

mitsubishi

MITSUBISHI CARBIDE

Neue Sorten für die produktive
Bearbeitung von Gusswerkstoffen.

B061D

UC5105 UC5115

**Neue CVD-beschichtete WSP
für die Gussbearbeitung.
Höchster Verschleiß- und
Temperaturwiderstand dank
innovativster Beschichtungs-
technologie
„ALL BLACK SUPER EVEN COAT“**



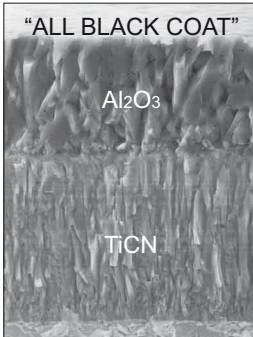
UC5105/UC5115

Eigenschaften von UC5105/UC5115

Neu entwickelte "ALL BLACK SUPER EVEN COAT" Beschichtungstechnologie

Hoher Verschleißschutz

Dank der extrem glatten Oberfläche wird eine deutlich höhere Verschleißfestigkeit gegenüber herkömmlichen CVD- sowie auch Keramik Sorten erreicht. Die "ALL BLACK SUPER EVEN COAT" Sorten zeichnen sich durch höchste Prozesssicherheit und Produktivität aus.



UC5105

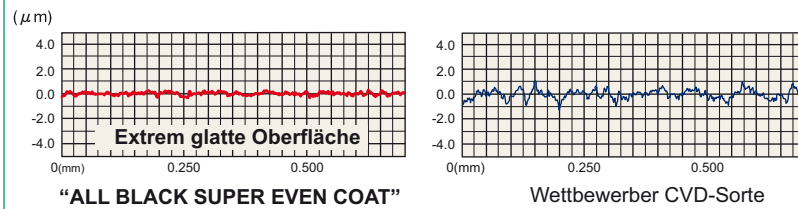
1. Empfehlung für kontinuierlichen Schnitt mit hohen Schnittgeschwindigkeiten.

UC5115

1. Empfehlung für unterbrochenen Schnitt mit hohen Schnittgeschwindigkeiten.

UC5105/UC5115

Oberflächenstruktur der neuen "ALL BLACK SUPER EVEN COAT" Beschichtung



Anwendungsbereich

TOOL NAVI SYSTEM

K05 Sorte, für kontinuierliche Bearbeitungen von Gusswerkstoffen

K10 Sorte, für unterbrochene Bearbeitung von Gusswerkstoffen

Wendeplattenauswahl



1. Empfehlung für die Bearbeitung von Gusswerkstoffen

Bearbeitung

K Kontinuierlich

Kontinuierlicher Schnitt
Gleichbleibende Schnitttiefe
Stabile Werkstückspannung
Hohe Schnittgeschwindigkeit

C Allgemein

Allgemeiner Einsatz
Plan- Kopierdrehen von Werkstücken mit leichter Schnittunterbrechung

+ Unterbrochen

Schruppbearbeitung
Schwer unterbrochene Bearbeitung
Rohwerkstücke

Bearbeitungsmethode

F Endbearbeitung ($a_p \leq 0.5\text{mm}$)

G Schruppen ($a_p = 4.0 - 7.0\text{mm}$)

M Mittlere Bearbeitung ($a_p = 1.5 - 4.0\text{mm}$)

Sortenauswahl

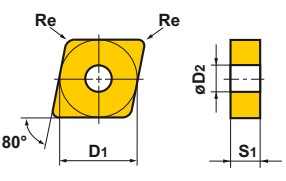
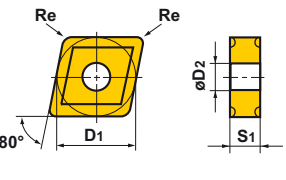
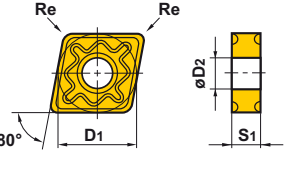
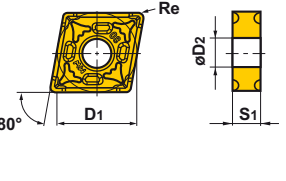
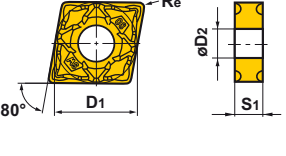
ISO	Guss, Grauguss, duktiler Guss
K01	
K10	
K20	
K30	

