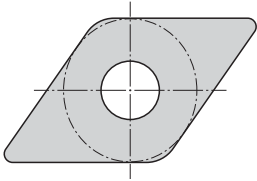
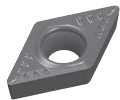






**Wendeschneidplatten positiv**  
**Indexable inserts positive**

		<b>Anwendung Application</b>		<b>Semi-Schichten Semi-finishing</b>			
		<b>Positiver Spanformer</b>		<b>MM</b>			
		<b>Positive chipformer</b>					
		<b>Sorte Grade</b>			<b>LCM25T</b>	<b>LCM35T</b>	
		<b>Konstante Schnitttiefe</b>			■	■	
		<b>Konstante Schnitttiefe</b>			■	■	
<b>Inkonstante Schnitttiefe</b>			□	■			
<b>Unterbrochener Schnitt</b>			■	■			
	▼		■	■			
	▼▼		□				
	▼▼▼						
<b>LMT-Code</b>	<b>ANSI-Code</b>	<b>a<sub>p</sub> (mm)</b>	<b>f (mm)</b>	<b>Ident No.</b>			
DCMT 070204 MM	DCMT 2 (1.5) 1 MM	0,5–3,0	0,12–0,21	7171951			
DCMT 070208 MM	DCMT 2 (1.5) 2 MM			7171952			
DCMT 11T304 MM	DCMT 3 (2.5) 1 MM			7171953 7171982			
DCMT 11T308 MM	DCMT 3 (2.5) 2 MM			7171954 7171983			
DCMT 070202 MF	DCMT 2 (1.5) (.5) MF	0,5–2,25	0,07–0,14				
DCMT 070204 MF	DCMT 2 (1.5) 1 MF						
DCMT 11T302 MF	DCMT 3 (2.5) (.5) MF						
DCMT 11T304 MF	DCMT 3 (2.5) 1 MF						
DCMT 11T308 MF	DCMT 3 (2.5) 2 MF						
DCMT 070204 MFC	–	0,1–1,65	0,05–0,2				
DCMT 11T304 MFC	–						
<b>Werkstoff Material</b>		<b>HB/R<sub>m</sub></b>		<b>v<sub>c</sub> (m/min)</b>			
<b>P1</b>	Unlegierter Stahl 0–0,45 % C Non alloyed steel 0–0.45 % C	150–250		□ 130–250	□ 170–190		
<b>P2</b>	Niedriglegierter Stahl Low alloyed steel	250–300		□ 60–180	□ 90–150		
<b>P3</b>	Hochlegierter Stahl High alloyed steel	200		□ 80–200	□ 120–200		
<b>P4</b>	Korrosionsbeständiger Stahl Corrosion resistant steel	200		□ 100–200	□ 140–180		
<b>M1</b>	Rostfreie ferritische Stähle Stainless steel ferritic	200		■ 120–250	■ 140–200		
<b>M2</b>	Rostfreie austenitische Stähle Stainless steel austenitic	180		■ 100–220	■ 110–190		
<b>M3</b>	Rostfreie Duplexstähle Stainless steel duplex	230–260		■ 60–160	■ 80–150		
<b>M4</b>	Rostfreie martensitische Stähle Stainless steel martensitic	330		■ 40–100	■ 55– 75		
<b>K1</b>	Grauguss Grey cast iron	180					
<b>K2</b>	Sphäroguss Spheroidal	160					
<b>K3</b>	Temperguss Malleable cast iron	130					
<b>N1</b>	Aluminium-Knetlegierungen Aluminium wrought alloys	60–100					
<b>N2</b>	Aluminium-Gusslegierungen Aluminium cast alloys	75–130					
<b>N3</b>	Kupfer und Kupferlegierungen Copper and copper alloys	100					
<b>N4</b>	Nichtmetallische Werkstoffe Nonmetallic materials						
<b>S1</b>	Warmfeste Legierungen Fe-Basis Heat resistant alloys Fe-based	200–280					
<b>S2</b>	Warmfeste Legierungen Ni- oder Co-Basis Heat resistant alloys Ni- or Co-based	250–350					
<b>S3</b>	Titanlegierungen Titanium alloys	400					
<b>H1</b>	Gehärteter Stahl Hardened steel	55–60 HRC					