	125	0.18	1.0	185	0.20	1.0	630	0.24	1.0	45	0.14	0.8	35	0.15	1.0
	T9315	0.8	315	0.20	1.0	–	–	–	295	0.20	1.0	–	–	–	–	–	–	60	0.15	1.0
T9325	0.8	280	0.20	1.0	165	0.18	1.0	265	0.20	1.0	–	–	–	60	0.16	0.8	–	–	–	
CNMG 120412E-SF	T6310	1.2	190	0.25	1.5	135	0.23	1.5	150	0.25	1.5	570	0.30	1.5	55	0.18	1.2	35	0.15	1.0
	T7325	1.2	220	0.25	1.5	170	0.23	1.5	–	–	–	–	–	–	70	0.18	1.2	–	–	–
	T8315	1.2	200	0.25	1.5	120	0.23	1.5	190	0.25	1.5	600	0.30	1.5	50	0.18	1.2	40	0.15	1.0
	T8430	1.2	210	0.25	1.5	115	0.23	1.5	175	0.25	1.5	585	0.30	1.5	45	0.18	1.2	35	0.15	1.0