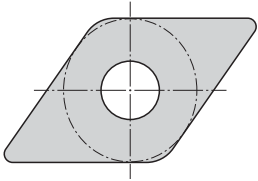
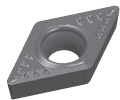





Wendeschneidplatten positiv
Indexable inserts positive

		Anwendung Application		Semi-Schlichten Semi-finishing			
		Positiver Spanformer Positive chipformer		PM			
		Sorte Grade		LCP15T	LCP25T	LCP35T	
		Konstante Schnitttiefe Consistent cutting depth		■	■	■	
		Inkonstante Schnitttiefe Inconsistent cutting depth		□	■	■	
Unterbrochener Schnitt Interrupted cut			□	□			
		▼					
		▼▼	■	■	■		
		▼▼▼	□	□			
LMT-Code	ANSI-Code	a_p (mm)	f (mm)	Ident No.			
DCMT 070204 PM	DCMT 2 (1.5) 1 PM	0,5–3,0	0,12–0,21		7171856	7171891	
DCMT 070208 PM	DCMT 2 (1.5) 2 PM				7171857	7171892	
DCMT 11T304 PM	DCMT 3 (2.5) 1 PM			7171846	7171858	7171893	
DCMT 11T308 PM	DCMT 3 (2.5) 2 PM			7171847	7171859	7171894	
DCMT 070202 PF	DCMT 2 (1.5) (.5) PF	0,5–2,25	0,07–0,14				
DCMT 070204 PF	DCMT 2 (1.5) 1 PF						
DCMT 11T302 PF	DCMT 3 (2.5) (.5) PF						
DCMT 11T304 PF	DCMT 3 (2.5) 1 PF						
DCMT 11T308 PF	DCMT 3 (2.5) 2 PF						
DCMT 070204 PFC	DCMT 2 (1.5) 1 PFC	0,1–1,65	0,05–0,2				
DCMT 11T304 PFC	DCMT 3 (2.5) 1 PFC						
Werkstoff Material		HB/R_m		v_c (m/min)			
P1	Unlegierter Stahl 0–0,45 % C Non alloyed steel 0–0.45 % C	150–250		■ 220–400	■ 170–240	■ 170–190	
P2	Niedriglegierter Stahl Low alloyed steel	250–300		■ 200–320	■ 100–190	■ 90–150	
P3	Hochlegierter Stahl High alloyed steel	200		■ 180–320	■ 130–210	■ 120–200	
P4	Korrosionsbeständiger Stahl Corrosion resistant steel	200		■ 200–320	■ 130–220	■ 140–180	
M1	Rostfreie ferritische Stähle Stainless steel ferritic	200		□ 220–320	□ 140–210	□ 140–200	
M2	Rostfreie austenitische Stähle Stainless steel austenitic	180			□ 100–210	□ 110–190	
M3	Rostfreie Duplexstähle Stainless steel duplex	230–260				□ 80–150	
M4	Rostfreie martensitische Stähle Stainless steel martensitic	330			□ 70–100	□ 55– 75	
K1	Grauguss Grey cast iron	180		□ 140–370	□ 130–210		
K2	Sphäroguss Spheroidal	160		□ 190–430	□ 120–240		
K3	Temperguss Malleable cast iron	130		□ 180–520	□ 150–250		
N1	Aluminium-Knetlegierungen Aluminium wrought alloys	60–100					
N2	Aluminium-Gusslegierungen Aluminium cast alloys	75–130					
N3	Kupfer und Kupferlegierungen Copper and copper alloys	100					
N4	Nichtmetallische Werkstoffe Nonmetallic materials						
S1	Warmfeste Legierungen Fe-Basis Heat resistant alloys Fe-based	200–280					
S2	Warmfeste Legierungen Ni- oder Co-Basis Heat resistant alloys Ni- or Co-based	250–350					
S3	Titanlegierungen Titanium alloys	400					
H1	Gehärteter Stahl Hardened steel	55–60 HRC					