

MB4120

SİNERLENMİŞ ALAŞIM VE DÖKME DEMİR
İÇİN CNB KALİTESİ



MB4120

DAHA YÜKSEK VERİMLİLİK İÇİN MÜKEMMEL KIRILMA DİRENCİ VE DAYANIKLILIK



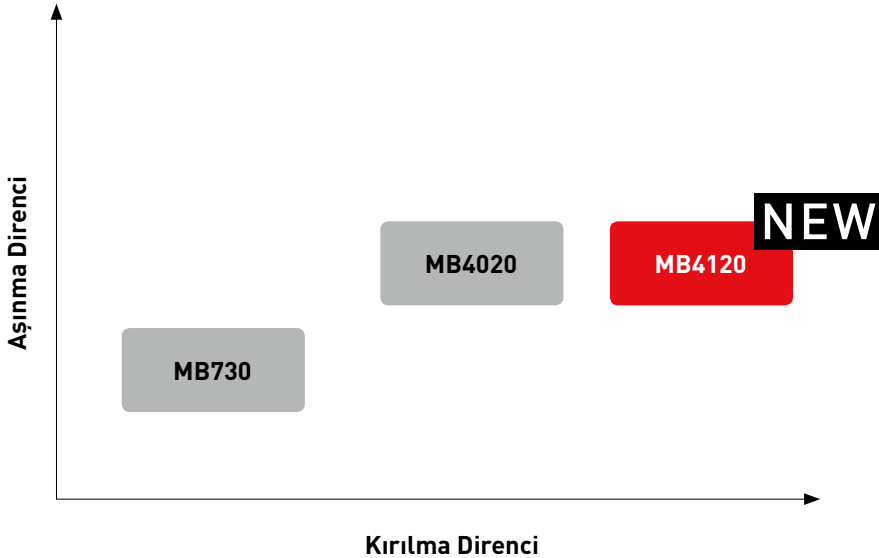
Arttırılan CBN partikül katkı oranı ve bağlama kuvveti sayesinde çok çeşitli sinterlenmiş malzemelerin işlenmesi için idealdir.

YÜKSEK KIRILMA DİRENCİ

İnce CBN partikülleri kesme kenarının tokluğunu artırır. Yüksek kırılma direnci, darbeli işlemede bile dengeli performans sağlar.

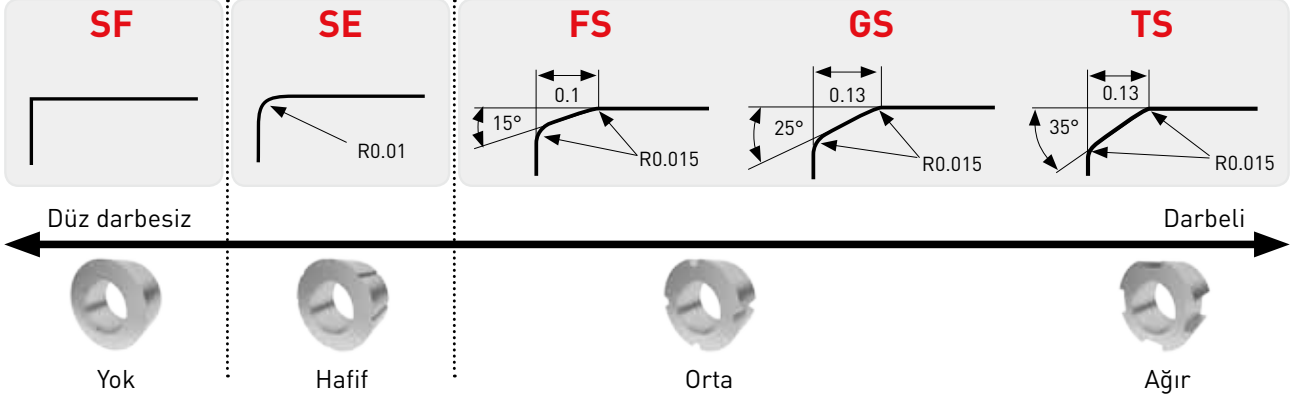
İNCE CBN PARTİKÜLLERİNİN YÜKSEK BAĞLANMA KUVVETİ

Sinterleme koşullarının optimizasyonu, ince CBN partikülleri arasındaki bağlanmayı güçlendirir. Bu hem kırılma hemde aşınma direncini artırır.



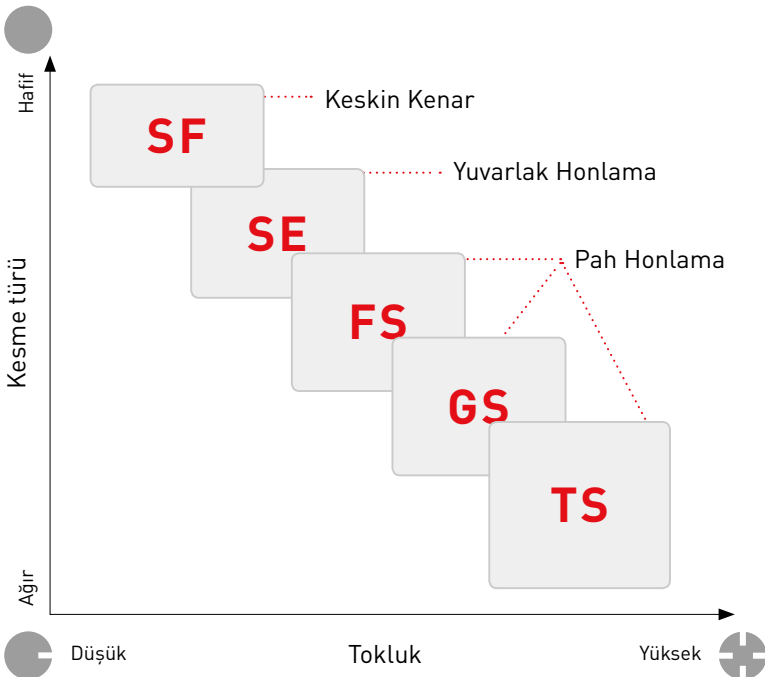
GEOMETRİ

KESME KENARI HAZIRLAMA



KAPSAMLI KENAR HAZIRLAMA (HONLAMA)

