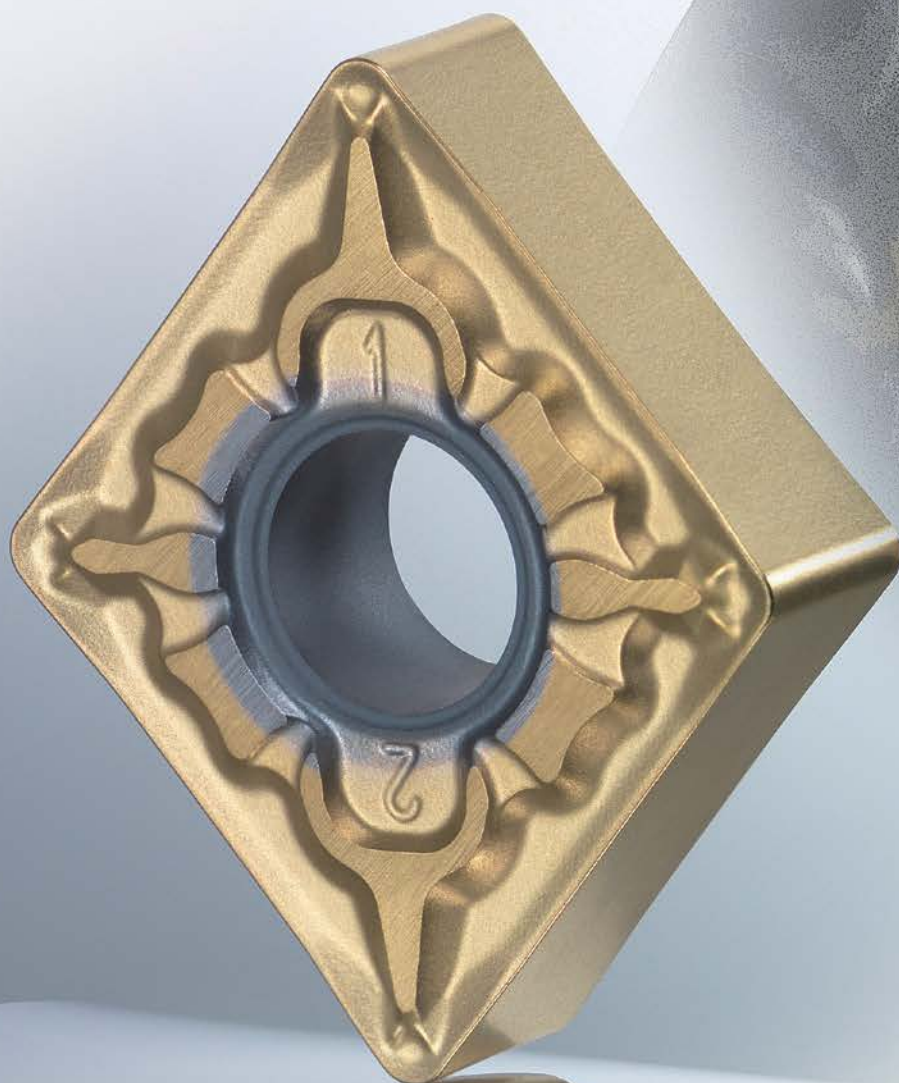


Cermet recubierto de PVD para acero

# ***MIP3025***

## **Acabado superficial excelente**

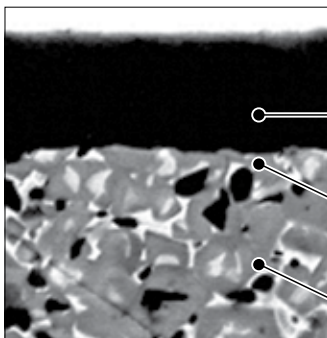


# Cermet recubierto de PVD para acero

# **MP3025**

MP3025 tiene excelentes propiedades de resistencia a la rotura y al desgaste.

Debido a la mejorada fuerza de adhesión de la superficie, la calidad MP3025 permite obtener unos excelentes acabados de superficies, ideales para una gran producción de piezas pequeñas.



Cpa de compuesto Ti para alta resistencia al desgaste y evita el recrecimiento del filo

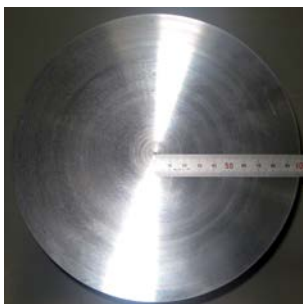
La superficie del sustrato proporciona una resistencia excelente de adhesión en la capa de recubrimiento.

Sustrato con resistencia a la rotura y al choque térmico.

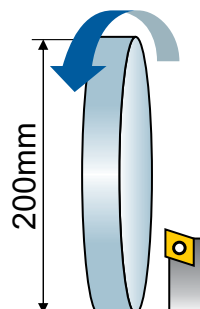
## Mejor acabado a bajas velocidades.

MP3025 consigue mejores acabados de superficie a bajas velocidades de corte que las calidades cermet de PVD de la competencia.

**MP3025**

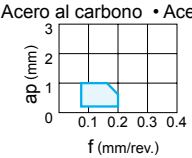
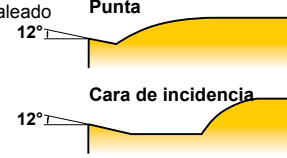
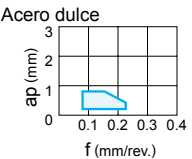
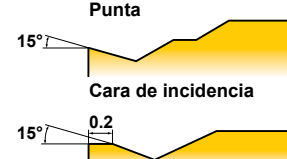
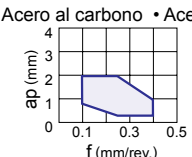
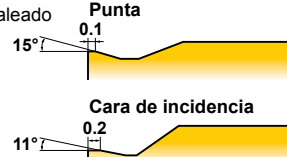
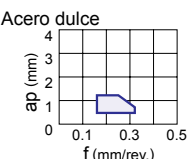
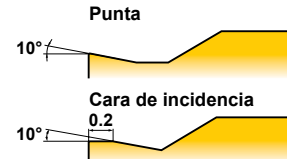
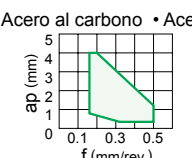
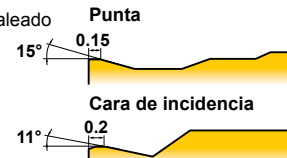


Convencional

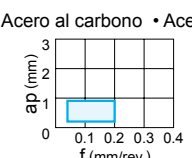
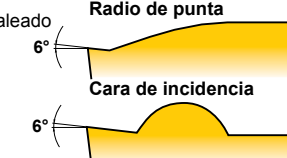
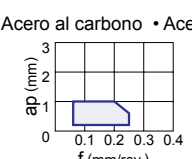
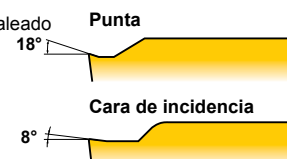
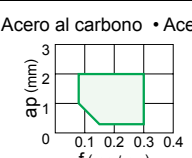
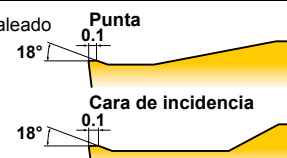


<Condiciones de corte>  
Material: S25C  
Revolución:  $n=398 \text{ min}^{-1}$   
(Exterior:  $vc=250 \text{ m/min.}$ )  
Profundidad de corte:  $ap=1,5 \text{ mm}$   
Avance:  $f=0,15 \text{ mm/rev.}$   
Corte en húmedo

