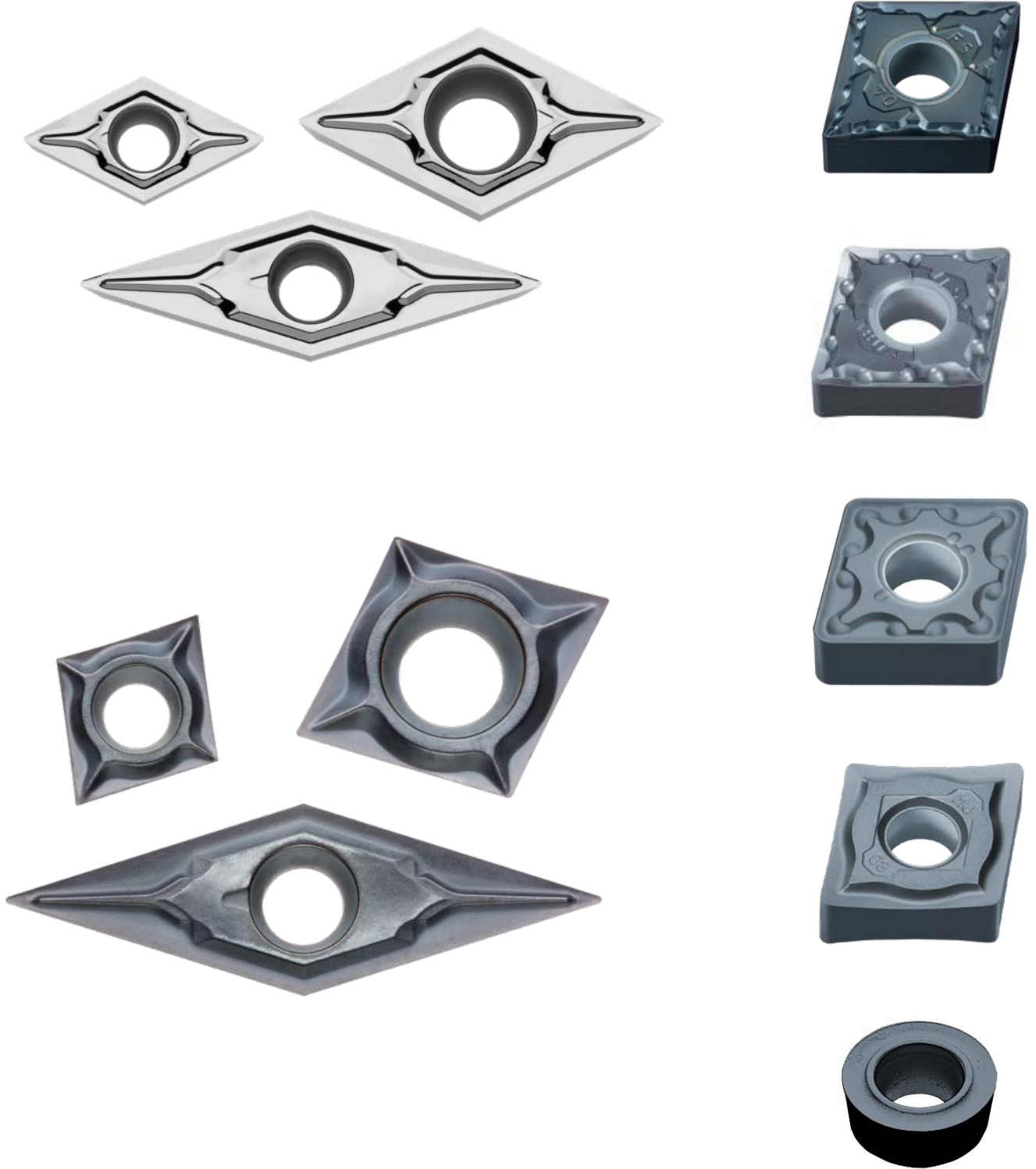


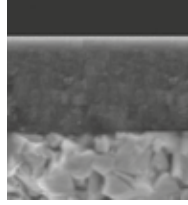
MP / MT9000

KESİLMESİ ZOR MALZEMELER İÇİN
ISO TORNALAMA KESİCİ UÇLARI



MP9005 / MP9015 / MP9025

PVD KAPLAMALI KALİTE

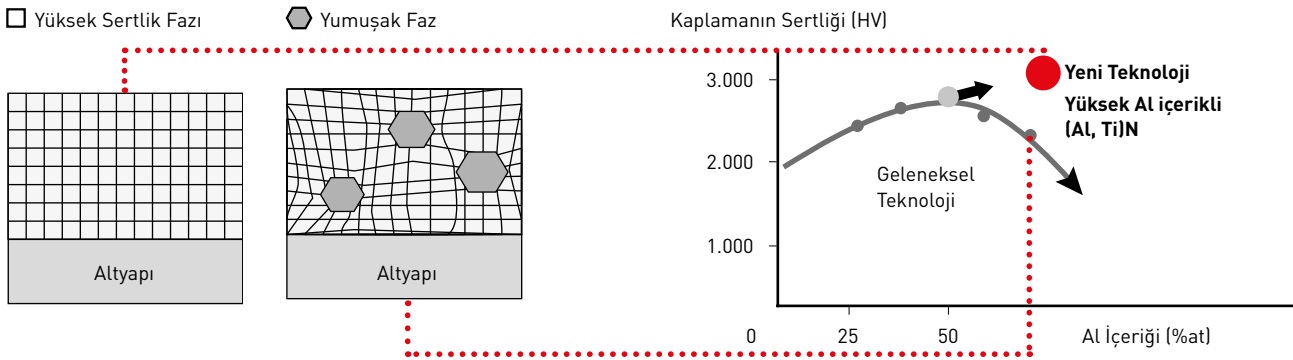


Yüksek Alüminyum İçerikli (Al,Ti)N Tek Katlı Kaplama Teknolojisi

Özel Sinterlenmiş Karbür Altyapı

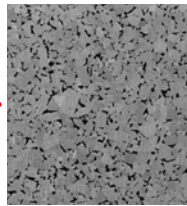
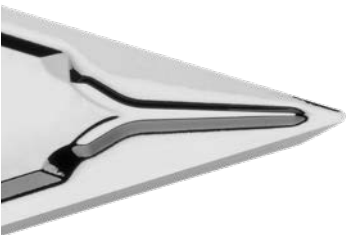
YÜKSEK AL. İÇERİĞİ – GELENEKSEL KAPLAMA KIYASLAMASI

Yeni teknoloji yüksek Al içerikli (Al, Ti)N kaplama, yüksek sertlik fazının stabilize edilmesini sağlar ve aşınma, krater oluşumu ve yapışma direncini büyük oranda artırır.



MT9005 / MT9015

KARBÜR KESİCİ (KAPLAMASIZ)



MT9015

ISO	Kalite	Görüş	Uygulama	
S	S05	MP9005/ MT9005	Aşınma direnci odaklı üstün kalite	Isıya Dirençli Alaşım Finiş Kesme - Orta kesme
		MP9015	Genel uygulamalar için ilk öneri	Isıya Dirençli Alaşım Orta Kesme - Kaba kesme
	S15	MP9025	Daha uzun dayanıklılık için hızlı hasarlanmayı engeller	Isıya Dayanaklı Alaşım Darbeli - Hafif - Kaba Kesme
		MT9015	Keskin kesme kenarlı yeni teknoloji ile sinterlenmiş karbür, mükemmel aşınma ve çatlak direnci	Titanyum Alaşımı Genel Kesme

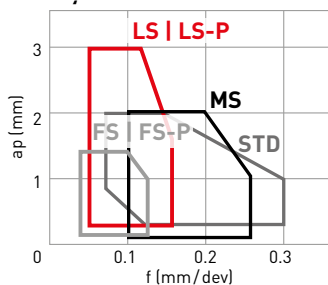
ISO	PVD	
S	S01	MP9005
	S10	MP9015
	S20	MP9025
	S30	MP9005
		MP9015