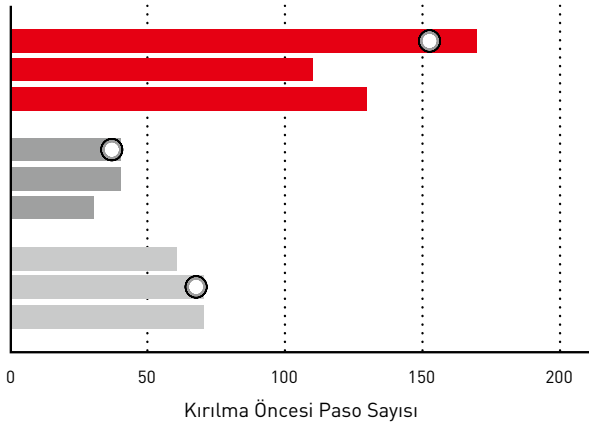
SF honlama tipi, kesme direncinde düşmeye yol açan daha keskin bir kesme kenarı sunar ve çapak oluşumu yanı sıra parça yüzey kalitesinde de iyileştirme sağlar. SF tipi ilk genel tavsiyedir ancak kesme kenarı sağlamlığı ve kenar dökülmesi direnci artışı için SE, FS, GS ve TS honlama türleri tavsiye edilir.



AĞIR DARBELİ İŞLEME SIRASINDA ARTTIRILMIŞ KIRILMA DİRENCİ

Yüksek mukavemetli sinterlenmiş alaşımın darbeli yüzeyinin kesilmesi sırasında kırılma direnci karşılaştırması.

Malzeme	Yüksek Mukavemetli Sinterlenmiş Alaşım
Kesici uç	NP-TNGA160408SE3
Kesme Hızı Vc (m/dak)	150
Devir Başına İlerleme fr (mm/dev)	0.15
Kesme Derinliği ap (mm)	0.1
Kesme Türü	Islak Kesme



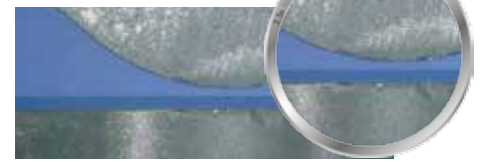
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Dökülme

150 geçiş

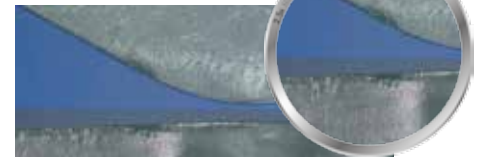
Klasik A



Dökülme

40 geçiş

Klasik B



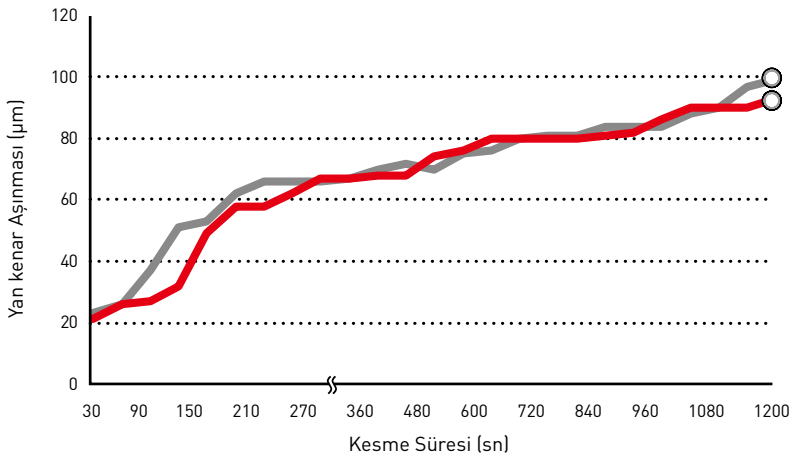
Dökülme

70 geçiş

DIN GG25'İN DÜZ SÜREKLİ İŞLEME KARŞILAŞTIRMASI

Klasik ürünler ile karşılaştırıldığında mükemmel kırılma direnci.

Malzeme	DIN GG25 (Perlite)
Kesici uç	NP-TNGA160408SF3
Kesme Hızı Vc (m/dak)	800
Devir Başına İlerleme fr (mm/dev)	0.1
Kesme Derinliği ap (mm)	0.2
Kesme Türü	Kuru Kesme



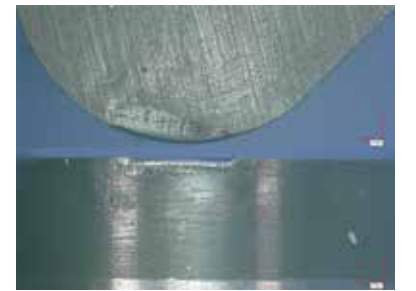
■ MB4120

■ Klasik A

■ Klasik B

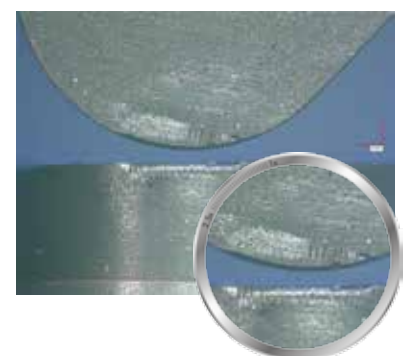
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1200 sn