# Sistema de rompevirutas para acero (placas negativas)


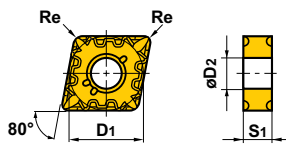

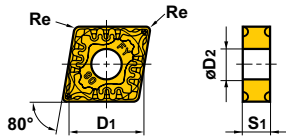

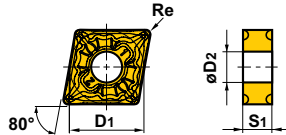

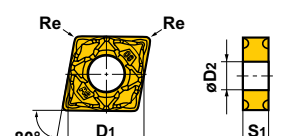

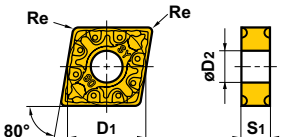

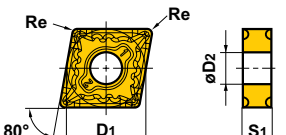

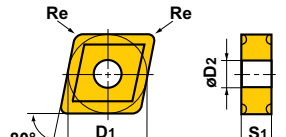

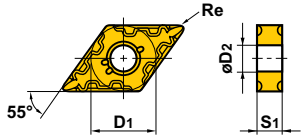
Aplicación	Tolerancia	Rompevirutas	Características	Sección transversal Geometría
Corte acabado	M	<b>FH</b>	<b>Primera recomendación para acabado de acero al carbono, acero de aleación y acero inoxidable.</b> Rompevirutas de doble cara. Control estable de virutas incluso a pocas profundidades de corte.	Acero al carbono • Acero aleado  
	M	<b>FY</b>	<b>Primera recomendación para acabado de acero dulce.</b> Rompevirutas de doble cara. Control efectivo de las virutas. Apto para acabado de acero dulce.	Acero dulce  
Corte ligero	M	<b>LP</b>	<b>Primera recomendación para corte ligero de acero al carbono y de aleación</b> Control de viruta estable en la gama de corte ligero. El filo curvado permite una perfecta evacuación de las virutas.	Acero al carbono • Acero aleado  
	M	<b>SY</b>	<b>Primera recomendación para corte ligero de acero dulce</b> Rompevirutas de doble cara. Control efectivo de las virutas. Apta para corte ligero.	Acero dulce  
Corte medio	M	<b>MP</b>	<b>Primera recomendación para corte medio de acero al carbono y de aleación</b> Apto para corte medio a ligero. Geometría del rompevirutas óptima para copiado y torneado hacia atrás. La geometría del filo de corte es para un equilibrio óptimo entre afilado y resistencia a las roturas.	Acero al carbono • Acero aleado  

# Sistema de rompevirutas para acero (placas positivas)


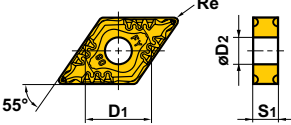

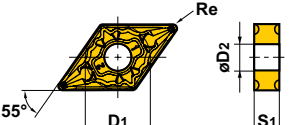

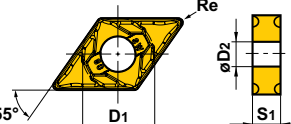

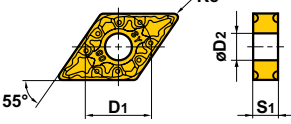

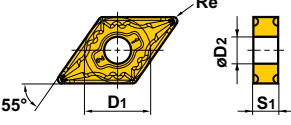

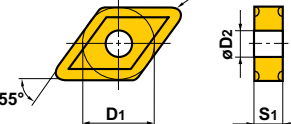

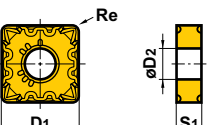

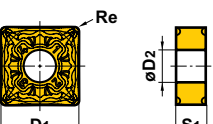
Aplicación	Tolerancia	Rompevirutas	Características	Sección transversal Geometría
Corte acabado	M	<b>NEW FP</b>	<b>Primera recomendación para corte acabado de acero al carbono y de aleación</b> La protuberancia en la punta del rompevirutas controla que las virutas sean regulares a pequeñas profundidades de corte. La rigidez de la punta se mantiene para evitar una rotura anormal. <b>5° 7° Placa positiva</b>	Acero al carbono • Acero aleado  
Corte ligero	M	<b>NEW LP</b>	<b>Primera recomendación para corte ligero de acero al carbono y de aleación</b> Excelente filo de corte debido al gran ángulo de incidencia. Previene la adhesión de las virutas y garantizar un buen acabado de la superficie. El rompevirutas logra una amplia gama de control de las virutas. <b>5° 7° Placa positiva</b>	Acero al carbono • Acero aleado  
Corte medio	M	<b>NEW MP</b>	<b>Primera recomendación para corte medio de acero al carbono y de aleación</b> Excelente resistencia al desgaste y una resistencia superior a la rotura por la parte plana. El ancho rompevirutas reduce la vibración y los atascos de virutas y también previene el aumento de la resistencia al corte incluso en cortes de gran profundidad. <b>5° 7° Placa positiva</b>	Acero al carbono • Acero aleado  

## PLACAS

### ● Placas negativas (con agujero)


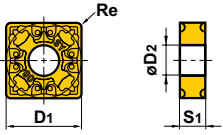

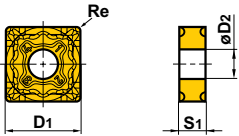

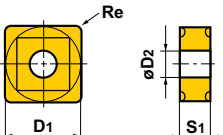

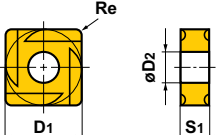

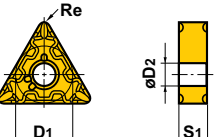

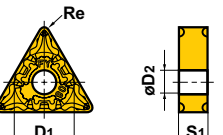

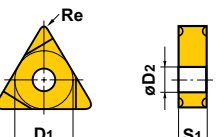

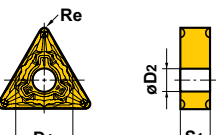
Forma	Referencia	Clase	Stock	Dimensiones (mm)				Geometría
			MP3025	D1	S1	Re	D2	
 Corte acabado	CNMG120402-FH	M	●	12.7	4.76	0.2	5.16	
	120404-FH	M	●	12.7	4.76	0.4	5.16	
	120408-FH	M	●	12.7	4.76	0.8	5.16	
 Corte acabado	CNMG120404-FY	M	●	12.7	4.76	0.4	5.16	
	120408-FY	M	●	12.7	4.76	0.8	5.16	
 Corte ligero	CNMG120404-LP	M	●	12.7	4.76	0.4	5.16	
	120408-LP	M	●	12.7	4.76	0.8	5.16	
 Corte ligero (Wiper)	CNMG120404-SW	M	●	12.7	4.76	0.4	5.16	
	120408-SW	M	●	12.7	4.76	0.8	5.16	
	120412-SW	M	●	12.7	4.76	1.2	5.16	
 Corte ligero	CNMG120404-SY	M	●	12.7	4.76	0.4	5.16	
	120408-SY	M	●	12.7	4.76	0.8	5.16	
 Corte medio	CNMG120404-MP	M	●	12.7	4.76	0.4	5.16	
	120408-MP	M	●	12.7	4.76	0.8	5.16	
	120412-MP	M	●	12.7	4.76	1.2	5.16	
 Corte medio	CNMG120404	M	●	12.7	4.76	0.4	5.16	
	120408	M	●	12.7	4.76	0.8	5.16	
 Corte acabado	DNMG150402-FH	M	●	12.7	4.76	0.2	5.16	
	150404-FH	M	●	12.7	4.76	0.4	5.16	
	150408-FH	M	●	12.7	4.76	0.8	5.16	
	150602-FH	M	●	12.7	6.35	0.2	5.16	
	150604-FH	M	●	12.7	6.35	0.4	5.16	
	150608-FH	M	●	12.7	6.35	0.8	5.16	