Schnittdatenempfehlung

Werkstoff	(MPa)	Vc (m/min)	
		UC5105	UC5115
K Grauguss	≤ 300	300 (200–400)	250 (150–300)
	≤ 450	300 (200–400)	250 (150–300)
duktiler Grauguss	500–800	230 (180–300)	200 (150–250)

UC5105/UC5115

● Negative Wendeschneidplatten

Geometrie	Bestellbezeichnung	Lager		Abmessungen (mm)			
		UC5105	UC5115	D1	S1	Re	D2
CNMA... 	CNMA120404	●	●	12.7	4.76	0.4	5.16
	120408	●	●	12.7	4.76	0.8	5.16
	120412	●	●	12.7	4.76	1.2	5.16
	120416	●	●	12.7	4.76	1.6	5.16
	160612	●	●	15.875	6.35	1.2	6.35
	160616	●	●	15.875	6.35	1.6	6.35
	190612	●	●	19.05	6.35	1.2	7.93
	190616	●	●	19.05	6.35	1.6	7.93
CNMG... 	CNMG120404	●	●	12.7	4.76	0.4	5.16
	120408	●	●	12.7	4.76	0.8	5.16
	120412	●	●	12.7	4.76	1.2	5.16
	120416	●	●	12.7	4.76	1.6	5.16
	160612	●	●	15.875	6.35	1.2	6.35
	160616	●	●	15.875	6.35	1.6	6.35
	190612	★	★	19.05	6.35	1.2	7.93
	190616	★	★	19.05	6.35	1.6	7.93
CNMG...-GH 	CNMG120408-GH	●	●	12.7	4.76	0.8	5.16
	120412-GH	●	●	12.7	4.76	1.2	5.16
	120416-GH	●	●	12.7	4.76	1.6	5.16
	160612-GH	●	●	15.875	6.35	1.2	6.35
	160616-GH	●	●	15.875	6.35	1.6	6.35
	190612-GH	★	★	19.05	6.35	1.2	7.93
	190616-GH	★	★	19.05	6.35	1.6	7.93
CNMG...-MW (Wiper) 	CNMG120408-MW	●	●	12.7	4.76	0.8	5.16
	120412-MW	●	●	12.7	4.76	1.2	5.16
CNMG...-SW (Wiper) 	CNMG120408-SW	□	□	12.7	4.76	0.8	5.16

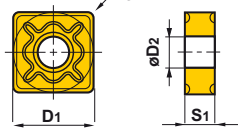
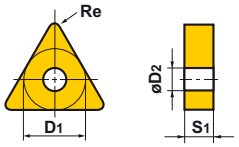
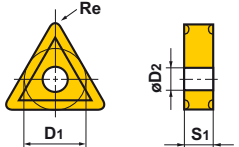
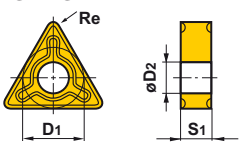
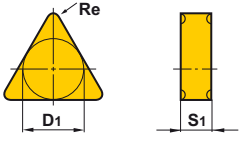
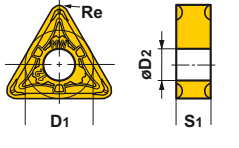
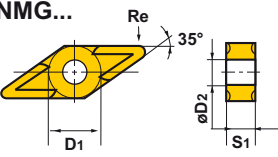
● : Lagerstandard ★ : Lagerstandard in Japan □ : Nicht Lagerstandard, Herstellung nur auf Anfrage