Klasik

1200 sn



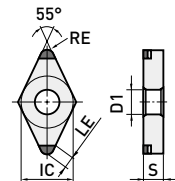
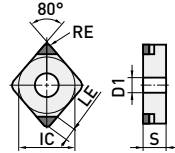
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NEGATİF KESİCİ UÇLAR (DELİKLİ)

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G Sınıfı

Sipariş Numarası	MB4020	MB4120 NEW	Kesme Kenarları	IC	S	RE	D1	LE	Şekil	Geometri
NP-CNGA120404SF2	▲	★	2	12.7	4.76	0.4	5.16	1.9	NEW PETIT CUT	
NP-CNGA120408SF2	▲	●	2	12.7	4.76	0.8	5.16	2.1		
NP-CNGA120412SF2	▲	★	2	12.7	4.76	1.2	5.16	2.3		
NP-CNGA120404SE2	▲	★	2	12.7	4.76	0.4	5.16	1.9		
NP-CNGA120408SE2	▲	●	2	12.7	4.76	0.8	5.16	2.1		
NP-CNGA120412SE2	▲	★	2	12.7	4.76	1.2	5.16	2.3		
NP-CNGA120404FS2	▲	●	2	12.7	4.76	0.4	5.16	1.9		
NP-CNGA120408FS2	▲	●	2	12.7	4.76	0.8	5.16	2.1		
NP-CNGA120412FS2	▲	●	2	12.7	4.76	1.2	5.16	2.3		
NP-CNGA120404GS2	▲	●	2	12.7	4.76	0.4	5.16	1.9		
NP-CNGA120408GS2	▲	●	2	12.7	4.76	0.8	5.16	2.1		
NP-CNGA120412GS2	▲	★	2	12.7	4.76	1.2	5.16	2.3		
NP-CNGA120404TS2	▲	★	2	12.7	4.76	0.4	5.16	1.9		
NP-CNGA120408TS2	▲	●	2	12.7	4.76	0.8	5.16	2.1		
NP-CNGA120412TS2	▲	★	2	12.7	4.76	1.2	5.16	2.3		
NP-DNGA150404SF2	▲	★	2	12.7	4.76	0.4	5.16	2.1	NEW PETIT CUT	
NP-DNGA150408SF2	▲	★	2	12.7	4.76	0.8	5.16	2.0		
NP-DNGA150412SF2	▲	★	2	12.7	4.76	1.2	5.16	1.9		
NP-DNGA150604SF2	▲	★	2	12.7	6.35	0.4	5.16	2.1		
NP-DNGA150608SF2	▲	★	2	12.7	6.35	0.8	5.16	2.0		
NP-DNGA150612SF2	▲	★	2	12.7	6.35	1.2	5.16	1.9		
NP-DNGA150404SE2	▲	★	2	12.7	4.76	0.4	5.16	2.1		
NP-DNGA150408SE2	▲	★	2	12.7	4.76	0.8	5.16	2.0		
NP-DNGA150412SE2	▲	★	2	12.7	4.76	1.2	5.16	1.9		
NP-DNGA150604SE2	▲	★	2	12.7	6.35	0.4	5.16	2.1		
NP-DNGA150608SE2	▲	★	2	12.7	6.35	0.8	5.16	2.0		
NP-DNGA150612SE2	▲	★	2	12.7	6.35	1.2	5.16	1.9		
NP-DNGA150404FS2	▲	★	2	12.7	4.76	0.4	5.16	2.1		
NP-DNGA150408FS2	▲	★	2	12.7	4.76	0.8	5.16	2.0		
NP-DNGA150412FS2	▲	★	2	12.7	4.76	1.2	5.16	1.9		
NP-DNGA150604FS2	▲	●	2	12.7	6.35	0.4	5.16	2.1		
NP-DNGA150608FS2	▲	●	2	12.7	6.35	0.8	5.16	2.0		
NP-DNGA150612FS2	▲	●	2	12.7	6.35	1.2	5.16	1.9		
NP-DNGA150404GS2	▲	★	2	12.7	4.76	0.4	5.16	2.1		
NP-DNGA150408GS2	▲	★	2	12.7	4.76	0.8	5.16	2.0		
NP-DNGA150412GS2	▲	★	2	12.7	4.76	1.2	5.16	1.9		
NP-DNGA150604GS2	▲	★	2	12.7	6.35	0.4	5.16	2.1		
NP-DNGA150608GS2	▲	●	2	12.7	6.35	0.8	5.16	2.0		
NP-DNGA150612GS2	▲	★	2	12.7	6.35	1.2	5.16	1.9		
NP-DNGA150404TS2	▲	★	2	12.7	4.76	0.4	5.16	2.1		
NP-DNGA150408TS2	▲	★	2	12.7	4.76	0.8	5.16	2.0		
NP-DNGA150412TS2	▲	★	2	12.7	4.76	1.2	5.16	1.9		
NP-DNGA150604TS2	▲	★	2	12.7	6.35	0.4	5.16	2.1		
NP-DNGA150608TS2	▲	★	2	12.7	6.35	0.8	5.16	2.0		
NP-DNGA150612TS2	▲	★	2	12.7	6.35	1.2	5.16	1.9		



