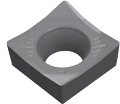
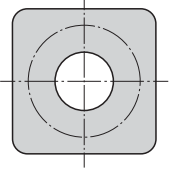





**Wendeschneidplatten positiv**  
**Indexable inserts positive**

|   |  | Anwendung Application                                  |           | Semi-Schlichten Semi-finishing  |   |  |
|---|--|--|-----------|---|---|--|
|   |  | Positiver Spanformer<br>Positive chipformer            |           | ALM   |  |  |
|  |  | Sorte Grade  |           | LWN15T  |   |  |
|   |  | Konstante Schnitttiefe<br>Consistent cutting depth     |           |  | ■   |  |
|   |  | Inkonstante Schnitttiefe<br>Inconsistent cutting depth |           |  | ■   |  |
|   |  | Unterbrochener Schnitt<br>Interrupted cut              |           |  | □   |  |
|   |  | ▼  |           |   |   |  |
|   |  | ▼▼   |           | ■   |   |  |
|   |  | ▼▼▼  |           | □   |   |  |
| LMT-Code  | ANSI-Code  | a <sub>p</sub> (mm)                                    | f (mm)    | Ident No.   |   |  |
| SCGT 09T304 ALM   | SCGT 3 (2.5) 1 ALM   | 1,5–6,5  | 0,20–0,50 | 7172020   |   |  |
| SCMT 09T304 PM  | SCMT 3 (2.5) 1 PM  | 0,5–3,0  | 0,12–0,21 |   |   |  |
| SCMT 09T308 PM  | SCMT 3 (2.5) 2 PM  |  |           |   |   |  |
| SCMT 120404 PM  | SCMT 431 PM  |  |           |   |   |  |
| SCMT 120408 PM  | SCMT 432 PM  |  |           |   |   |  |
| SCMT 120412 PM  | SCMT 433 PM  |  |           |   |   |  |
|   |  |  |           |   |   |  |
| Werkstoff Material  |  | HB/R <sub>m</sub>                                      |           | v <sub>c</sub> (m/min)  |   |  |
| <b>P1</b>   | Unlegierter Stahl 0–0,45 % C<br>Non alloyed steel 0–0.45 % C                     | 150–250  |           |   |   |  |
| <b>P2</b>   | Niedriglegierter Stahl<br>Low alloyed steel                                      | 250–300  |           |   |   |  |
| <b>P3</b>   | Hochlegierter Stahl<br>High alloyed steel  | 200  |           |   |   |  |
| <b>P4</b>   | Korrosionsbeständiger Stahl<br>Corrosion resistant steel                         | 200  |           |   |   |  |
| <b>M1</b>   | Rostfreie ferritische Stähle<br>Stainless steel ferritic                         | 200  |           |   |   |  |
| <b>M2</b>   | Rostfreie austenitische Stähle<br>Stainless steel austenitic                     | 180  |           |   |   |  |
| <b>M3</b>   | Rostfreie Duplexstähle<br>Stainless steel duplex                                 | 230–260  |           |   |   |  |
| <b>M4</b>   | Rostfreie martensitische Stähle<br>Stainless steel martensitic                   | 330  |           |   |   |  |
| <b>K1</b>   | Grauguss<br>Grey cast iron   | 180  |           | □ 120–160   |   |  |
| <b>K2</b>   | Sphäroguss<br>Spheroidal   | 160  |           | □ 130–170   |   |  |
| <b>K3</b>   | Temperguss<br>Malleable cast iron  | 130  |           | □ 140–200   |   |  |
| <b>N1</b>   | Aluminium-Knetlegierungen<br>Aluminium wrought alloys                            | 60–100   |           | ■ 100–2000  |   |  |
| <b>N2</b>   | Aluminium-Gusslegierungen<br>Aluminium cast alloys                               | 75–130   |           | ■ 100–800   |   |  |
| <b>N3</b>   | Kupfer und Kupferlegierungen<br>Copper and copper alloys                         | 100  |           | ■ 100–600   |   |  |
| <b>N4</b>   | Nichtmetallische Werkstoffe<br>Nonmetallic materials                             |  |           | ■ 100–300   |   |  |
| <b>S1</b>   | Warmfeste Legierungen Fe-Basis<br>Heat resistant alloys Fe-based                 | 200–280  |           | □ 30– 45  |   |  |
| <b>S2</b>   | Warmfeste Legierungen Ni- oder Co-Basis<br>Heat resistant alloys Ni- or Co-based | 250–350  |           | □ 20– 35  |   |  |
| <b>S3</b>   | Titanlegierungen<br>Titanium alloys  | 400  |           | □ 60–120  |   |  |
| <b>H1</b>   | Gehärteter Stahl<br>Hardened steel   | 55–60 HRC  |           |   |   |  |