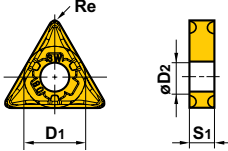

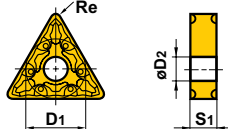

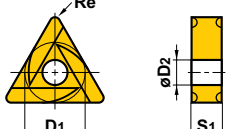

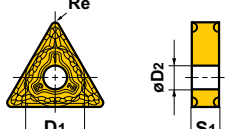

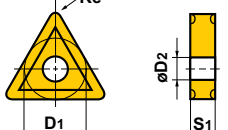

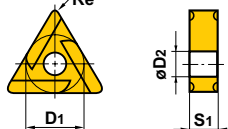

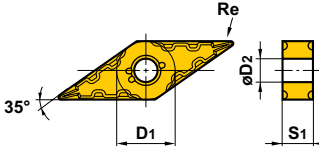

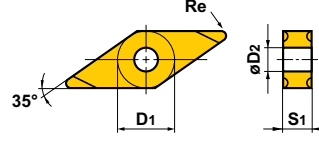


Forma	Referencia	Clase	Stock	Dimensiones (mm)				Geometría
			MP3025	D1	S1	Re	D2	
 Corte acabado	<b>DNMG150404-FY</b>	M	●	12.7	4.76	0.4	5.16	
	<b>150408-FY</b>	M	●	12.7	4.76	0.8	5.16	
	<b>150604-FY</b>	M	●	12.7	6.35	0.4	5.16	
	<b>150608-FY</b>	M	●	12.7	6.35	0.8	5.16	
 Corte ligero	<b>NEW DNMG110404-LP</b>	M	●	9.525	4.76	0.4	3.81	
	<b>NEW 110408-LP</b>	M	●	9.525	4.76	0.8	3.81	
	<b>150404-LP</b>	M	●	12.7	4.76	0.4	5.16	
	<b>150408-LP</b>	M	●	12.7	4.76	0.8	5.16	
	<b>NEW 150412-LP</b>	M	●	12.7	4.76	1.2	5.16	
	<b>150604-LP</b>	M	●	12.7	6.35	0.4	5.16	
<b>150608-LP</b>	M	●	12.7	6.35	0.8	5.16		
 Corte ligero (Wiper)	<b>DNMX150404-SW</b>	M	●	12.7	4.76	0.4	5.16	
	<b>150408-SW</b>	M	●	12.7	4.76	0.8	5.16	
	<b>150604-SW</b>	M	●	12.7	6.35	0.4	5.16	
	<b>150608-SW</b>	M	●	12.7	6.35	0.8	5.16	
 Corte ligero	<b>DNMG150404-SY</b>	M	●	12.7	4.76	0.4	5.16	
	<b>150408-SY</b>	M	●	12.7	4.76	0.8	5.16	
	<b>150604-SY</b>	M	●	12.7	6.35	0.4	5.16	
	<b>150608-SY</b>	M	●	12.7	6.35	0.8	5.16	
 Corte medio	<b>DNMG150404-MP</b>	M	●	12.7	4.76	0.4	5.16	
	<b>150408-MP</b>	M	●	12.7	4.76	0.8	5.16	
	<b>150412-MP</b>	M	●	12.7	4.76	1.2	5.16	
	<b>150604-MP</b>	M	●	12.7	6.35	0.4	5.16	
	<b>150608-MP</b>	M	●	12.7	6.35	0.8	5.16	
	<b>150612-MP</b>	M	●	12.7	6.35	1.2	5.16	
 Corte medio	<b>DNMG150404</b>	M	●	12.7	4.76	0.4	5.16	
	<b>150408</b>	M	●	12.7	4.76	0.8	5.16	
	<b>150604</b>	M	●	12.7	6.35	0.4	5.16	
	<b>150608</b>	M	●	12.7	6.35	0.8	5.16	
 Corte acabado	<b>SNMG120404-FH</b>	M	●	12.7	4.76	0.4	5.16	
	<b>120408-FH</b>	M	●	12.7	4.76	0.8	5.16	
 Corte ligero	<b>SNMG120404-LP</b>	M	●	12.7	4.76	0.4	5.16	
	<b>120408-LP</b>	M	●	12.7	4.76	0.8	5.16	

## PLACAS


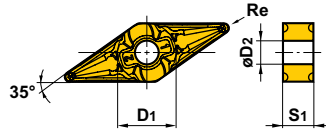

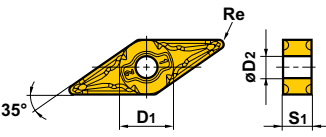

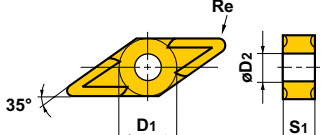

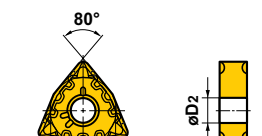

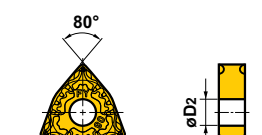

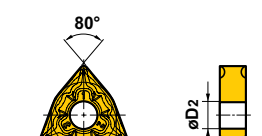

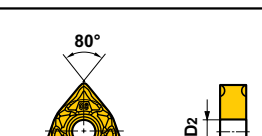

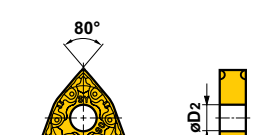
### ● Placas negativas (con agujero)

Forma	Referencia	Clase	Stock	Dimensiones (mm)				Geometría
			MP3025	D1	S1	Re	D2	
 Corte ligero	<b>SNMG120408-SY</b>	M	●	12.7	4.76	0.8	5.16	
 Corte medio	<b>SNMG120404-MP</b>	M	●	12.7	4.76	0.4	5.16	
	<b>120408-MP</b>	M	●	12.7	4.76	0.8	5.16	
	<b>120412-MP</b>	M	●	12.7	4.76	1.2	5.16	
 Corte medio	<b>SNMG090304</b>	M	●	9.525	3.18	0.4	3.81	
	<b>090308</b>	M	●	9.525	3.18	0.8	3.81	
	<b>120404</b>	M	●	12.7	4.76	0.4	5.16	
	<b>120408</b>	M	●	12.7	4.76	0.8	5.16	
 Corte medio	<b>SNGG120404R</b>	G	●	12.7	4.76	0.4	5.16	
	<b>120408R</b>	G	●	12.7	4.76	0.8	5.16	
	<b>120404L</b>	G	●	12.7	4.76	0.4	5.16	
	<b>120408L</b>	G	●	12.7	4.76	0.8	5.16	
 Corte acabado	<b>TNMG160402-FH</b>	M	●	9.525	4.76	0.2	3.81	
	<b>160404-FH</b>	M	●	9.525	4.76	0.4	3.81	
	<b>160408-FH</b>	M	●	9.525	4.76	0.8	3.81	
 Corte acabado	<b>TNMG160404-FY</b>	M	●	9.525	4.76	0.4	3.81	
	<b>160408-FY</b>	M	●	9.525	4.76	0.8	3.81	
 Corte acabado	<b>TNGG160402R-F</b>	G	●	9.525	4.76	0.2	3.81	
	<b>160404R-F</b>	G	●	9.525	4.76	0.4	3.81	
	<b>160408R-F</b>	G	●	9.525	4.76	0.8	3.81	
	<b>160402L-F</b>	G	●	9.525	4.76	0.2	3.81	
	<b>160404L-F</b>	G	●	9.525	4.76	0.4	3.81	
	<b>160408L-F</b>	G	●	9.525	4.76	0.8	3.81	
 Corte ligero	<b>TNMG160404-LP</b>	M	●	9.525	4.76	0.4	3.81	
	<b>160408-LP</b>	M	●	9.525	4.76	0.8	3.81	
	<b>NEW 160412-LP</b>	M	●	9.525	4.76	1.2	3.81	
	<b>NEW 220408-LP</b>	M	●	12.7	4.76	0.8	5.16	


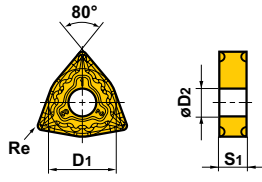

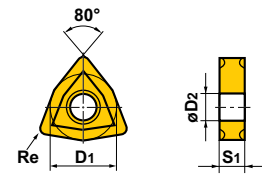
Forma	Referencia	Clase	Stock	Dimensiones (mm)				Geometría
			MP3025	D1	S1	Re	D2	
 Corte ligero (Wiper)	TNMX160404-SW	M	●	9.525	4.76	0.4	3.81	
	160408-SW	M	●	9.525	4.76	0.8	3.81	
 Corte ligero	TNMG160404-SY	M	●	9.525	4.76	0.4	3.81	
	160408-SY	M	●	9.525	4.76	0.8	3.81	
 Corte ligero	TNGG160402R-K	G	●	9.525	4.76	0.2	3.81	
	160404R-K	G	●	9.525	4.76	0.4	3.81	
	160408R-K	G	●	9.525	4.76	0.8	3.81	
	160402L-K	G	●	9.525	4.76	0.2	3.81	
	160404L-K	G	●	9.525	4.76	0.4	3.81	
	160408L-K	G	●	9.525	4.76	0.8	3.81	
 Corte medio	TNMG160404-MP	M	●	9.525	4.76	0.4	3.81	
	160408-MP	M	●	9.525	4.76	0.8	3.81	
	160412-MP	M	●	9.525	4.76	1.2	3.81	
 Corte medio	TNMG160404	M	●	9.525	4.76	0.4	3.81	
	160408	M	●	9.525	4.76	0.8	3.81	
 Corte medio	TNGG160402R	G	●	9.525	4.76	0.2	3.81	
	160404R	G	●	9.525	4.76	0.4	3.81	
	160408R	G	●	9.525	4.76	0.8	3.81	
	160402L	G	●	9.525	4.76	0.2	3.81	
	160404L	G	●	9.525	4.76	0.4	3.81	
	160408L	G	●	9.525	4.76	0.8	3.81	
 Corte acabado	VNMG160402-FH	M	●	9.525	4.76	0.2	3.81	
	160404-FH	M	●	9.525	4.76	0.4	3.81	
	160408-FH	M	●	9.525	4.76	0.8	3.81	
 Corte acabado	VNGG160402R-F	G	●	9.525	4.76	0.2	3.81	
	160404R-F	G	●	9.525	4.76	0.4	3.81	
	160402L-F	G	●	9.525	4.76	0.2	3.81	
	160404L-F	G	●	9.525	4.76	0.4	3.81	