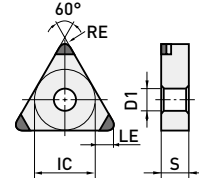
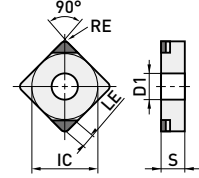
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NEGATİF KESİCİ UÇLAR (DELİKLİ)

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Sipariş Numarası	MB4020	MB4120 NEW	Kesme Kenarları	IC	S	RE	D1	LE	Şekil	Geometri
NP-SNGA120404SF2	▲	★	2	12.7	4.76	0.4	5.16	2.1	NEW PETIT CUT	
NP-SNGA120408SF2	▲	★	2	12.7	4.76	0.8	5.16	2.3		
NP-SNGA120412SF2	▲	★	2	12.7	4.76	1.2	5.16	2.5		
NP-SNGA120404SE2	▲	★	2	12.7	4.76	0.4	5.16	2.1		
NP-SNGA120408SE2	▲	★	2	12.7	4.76	0.8	5.16	2.3		
NP-SNGA120412SE2	▲	★	2	12.7	4.76	1.2	5.16	2.5		
NP-SNGA120404FS2	▲	★	2	12.7	4.76	0.4	5.16	2.1		
NP-SNGA120408FS2	▲	●	2	12.7	4.76	0.8	5.16	2.3		
NP-SNGA120412FS2	▲	●	2	12.7	4.76	1.2	5.16	2.5		
NP-SNGA120404GS2	▲	★	2	12.7	4.76	0.4	5.16	2.1		
NP-SNGA120408GS2	▲	●	2	12.7	4.76	0.8	5.16	2.3		
NP-SNGA120412GS2	▲	★	2	12.7	4.76	1.2	5.16	2.5		
NP-SNGA120404TS2	▲	★	2	12.7	4.76	0.4	5.16	2.1		
NP-SNGA120408TS2	▲	★	2	12.7	4.76	0.8	5.16	2.3		
NP-SNGA120412TS2	▲	★	2	12.7	4.76	1.2	5.16	2.5		
NP-TNGA160404SF3	▲	★	3	9.525	4.76	0.4	3.81	1.6	NEW PETIT CUT	
NP-TNGA160408SF3	▲	★	3	9.525	4.76	0.8	3.81	1.8		
NP-TNGA160412SF3	▲	★	3	9.525	4.76	1.2	3.81	1.9		
NP-TNGA160404SE3	▲	★	3	9.525	4.76	0.4	3.81	1.6		
NP-TNGA160408SE3	▲	★	3	9.525	4.76	0.8	3.81	1.8		
NP-TNGA160412SE3	▲	★	3	9.525	4.76	1.2	3.81	1.9		
NP-TNGA160404FS3	▲	●	3	9.525	4.76	0.4	3.81	1.6		
NP-TNGA160408FS3	▲	★	3	9.525	4.76	0.8	3.81	1.8		
NP-TNGA160412FS3	▲	★	3	9.525	4.76	1.2	3.81	1.9		
NP-TNGA160404GS3	▲	★	3	9.525	4.76	0.4	3.81	1.6		
NP-TNGA160408GS3	▲	●	3	9.525	4.76	0.8	3.81	1.8		
NP-TNGA160412GS3	▲	★	3	9.525	4.76	1.2	3.81	1.9		
NP-TNGA160404TS3	▲	★	3	9.525	4.76	0.4	3.81	1.6		
NP-TNGA160408TS3	▲	★	3	9.525	4.76	0.8	3.81	1.8		
NP-TNGA160412TS3	▲	★	3	9.525	4.76	1.2	3.81	1.9		



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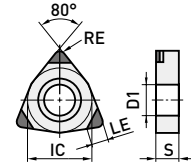
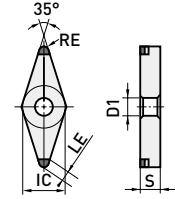
NEGATİF KESİCİ UÇLAR (DELİKLİ)

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Sipariş Numarası	MB4020	MB4120 NEW	Kesme Kenarları	IC	S	RE	D1	LE	Şekil	Geometri
NP-VNGA160404SF2	▲	★	2	9.525	4.76	0.4	3.81	2.5	NEW PETIT CUT	
NP-VNGA160408SF2	▲	★	2	9.525	4.76	0.8	3.81	2.0		
NP-VNGA160404SE2	▲	★	2	9.525	4.76	0.4	3.81	2.5		
NP-VNGA160408SE2	▲	★	2	9.525	4.76	0.8	3.81	2.0		
NP-VNGA160404FS2	▲	★	2	9.525	4.76	0.4	3.81	2.5		
NP-VNGA160408FS2	▲	●	2	9.525	4.76	0.8	3.81	2.0		
NP-VNGA160404GS2	▲	★	2	9.525	4.76	0.4	3.81	2.5		
NP-VNGA160408GS2	▲	★	2	9.525	4.76	0.8	3.81	2.0		
NP-VNGA160404TS2	▲	★	2	9.525	4.76	0.4	3.81	2.5		
NP-VNGA160408TS2	▲	★	2	9.525	4.76	0.8	3.81	2.0		
NP-WNGA080408SF3	▲	★	3	12.7	4.76	0.8	5.16	2.1	NEW PETIT CUT	
NP-WNGA080408SE3	▲	★	3	12.7	4.76	0.8	5.16	2.1		
NP-WNGA080408FS3	▲	★	3	12.7	4.76	0.8	5.16	2.1		
NP-WNGA080408GS3	▲	★	3	12.7	4.76	0.8	5.16	2.1		
NP-WNGA080408TS3	▲	★	3	12.7	4.76	0.8	5.16	2.1		