YENİ KIRICI SİSTEMİ

POZİTİF KESİCİ UÇLAR/HASSAS POZİTİF KESİCİ UÇLAR

Tolerans	Özellikler	Kesit Geometrisi
FINİŞ KESME İÇİN		
G	FS Pozitif Kesici Uçlar KESİLMESİ ZOR MALZEMELERİN FINİŞ İŞLEMİ İÇİN İLK TAVSİYE Isıya dirençli, titanyum ve kobalt krom alaşımları için idealdir. Keskin kesme kenarları mükemmel finiş yüzeyler ve geometrik tolerans sağlar. Kavisli kesme kenarları sayesinde son derece yeterli talaş atma olabilir.	Köşe 14° Dış Yan 9°
	FS-P Pozitif Kesici Uçlar TİTANYUM ALAŞIMLARININ FINİŞ İŞLEMİ İÇİN İLK TAVSİYE Titanyum ve bakır alaşımları için idealdir. Keskin kesme kenarları mükemmel finiş yüzey ve geometrik tolerans sağlar. Kavisli kesme kenarları sayesinde son derece yeterli talaş atma olabilir. Parlatılmış, ayna finiş kesici uç yüzeyi kaynak direncini artırır ve takım ömrünü uzatır.	Köşe 14° Dış Yan 9°
HAFİF KESME İÇİN		
M	LS Pozitif Kesici Uçlar/Hassas Pozitif Kesici Uçlar KESİLMESİ ZOR MALZEMELERİN HAFİF KESME İŞLEMLERİ İÇİN İLK TAVSİYE Isıya dirençli, titanyum ve kobalt krom alaşımları için idealdir. Düşükden orta seviyeye kadar kesme derinliklerinde mükemmel talaş kontrolü.	Köşe 18° Dış Yan 8°
	LS-P Pozitif Kesici Uçlar TİTANYUM ALAŞIMLARININ HAFİF KESME İŞLEMLERİ İÇİN İLK TAVSİYE Titanyum ve bakır alaşımları için idealdir. Düşükden orta seviyeye kadarkesme derinliklerinde mükemmel talaş kontrolü. Parlatılmış, ayna finiş kesici uç yüzeyi kaynak direncini artırır ve takım ömrünü uzatır.	Köşe 12° Dış Yan 6°
ORTA KESME İÇİN		
M	MS Hassas Pozitif Kesici Uçlar KESİLMESİ ZOR MALZEMELERİN ORTA KESME İŞLEMLERİ İÇİN İLK TAVSİYE Geniş talaş cebi, kesme direncindeki değişikliklerle başa çıkmakta ve büyük ölçüde değişen kesme derinliklerinde bile titreşimi ve talaş sıkışmasını azaltmaktadır.	Köşe 18° Dış Yan 18°
	STD Pozitif Kesici Uçlar KESİLMESİ ZOR MALZEMELERİN ORTA KESME İŞLEMLERİ İÇİN İLK TAVSİYE Düz yer ve büyük eğim açısı kombinasyonu sayesinde kenar kuvveti ve keskinliğinin dengesi gerçekleşir.	Köşe 15° Dış Yan 15°

TALAŞ KONTROL ARALIĞI



YENİ KIRICI SİSTEMİ – NEGATİF KESİCİ UÇLAR / HASSAS NEGATİF KESİCİ UÇLAR

Tolerans



Özellikler

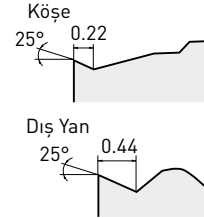
Kesit Geometrisi

FINİŞ KESME İÇİN

FS

NEW

Hassas Negatif Kesici Uçlar

KESİLMESİ ZOR MALZEMELERİN FINİŞ İŞLEMİ İÇİN İLK TAVSİYEÇok küçük kesme derinliklerinde bile mükemmel talaş kırma.
Büyük dalma açısı ve hassas kalite, mükemmel keskinlik sağlar.

HAFİF KESME

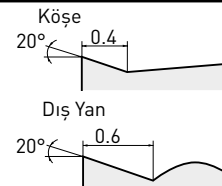
LS

NEW

Negatif Kesici Uçlar / Hassas Negatif Kesici Uçlar

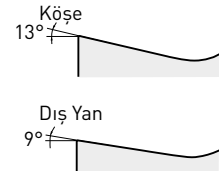
KESİLMESİ ZOR MALZEMELERİN HAFİF KESME İŞLEMLERİ İÇİN İLK TAVSİYEDİR

Radyus köşesinden daha küçük kesme derinlikleri için geliştirilmiş talaş atımı.



MJ

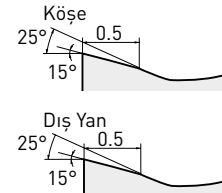
Negatif Kesici Uçlar

KESİLMESİ ZOR MALZEMELERİN HAFİF KESME İŞLEMLERİ İÇİN İLK TAVSİYEDİRÇift taraflı talaş kırıcı.
Isıya dirençli alaşım ve titanyum alaşım için idealdir.
Keskin kenar finiş kesmede iyi yüzey sağlar.
Eğimli kenar sorunsuz talaş boşaltımı sağlar.

ORTA KESME

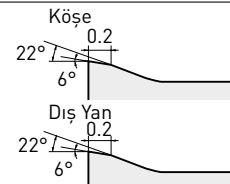
MS

Negatif Kesici Uçlar

YUMUŞAK ÇELİKLERİN , KESİLMESİ ZOR MALZEMELERİN HAFİF KESME İŞLEMLERİ VE PASLANMAZ ÇELİKLERİN ORTA KESME İŞLEMLERİ İÇİN İLK TAVSİYEDİRÇift taraflı talaş kırıcı.
Keskin kenar en iyi performansı verir.

MA

Negatif Kesici Uçlar

**ÇOK AMAÇLI TALAŞ KIRICI
KESİLMESİ ZOR MALZEMELERİN ORTA KESME İŞLEMLERİ İÇİN**Çift taraflı talaş kırıcı.
Pozitif zemin, keskinlik etkisi sağlar.

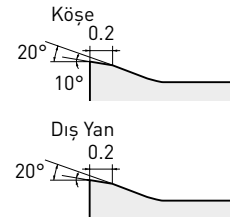
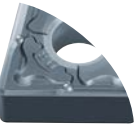
KABA KESEME

RS

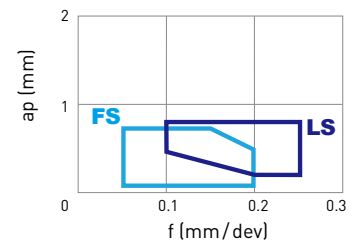
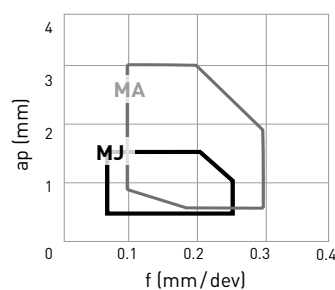
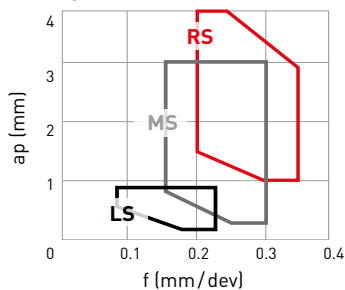
Negatif Kesici Uçlar

KESİLMESİ ZOR MALZEMELERİN KABA KESME İŞLEMLERİ İÇİN İLK TAVSİYEDİR

Düşük hızda kesme sırasında pozitif zemin kesme hattının derinliğinde talaş yapışmasını ve aşınmayı kontrol eder.



TALAŞ KONTROL ARALIĞI



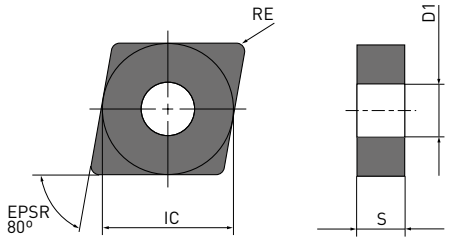
CNGG, DNGG

NEGATİF KESİCİ UÇLAR (DELİKLİ)

S

G Sınıfı

CNGG



TALAŞ KIRICI TANIMI

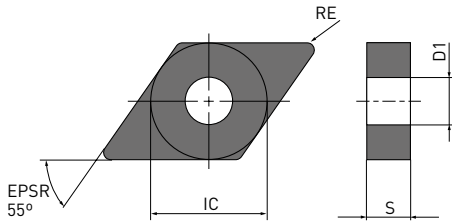
UYGULAMA



LS

FS

DNGG



Sipariş Numarası



MP9005

MP9015

MP9025

MT9015

IC

S

RE

D1

Sipariş Numarası		MP9005	MP9015	MP9025	MT9015	IC	S	RE	D1
CNGG1204V5-FS	F	●	●		★	12.7	4.76	0.05	5.16
CNGG120401-FS	F	●	●	●	★	12.7	4.76	0.1	5.16
CNGG120402-FS	F	●	●	●	★	12.7	4.76	0.2	5.16
CNGG120404-FS	F	●	●	●	★	12.7	4.76	0.4	5.16
CNGG120408-FS	F	●	●	●	★	12.7	4.76	0.8	5.16
CNGG120402-LS	L	●	●	●	★	12.7	4.76	0.2	5.16
CNGG120404-LS	L	●	●	●	★	12.7	4.76	0.4	5.16
CNGG120408-LS	L	●	●	●	★	12.7	4.76	0.8	5.16
DNGG150402-FS	F	●	●	●	★	12.7	4.76	0.2	5.16
DNGG150404-FS	F	●	●	●	★	12.7	4.76	0.4	5.16
DNGG150408-FS	F	●	●	●	★	12.7	4.76	0.8	5.16
DNGG150604-FS	F	●	●	●	★	12.7	6.35	0.4	5.16
DNGG150608-FS	F	●	●	●	★	12.7	6.35	0.8	5.16
DNGG150402-LS	L	●	●	●	★	12.7	4.76	0.2	5.16
DNGG150404-LS	L	●	●	●	★	12.7	4.76	0.4	5.16
DNGG150408-LS	L	●	●	●	★	12.7	4.76	0.8	5.16
DNGG150604-LS	L	●	●	●	★	12.7	6.35	0.4	5.16
DNGG150608-LS	L	●	●	●	★	12.7	6.35	0.8	5.16

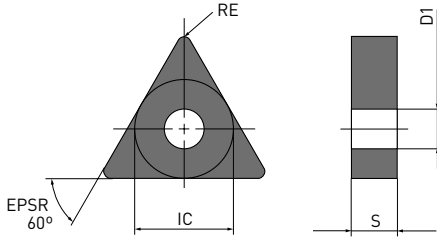
TNGG, VNGG

NEGATİF KESİCİ UÇLAR (DELİKLİ)