## PLACAS

### ● Placas negativas (con agujero)


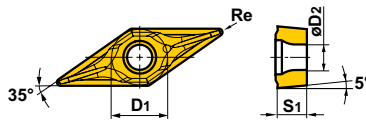

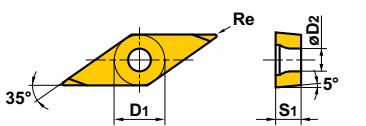

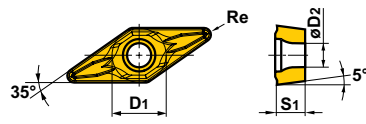

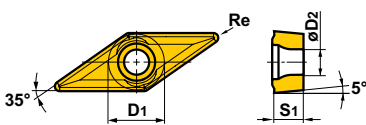

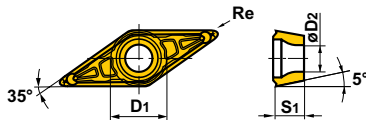

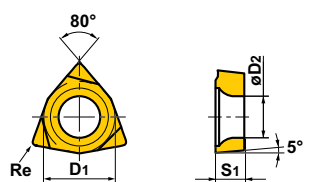

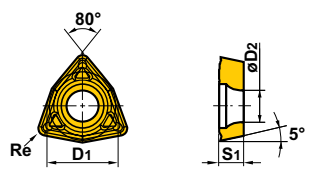
Forma	Referencia	Clase	Stock	Dimensiones (mm)				Geometría
			MP3025	D1	S1	Re	D2	
 Corte ligero	VNMG160404-LP	M	●	9.525	4.76	0.4	3.81	
	160408-LP	M	●	9.525	4.76	0.8	3.81	
 Corte medio	VNMG160404-MP	M	●	9.525	4.76	0.4	3.81	
	160408-MP	M	●	9.525	4.76	0.8	3.81	
 Corte medio	VNMG160404	M	●	9.525	4.76	0.4	3.81	
	160408	M	●	9.525	4.76	0.8	3.81	
 Corte acabado	WNMG080404-FH	M	●	12.7	4.76	0.4	5.16	
	080408-FH	M	●	12.7	4.76	0.8	5.16	
 Corte acabado	WNMG080404-FY	M	●	12.7	4.76	0.4	5.16	
	080408-FY	M	●	12.7	4.76	0.8	5.16	
 Corte ligero	<b>NEW</b> WNMG06T304-LP	M	●	9.525	3.97	0.4	3.81	
	<b>NEW</b> 06T308-LP	M	●	9.525	3.97	0.8	3.81	
	080404-LP	M	●	12.7	4.76	0.4	5.16	
	080408-LP	M	●	12.7	4.76	0.8	5.16	
 Corte ligero (Wiper)	WNMG060404-SW	M	●	9.525	4.76	0.4	3.81	
	060408-SW	M	●	9.525	4.76	0.8	3.81	
	080404-SW	M	●	12.7	4.76	0.4	5.16	
	080408-SW	M	●	12.7	4.76	0.8	5.16	
	080412-SW	M	●	12.7	4.76	1.2	5.16	
 Corte ligero	WNMG080404-SY	M	●	12.7	4.76	0.4	5.16	
	080408-SY	M	●	12.7	4.76	0.8	5.16	





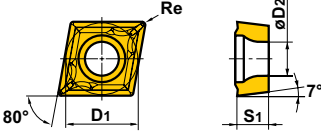

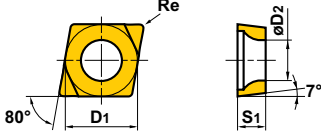


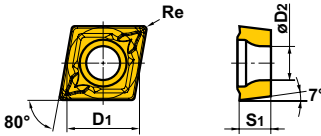

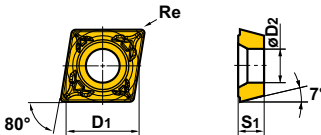

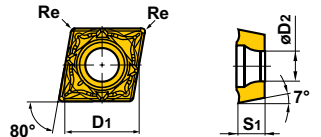


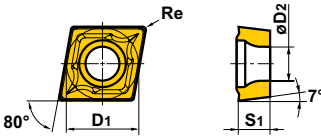

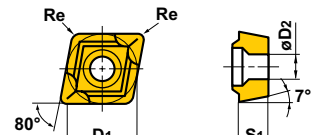
Forma	Referencia	Clase	Stock	Dimensiones (mm)				Geometría
			<i>MP3025</i>	D1	S1	Re	D2	
<b>MP</b>  Corte medio	<b>WNMG080404-MP</b>	M	●	12.7	4.76	0.4	5.16	
	<b>080408-MP</b>	M	●	12.7	4.76	0.8	5.16	
	<b>080412-MP</b>	M	●	12.7	4.76	1.2	5.16	
<b>Estándar</b>  Corte medio	<b>WNMG080404</b>	M	●	12.7	4.76	0.4	5.16	
	<b>080408</b>	M	●	12.7	4.76	0.8	5.16	

## PLACAS

### ● Placas positivas de 5° (con agujero)

Forma	Referencia	Clase	Stock	Dimensiones (mm)				Geometría
			MP3025	D1	S1	Re	D2	
 Corte acabado	VBMT110302-FP	M	●	6.35	3.18	0.2	2.9	
	110304-FP	M	●	6.35	3.18	0.4	2.9	
	110308-FP	M	●	6.35	3.18	0.8	2.9	
	160404-FP	M	●	9.525	4.76	0.4	4.4	
	160408-FP	M	●	9.525	4.76	0.8	4.4	
 Corte acabado	VBGT110302R-F	G	●	6.35	3.18	0.2	2.85	
	110302L-F	G	●	6.35	3.18	0.2	2.85	
 Corte ligero	VBMT110304-LP	M	●	6.35	3.18	0.4	2.9	
	110308-LP	M	●	6.35	3.18	0.8	2.9	
	160404-LP	M	●	9.525	4.76	0.4	4.4	
	160408-LP	M	●	9.525	4.76	0.8	4.4	
 Corte medio	VBMT160404-MP	M	●	9.525	4.76	0.4	4.4	
	160408-MP	M	●	9.525	4.76	0.8	4.4	
 Corte medio	VBMT110304-MV	M	●	6.35	3.18	0.4	2.85	
	110308-MV	M	●	6.35	3.18	0.8	2.85	
	160404-MV	M	●	9.525	4.76	0.4	4.43	
	160408-MV	M	●	9.525	4.76	0.8	4.43	
 Corte acabado	WBGT020102L-F	G	●	3.97	1.59	0.2	2.3	
	020104L-F	G	●	3.97	1.59	0.4	2.3	
	L30202L-F	G	●	4.76	2.38	0.2	2.3	
	L30204L-F	G	●	4.76	2.38	0.4	2.3	
 Corte medio	WBMTL30202L-MV	M	●	4.76	2.38	0.2	2.3	
	L30202R-MV	M	●	4.76	2.38	0.2	2.3	
	L30204L-MV	M	●	4.76	2.38	0.4	2.3	
	L30204R-MV	M	●	4.76	2.38	0.4	2.3	