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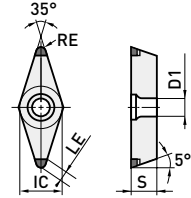
POZİTİF KESİCİ UÇLAR (DELİKLİ)

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Sipariş Numarası	MB4020	MB4120 NEW	Kesme Kenarları	IC	S	RE	D1	LE	Şekil	Geometri
NP-VBGW110304SF2	▲	★	2	6.35	3.18	0.4	2.85	2.5	NEW PETIT CUT	
NP-VBGW110308SF2	▲	★	2	6.35	3.18	0.8	2.85	2.0		
NP-VBGW160404SF2	▲	●	2	9.525	4.76	0.4	4.43	2.5		
NP-VBGW160408SF2	▲	★	2	9.525	4.76	0.8	4.43	2.0		
NP-VBGW110304SE2	▲	★	2	6.35	3.18	0.4	2.85	2.5		
NP-VBGW110308SE2	▲	★	2	6.35	3.18	0.8	2.85	2.0		
NP-VBGW160404SE2	▲	●	2	9.525	4.76	0.4	4.43	2.5		
NP-VBGW160408SE2	▲	★	2	9.525	4.76	0.8	4.43	2.0		
NP-VBGW110304FS2	▲	★	2	6.35	3.18	0.4	2.85	2.5		
NP-VBGW110308FS2	▲	★	2	6.35	3.18	0.8	2.85	2.0		
NP-VBGW160404FS2	▲	●	2	9.525	4.76	0.4	4.43	2.5		
NP-VBGW160408FS2	▲	●	2	9.525	4.76	0.8	4.43	2.0		
NP-VBGW110304GS2	▲	★	2	6.35	3.18	0.4	2.85	2.5		
NP-VBGW110308GS2	▲	★	2	6.35	3.18	0.8	2.85	2.0		
NP-VBGW160404GS2	▲	●	2	9.525	4.76	0.4	4.43	2.5		
NP-VBGW160408GS2	▲	●	2	9.525	4.76	0.8	4.43	2.0		



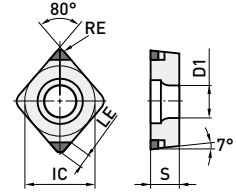
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POZİTİF KESİCİ UÇLAR (DELİKLİ)

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G Sınıfı

Sipariş Numarası	MB4020	MB4120 NEW	Kesme Kenarları	IC	S	RE	D1	LE	Şekil	Geometri
NP-CCGW060202SF2	▲	★	2	6.35	2.38	0.2	2.8	1.8	NEW PETIT CUT	
NP-CCGW060204SF2	▲	●	2	6.35	2.38	0.4	2.8	1.9		
NP-CCGW060208SF2	▲	★	2	6.35	2.38	0.8	2.8	2.1		
NP-CCGW09T302SF2	▲	★	2	9.525	3.97	0.2	4.4	1.8		
NP-CCGW09T304SF2	▲	●	2	9.525	3.97	0.4	4.4	1.9		
NP-CCGW09T308SF2	▲	●	2	9.525	3.97	0.8	4.4	2.1		
NP-CCGW060202SE2	▲	★	2	6.35	2.38	0.2	2.8	1.8		
NP-CCGW060204SE2	▲	●	2	6.35	2.38	0.4	2.8	1.9		
NP-CCGW060208SE2	▲	★	2	6.35	2.38	0.8	2.8	2.1		
NP-CCGW09T302SE2	▲	★	2	9.525	3.97	0.2	4.4	1.8		
NP-CCGW09T304SE2	▲	★	2	9.525	3.97	0.4	4.4	1.9		
NP-CCGW09T308SE2	▲	●	2	9.525	3.97	0.8	4.4	2.1		
NP-CCGW060202FS2	▲	●	2	6.35	2.38	0.2	2.8	1.8		
NP-CCGW060204FS2	▲	●	2	6.35	2.38	0.4	2.8	1.9		
NP-CCGW060208FS2	▲	●	2	6.35	2.38	0.8	2.8	2.1		
NP-CCGW09T302FS2	▲	★	2	9.525	3.97	0.2	4.4	1.8		
NP-CCGW09T304FS2	▲	●	2	9.525	3.97	0.4	4.4	1.9		
NP-CCGW09T308FS2	▲	●	2	9.525	3.97	0.8	4.4	2.1		
NP-CCGW060202GS2	▲	★	2	6.35	2.38	0.2	2.8	1.8		
NP-CCGW060204GS2	▲	●	2	6.35	2.38	0.4	2.8	1.9		
NP-CCGW060208GS2	▲	★	2	6.35	2.38	0.8	2.8	2.1		
NP-CCGW09T302GS2	▲	★	2	9.525	3.97	0.2	4.4	1.8		
NP-CCGW09T304GS2	▲	★	2	9.525	3.97	0.4	4.4	1.9		
NP-CCGW09T308GS2	▲	★	2	9.525	3.97	0.8	4.4	2.1		
NP-CCGW060208TS2	▲	★	2	6.35	2.38	0.8	2.8	2.1		
NP-CCGW09T308TS2	▲	★	2	9.525	3.97	0.8	4.4	2.1		



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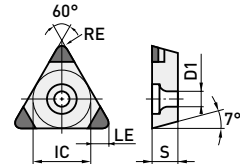
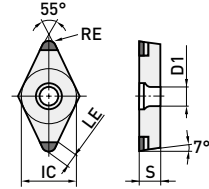
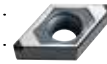
POZİTİF KESİCİ UÇLAR (DELİKLİ)