S

G Sınıfı

TNGG



TALAŞ KIRICI TANIMI

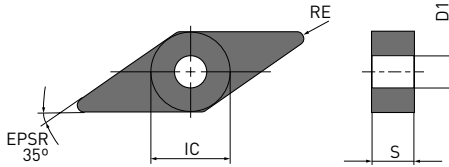
UYGULAMA



LS

FS

VNGG



Sipariş Numarası



MP9005

MP9015

MP9025

MT9015

IC

S

RE

D1

Sipariş Numarası		MP9005	MP9015	MP9025	MT9015	IC	S	RE	D1
TNGG160402-FS	F	●	●	●	★	9.525	4.76	0.2	3.81
TNGG160404-FS	F	●	●	●	★	9.525	4.76	0.4	3.81
TNGG160408-FS	F	●	●	●	★	9.525	4.76	0.8	3.81
TNGG160402-LS	L	●	●	●	★	9.525	4.76	0.2	3.81
TNGG160404-LS	L	●	●	●	★	9.525	4.76	0.4	3.81
TNGG160408-LS	L	●	●	●	★	9.525	4.76	0.8	3.81
VNGG1604V5-FS	F	●	●		★	9.525	4.76	0.05	3.81
VNGG160401-FS	F	●	●	●	★	9.525	4.76	0.1	3.81
VNGG160402-FS	F	●	●	●	★	9.525	4.76	0.2	3.81
VNGG160404-FS	F	●	●	●	★	9.525	4.76	0.4	3.81
VNGG160408-FS	F	●	●	●	★	9.525	4.76	0.8	3.81
VNGG160402-LS	L	●	●	●	★	9.525	4.76	0.2	3.81
VNGG160404-LS	L	●	●	●	★	9.525	4.76	0.4	3.81
VNGG160408-LS	L	●	●	●	★	9.525	4.76	0.8	3.81

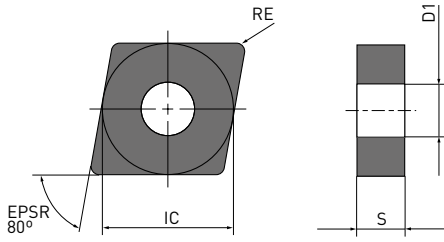
CNMG

NEGATİF KESİCİ UÇLAR (DELİKLİ)

S

M Sınıfı

CNMG



TALAŞ KIRICI TANIMI

UYGULAMA



LS

MA, MJ, MS

RS

Sipariş Numarası	L M		MP9005	MP9015	MP9025	MT9015	IC	S	RE	D1
	R									
CNMG090304-LS	L		●	●	●		9.525	3.18	0.4	3.81
CNMG090308-LS	L		●	●	●		9.525	3.18	0.8	3.81
CNMG120402-LS	L		●	●	●	●	12.7	4.76	0.2	5.16
CNMG120404-LS	L		●	●	●	●	12.7	4.76	0.4	5.16
CNMG120408-LS	L		●	●	●	●	12.7	4.76	0.8	5.16
CNMG090304-MS	M		●	●	●		9.525	3.18	0.4	3.81
CNMG090308-MS	M		●	●	●		9.525	3.18	0.8	3.81
CNMG120404-MS	M		●	●	●	●	12.7	4.76	0.4	5.16
CNMG120408-MS	M		●	●	●	●	12.7	4.76	0.8	5.16
CNMG120412-MS	M		●	●	●	●	12.7	4.76	1.2	5.16
CNMG160612-MS	M		★	★	●	★	15.875	6.35	1.2	6.35
CNMG160616-MS	M		★	★	●	★	15.875	6.35	1.6	6.35
CNMG120404-MA	M			●	●		12.7	4.76	0.4	5.16
CNMG120408-MA	M			●	●		12.7	4.76	0.8	5.16
CNMG120412-MA	M			●	●		12.7	4.76	1.2	5.16
CNMG120416-MA	M			●	●		12.7	4.76	1.6	5.16
CNMG120404-MJ	M		●	●			12.7	4.76	0.4	5.16
CNMG120408-MJ	M		●	●			12.7	4.76	0.8	5.16
CNMG120412-MJ	M		●	●			12.7	4.76	1.2	5.16
CNMG120416-MJ	M		●	●			12.7	4.76	1.6	5.16
CNMG120408-RS	R			●	●	●	12.7	4.76	0.8	5.16
CNMG120412-RS	R			●	●	●	12.7	4.76	1.2	5.16
CNMG120416-RS	R			●	●	★	12.7	4.76	1.6	5.16
CNMG160612-RS	R			●	●	★	15.875	6.35	1.2	6.35
CNMG160616-RS	R			●	●	★	15.875	6.35	1.6	6.35
CNMG190612-RS	R			●	●	★	19.05	6.35	1.2	7.93
CNMG190616-RS	R			●	●	★	19.05	6.35	1.6	7.93

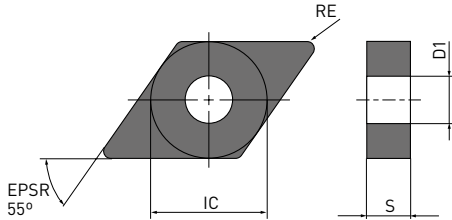
DNMG

NEGATİF KESİCİ UÇLAR (DELİKLİ)

S

M Sınıfı

DNMG



TALAŞ KIRICI TANIMI

UYGULAMA



LS

MA, MJ, MS

RS

Sipariş Numarası			MP9005	MP9015	MP9025	MT9015	IC	S	RE	D1
	L	M								
DNMG150402-LS	L		●	●	●	●	12.7	4.76	0.2	5.16
DNMG150404-LS	L		●	●	●	●	12.7	4.76	0.4	5.16
DNMG150408-LS	L		●	●	●	●	12.7	4.76	0.8	5.16
DNMG150604-LS	L		●	●	●	●	12.7	6.35	0.4	5.16
DNMG150608-LS	L		●	●	●	●	12.7	6.35	0.8	5.16
DNMG150404-MS	M		●	●	●	●	12.7	4.76	0.4	5.16
DNMG150408-MS	M		●	●	●	●	12.7	4.76	0.8	5.16
DNMG150412-MS	M		●	●	●	★	12.7	4.76	1.2	5.16
DNMG150604-MS	M		●	●	●	●	12.7	6.35	0.4	5.16
DNMG150608-MS	M		●	●	●	●	12.7	6.35	0.8	5.16
DNMG150612-MS	M		●	●	●	★	12.7	6.35	1.2	5.16
DNMG150404-MA	M			●	●		12.7	4.76	0.4	5.16
DNMG150408-MA	M			●	●		12.7	4.76	0.8	5.16
DNMG150412-MA	M			●	●		12.7	4.76	1.2	5.16
DNMG150604-MA	M			●	●		12.7	6.35	0.4	5.16
DNMG150608-MA	M			●	●		12.7	6.35	0.8	5.16
DNMG150612-MA	M			●	●		12.7	6.35	1.2	5.16
DNMG150404-MJ	M		●	●			12.7	4.76	0.4	5.16
DNMG150408-MJ	M		●	●			12.7	4.76	0.8	5.16
DNMG150412-MJ	M		●	●			12.7	4.76	1.2	5.16
DNMG150416-MJ	M		●	●			12.7	4.76	1.6	5.16
DNMG150604-MJ	M		●	●			12.7	6.35	0.4	5.16
DNMG150608-MJ	M		●	●			12.7	6.35	0.8	5.16
DNMG150612-MJ	M		●	●			12.7	6.35	1.2	5.16
DNMG150616-MJ	M		●	●			12.7	6.35	1.6	5.16
DNMG150408-RS	R			●	●	●	12.7	4.76	0.8	5.16
DNMG150412-RS	R			●	●	●	12.7	4.76	1.2	5.16
DNMG150416-RS	R			●	●	★	12.7	4.76	1.6	5.16
DNMG150608-RS	R			●	●	●	12.7	6.35	0.8	5.16
DNMG150612-RS	R			●	●	●	12.7	6.35	1.2	5.16
DNMG150616-RS	R			●	●	★	12.7	6.35	1.6	5.16

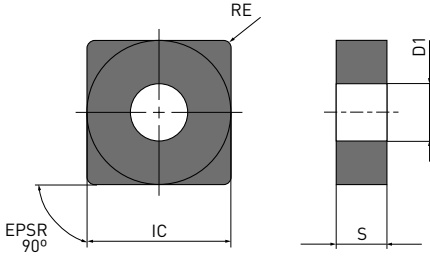
SNMG, TNMG

NEGATİF KESİCİ UÇLAR (DELİKLİ)

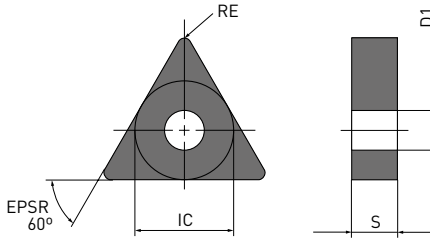
S

M Sınıfı

SNMG



TNMG



TALAŞ KIRICI TANIMI

UYGULAMA





LS

MA, MJ, MS

RS

Sipariş Numarası	L M		MP9005	MP9015	MP9025	MT9015	IC	S	RE	D1
	R									
SNMG120404-MS	M		●	●	●	●	12.7	4.76	0.4	5.16
SNMG120408-MS	M		●	●	●	●	12.7	4.76	0.8	5.16
SNMG120412-MS	M		●	●	●	★	12.7	4.76	1.2	5.16
SNMG150612-MS	M		★	★	●	★	15.875	6.35	1.2	6.35
SNMG150616-MS	M		★	★	●	★	15.875	6.35	1.6	6.35
SNMG190612-MS	M		●	●	●		19.05	6.35	1.2	7.93
SNMG120404-MA	M			●	●		12.7	4.76	0.4	5.16
SNMG120408-MA	M			●	●		12.7	4.76	0.8	5.16
SNMG120412-MA	M			●	●		12.7	4.76	1.2	5.16
SNMG120416-MA	M			●	●		12.7	4.76	1.6	5.16
SNMG120408-RS	R			●	●	●	12.7	4.76	0.8	5.16
SNMG120412-RS	R			●	●	●	12.7	4.76	1.2	5.16
SNMG120416-RS	R			●	●	★	12.7	4.76	1.6	5.16
SNMG150616-RS	R			★	●	★	15.875	6.35	1.6	6.35
SNMG190612-RS	R			●	●		19.05	6.35	1.2	7.93
SNMG190616-RS	R			★	●	★	19.05	6.35	1.6	7.93