● Negative Wendeschneidplatten

Geometrie	Bestellbezeichnung	Lager		Abmessungen (mm)			
		UC5105	UC5115	D1	S1	Re	D2
	DNMA 150404	★	★	12.7	4.76	0.4	5.16
	150408	●	●	12.7	4.76	0.8	5.16
	150412	●	●	12.7	4.76	1.2	5.16
	150416	●	●	12.7	4.76	1.6	5.16
	150604	□	□	12.7	6.35	0.4	5.16
	150608	●	●	12.7	6.35	0.8	5.16
	150612	●	●	12.7	6.35	1.2	5.16
	DNMG 110408	●	●	9.525	4.76	0.8	3.81
	150404	●	●	12.7	4.76	0.4	5.16
	150408	●	●	12.7	4.76	0.8	5.16
	150412	●	●	12.7	4.76	1.2	5.16
	150604	□	●	12.7	6.35	0.4	5.16
	150608	★	●	12.7	6.35	0.8	5.16
	150612	●	●	12.7	6.35	1.2	5.16
	DNMG150408-GH	●	●	12.7	4.76	0.8	5.16
	150412-GH	●	●	12.7	4.76	1.2	5.16
	150608-GH	●	●	12.7	6.35	0.8	5.16
	150612-GH	●	●	12.7	6.35	1.2	5.16
	DNMG150608-MH	□	●	12.7	4.76	0.8	5.16
	DNMX150408-MW	●	●	12.7	4.76	0.8	5.16
	150412-MW	●	●	12.7	4.76	1.2	5.16
	150608-MW	●	●	12.7	6.35	0.8	5.16
	150612-MW	●	●	12.7	6.35	1.2	5.16
	SNMA090308	★	★	9.525	3.18	0.8	3.81
	120408	●	●	12.7	4.76	0.8	5.16
	120412	●	●	12.7	4.76	1.2	5.16
	120416	●	●	12.7	4.76	1.6	5.16
	150612	□	□	15.875	6.35	1.2	7.93
	190612	●	●	19.05	6.35	1.2	7.93
	190616	●	●	19.05	6.35	1.6	7.93
	SNMG120408	●	●	12.7	4.76	0.8	5.16
	120412	●	●	12.7	4.76	1.2	5.16
	120416	●	●	12.7	4.76	1.6	5.16
	150612	□	□	15.875	6.35	1.2	6.35
	190612	★	★	19.05	6.35	1.2	7.93
	190616	★	★	19.05	6.35	1.6	7.93
	SNMN120408	●	●	12.7	4.76	0.8	
	120412	●	●	12.7	4.76	1.2	
	120416	●	●	12.7	4.76	1.6	

UC5105/UC5115

● Negative Wendeschneidplatten

Geometrie	Bestellbezeichnung	Lager		Abmessungen (mm)			
		UC5105	UC5115	D1	S1	Re	D2
SNMG...-GH 	SNMG120408-GH	●	●	12.7	4.76	0.8	5.16
	120412-GH	●	●	12.7	4.76	1.2	5.16
TNMA... 	TNMA160404	●	●	9.525	4.76	0.4	3.81
	160408	●	●	9.525	4.76	0.8	3.81
	160412	●	●	9.525	4.76	1.2	3.81
	160416	●	●	9.525	4.76	1.6	3.81
	160420	★	★	9.525	4.76	2.0	3.81
	220408	●	●	12.7	4.76	0.8	5.16
	220412	●	●	12.7	4.76	1.2	5.16
TNMG... 	TNMG160404	●	●	9.525	4.76	0.4	3.81
	160408	●	●	9.525	4.76	0.8	3.81
	160412	●	●	9.525	4.76	1.2	3.81
	160416	★	★	9.525	4.76	1.6	3.81
	160420	★	★	9.525	4.76	2.0	3.81
	220408	●	●	12.7	4.76	0.8	5.16
	220412	●	●	12.7	4.76	1.2	5.16
TNMG...-GH 	TNMG160408-GH	●	●	9.525	4.76	0.8	3.81
	160412-GH	●	●	9.525	4.76	1.2	3.81
	220408-GH	●	●	12.7	4.76	0.8	5.16
	220412-GH	●	●	12.7	4.76	1.2	5.16
TNMN... 	TNMN160408	●	●	9.525	4.76	0.8	
	160412	●	●	9.525	4.76	1.2	
	160416	●	●	9.525	4.76	1.6	
	160420	★	★	9.525	4.76	2.0	
TNMX...-MW (Wiper) 	TNMX160408-MW	●	●	9.525	4.76	0.8	3.81
	160412-MW	●	●	9.525	4.76	1.2	3.81
VNMG... 	VNMG160404	●	●	9.525	4.76	0.4	3.81
	160408	●	●	9.525	4.76	0.8	3.81
	160412	★	★	9.525	4.76	1.2	3.81

● : Lagerstandard ★ : Lagerstandard in Japan □ : Nicht Lagerstandard, Herstellung nur auf Anfrage