K

H

G Sınıfı

Sipariş Numarası	MB4020	MB4120 NEW	Kesme Kenarları	IC	S	RE	D1	LE	Şekil	Geometri
NP-DCGW070204SF2	▲	●	2	6.35	2.38	0.4	2.8	2.1	NEW PETIT CUT	
NP-DCGW070208SF2	▲	●	2	6.35	2.38	0.8	2.8	2.0		
NP-DCGW11T302SF2	▲	★	2	9.525	3.97	0.2	4.4	1.5		
NP-DCGW11T304SF2	▲	●	2	9.525	3.97	0.4	4.4	2.1		
NP-DCGW11T308SF2	▲	●	2	9.525	3.97	0.8	4.4	2.0		
NP-DCGW070204SE2	▲	●	2	6.35	2.38	0.4	2.8	2.1		
NP-DCGW070208SE2	▲	★	2	6.35	2.38	0.8	2.8	2.0		
NP-DCGW11T302SE2	▲	●	2	9.525	3.97	0.2	4.4	1.5		
NP-DCGW11T304SE2	▲	●	2	9.525	3.97	0.4	4.4	2.1		
NP-DCGW11T308SE2	▲	●	2	9.525	3.97	0.8	4.4	2.0		
NP-DCGW070204FS2	▲	●	2	6.35	2.38	0.4	2.8	2.1		
NP-DCGW070208FS2	▲	●	2	6.35	2.38	0.8	2.8	2.0		
NP-DCGW11T302FS2	▲	●	2	9.525	3.97	0.2	4.4	1.5		
NP-DCGW11T304FS2	▲	●	2	9.525	3.97	0.4	4.4	2.1		
NP-DCGW11T308FS2	▲	●	2	9.525	3.97	0.8	4.4	2.0		
NP-DCGW070204GS2	▲	●	2	6.35	2.38	0.4	2.8	2.1		
NP-DCGW070208GS2	▲	★	2	6.35	2.38	0.8	2.8	2.0		
NP-DCGW11T302GS2	▲	★	2	9.525	3.97	0.2	4.4	1.5		
NP-DCGW11T304GS2	▲	●	2	9.525	3.97	0.4	4.4	2.1		
NP-DCGW11T308GS2	▲	●	2	9.525	3.97	0.8	4.4	2.0		
NP-TCGW110204SF3	▲	★	3	6.35	2.38	0.4	2.8	1.6	NEW PETIT CUT	
NP-TCGW110208SF3	▲	★	3	6.35	2.38	0.8	2.8	1.8		
NP-TCGW110204SE3	▲	★	3	6.35	2.38	0.4	2.8	1.6		
NP-TCGW110208SE3	▲	★	3	6.35	2.38	0.8	2.8	1.8		
NP-TCGW110204FS3	▲	●	3	6.35	2.38	0.4	2.8	1.6		
NP-TCGW110208FS3	▲	●	3	6.35	2.38	0.8	2.8	1.8		
NP-TCGW110204GS3	▲	★	3	6.35	2.38	0.4	2.8	1.6		



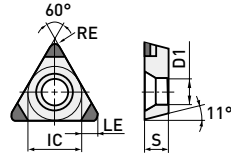
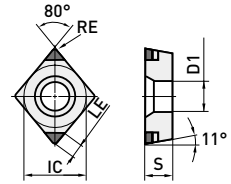
MB4120

POZİTİF KESİCİ UÇLAR (DELİKLİ)

K H

G Sınıfı

Sipariş Numarası	MB4020	MB4120 NEW	Kesme Kenarları	IC	S	RE	D1	LE	Şekil	Geometri
NP-CPGB080202SE2	▲	★	2	7.94	2.38	0.2	3.5	1.8	NEW PETIT CUT	
NP-CPGB080204SE2	▲	★	2	7.94	2.38	0.4	3.5	1.9		
NP-CPGB090302SE2	▲	★	2	9.525	3.18	0.2	4.5	1.8		
NP-CPGB090304SE2	▲	★	2	9.525	3.18	0.4	4.5	1.9		
NP-CPGB090308SE2	▲	★	2	9.525	3.18	0.8	4.5	2.1		
NP-CPGB080202FS2	▲	★	2	7.94	2.38	0.2	3.5	1.8		
NP-CPGB080204FS2	▲	●	2	7.94	2.38	0.4	3.5	1.9		
NP-CPGB090302FS2	▲	★	2	9.525	3.18	0.2	4.5	1.8		
NP-CPGB090304FS2	▲	★	2	9.525	3.18	0.4	4.5	1.9		
NP-CPGB090308FS2	▲	★	2	9.525	3.18	0.8	4.5	2.1		
NP-TPGB090202SF3	▲	★	3	5.56	2.38	0.2	2.9	1.5	NEW PETIT CUT	
NP-TPGB090204SF3	▲	★	3	5.56	2.38	0.4	2.9	1.6		
NP-TPGB110302SF3	▲	★	3	6.35	3.18	0.2	3.4	1.5		
NP-TPGB110304SF3	▲	★	3	6.35	3.18	0.4	3.4	1.6		
NP-TPGB110308SF3	▲	★	3	6.35	3.18	0.8	3.4	1.8		
NP-TPGB090202SE3	▲	★	3	5.56	2.38	0.2	2.9	1.5		
NP-TPGB090204SE3	▲	★	3	5.56	2.38	0.4	2.9	1.6		
NP-TPGB110302SE3	▲	★	3	6.35	3.18	0.2	3.4	1.5		
NP-TPGB110304SE3	▲	★	3	6.35	3.18	0.4	3.4	1.6		
NP-TPGB110308SE3	▲	★	3	6.35	3.18	0.8	3.4	1.8		
NP-TPGB090202FS3	▲	★	3	5.56	2.38	0.2	2.9	1.5		
NP-TPGB090204FS3	▲	★	3	5.56	2.38	0.4	2.9	1.6		
NP-TPGB110302FS3	▲	★	3	6.35	3.18	0.2	3.4	1.5		
NP-TPGB110304FS3	▲	★	3	6.35	3.18	0.4	3.4	1.6		
NP-TPGB110308FS3	▲	★	3	6.35	3.18	0.8	3.4	1.8		
NP-TPGB090202GS3	▲	★	3	5.56	2.38	0.2	2.9	1.5		
NP-TPGB090204GS3	▲	★	3	5.56	2.38	0.4	2.9	1.6		
NP-TPGB110302GS3	▲	★	3	6.35	3.18	0.2	3.4	1.5		
NP-TPGB110304GS3	▲	★	3	6.35	3.18	0.4	3.4	1.6		
NP-TPGB110308GS3	▲	★	3	6.35	3.18	0.8	3.4	1.8		