SNMG, TNMG – NEGATİF KESİCİ UÇLAR (DELİKLİ)

Sipariş Numarası			MP9005	MP9015	MP9025	MT9015	IC	S	RE	D1
										
TNMG160402-LS	L		●	●	●	●	9.525	4.76	0.2	3.81
TNMG160404-LS	L		●	●	●	●	9.525	4.76	0.4	3.81
TNMG160408-LS	L		●	●	●	●	9.525	4.76	0.8	3.81
TNMG160404-MS	M		●	●	●	●	9.525	4.76	0.4	3.81
TNMG160408-MS	M		●	●	●	●	9.525	4.76	0.8	3.81
TNMG160412-MS	M		●	●	●	★	9.525	4.76	1.2	3.81
TNMG220408-MS	M		●	●	●	★	12.7	4.76	0.8	5.16
TNMG220412-MS	M		●	●	●	★	12.7	4.76	1.2	5.16
TNMG160404-MA	M			●	●		9.525	4.76	0.4	3.81
TNMG160408-MA	M			●	●		9.525	4.76	0.8	3.81
TNMG160412-MA	M			●	●		9.525	4.76	1.2	3.81
TNMG220408-MA	M			●	●		12.7	4.76	0.8	5.16
TNMG220412-MA	M			●	●		12.7	4.76	1.2	5.16
TNMG220416-MA	M			●	●		12.7	4.76	1.6	5.16
TNMG270616-MA	M			●	●		15.875	6.35	1.6	6.35
TNMG330924-MA	M			●	●		19.05	9.52	2.4	7.93
TNMG160404-MJ	M		●	●			9.525	4.76	0.4	3.81
TNMG160408-MJ	M		●	●			9.525	4.76	0.8	3.81
TNMG160412-MJ	M		●	●			9.525	4.76	1.2	3.81
TNMG160408-RS	R			●	●	●	9.525	4.76	0.8	3.81
TNMG160412-RS	R			●	●	●	9.525	4.76	1.2	3.81
TNMG220408-RS	R			●	●	★	12.7	4.76	0.8	5.16
TNMG220412-RS	R			●	●	★	12.7	4.76	1.2	5.16

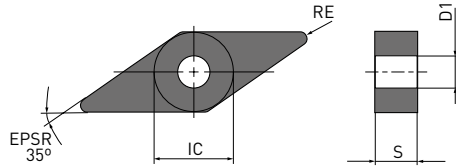
VNMG, WNMG

NEGATİF KESİCİ UÇLAR (DELİKLİ)

S

M Sınıfı

VNMG



TALAŞ KIRICI TANIMI

UYGULAMA

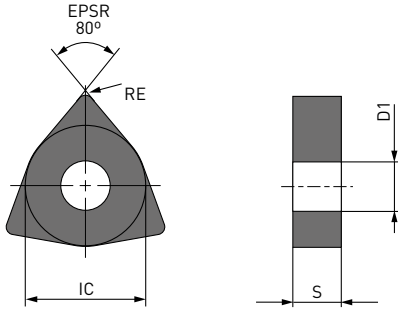


LS

MA, MJ, MS

RS



WNMG



Sipariş Numarası	L M		MP9005	MP9015	MP9025	MT9015	IC	S	RE	D1
	R									
VNMG160402-LS	L		●	●	●	●	9.525	4.76	0.2	3.81
VNMG160404-LS	L		●	●	●	●	9.525	4.76	0.4	3.81
VNMG160408-LS	L		●	●	●	●	9.525	4.76	0.8	3.81
VNMG160404-MS	M		●	●	●	●	9.525	4.76	0.4	3.81
VNMG160408-MS	M		●	●	●	●	9.525	4.76	0.8	3.81
VNMG160404-MJ	M		●	●			9.525	4.76	0.4	3.81
VNMG160408-MJ	M		●	●			9.525	4.76	0.8	3.81
VNMG160412-MJ	M		●	●			9.525	4.76	1.2	3.81

13

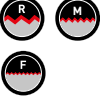

VNMG, WNMG - NEGATİF KESİCİ UÇLAR (DELİKLİ)

Sipariş Numarası			MP9005	MP9015	MP9025	MT9015	IC	S	RE	D1
										
WNMG080402-LS	L		●	●	●	●	12.7	4.76	0.2	5.16
WNMG080404-LS	L		●	●	●	●	12.7	4.76	0.4	5.16
WNMG080408-LS	L		●	●	●	●	12.7	4.76	0.8	5.16
WNMG080404-MS	M		●	●	●	●	12.7	4.76	0.4	5.16
WNMG080408-MS	M		●	●	●	●	12.7	4.76	0.8	5.16
WNMG080412-MS	M		●	●	●	★	12.7	4.76	1.2	5.16
WNMG080404-MA	M			●	●		12.7	4.76	0.4	5.16
WNMG080408-MA	M			●	●		12.7	4.76	0.8	5.16
WNMG080412-MA	M			●	●		12.7	4.76	1.2	5.16
WNMG080416-MA	M			●	●		12.7	4.76	1.6	5.16
WNMG080408-MJ	M		●	●			12.7	4.76	0.8	5.16
WNMG080412-MJ	M		●	●			12.7	4.76	1.2	5.16
WNMG080416-MJ	M		●	●			12.7	4.76	1.6	5.16
WNMG080408-RS	R			●	●	●	12.7	4.76	0.8	5.16
WNMG080412-RS	R			●	●	●	12.7	4.76	1.2	5.16
WNMG080416-RS	R			●	●	★	12.7	4.76	1.6	5.16
WNMG100612-RS	R			●	●	★	15.875	6.35	1.2	6.35

MP / MT9000

ÖNERİLEN KESME KOŞULLARI



NEGATİF KESİCİ UÇLAR

Malzeme	Koşullar			Kalite	Vc	f	ap
M Çökeltme ile Sertleştirilmiş Paslanmaz Çelikler (DIN X5CrNiCuNb17-4)	●	L	LS	MP9005	125 – 175	0.10 – 0.25	0.2 – 0.8
		M	MS	MP9005	115 – 160	0.10 – 0.25	0.5 – 4.0
		R	RS	MP9015	105 – 150	0.20 – 0.35	1.0 – 4.0
	●	L	LS	MP9015	120 – 165	0.10 – 0.25	0.2 – 0.8
		M	MS	MP9015	110 – 150	0.10 – 0.25	0.5 – 4.0
		R	RS	MP9015	100 – 140	0.20 – 0.35	1.0 – 4.0
	✚	L	LS	MP9025	80 – 95	0.10 – 0.25	0.2 – 0.8
		M	MS	MP9025	75 – 90	0.16 – 0.50	0.5 – 4.0
		R	RS	MP9025	70 – 85	0.20 – 0.35	1.0 – 4.0
Titanium Alaşımı (Ti-6Al-4V)	●	L	LS	MT9015	40 – 85	0.10 – 0.25	0.2 – 0.8
		M	MS	MT9015	40 – 80	0.10 – 0.25	0.5 – 4.0
		R	RS	MT9015	35 – 75	0.20 – 0.35	1.0 – 4.0
	●	L	LS	MT9015	40 – 85	0.10 – 0.25	0.2 – 0.8
		M	MS	MT9015	40 – 80	0.10 – 0.25	0.5 – 4.0
		R	RS	MT9015	35 – 75	0.20 – 0.35	1.0 – 4.0
S Nikel Bazlı Isıya Dirençli Alaşım (Inconel®718, Hastelloy®, WSPALOY®) Kobalt Bazlı Alaşım (Tribaloy®, Stellite®)	●	L	LS	MP9005	30 – 110	0.10 – 0.25	0.2 – 0.8
		M	MS	MP9005	30 – 100	0.10 – 0.25	0.5 – 4.0
		R	RS	MP9015	20 – 75	0.20 – 0.35	1.0 – 4.0
	●	L	LS	MP9015	25 – 85	0.10 – 0.25	0.2 – 0.8
		M	MS	MP9015	25 – 80	0.10 – 0.25	0.5 – 4.0
		R	RS	MP9015	20 – 75	0.20 – 0.35	1.0 – 4.0
	✚	L	LS	MP9025	20 – 30	0.10 – 0.25	0.2 – 0.8
		M	MS	MP9025	20 – 30	0.10 – 0.25	0.5 – 4.0
		R	RS	MP9025	20 – 30	0.20 – 0.35	1.0 – 4.0

1. Kesme koşullarının dengesiz olması durumunda, lütfen sayfa 4 te önerilen talaş kırıcı ve kalitelere bakınız.
2. Delik barası serbest boy uzunluğuna bağlı olarak kesme koşulları delik işleme sırasında farklılık göstereceğinden, her bir delik barası için önerilen koşulları doğrulayınız.
3. MC7015, MC7025 ve MP7035 kaliteleri çökeltme ile sertleştirilmiş paslanmaz çelikler için de önerilir.