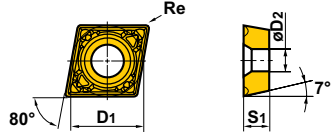

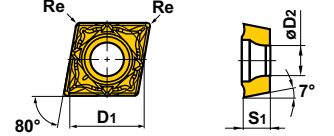

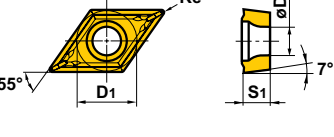

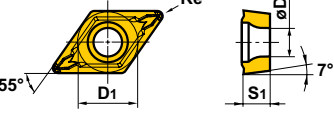

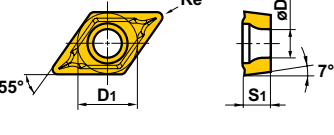

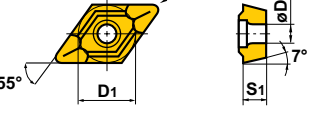


## ● Placas positivas de 7° (con agujero)

Forma	Referencia	Clase	Stock	Dimensiones (mm)				Geometría
			MP3025	D1	S1	Re	D2	
  Corte acabado	CCMT060202-FP	M	●	6.35	2.38	0.2	2.8	
	060204-FP	M	●	6.35	2.38	0.4	2.8	
	09T302-FP	M	●	9.525	3.97	0.2	4.4	
	09T304-FP	M	●	9.525	3.97	0.4	4.4	
	09T308-FP	M	●	9.525	3.97	0.8	4.4	
 Corte acabado	CCGT03S102L-F	G	●	3.97	1.39	0.2	2.0	
	03S104L-F	G	●	3.97	1.39	0.4	2.0	
	04T002L-F	G	●	4.76	1.79	0.2	2.4	
	04T004L-F	G	●	4.76	1.79	0.4	2.4	
  Corte ligero	CCMT060204-LP	M	●	6.35	2.38	0.4	2.8	
	060208-LP	M	●	6.35	2.38	0.8	2.8	
	09T304-LP	M	●	9.525	3.97	0.4	4.4	
	09T308-LP	M	●	9.525	3.97	0.8	4.4	
 Corte ligero	CCMH060202-SV	M	●	6.35	2.38	0.2	2.8	
	060204-SV	M	●	6.35	2.38	0.4	2.8	
 Corte ligero (Wiper)	CCMT060202-SW	M	●	6.35	2.38	0.2	2.8	
	060204-SW	M	●	6.35	2.38	0.4	2.8	
	09T302-SW	M	●	9.525	3.97	0.2	4.4	
	09T304-SW	M	●	9.525	3.97	0.4	4.4	
  Corte medio	CCMT060204-MP	M	●	6.35	2.38	0.4	2.8	
	060208-MP	M	●	6.35	2.38	0.8	2.8	
	09T304-MP	M	●	9.525	3.97	0.4	4.4	
	09T308-MP	M	●	9.525	3.97	0.8	4.4	
	120404-MP	M	●	12.7	4.76	0.4	5.5	
	120408-MP	M	●	12.7	4.76	0.8	5.5	
 Corte medio	CCMT060202	M	●	6.35	2.38	0.2	2.8	
	060204	M	●	6.35	2.38	0.4	2.8	
	080304	M	●	7.94	3.18	0.4	3.4	
	09T302	M	●	9.525	3.97	0.2	4.4	
	09T304	M	●	9.525	3.97	0.4	4.4	
	09T308	M	●	9.525	3.97	0.8	4.4	
	120404	M	●	12.7	4.76	0.4	5.5	
	120408	M	●	12.7	4.76	0.8	5.5	


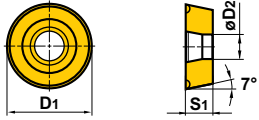

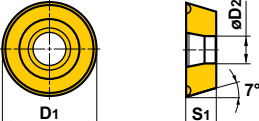

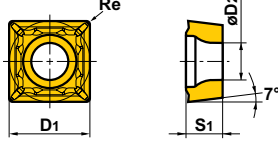

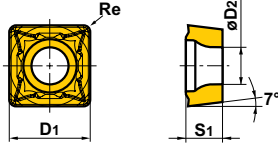

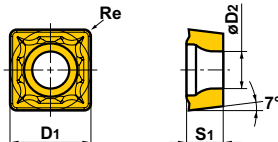

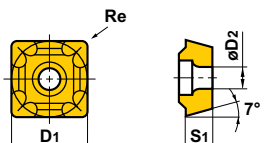

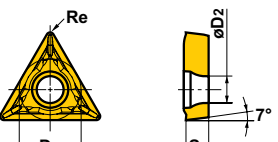
# MP3025

## PLACAS

### ● Placas positivas de 7° (con agujero)


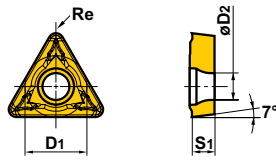

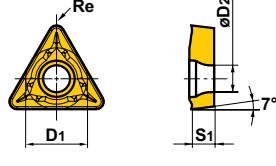

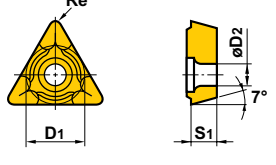

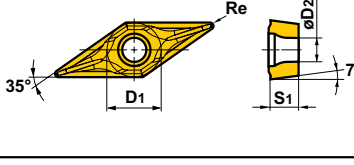

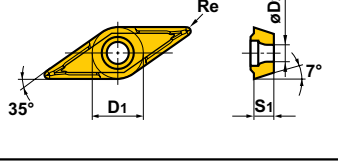

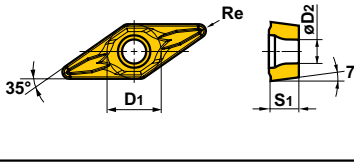
Forma	Referencia	Clase	Stock	Dimensiones (mm)				Geometría
			MP3025	D1	S1	Re	D2	
 Corte medio	CCMH060202-MV	M	●	6.35	2.38	0.2	2.8	
	060204-MV	M	●	6.35	2.38	0.4	2.8	
 Corte medio (Wiper)	CCMT060204-MW	M	●	6.35	2.38	0.4	2.8	
	060208-MW	M	●	6.35	2.38	0.8	2.8	
	09T304-MW	M	●	9.525	3.97	0.4	4.4	
	09T308-MW	M	●	9.525	3.97	0.8	4.4	
 Corte acabado	DCMT070202-FP	M	●	6.35	2.38	0.2	2.8	
	070204-FP	M	●	6.35	2.38	0.4	2.8	
	11T302-FP	M	●	9.525	3.97	0.2	4.4	
	11T304-FP	M	●	9.525	3.97	0.4	4.4	
	11T308-FP	M	●	9.525	3.97	0.8	4.4	
 Corte ligero	DCMT070204-LP	M	●	6.35	2.38	0.4	2.8	
	070208-LP	M	●	6.35	2.38	0.8	2.8	
	11T304-LP	M	●	9.525	3.97	0.4	4.4	
	11T308-LP	M	●	9.525	3.97	0.8	4.4	
 Corte medio	DCMT070204-MP	M	●	6.35	2.38	0.4	2.8	
	070208-MP	M	●	6.35	2.38	0.8	2.8	
	11T304-MP	M	●	9.525	3.97	0.4	4.4	
	11T308-MP	M	●	9.525	3.97	0.8	4.4	
	150404-MP	M	●	12.7	4.76	0.4	5.5	
	150408-MP	M	●	12.7	4.76	0.8	5.5	
 Corte medio	DCMT070202	M	●	6.35	2.38	0.2	2.8	
	070204	M	●	6.35	2.38	0.4	2.8	
	070208	M	●	6.35	2.38	0.8	2.8	
	11T302	M	●	9.525	3.97	0.2	4.4	
	11T304	M	●	9.525	3.97	0.4	4.4	
	11T308	M	●	9.525	3.97	0.8	4.4	
	150404	M	●	12.7	4.76	0.4	5.5	
	150408	M	●	12.7	4.76	0.8	5.5	
 Corte medio	DCMT070202-MV	M	●	6.35	2.38	0.2	2.8	
	070204-MV	M	●	6.35	2.38	0.4	2.8	
	070208-MV	M	●	6.35	2.38	0.8	2.8	
	11T302-MV	M	●	9.525	3.97	0.2	4.4	
	11T304-MV	M	●	9.525	3.97	0.4	4.4	
	11T308-MV	M	●	9.525	3.97	0.8	4.4	