MB4120

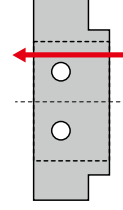
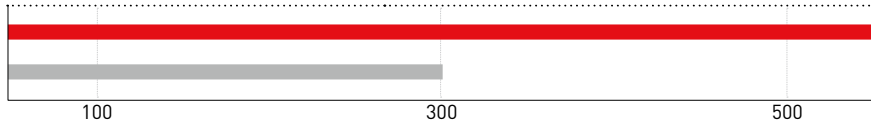
ÖNERİLEN KESME KOŞULLARI

Malzeme	Kesme Türü	Kalite	f (mm/rev)	ap (mm)	Vc (m/min)	
H	Genel Sinterlenmiş Alaşımlar	Kuru, Islak	≤0.2	≤0.3	100 - 300	
	Yüksek Dayanıklı Sinterlenmiş Alaşımlar	Kuru, Islak	MB4120	≤0.2	≤0.3	100 - 225
	Sertleştirilmiş Sinterlenmiş Alaşımlar	Kuru, Islak	≤0.2	≤0.3	100 - 175	
K	Gri Dökme Demir	Kuru, Islak	MB4120	≤0.2	≤0.3	210 - 300

UYGULAMA ÖRNEKLERİ

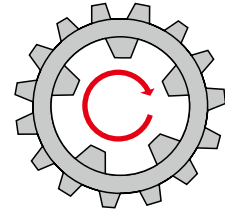
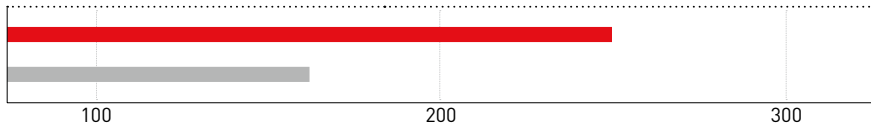
Kesici uç	NP-DCGW11T308SF2
İş Parçası Malzemesi	Genel Sinterlenmiş Alaşım
Parça	Gövde (Darbeli delik işleme)
Kesme Hızı Vc (m/dak)	200
İlerleme f (mm/dev)	0.07
Kesme Derinliği ap (mm)	0.2
Kesme türü	Islak Kesme

Sonuçlar Klasik ürüne göre iki kat takım ömrü.



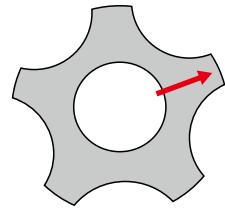
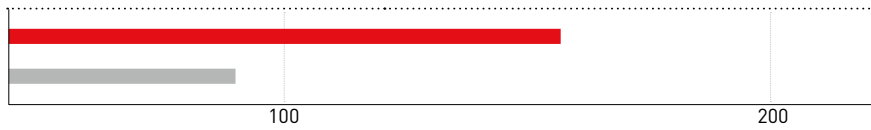
Kesici uç	NP-DCGW11T308SF2
İş Parçası Malzemesi	Genel Sinterlenmiş Alaşım
Parça	Muhafaza (Darbeli Delik İşleme)
Kesme Hızı Vc (m/dak)	180
İlerleme f (mm/dev)	0.25
Kesme Derinliği ap (mm)	0.2-0.3
Kesme türü	Islak Kesme

Sonuçlar Klasik ürüne göre iki kat takım ömrü.



Kesici uç	NP-DCGW11T308SF2
İş Parçası Malzemesi	Demir Esaslı Sinterlenmiş Alaşım (60 HRB) Ra<1,0 µm
Parça	Pinyon (Darbeli alın işleme)
Kesme Hızı Vc (m/dak)	200
İlerleme f (mm/dev)	0.04-0.05
Kesme Derinliği ap (mm)	0.4
Kesme modu	Islak Kesme

Sonuçlar Klasik bir ürüne göre iyi yüzey kalitesi sağlanmış ve 2,5 kat daha uzun takım ömrü elde edilmiştir.



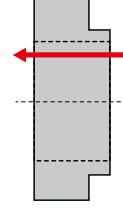
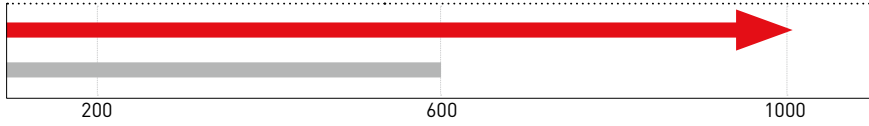
Yukarıdaki uygulama örnekleri müşteri uygulamalarıdır, bu nedenle önerilen koşullardan farklılık gösterebilir.