● Negative Wendeschneidplatten

Geometrie	Bestellbezeichnung	Lager		Abmessungen (mm)				
		UC5105	UC5115	D1	S1	Re	D2	
WNMA... 	WNMA080404	●	●	12.7	4.76	0.4	5.16	
	080408	●	●	12.7	4.76	0.8	5.16	
	080412	●	●	12.7	4.76	1.2	5.16	
	080416	●	●	12.7	4.76	1.6	5.16	
WNMG... 	WNMG080404	□	□	12.7	4.76	0.4	5.16	
	080408	●	●	12.7	4.76	0.8	5.16	
	080412	●	●	12.7	4.76	1.2	5.16	
	080416	●	●	12.7	4.76	1.6	5.16	
WNMG...-GH 	WNMG080408-GH	●	●	12.7	4.76	0.8	5.16	
	080412-GH	●	●	12.7	4.76	1.2	5.16	
WNMG...-MW (Wiper) 	WNMG060408-MW	●	●	9.525	4.76	0.8	3.81	
	060412-MW	●	●	9.525	4.76	1.2	3.81	
	080408-MW	●	●	12.7	4.76	0.8	5.16	
	080412-MW	●	●	12.7	4.76	1.2	5.16	
WNMG...-MH 	WNMG080408-MH	□	□	12.7	4.76	0.8	5.16	
RNMA... 	RNMA120400			12.7	4.76	5.16	—	

UC5105/UC5115

● Positive Wendeschneidplatten

Geometrie	Bestellbezeichnung	Lager		Abmessungen (mm)			
		UC5105	UC5115	D1	S1	Re	D2
CCMW... 	CCMW060204	●	●	6.35	2.38	0.4	2.8
	09T304	●	●	9.525	3.97	0.4	4.4
	09T308	●	●	9.525	3.97	0.8	4.4
	120404	●	●	12.7	4.76	0.4	5.5
	120408	●	●	12.7	4.76	0.8	5.5
	120412	●	●	12.7	4.76	1.2	5.5
CCMT... 	CCMT09T304	●	●	9.525	3.97	0.4	4.4
	09T308	●	●	9.525	3.97	0.4	4.4
	120404	●	●	12.7	4.76	0.4	5.5
	120408	●	●	12.7	4.76	0.8	5.5
DCMW... 	DCMW070204	●	●	6.35	2.38	0.4	2.8
	11T304	●	●	9.525	3.97	0.4	4.4
	11T308	●	●	9.525	3.97	0.8	4.4
	150404	□	□	12.7	4.76	0.8	5.5
	150408	□	□	12.7	4.76	0.8	5.5
DCMT... 	DCMT070202	□	□	6.35	2.38	0.2	2.8
	11T304	●	●	9.525	3.97	0.4	4.4
	11T308	●	●	9.525	3.97	0.8	4.4
SCMW... 	SCMW09T304	●	●	9.525	3.97	0.4	4.4
	09T308	●	●	9.525	3.97	0.8	4.4
	120404	●	●	12.7	4.76	0.4	5.5
	120408	●	●	12.7	4.76	0.8	5.5
SCMT... 	SCMT09T308	□	□	9.525	3.97	0.8	4.4

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● Positive Wendeschneidplatten

Geometrie	Bestellbezeichnung	Lager		Abmessungen (mm)			
		UC5105	UC5115	D1	S1	Re	D2
	TCMW110204	●	●	6.35	2.38	0.4	2.8
	16T304	●	●	9.525	3.97	0.4	4.4
	16T308	●	●	9.525	3.97	0.8	4.4
	TPMN110304	●	●	6.35	3.18	0.4	—
	110308	●	●	6.35	3.18	0.8	—
	160304	●	●	9.525	3.18	0.4	—
	160308	●	●	9.525	3.18	0.8	—
	160312	□	●	9.525	3.18	1.2	—
	220408	□	□	12.7	4.76	0.8	—
	VCMT160404	●	●	9.525	4.76	0.4	4.4
	160408	●	●	9.525	4.76	0.8	4.4
	VCMW110304	●	●	6.35	3.18	0.4	2.8
	160404	●	●	9.525	4.76	0.4	4.4
	160408	●	●	9.525	4.76	0.8	4.4

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