NEW

HASSAS NEGATİF UÇLAR

Malzeme	Koşullar			Kalite	Vc	f	ap
Titanium Alaşımı (Ti-6Al-4V)	●	F	FS	MT9015	45 – 95	0.05 – 0.20	0.1 – 0.7
		L	LS	MT9015	40 – 85	0.10 – 0.25	0.2 – 0.8
	●	F	FS	MT9015	45 – 95	0.05 – 0.20	0.1 – 0.7
		L	LS	MT9015	40 – 85	0.10 – 0.25	0.2 – 0.8
	✚	F	FS	MT9015	45 – 95	0.05 – 0.20	0.1 – 0.7
		L	LS	MT9015	40 – 85	0.10 – 0.25	0.2 – 0.8
S Nikel Bazlı Isıya Dirençli Alaşım (Inconel®718, Hastelloy®, WSPALOY®) Kobalt Bazlı Alaşım (Tribaloy®, Stellite®)	●	F	FS	MP9005	60 – 120	0.05 – 0.20	0.1 – 0.7
		L	LS	MP9005	55 – 110	0.10 – 0.25	0.2 – 0.8
	●	F	FS	MP9015	45 – 95	0.05 – 0.20	0.1 – 0.7
		L	LS	MP9015	40 – 85	0.10 – 0.25	0.2 – 0.8
	✚	F	FS	MP9025	35 – 50	0.05 – 0.20	0.1 – 0.7
		L	LS	MP9025	30 – 45	0.10 – 0.25	0.2 – 0.8

Kesme Koşulları: ●: Stabil Kesme ●: Genel Kesme ✚: Stabil Olmayan Kesme

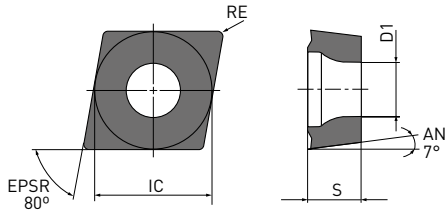
CCMT, DCMT, SCMT

7° POZİTİF KESİCİ UÇLAR (DELİKLİ)

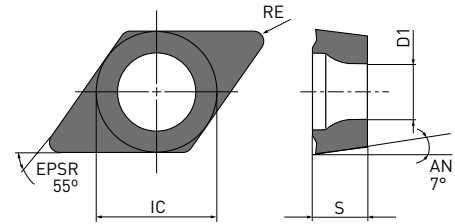
S

M Sınıfı

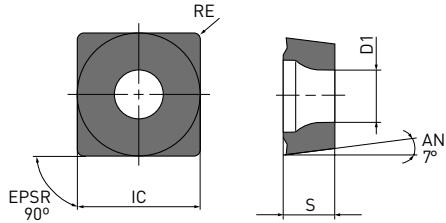
CCMT



DCMT



SCMT





TALAŞ KIRICI TANIMI

UYGULAMA





LS

MS

Sipariş Numarası	 	MP9005	MP9015	MP9025	MT9005	IC	S	RE	D1
CCMT060202-LS	L	●	●	●	●	6.35	2.38	0.2	2.8
CCMT060204-LS	L	●	●	●	●	6.35	2.38	0.4	2.8
CCMT060202-MS	M	●	●	●	●	6.35	2.38	0.2	2.8
CCMT060204-MS	M	●	●	●	●	6.35	2.38	0.4	2.8
CCMT060208-MS	M	●	●	●	●	6.35	2.38	0.8	2.8
CCMT09T302-LS	L	●	●	●	●	9.525	3.97	0.2	4.4
CCMT09T304-LS	L	●	●	●	●	9.525	3.97	0.4	4.4
CCMT09T308-LS	L	●	●	●	●	9.525	3.97	0.8	4.4
CCMT09T302-MS	M	●	●	●	●	9.525	3.97	0.2	4.4
CCMT09T304-MS	M	●	●	●	●	9.525	3.97	0.4	4.4
CCMT09T308-MS	M	●	●	●	●	9.525	3.97	0.8	4.4
CCMT120404-MS	M	●	●	●	●	12.7	4.76	0.4	5.5
CCMT120408-MS	M	●	●	●	●	12.7	4.76	0.8	5.5
CCMT120412-MS	M	●	●	●	●	12.7	4.76	1.2	5.5

CCMT, DCMT, SCMT - 7° POZİTİF KESİCİ UÇLAR (DELİKLİ)

Sipariş Numarası	 	MP9005	MP9015	MP9025	MT9005	IC	S	RE	D1
DCMT070202-LS	L	●	●	●	●	6.35	2.38	0.2	2.8
DCMT070204-LS	L	●	●	●	●	6.35	2.38	0.4	2.8
DCMT11T302-LS	L	●	●	●	●	9.525	3.97	0.2	4.4
DCMT11T304-LS	L	●	●	●	●	9.525	3.97	0.4	4.4
DCMT11T308-LS	L	●	●	●	●	9.525	3.97	0.8	4.4
DCMT11T312-MS	M	●	●	●	●	9.525	3.97	1.2	4.4
DCMT070204-MS	M	●	●	●	●	6.35	2.38	0.4	2.8
DCMT070208-MS	M	●	●	●	●	6.35	2.38	0.8	2.8
DCMT11T304-MS	M	●	●	●	●	9.525	3.97	0.4	4.4
DCMT11T308-MS	M	●	●	●	●	9.525	3.97	0.8	4.4
SCMT09T304-MS	M	●	●	●	●	9.525	3.97	0.4	4.4
SCMT09T308-MS	M	●	●	●	●	9.525	3.97	0.8	4.4
SCMT120404-MS	M	●	●	●	●	12.7	4.76	0.4	5.5
SCMT120408-MS	M	●	●	●	●	12.7	4.76	0.8	5.5
SCMT120412-MS	M	●	●	●	●	12.7	4.76	1.2	5.5

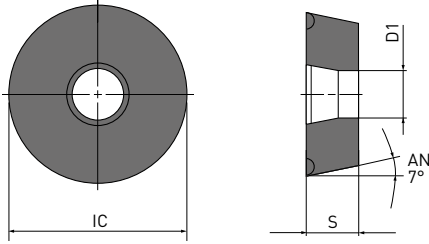
RCMT

7° POZİTİF KESİCİ UÇLAR (DELİKLİ)

S

M Sınıfı

RCMT




TALAŞ KIRICI TANIMI

UYGULAMA



STD

Sipariş Numarası		MP9005	MP9015	MP9025	MT9005	MT9015	IC	S	RE	D1
RCMT0602M0	M	●	●	●	●	●	6	2.38	-	2.8
RCMT0803M0	M	●	●	●	●	●	8	3.18	-	3.4
RCMT10T3M0	M	●	●	●	●	●	10	3.97	-	4.4
RCMT1204M0	M	●	●	●	●	●	12	4.76	-	4.4
RCMT1606M0	M	●	●	●	●	●	16	6.35	-	5.5

23 

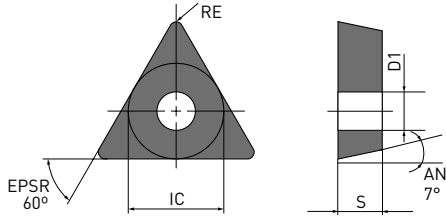
TCMT, VBMT, VCMT

5°/7° POZİTİF KESİCİ UÇLAR (DELİKLİ)

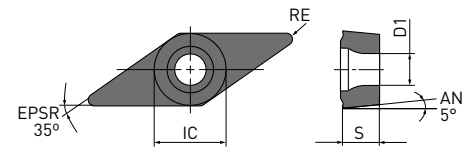
S

M Sınıfı

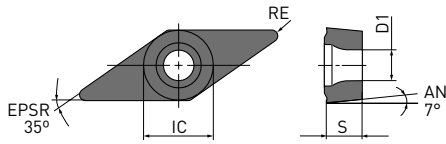
TCMT



VBMT



VCMT





TALAŞ KIRICI TANIMI

UYGULAMA





LS

MS

Sipariş Numarası	 	MP9005	MP9015	MP9025	MT9005	IC	S	RE	D1
TCMT090202-LS	L	●	●	●	●	5.56	2.38	0.2	2.5
TCMT090204-MS	M	●	●	●	●	5.56	2.38	0.4	2.5
TCMT090208-MS	M	●	●	●	●	5.56	2.38	0.8	2.5
TCMT110202-LS	L	●	●	●	●	6.35	2.38	0.2	2.8
TCMT110204-MS	M	●	●	●	●	6.35	2.38	0.4	2.8
TCMT110208-MS	M	●	●	●	●	6.35	2.38	0.8	2.8
TCMT16T304-MS	M	●	●	●	●	9.525	3.97	0.4	4.4
TCMT16T308-MS	M	●	●	●	●	9.525	3.97	0.8	4.4
TCMT16T312-MS	M	●	●	●	●	9.525	3.97	1.2	4.4
VBMT110302-LS	L	●	●	●	●	6.35	3.18	0.2	2.85
VBMT110304-LS	L	●	●	●	●	6.35	3.18	0.4	2.85
VBMT110308-LS	L	●	●	●	●	6.35	3.18	0.8	2.85
VBMT160404-LS	L	●	●	●	●	9.525	4.76	0.4	4.4
VBMT160408-LS	L	●	●	●	●	9.525	4.76	0.8	4.4
VBMT160402-MS	M	●	●	●	●	9.525	4.76	0.2	4.43
VBMT160404-MS	M	●	●	●	●	9.525	4.76	0.4	4.4
VBMT160408-MS	M	●	●	●	●	9.525	4.76	0.8	4.4
VBMT160412-MS	M	●	●	●	●	9.525	4.76	1.2	4.43