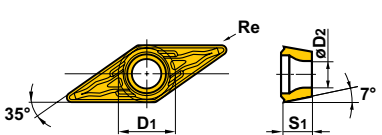

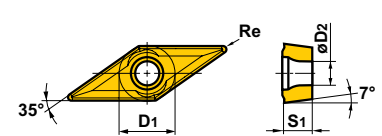

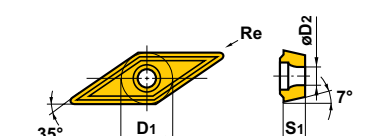

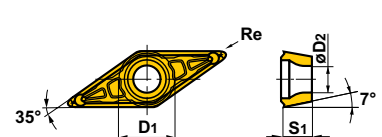

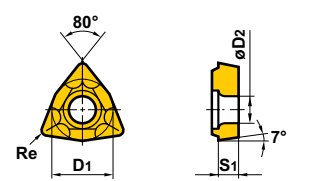


Forma	Referencia	Clase	Stock	Dimensiones (mm)				Geometría
			MP3025	D1	S1	Re	D2	
<b>Estándar</b>  Corte medio	<b>RCMT0602M0</b>	M	●	6	2.38	-	2.8	
	<b>0803M0</b>	M	●	8	3.18	-	3.4	
<b>Estándar</b>  Corte medio	<b>RCMX1003M0</b>	M	●	10	3.18	-	3.6	
	<b>1204M0</b>	M	●	12	4.76	-	4.2	
<b>NEW</b> <b>FP</b>  Corte acabado	<b>SCMT09T304-FP</b>	M	●	9.525	3.97	0.4	4.4	
	<b>09T308-FP</b>	M	●	9.525	3.97	0.8	4.4	
<b>NEW</b> <b>LP</b>  Corte ligero	<b>SCMT09T304-LP</b>	M	●	9.525	3.97	0.4	4.4	
	<b>09T308-LP</b>	M	●	9.525	3.97	0.8	4.4	
<b>NEW</b> <b>MP</b>  Corte medio	<b>SCMT09T304-MP</b>	M	●	9.525	3.97	0.4	4.4	
	<b>09T308-MP</b>	M	●	9.525	3.97	0.8	4.4	
	<b>120404-MP</b>	M	●	12.7	4.76	0.4	5.5	
	<b>120408-MP</b>	M	●	12.7	4.76	0.8	5.5	
<b>Estándar</b>  Corte medio	<b>SCMT09T304</b>	M	●	9.525	3.97	0.4	4.4	
	<b>09T308</b>	M	●	9.525	3.97	0.8	4.4	
	<b>120404</b>	M	●	12.7	4.76	0.4	5.5	
	<b>120408</b>	M	●	12.7	4.76	0.8	5.5	
<b>NEW</b> <b>FP</b>  Corte acabado	<b>TCMT090202-FP</b>	M	●	5.56	2.38	0.2	2.5	
	<b>090204-FP</b>	M	●	5.56	2.38	0.4	2.5	
	<b>110202-FP</b>	M	●	6.35	2.38	0.2	2.8	
	<b>110204-FP</b>	M	●	6.35	2.38	0.4	2.8	
	<b>16T304-FP</b>	M	●	9.525	3.97	0.4	4.4	

## PLACAS


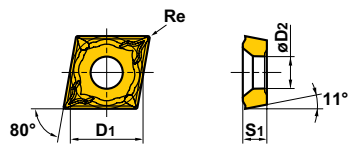

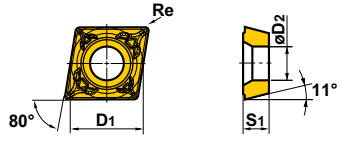

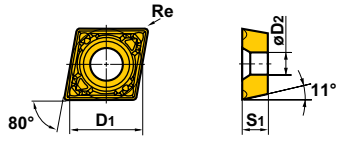

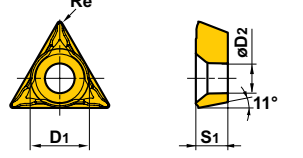

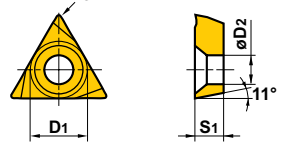

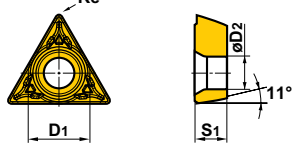
### ● Placas positivas de 7° (con agujero)

Forma	Referencia	Clase	Stock	Dimensiones (mm)				Geometría
			MP3025	D1	S1	Re	D2	
 Corte ligero	TCMT090204-LP	M	●	5.56	2.38	0.4	2.5	
	090208-LP	M	●	5.56	2.38	0.8	2.5	
	110204-LP	M	●	6.35	2.38	0.4	2.8	
	110208-LP	M	●	6.35	2.38	0.8	2.8	
	16T304-LP	M	●	9.525	3.97	0.4	4.4	
	16T308-LP	M	●	9.525	3.97	0.8	4.4	
 Corte medio	TCMT090204-MP	M	●	5.56	2.38	0.4	2.5	
	090208-MP	M	●	5.56	2.38	0.8	2.5	
	110204-MP	M	●	6.35	2.38	0.4	2.8	
	110208-MP	M	●	6.35	2.38	0.8	2.8	
	130304-MP	M	●	7.94	3.18	0.4	3.4	
	16T304-MP	M	●	9.525	3.97	0.4	4.4	
	16T308-MP	M	●	9.525	3.97	0.8	4.4	
16T312-MP	M	●	9.525	3.97	1.2	4.4		
 Corte medio	TCMT080204	M	●	4.76	2.38	0.4	2.3	
	090204	M	●	5.56	2.38	0.4	2.5	
	110202	M	●	6.35	2.38	0.2	2.8	
	110204	M	●	6.35	2.38	0.4	2.8	
	110208	M	●	6.35	2.38	0.8	2.8	
	130302	M	●	7.94	3.18	0.2	3.4	
	130304	M	●	7.94	3.18	0.4	3.4	
	16T304	M	●	9.525	3.97	0.4	4.4	
16T308	M	●	9.525	3.97	0.8	4.4		
 Corte acabado	VCMT110302-FP	M	●	6.35	3.18	0.2	2.8	
	110304-FP	M	●	6.35	3.18	0.4	2.8	
	160404-FP	M	●	9.525	4.76	0.4	4.4	
	160408-FP	M	●	9.525	4.76	0.8	4.4	
 Corte acabado	VCMT080202-FV	M	●	4.76	2.38	0.2	2.42	
	080204-FV	M	●	4.76	2.38	0.4	2.42	
 Corte ligero	VCMT110304-LP	M	●	6.35	3.18	0.4	2.8	
	110308-LP	M	●	6.35	3.18	0.8	2.8	
	160404-LP	M	●	9.525	4.76	0.4	4.4	
	160408-LP	M	●	9.525	4.76	0.8	4.4	


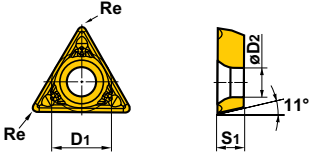

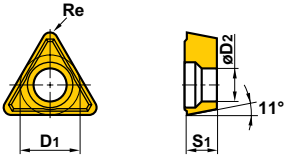

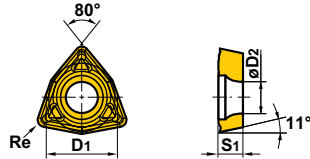
Forma	Referencia	Clase	Stock	Dimensiones (mm)				Geometría
			MP3025	D1	S1	Re	D2	
<b>SV</b>  Corte ligero	VCMT080202-SV	M	●	4.76	2.38	0.2	2.42	
	080204-SV	M	●	4.76	2.38	0.4	2.42	
<b>MP</b>  Corte medio	VCMT160404-MP	M	●	9.525	4.76	0.4	4.4	
	160408-MP	M	●	9.525	4.76	0.8	4.4	
	160412-MP	M	●	9.525	4.76	1.2	4.4	
<b>Estándar</b>  Corte medio	VCMT110304	M	●	6.35	3.18	0.4	2.8	
	160404	M	●	9.525	4.76	0.4	4.4	
	160408	M	●	9.525	4.76	0.8	4.4	
<b>MV</b>  Corte medio	VCMT080202-MV	M	●	4.76	2.38	0.2	2.42	
	080204-MV	M	●	4.76	2.38	0.4	2.42	
<b>Estándar</b>  Corte medio	WCMT020102	M	●	3.97	1.59	0.2	2.3	
	020104	M	●	3.97	1.59	0.4	2.3	
	L30202	M	●	4.76	2.38	0.2	2.3	
	L30204	M	●	4.76	2.38	0.4	2.3	
	040202	M	●	6.35	2.38	0.2	2.8	
	040204	M	●	6.35	2.38	0.4	2.8	
	06T304	M	●	9.525	3.97	0.4	4.4	
	06T308	M	●	9.525	3.97	0.8	4.4	

## PLACAS


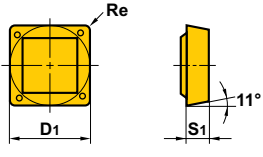

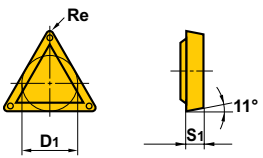
### ● Placas positivas de 11° (con agujero)