UYGULAMA ÖRNEKLERİ

Kesici uç	NP-TNGA160408SF3
İş Parçası Malzemesi	Yüksek Dirençli Sinterlenmiş Alaşım
Parça	Dişli (Düz Sürekli Delik İşleme)
Kesme Hızı Vc (m/dak)	250
İlerleme f (mm/dev)	0.1
Kesme Derinliği ap (mm)	0.1
Kesme modu	Islak Kesme

Sonuçlar

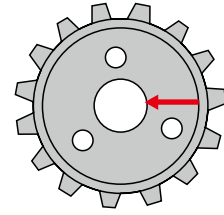
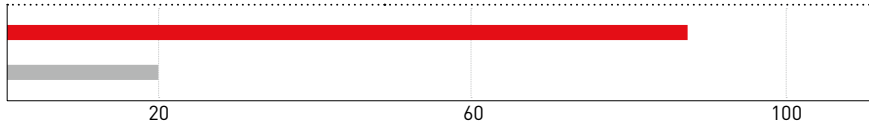
Klasik bir ürünle karşılaştırıldığında yan kenar aşınması daha azdır ve kesici uç kullanılmaya devam edilebilmiştir.



Kesici uç	NP-TNGA160408SE3
İş Parçası Malzemesi	Genel Sinterlenmiş Alaşım
Parça	Dişli (Darbeli alın işleme)
Kesme Hızı Vc (m/dak)	240
İlerleme f (mm/dev)	0.12
Kesme Derinliği ap (mm)	0.05
Kesme türü	Islak Kesme

Sonuçlar

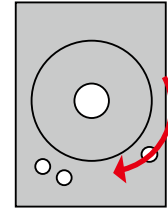
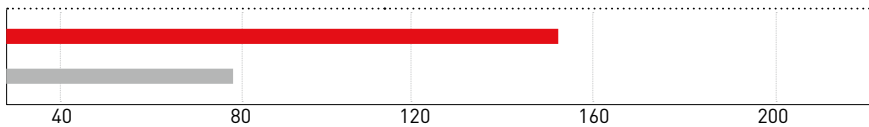
Klasik bir sermet ürüne göre daha yüksek yüzey kalitesi ve en az 4 kat daha uzun takım ömrü elde edilmiştir.



Kesici uç	NP-CNGA120408SF2
İş Parçası Malzemesi	Dökme Demir
Parça	Mekanik Parçalar (Darbeli alın işleme)
Kesme Hızı Vc (m/dak)	600
İlerleme f (mm/dev)	0.175-0.25
Kesme Derinliği ap (mm)	0.15-0.2
Kesme türü	Kuru Kesme

Sonuçlar

Anormal hasar yoktur ve en az 1,5 kat daha uzun takım ömrü elde edilmiştir.

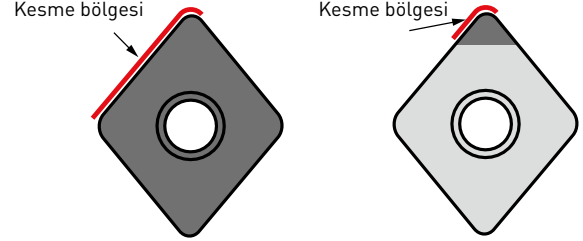


Yukarıdaki uygulama örnekleri müşteri uygulamalarıdır, bu nedenle önerilen koşullardan farklılık gösterebilir.

MB4020

TAM YÜZ CBN

Tam yüz ve yekpare CBN, daha yüksek kesme derinliklerinde ve ucu lehimli geleneksel CBN kesici uçlar uygun olmadığında pah kırmak için kullanılabilir.



Sipariş Numarası	MB4020	MB4120	Kesme Kenarları	IC	S	RE	D1	Şekil	Geometri
CCGW060202FS	★	—	2	6.35	2.38	0.2	2.8		
CCGW060204FS	★	—	2	6.35	2.38	0.4	2.8		
CCGW060208FS	★	—	2	6.35	2.38	0.8	2.8		
CCGW09T304FS	★	—	2	9.525	3.97	0.4	4.4		
CCGW09T308FS	★	—	2	9.525	3.97	0.8	4.4		
DCGW070204FS	★	—	2	6.35	2.38	0.4	2.8		
DCGW070208FS	★	—	2	6.35	2.38	0.8	2.8		
TCGW090204FS	★	—	3	5.56	2.38	0.4	2.5		
TCGW090208FS	★	—	3	5.56	2.38	0.8	2.5		
TCGW110204FS	★	—	3	6.35	2.38	0.4	2.8		
TCGW110208FS	★	—	3	6.35	2.38	0.8	2.8		

ÖNERİLEN KESME KOŞULLARI

TAM YÜZ İÇİN KESME KOŞULLARI

Malzeme	Kesme Türü	Kalite	f (mm/rev)	ap (mm)	Vc (m/min)				
					100	150	200	250	300
H Genel Sinterlenmiş Alaşımlar	Kuru, Islak	MB4020	-0.2	-0.3 [-2.0]	[Bar chart showing recommended Vc range from 100 to 250 m/min]				
					[Bar chart showing recommended Vc range from 100 to 250 m/min]				
					[Bar chart showing recommended Vc range from 100 to 250 m/min]				
K Gri Dökme Demir	Kuru, Islak	MB4020	-0.4	-0.5 [-2.0]	[Bar chart showing recommended Vc range from 250 to 750 m/min]				
					[Bar chart showing recommended Vc range from 500 to 1000 m/min]				

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