TCMT, VBMT, VCMT - 5°/7° POZİTİF KESİCİ UÇLAR (DELİKLİ)

Sipariş Numarası	 	MP9005	MP9015	MP9025	MT9005	IC	S	RE	D1
VCMT110302-LS	L	●	●	●	●	6.35	3.18	0.2	2.8
VCMT110304-LS	L	●	●	●	●	6.35	3.18	0.4	2.8
VCMT110302-MS	M	●	●	●	●	6.35	3.18	0.2	2.8
VCMT110304-MS	M	●	●	●	●	6.35	3.18	0.4	2.8
VCMT110308-MS	M	●	●	●	●	6.35	3.18	0.8	2.8
VCMT160404-LS	L	●	●	●	●	9.525	4.76	0.4	4.4
VCMT160408-LS	L	●	●	●	●	9.525	4.76	0.8	4.4
VCMT160404-MS	M	●	●	●	●	9.525	4.76	0.4	4.4
VCMT160408-MS	M	●	●	●	●	9.525	4.76	0.8	4.4

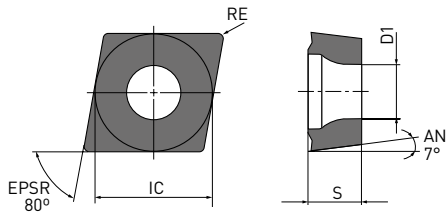
CCGT, DCGT, VCGT

7° HASSAS POZİTİF KESİCİ UÇLAR EKSİ TOLERANS (DELİKLİ)

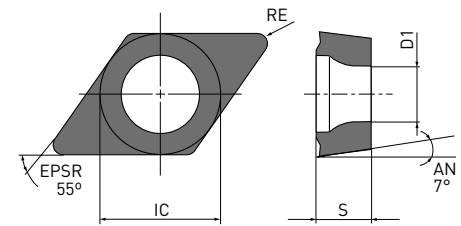
S

G Sınıfı

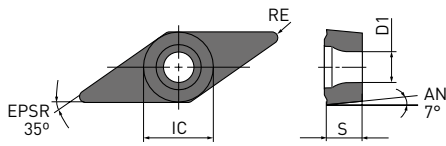
CCGT



DCGT



VCGT





TALAŞ KIRICI TANIMI

UYGULAMA




FS

LS

Sipariş Numarası	 	MP9005	MP9015	MP9025	IC	S	RE	D1
CCGT060201M-FS	F	●	●	●	6.35	2.38	0.08	2.8
CCGT060201M-LS	L	●	●	●	6.35	2.38	0.08	2.8
CCGT060202M-FS	F	●	●	●	6.35	2.38	0.18	2.8
CCGT060202M-LS	L	●	●	●	6.35	2.38	0.18	2.8
CCGT09T301M-FS	F	●	●	●	9.525	3.97	0.08	4.4
CCGT09T301M-LS	L	●	●	●	9.525	3.97	0.08	4.4
CCGT09T302M-FS	F	●	●	●	9.525	3.97	0.18	4.4
CCGT09T302M-LS	L	●	●	●	9.525	3.97	0.18	4.4
CCGT09T304M-FS	F	●	●	●	9.525	3.97	0.38	4.4
CCGT09T304M-LS	L	●	●	●	9.525	3.97	0.38	4.4

CCGT, DCGT, VCGT - 7° HASSAS POZİTİF KESİCİ UÇLAR EKŞİ TOLERANS (DELİKLİ)

Sipariş Numarası		MP9005	MP9015	MP9025	IC	S	RE	D1
DCGT070201M-FS	F	●	●	●	6.35	2.38	0.08	2.8
DCGT070201M-LS	L	●	●	●	6.35	2.38	0.08	2.8
DCGT070202M-FS	F	●	●	●	6.35	2.38	0.18	2.8
DCGT070202M-LS	L	●	●	●	6.35	2.38	0.18	2.8
DCGT070204M-FS	F	●	●	●	6.35	2.38	0.38	2.8
DCGT070204M-LS	L	●	●	●	6.35	2.38	0.38	2.8
DCGT11T301M-FS	F	●	●	●	9.525	3.97	0.08	4.4
DCGT11T301M-LS	L	●	●	●	9.525	3.97	0.08	4.4
DCGT11T302M-FS	F	●	●	●	9.525	3.97	0.18	4.4
DCGT11T302M-LS	L	●	●	●	9.525	3.97	0.18	4.4
DCGT11T304M-FS	F	●	●	●	9.525	3.97	0.38	4.4
DCGT11T304M-LS	L	●	●	●	9.525	3.97	0.38	4.4
VCGT110301M-LS	L	●	●	●	6.35	3.18	0.08	2.8
VCGT110302M-LS	L	●	●	●	6.35	3.18	0.18	2.8
VCGT110304M-LS	L	●	●	●	6.35	3.18	0.38	2.8
VCGT130301M-LS	L	●	●	●	7.94	3.18	0.08	3.4
VCGT130302M-LS	L	●	●	●	7.94	3.18	0.18	3.4
VCGT130304M-LS	L	●	●	●	7.94	3.18	0.38	3.4

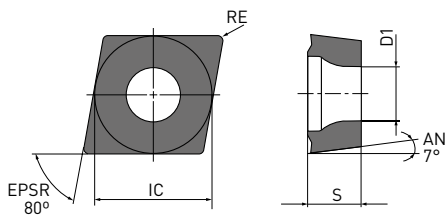
CCGT, DCGT, VCGT

7° HASSAS POZİTİF KESİCİ UÇLAR EKSİ TOLERANS / CİLALI (DELİKLİ)

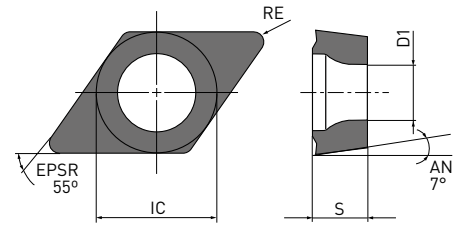
S

G Sınıfı

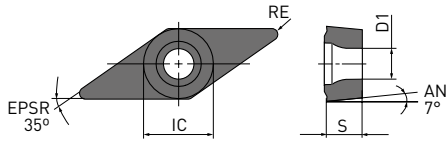
CCGT



DCGT



VCGT





TALAŞ KIRICI TANIMI

UYGULAMA




FS-P

LS-P

Sipariş Numarası	 	MT9005	IC	S	RE	D1
CCGT060201M-FS-P	F	●	6.35	2.38	0.08	2.8
CCGT060202M-FS-P	F	●	6.35	2.38	0.18	2.8
CCGT09T301M-FS-P	F	●	9.525	3.97	0.08	4.4
CCGT09T302M-FS-P	F	●	9.525	3.97	0.18	4.4
CCGT09T304M-FS-P	F	●	9.525	3.97	0.38	4.4
DCGT070201M-FS-P	F	●	6.35	2.38	0.08	2.8
DCGT070202M-FS-P	F	●	6.35	2.38	0.18	2.8
DCGT070204M-FS-P	F	●	6.35	2.38	0.38	2.8
DCGT11T301M-FS-P	F	●	9.525	3.97	0.08	4.4
DCGT11T302M-FS-P	F	●	9.525	3.97	0.18	4.4
DCGT11T304M-FS-P	F	●	9.525	3.97	0.38	4.4

CCGT, DCGT, VCGT - 7° HASSAS POZİTİF KESİCİ UÇLAR EKŞİ TOLERANS / CİLALİ (DELİKLİ)

Sipariş Numarası		MT9005	IC	S	RE	D1
CCGT060201M-LS-P	L	●	6.35	2.38	0.08	2.8
CCGT060202M-LS-P	L	●	6.35	2.38	0.18	2.8
CCGT09T301M-LS-P	L	●	9.525	3.97	0.08	4.4
CCGT09T302M-LS-P	L	●	9.525	3.97	0.18	4.4
CCGT09T304M-LS-P	L	●	9.525	3.97	0.38	4.4
DCGT070201M-LS-P	L	●	6.35	2.38	0.08	2.8
DCGT070202M-LS-P	L	●	6.35	2.38	0.18	2.8
DCGT070204M-LS-P	L	●	6.35	2.38	0.38	2.8
DCGT11T301M-LS-P	L	●	9.525	3.97	0.08	4.4
DCGT11T302M-LS-P	L	●	9.525	3.97	0.18	4.4
DCGT11T304M-LS-P	L	●	9.525	3.97	0.38	4.4
VCGT110301M-LS-P	L	●	6.35	3.18	0.08	2.8
VCGT110302M-LS-P	L	●	6.35	3.18	0.18	2.8
VCGT110304M-LS-P	L	●	6.35	3.18	0.38	2.8
VCGT130301M-LS-P	L	●	7.94	3.18	0.08	3.4
VCGT130302M-LS-P	L	●	7.94	3.18	0.18	3.4
VCGT130304M-LS-P	L	●	7.94	3.18	0.38	3.4