Forma	Referencia	Clase	Stock	Dimensiones (mm)				Geometría
			MP3025	D1	S1	Re	D2	
 Corte acabado	CPMH080202-FV	M	●	7.94	2.38	0.2	3.5	
	080204-FV	M	●	7.94	2.38	0.4	3.5	
	090302-FV	M	●	9.525	3.18	0.2	4.5	
	090304-FV	M	●	9.525	3.18	0.4	4.5	
	090308-FV	M	●	9.525	3.18	0.8	4.5	
 Corte ligero	CPMH080202-SV	M	●	7.94	2.38	0.2	3.5	
	080204-SV	M	●	7.94	2.38	0.4	3.5	
	090302-SV	M	●	9.525	3.18	0.2	4.5	
	090304-SV	M	●	9.525	3.18	0.4	4.5	
	090308-SV	M	●	9.525	3.18	0.8	4.5	
 Corte medio	CPMH080204-MV	M	●	7.94	2.38	0.4	3.5	
	080208-MV	M	●	7.94	2.38	0.8	3.5	
	090304-MV	M	●	9.525	3.18	0.4	4.5	
	090308-MV	M	●	9.525	3.18	0.8	4.5	
 Corte acabado	TPMH080202-FV	M	●	4.76	2.38	0.2	2.4	
	080204-FV	M	●	4.76	2.38	0.4	2.4	
	090202-FV	M	●	5.56	2.38	0.2	2.9	
	090204-FV	M	●	5.56	2.38	0.4	2.9	
	110302-FV	M	●	6.35	3.18	0.2	3.4	
	110304-FV	M	●	6.35	3.18	0.4	3.4	
	110308-FV	M	●	6.35	3.18	0.8	3.4	
	160302-FV	M	●	9.525	3.18	0.2	4.4	
	160304-FV	M	●	9.525	3.18	0.4	4.4	
160308-FV	M	●	9.525	3.18	0.8	4.4		
 Corte acabado	TPGH080202L-FS	G	●	4.76	2.38	0.2	2.4	
	080204L-FS	G	●	4.76	2.38	0.4	2.4	
	090202L-FS	G	●	5.56	2.38	0.2	2.9	
	090204L-FS	G	●	5.56	2.38	0.4	2.9	
	110302L-FS	G	●	6.35	3.18	0.2	3.4	
	110304L-FS	G	●	6.35	3.18	0.4	3.4	
	160304L-FS	G	●	9.525	3.18	0.4	4.4	
	160308L-FS	G	●	9.525	3.18	0.8	4.4	
 Corte ligero	TPMH080202-SV	M	●	4.76	2.38	0.2	2.4	
	080204-SV	M	●	4.76	2.38	0.4	2.4	
	090202-SV	M	●	5.56	2.38	0.2	2.9	
	090204-SV	M	●	5.56	2.38	0.4	2.9	
	110302-SV	M	●	6.35	3.18	0.2	3.4	
	110304-SV	M	●	6.35	3.18	0.4	3.4	
	110308-SV	M	●	6.35	3.18	0.8	3.4	
	160302-SV	M	●	9.525	3.18	0.2	4.4	
	160304-SV	M	●	9.525	3.18	0.4	4.4	
160308-SV	M	●	9.525	3.18	0.8	4.4		



Forma	Referencia	Clase	Stock	Dimensiones (mm)				Geometría
			MP3025	D1	S1	Re	D2	
 Corte medio	TPMH080202-MV	M	●	4.76	2.38	0.2	2.4	
	080204-MV	M	●	4.76	2.38	0.4	2.4	
	090202-MV	M	●	5.56	2.38	0.2	2.9	
	090204-MV	M	●	5.56	2.38	0.4	2.9	
	090208-MV	M	●	5.56	2.38	0.8	2.9	
	110302-MV	M	●	6.35	3.18	0.2	3.4	
	110304-MV	M	●	6.35	3.18	0.4	3.4	
	110308-MV	M	●	6.35	3.18	0.8	3.4	
	160304-MV	M	●	9.525	3.18	0.4	4.4	
	160308-MV	M	●	9.525	3.18	0.8	4.4	
 Corte medio	TPMX110304	M	●	6.35	3.18	0.4	3.5	
	110308	M	●	6.35	3.18	0.8	3.5	
 Corte medio	WPMT040202-MV	M	●	6.35	2.38	0.2	2.8	
	040204-MV	M	●	6.35	2.38	0.4	2.8	
	060304-MV	M	●	9.525	3.18	0.4	4.4	
	060308-MV	M	●	9.525	3.18	0.8	4.4	

### ● Placas positivas de 11° (sin agujero)

Forma	Referencia	Clase	Stock	Dimensiones (mm)				Geometría
			MP3025	D1	S1	Re	D2	
 Ligero a Corte medio	SPMR090304	M	●	9.525	3.18	0.4	-	
	090308	M	●	9.525	3.18	0.8	-	
	120304	M	●	12.7	3.18	0.4	-	
	120308	M	●	12.7	3.18	0.8	-	
 Ligero a Corte medio	TPMR090202	M	●	5.56	2.38	0.2	-	
	090204	M	●	5.56	2.38	0.4	-	
	090208	M	●	5.56	2.38	0.8	-	
	110302	M	●	6.35	3.18	0.2	-	
	110304	M	●	6.35	3.18	0.4	-	
	110308	M	●	6.35	3.18	0.8	-	
	160304	M	●	9.525	3.18	0.4	-	
	160308	M	●	9.525	3.18	0.8	-	
	160312	M	●	9.525	3.18	1.2	-	

# Cermet recubierto de PVD para acero

## CONDICIONES DE CORTE RECOMENDADAS

### Placas negativas (torneado exterior)

Material de trabajo	Dureza	Modo de corte		Rompevirutas	Velocidad de corte (m/min)	Avance (mm/rev.)	Profundidad de corte (mm)
Acero dulce (SS400, S10C etc.)	<180HB	Corte general	Corte acabado	<b>FY</b>	275–420	0.09–0.23	0.20–0.80
			Corte ligero	<b>SY</b>	250–385	0.16–0.33	0.50–1.20
Acero al carbono, acero aleado (S45C, SCM440 etc.)	180–280HB	Corte estable	Corte acabado	<b>R/L-F</b>	210–325	0.05–0.15	0.10–0.50
			Corte ligero	<b>LP</b>	195–295	0.10–0.40	0.30–2.00
			Corte ligero	<b>SW</b>	195–295	0.10–0.50	0.30–2.50
			Corte ligero	<b>R/L-K</b>	195–295	0.08–0.20	0.30–1.20
			Corte medio	<b>MP</b>	175–270	0.16–0.50	0.30–4.00
			Corte medio	<b>Estándar</b>	175–270	0.25–0.60	1.50–5.00
		Corte medio	<b>Dcha./Izqda.</b>	175–270	0.15–0.32	0.40–2.00	
		Corte general	Corte acabado	<b>FH</b>	210–325	0.08–0.20	0.20–1.00
Corte general	Corte medio	<b>LP</b>	195–295	0.10–0.40	0.30–2.00		

### Placas positivas de 7° (portaherramientas SP, torneado exterior)

Material de trabajo	Dureza	Modo de corte		Rompevirutas	Velocidad de corte (m/min)	Avance (mm/rev.)	Profundidad de corte (mm)
Acero dulce (SS400, S10C etc.)	<180HB	Corte estable	Corte acabado	<b>R/L-F</b>	230–350	0.05–0.12	0.10–1.50
			Corte ligero	<b>MV, Estándar</b>	190–295	0.08–0.30	0.30–2.00
		Corte general	Corte acabado	<b>FP, FV</b>	230–350	0.04–0.20	0.20–0.90
			Corte ligero	<b>LP</b>	230–350	0.06–0.25	0.20–1.00
Acero al carbono, acero aleado (S45C, SCM440 etc.)	180–280HB	Corte estable	Corte acabado	<b>R/L-F</b>	170–260	0.05–0.12	0.10–0.50
			Corte ligero	<b>SV</b>	170–260	0.06–0.25	0.20–1.00
			Corte medio	<b>MV, Estándar</b>	140–215	0.08–0.30	0.30–2.00
			Corte medio	<b>MW</b>	140–215	0.10–0.35	0.80–2.50
		Corte general	Corte acabado	<b>FP, FV</b>	170–260	0.04–0.20	0.20–0.90
			Corte ligero	<b>LP</b>	170–260	0.06–0.25	0.20–1.00
			Corte ligero	<b>SW</b>	170–260	0.06–0.24	0.20–1.50
			Corte medio	<b>MP</b>	140–215	0.08–0.30	0.30–2.00
Acero al carbono, acero aleado (SNCM439 etc.)	280–350HB	Corte general	Corte medio	<b>MP</b>	100–155	0.08–0.30	0.30–2.00

### Placas positivas de 11° (portaherramientas MC, torneado exterior)

Material de trabajo	Dureza	Modo de corte		Rompevirutas	Velocidad de corte (m/min)	Avance (mm/rev.)	Profundidad de corte (mm)
Acero dulce (SS400, S10C etc.)	<180HB	Corte general	Corte de ligero a medio	<b>Estándar</b>	190–295	0.08–0.30	0.30–2.00
Acero al carbono, acero aleado (S45C, SCM440 etc.)	180–280HB	Corte general	Corte de ligero a medio	<b>Estándar</b>	140–215	0.08–0.30	0.30–2.00