1. FS-P/LS-P: Daha iyi talaş tahliyesi için parlatılmış talaş kırıcı



MP / MT9000

ÖNERİLEN KESME KOŞULLARI



HASSAS POZİTİF KESİCİ UÇLAR

Malzeme	Koşullar			Kalite	Vc	f	ap
M Çökeltme ile Sertleştirilmiş Paslanmaz Çelikler (DIN X5CrNiCuNb17-4)	●	F	FS	MP9005	40-80	0.04-0.10	0.2-1.4
		L	LS	MP9005	40-80	0.04-0.15	0.3-2.0
	●	F	FS	MP9015	40-80	0.04-0.10	0.2-1.4
		L	LS	MP9015	40-80	0.04-0.15	0.3-2.0
	✚	L	LS	MP9015	30-60	0.04-0.10	0.3-1.0
S Titanyum Alaşımı (Ti-6Al-4V) Kobalt Krom Alaşımları (Co-Cr-Mo Alaşımları) Çökeltim Sertleştirmeli Paslanmaz Çelikler (X5CrNiCuNb17-4) Nikel Bazlı Isıya Dirençli Alaşım (Inconel®718, Hastelloy®, Waspaloy®)	●	F	FS-P	MT9005	40-80	0.04-0.12	0.2-1.4
		L	LS-P	MT9005	40-80	0.04-0.20	0.3-3.0
	●	F	FS-P	MT9005	40-80	0.04-0.12	0.2-1.4
		L	LS-P	MT9005	40-80	0.04-0.12	0.3-2.0
	✚	L	LS-P	MT9005	30-60	0.04-0.10	0.2-1.4
		F	FS	MP9005	40-80	0.04-0.10	0.2-1.4
	●	L	LS	MP9005	40-80	0.04-0.15	0.2-2.0
		F	FS	MP9015	40-80	0.04-0.10	0.2-1.4
	●	L	LS	MP9015	40-80	0.04-0.15	0.3-2.0
		✚	L	LS	MP9015	30-60	0.04-0.10
●	F	FS	MP9015	25-95	0.04-0.12	0.2-1.4	
	L	LS	MP9015	25-95	0.04-0.12	0.3-2.0	
●	F	FS	MP9015	20-75	0.04-0.12	0.2-1.4	
	L	LS	MP9015	20-75	0.04-0.12	0.3-2.0	
✚	L	LS	MP9015	20-60	0.04-0.10	0.3-1.0	

1. İç çap işleme için kesme koşulları takım serbest boyuna bağlı olarak değiştiğinden, her bir delik takımı için tavsiye edilen koşulları kontrol edin.

POZİTİF KESİCİ UÇLAR

Kesme Koşulları : ●: Stabil Kesme ●: Genel Kesme ✚: Stabil Olmayan Kesme

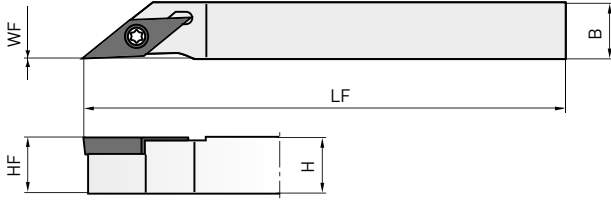
Malzeme	Koşullar			Kalite	Vc	f	ap
M Çökeltme ile Sertleştirilmiş Paslanmaz Çelikler (DIN X5CrNiCuNb17-4)	●	L	LS	MP9015	105-140	0.06-0.20	0.2-1.0
		M	MS	MP9015	85-120	0.08-0.25	0.3-2.0
	●	L	LS	MP9015	105-140	0.06-0.20	0.2-1.0
		M	MS	MP9015	85-120	0.08-0.25	0.3-2.0
	✚	L	LS	MP9025	70- 80	0.06-0.20	0.2-1.0
S Titanyum Alaşımı (Ti-6Al-4V) Nikel Bazlı Isıya Dirençli Alaşım (Inconel®718, Hastelloy®, Waspaloy®)	●	L	LS	MT9005	40- 80	0.06-0.20	0.2-1.0
		M	MS	MT9005	35- 65	0.08-0.25	0.3-2.0
	●	L	LS	MT9005	40- 80	0.06-0.20	0.2-1.0
		M	MS	MT9005	35- 65	0.08-0.25	0.3-2.0
	✚	L	LS	MT9005	40- 80	0.06-0.20	0.2-1.0
		M	MS	MT9005	35- 65	0.08-0.25	0.3-2.0
	●	L	LS	MP9005	25- 95	0.06-0.20	0.2-1.0
		M	MS	MP9005	20- 80	0.08-0.25	0.3-0.2
	●	L	LS	MP9015	20- 75	0.06-0.20	0.2-1.0
		M	MS	MP9015	20- 75	0.06-0.20	0.2-1.0
✚	L	LS	MP9025	15- 25	0.06-0.20	0.2-1.0	
✚	M	MS	MP9025	15- 30	0.08-0.25	0.3-2.0	

1. İç çap işleme için kesme koşulları takım serbest boyuna bağlı olarak değiştiğinden, her bir delik takımı için tavsiye edilen koşulları kontrol edin.

Kesme Koşulları: ●: Stabil Kesme ●: Genel Kesme ✚: Stabil Olmayan Kesme

SVJC

VCGT UÇLAR İÇİN TAKIM TUTUCU



Sipariş Numarası	Stok		Kesici uç	H	B	LF	HF	LH	WF	Kesici Uç Sıkma Vidası	Anahtar
	R	L									
SVJCR/L1010JX11-SM	●	●	VCGT	10	10	120	10	22	0	TS255	TKY08R
SVJCR/L1212JX11-SM	●	●		12	12	120	12	22	0		
SVJCR/L1616JX11-SM	●	●		16	16	120	16	22	0		
SVJCR/L1010JX13-SM	●	●	VCGT	10	10	120	10	26	0	TS32	TKY08R
SVJCR/L1212JX13-SM	●	●		12	12	120	12	26	0		
SVJCR/L1616JX13-SM	●	●		16	16	120	16	26	0		

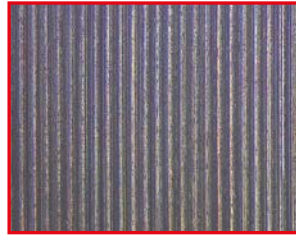
KESME PERFORMANSI

INCONEL® 718 YÜZEY FINİŞ KARŞILAŞTIRMASI

Mükemmel işleme ve talaş kırma yeteneği sayesinde çok iyi yüzey finışı.

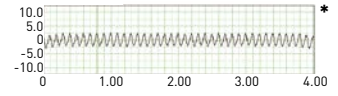
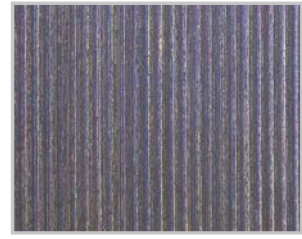
Malzeme	Inconel® 718
Kesici uç	CNGG120404
Vc (m/dk)	50
f (mm/dev)	0.1
ap (mm)	0.2
Kesme Modu	Islak Kesme

MP9005 



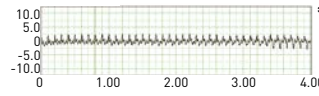
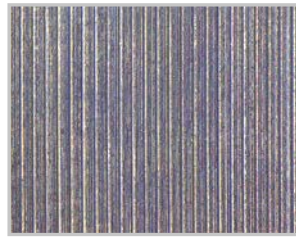
Rz 3.0312 µm

Geleneksel A



Rz 4.8944 µm

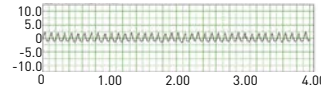
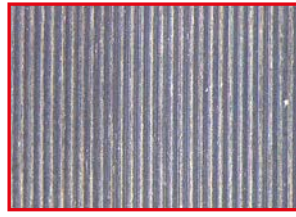
Geleneksel B



Rz 4.2160 µm

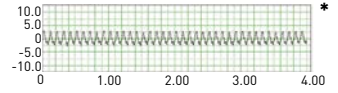
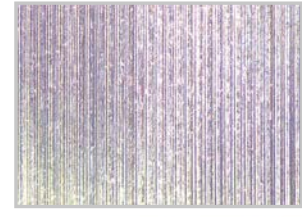
Malzeme	Inconel® 718
Kesici uç	CNGG120404
Vc (m/dk)	50
f (mm/dev)	0.1
ap (mm)	0.5
Kesme Modu	Islak Kesme

MP9005 



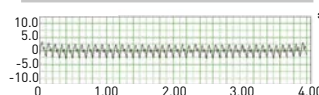
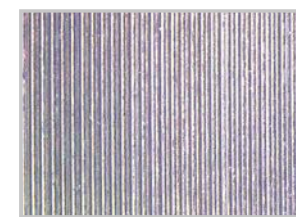
Rz 3.7020 µm

Geleneksel A



Rz 5.4880 µm

Geleneksel B



Rz 5.4120 µm

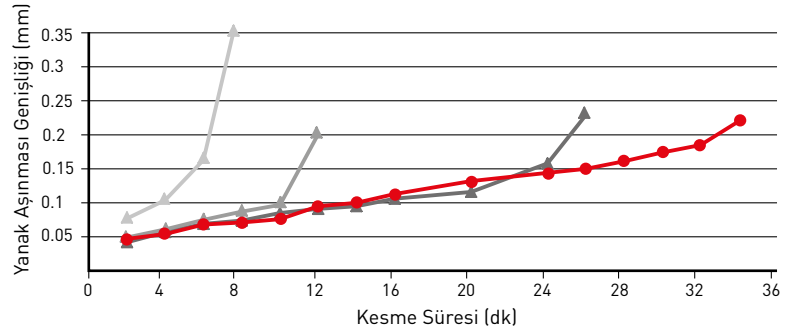
* Pürüzlülük eğrisi
dikey ölçek: x 2.000.00
yatay ölçek: x 50.00

KESME PERFORMANSI

INCONEL®718, DARBESİZ İŞLEME

Malzeme	Inconel®718
Kesici uç	CNMG120408-MS
Vc (m/dk)	60
f (mm/dev)	0.15
ap (mm)	0.75
Kesme Modu	Islak Kesme

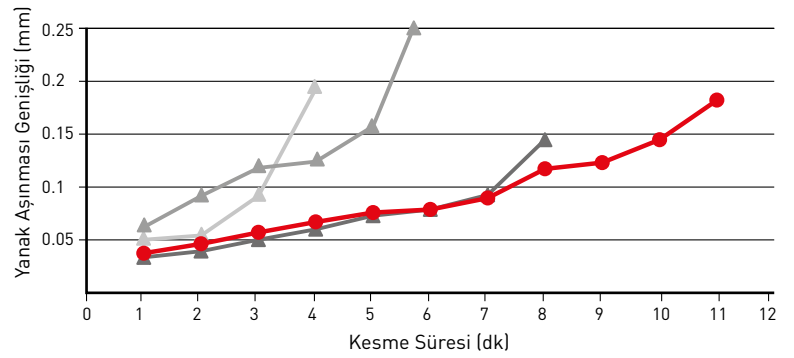
%28 Daha Uzun Takım Ömrü



INCONEL®718, DARBESİZ İŞLEME

Malzeme	Inconel®718
Kesici uç	CNMG120408-MS
Vc (m/dk)	100
f (mm/dev)	0.15
ap (mm)	0.5
Kesme Modu	Islak Kesme

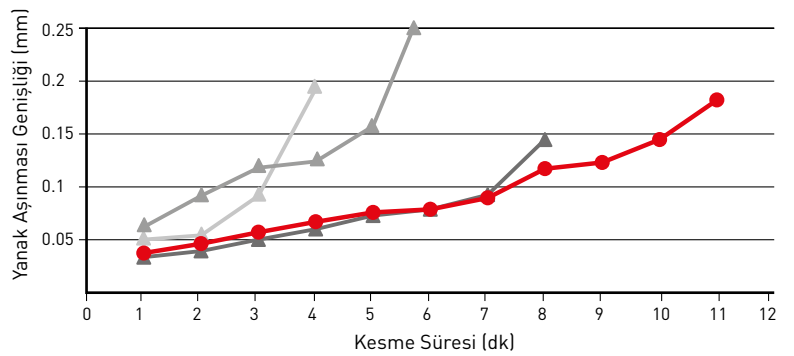
%37 Daha Uzun Takım Ömrü



INCONEL®718, DARBESİZ İŞLEME

Malzeme	Inconel®718
Kesici uç	CNMG120408-RS
Vc (m/dk)	40
f (mm/dev)	0.2
ap (mm)	2.0
Kesme Modu	Islak Kesme

%33 Daha Uzun Takım Ömrü



—●— MP9005/15 —▲— Geleneksel A

—▲— Geleneksel B

—▲— Geleneksel C

WASPALLOY® İŞLEME

RS KIRICILI MP9015 İLE MİNİMUM AŞINMA GÖRÜLMÜŞTÜR

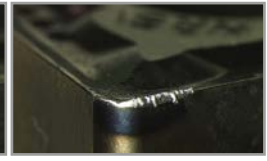
Malzeme	WA SPALLOY®
Kesici uç	CNMG120408-RS
Vc (m/dk)	29
f (mm/dev)	0.22
ap (mm)	4.0
Kesme süresi (dk)	7
Kesme Modu	Islak Kesme



MP9015 - RS



Geleneksel A

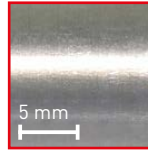


Geleneksel B

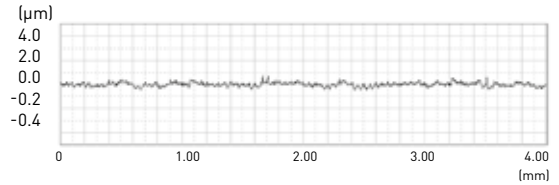
TİTANYUM ALAŞIMI, YÜZEY PÜRÜZLÜLÜK KARŞILAŞTIRMASI

Malzeme	Ti-6Al-6V(325HB)
Kesici uç	CNMG120408-LS
Vc (m/dk)	70
f (mm/dev)	0.05
ap (mm)	0.25
Kesme Modu	Islak Kesme

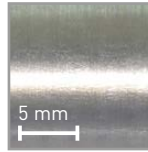
Parlak Yüzey



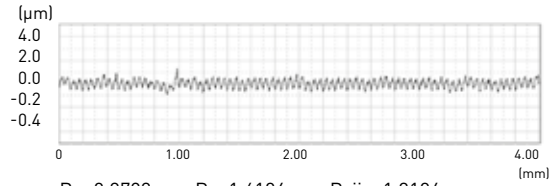
MP9015 - LS



Bulanık/Mat Yüzey



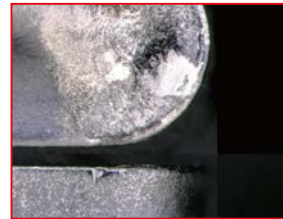
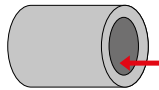
Geleneksel



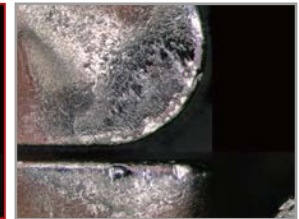
Mükemmel Finiş Yüzey Kalitesi

LS KIRICILI MP9015 İLE MİNİMUM AŞINMA GÖRÜLMÜŞTÜR

Malzeme	Isıya Dirençli Dökme Çelik
Kesici uç	DCMT11T304-LS
Vc (m/dk)	100
f (mm/dev)	0.1
ap (mm)	0.25
Kesme Modu	Islak Kesme



MP9015 - LS

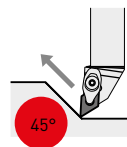


Geleneksel

AÇILI/KONİK TORNALAMADA TALAŞ KONTROLÜ

Inconel®718 ters tornalanırken talaş sıkışması meydana gelmez.

Malzeme	Inconel®718
Kesici uç	DNMG150408-MS
Vc (m/dk)	40
f (mm/dev)	0.2
ap (mm)	1.0
Kesme Modu	Islak Kesme

MS Talaş Kırıcı
(Yeni Tasarım)

Geleneksel

UYGULAMA ÖRNEKLERİ

Kesici uç	DNMG150408-MS (MP9005)
Malzemesi	Inconel®718 (Ni bazlı Alaşım)
Kesme Modu	Islak Kesme
Vc (m/dk)	60
f (mm/dev)	0.15
ap (mm)	0.25
Parça	Disk-Havacılık Bileşeni

Sonuçlar

MP9005 – Talaş sarması olmadan stabil işleme ve daha az aşınmayla daha uzun takım ömrü.



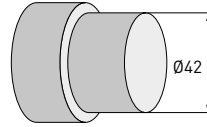
MP9005 + MS

Geleneksel (S10)

Kesici uç	CNMG120408-RS (MP9015)
Malzemesi	HAYNES® Alloy 25 (Ni,Co bazlı Alaşım)
Kesme Modu	Wet Cutting
Vc (m/dk)	34
f (mm/dev)	0.20
ap (mm)	1.5
Parça	Kapak Plakası-Havacılık Bileşeni

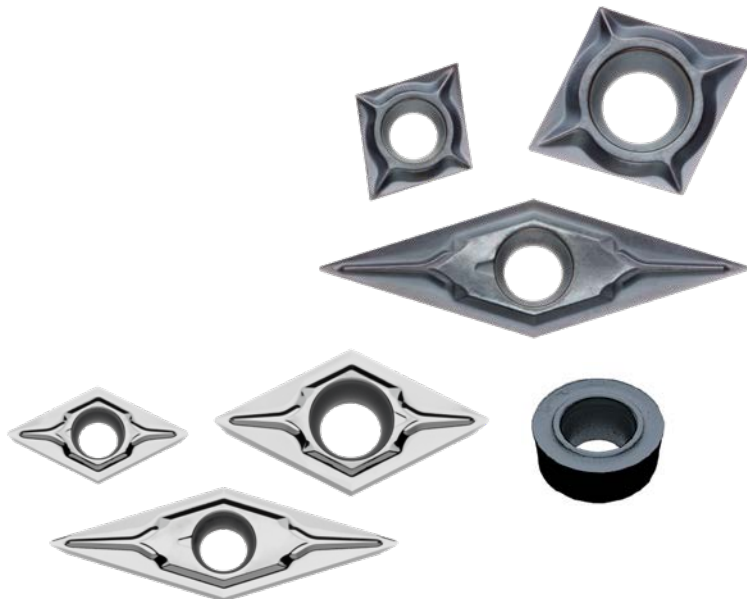
Sonuçlar

Hem geleneksel hem de MP9015 kalitelerinde çentik aşınması görünmesine rağmen, geleneksel kalitede çok daha büyük aşınma ve kaplamada atma gözlemlenmiştir.



MP9015 + RS

Geleneksel (S10)



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