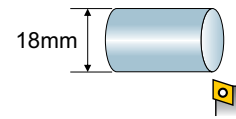
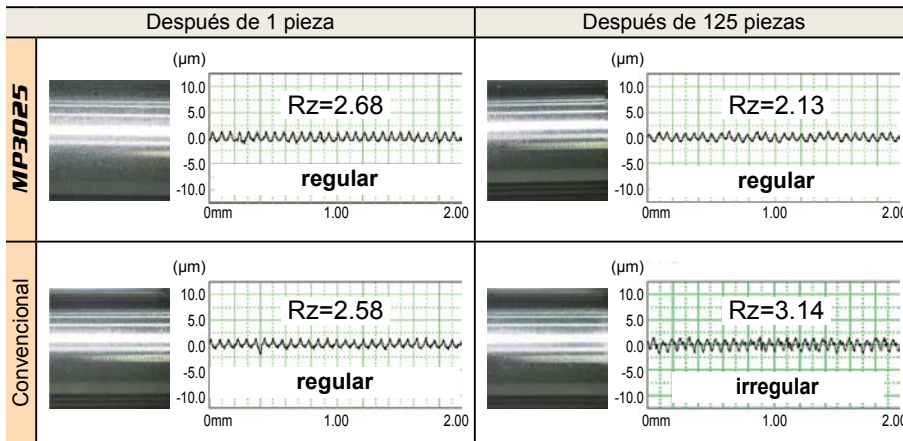
### Placas positivas, 5°/7° (barras de mandrinar)

Material de trabajo	Dureza	Modo de corte		Rompevirutas	Velocidad de corte (m/min)	Avance (mm/rev.)	Profundidad de corte (mm)
Acero dulce (SS400, S10C etc.)	<180HB	Corte general	Corte acabado	<b>FP, FV</b>	230–350	0.04–0.20	0.20–0.90
			Corte ligero	<b>LP</b>	230–350	0.06–0.25	0.20–1.00
			Corte medio	<b>MP, MV, estándar</b>	190–295	0.08–0.30	0.30–2.00
Acero al carbono, acero aleado (S45C, SCM440 etc.)	180–280HB	Corte general	Corte acabado	<b>FP</b>	170–260	0.04–0.20	0.20–0.90
			Corte ligero	<b>LP</b>	170–260	0.06–0.25	0.20–1.00
			Corte medio	<b>MP</b>	140–215	0.08–0.30	0.30–2.00
Acero al carbono, acero aleado (SNCM439 etc.)	280–350HB	Corte general	Corte acabado	<b>FP</b>	120–185	0.04–0.20	0.20–0.90
			Corte ligero	<b>LP</b>	120–185	0.06–0.25	0.20–1.00
			Corte medio	<b>MP</b>	100–155	0.08–0.30	0.30–2.00

\*Las condiciones de corte recomendadas para placa positiva de 5° y 7° pueden variar dependiendo del voladizo. Consulte las condiciones de corte recomendadas para la barra de mandrinar cuando avellane.

## DATOS TÉCNICOS

### Comparación acabado de la superficie.

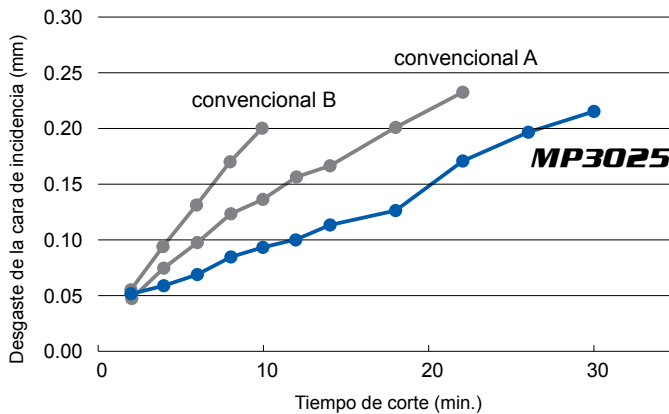


<Condiciones de corte>

Material: JIS-S45C  
 Placas: DCMT11T304  
 Velocidad de corte:  $vc=150$  m/min  
 Profundidad de corte:  $ap=1.0$  mm  
 Avance:  $f=0,07$  mm/rev  
 Corte en húmedo

MP3025 mantiene un acabado de superficie de gran calidad tras 125 piezas.

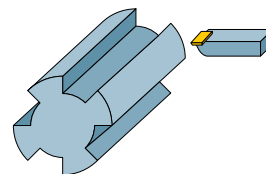
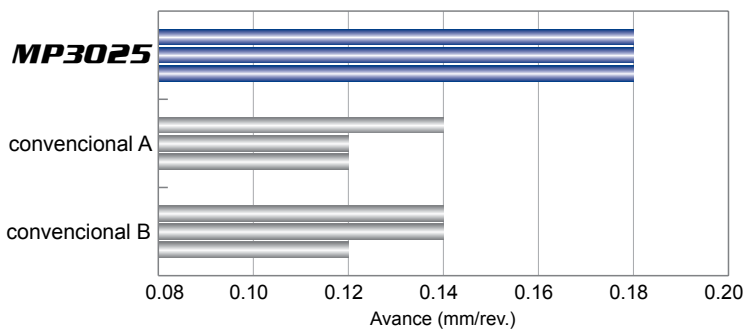
### Comparación de la resistencia al desgaste



<Condiciones de corte>

Material: S45C  
 Placas: CNMG120408-00  
 Velocidad de corte:  $vc=250$  m/min  
 Profundidad de corte:  $ap=1.0$  mm  
 Avance:  $f=0,15$  mm/rev  
 Corte en húmedo

### Comparación de resistencia a la rotura

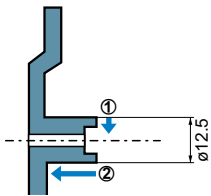
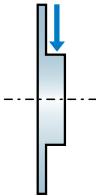
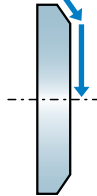
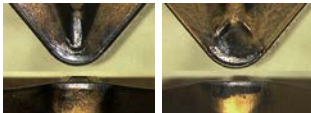
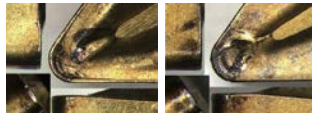
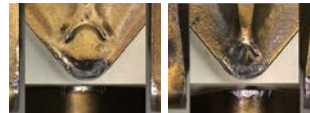


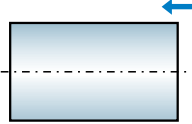
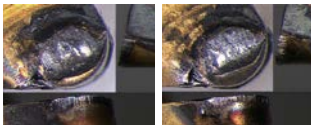
<Condiciones de corte>

Material: SCM440  
 Placas: CNMG120408-00  
 Velocidad de corte:  $vc=200$  m/min  
 Profundidad de corte:  $ap=1.0$  mm  
 Corte seco

# Cermet recubierto de PVD para acero

## Ejemplos de aplicación

Placa	WNMG080408-LP (MP3025)	DNMG150404-LP (MP3025)	WNMG080408-LP (MP3025)
Material	Piñón (JIS-SPHC) 	Piezas de motor (JIS-SCM420H) 	JIS-SS400 
Condiciones de corte	Velocidad de corte (m/min.)	98	200
	Área de avance (mm/min.)	0.2	0.12
	Profundidad de corte (mm)	0.35	0.3
Refrigerante	Corte húmedo	Corte húmedo	Corte seco
Resultados	Convencional <b>MP3025</b>  <p>MP3025 tiene una mejor resistencia al desgaste que el cermet convencional y permite un mayor tiempo entre el cambio de herramientas.</p>	Convencional <b>MP3025</b>  <p>MP3025 dobla la duración de vida de la herramienta y el rompevirutas LP permite un mecanizado sin vibraciones.</p>	Convencional <b>MP3025</b>  <p>MP3025 dobla la vida de la herramienta en comparación con placas convencionales durante mecanizado en seco.</p>

Placa	TNGG160404L-F (MP3025)	
Material	Ck45 	
Condiciones de corte	Velocidad de corte (m/min.)	250
	Área de avance (mm/min.)	0.15
	Profundidad de corte (mm)	0.5
Refrigerante	Corte húmedo	
Resultados	Convencional <b>MP3025</b>  <p>Comparado con productos convencionales, MP3025 sufre menos desgaste, con la consecuente ampliación de la duración de vida de la herramienta.</p>	



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